



- (51) **International Patent Classification:**  
*C07C 17/06* (2006.01)      *C07C 21/04* (2006.01)  
*C07C 17/25* (2006.01)      *C07C 17/20* (2006.01)  
*C07C 19/01* (2006.01)      *C07C 21/08* (2006.01)
- (21) **International Application Number:**  
PCT/US2012/049204
- (22) **International Filing Date:**  
1 August 2012 (01.08.2012)
- (25) **Filing Language:** English
- (26) **Publication Language:** English
- (30) **Priority Data:**  
61/515,959      7 August 2011 (07.08.2011)      US
- (71) **Applicant** (*for all designated States except US*): **DOW GLOBAL TECHNOLOGIES, LLC** [US/US]; 2040 Dow Center, Midland, Michigan 48674 (US).
- (72) **Inventors; and**
- (75) **Inventors/Applicants** (*for US only*): **TIRTOWIDJOJO, Max Markus** [US/US]; 110 Rosewood, Lake Jackson, Texas 77566 (US). **FISH, Barry** [US/US]; 71 Rosewood, Lake Jackson, Texas 77566 (US). **LAITAR, David Stephen** [US/US]; 2402 Plymouth Street, Midland, Michigan 48642 (US).
- (74) **Agent:** **JORDAHL, Kimberly S.**; PO Box 517, Willernie, MN 55090 (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, KM, 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, PE, PG, PH, PL, PT, QA, RO, RS, RU, RW, 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, ML, MR, NE, SN, TD, TG).

**Published:**

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

- (54) Title:** PROCESS FOR THE PRODUCTION OF CHLORINATED PROPENES

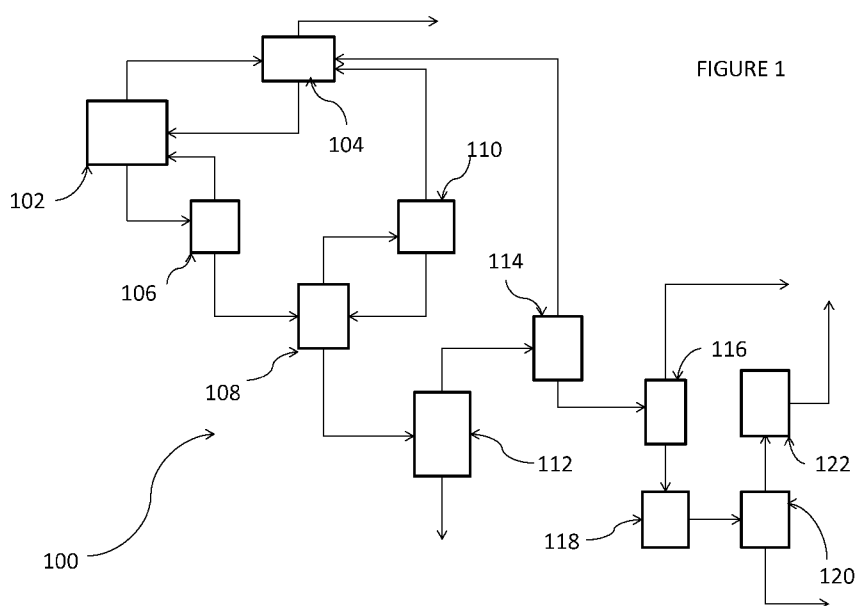


FIGURE 1

- (S7) Abstract:** Processes for the production of chlorinated propenes are provided. The present processes make use of a feedstock comprising 1,2,3-trichloropropane and chlorinates the 1,1,2,3-tetrachloropropane generated by the process prior to a dehydrochlorination step. Production of the less desirable pentachloropropane isomer, 1,1,2,3,3-pentachloropropane, is thus minimized. The present processes provide better reaction yield as compared to conventional processes that require dehydrochlorination of 1,1,2,3-tetrachloropropane prior to chlorinating the same. The present process can also generate anhydrous HCl as a byproduct that can be removed from the process and used as a feedstock for other processes, while limiting the production of waste water, thus providing further time and cost savings.

## PROCESS FOR THE PRODUCTION OF CHLORINATED PROPENES

## FIELD

[0001] The present invention relates to processes for the production of chlorinated propenes.

## BACKGROUND

[0002] Hydrofluorocarbon (HFC) products are widely utilized in many applications, including refrigeration, air conditioning, foam expansion, and as propellants for aerosol products including medical aerosol devices. Although HFC's have proven to be more climate friendly than the chlorofluorocarbon and hydrochlorofluorocarbon products that they replaced, it has now been discovered that they exhibit an appreciable global warming potential (GWP).

[0003] The search for more acceptable alternatives to current fluorocarbon products has led to the emergence of hydrofluoro-olefin (HFO) products. Relative to their predecessors, HFOs are expected to exert less impact on the atmosphere in the form of a lesser, or no, detrimental impact on the ozone layer and their much lower GWP as compared to HFC's. Advantageously, HFO's also exhibit low flammability and low toxicity.

[0004] As the environmental, and thus, economic importance of HFO's has developed, so has the demand for precursors utilized in their production. Many desirable HFO compounds, e.g., such as 2,3,3,3-tetrafluoroprop-1-ene or 1,3,3,3-tetrafluoroprop-1-ene, may typically be produced utilizing feedstocks of chlorocarbons, and in particular, chlorinated propenes, which may also find use as feedstocks for the manufacture of polyurethane blowing agents, biocides and polymers.

[0005] Unfortunately, many chlorinated propenes may have limited commercial availability, and/or may only be available at prohibitively high cost, due at least in part to the complicated, multi-step processes typically utilized in their manufacture. For example, in methods that utilize allyl chloride or 1,2,3-trichloropropane as starting materials, successive dehydrochlorinations and chlorinations with elemental chlorine may be done until the desired number of chlorine atoms has been added. Or, some conventional methods call for the

chlorination of chlorinated alkanes having fewer chlorine atoms than desired in the final product.

[0006] At some point in many, if not all, such processes, mixtures of isomers of tetrachloropropanes and pentachloropropanes may typically be produced, that once produced, may either be difficult to remove and/or react to produce undesirable by products. And so, many conventional processes call for the removal of these isomers, thereby lowering the yield of such processes. And, doing so introduces additional cost and time to an already multi-step and typically expensive process. Additionally, such processes may also result in the production of large amounts of contaminated waste water having high quantities of sodium chloride, and one or more chlorinated organic(s). The waste water thus must typically be treated before releasing it to the environment, requiring even further expenditure. Any recovered sodium chloride provides little in the way of recoverable cost.

[0007] It would thus be desirable to provide improved processes for the production of chlorocarbon precursors useful as feedstocks in the synthesis of refrigerants and other commercial products. More particularly, such processes would provide an improvement over the current state of the art if they were capable of minimizing, or even eliminating, the production of the less desirable tetrachloropropanes and pentachloropropanes, and/or economically utilizing any amounts of the less desirable isomers that may be produced. Further benefit would be realized if the processes would provide by-products of higher commercial or reuse value than sodium chloride.

#### BRIEF DESCRIPTION

[0008] The present invention provides efficient processes for the production of chlorinated propenes. The processes make use of 1,2,3-trichloropropane as a feedstock, and use at least one tetra- or penta- chloropropane isomer in a manner that is more commercially viable than the prior art. In so doing, the processes further minimize, or even eliminate the production of the less desirable pentachloropropane isomer, 1,1,2,3,3-pentachloropropane. As a result, yield and/or selectivity of the process is enhanced over conventional chlorination processes that discard these isomers, and time and cost savings are thus provided. Furthermore, the processes make use of at least one catalytic dehydrochlorination step, in place of one or more caustic dehydrochlorination step(s), and so waste water production is minimized, as is the production of the low-value by-product sodium chloride.

[0009] In one aspect, there is provided a process for the production of chlorinated propenes from a feedstream comprising 1,2,3-trichloropropane. Advantageously, at least a portion of the 1,1,2,3-tetrachloropropane produced by a first chlorination step is subjected to a second chlorination step prior to a first dehydrochlorination step to provide a mixture of 1,1,1,2,3-pentachloropropane and 1,1,2,2,3-pentachloropropane, while avoiding the production of the less desirable 1,1,2,3,3-pentachloropropane.

[0010] In some embodiments, at least one dehydrochlorination step may be conducted in the presence of a catalyst, and in such embodiments, further improvements in process productivity are expected. These embodiments also provide for the minimization of the production of the low value by-product sodium chloride, and instead, produce anhydrous HCl, which may be recovered from the process if desired. Useful chlorinating agents may include chlorine, sulfuryl chloride, or combinations of these.

[0011] The advantages provided by the present processes may be carried forward by utilizing the chlorinated and/or fluorinated propenes or higher alkenes to produce further downstream products, such as, e.g., 2,3,3,3-tetrafluoroprop-1-ene or 1,3,3,3-tetrafluoroprop-1-ene.

#### [0012] DESCRIPTION OF THE FIGURES

[0013] The detailed description that follows may be further understood and/or illustrated when considered along with the attached figures.

[0014] FIG. 1 is a schematic diagram of a process according to one embodiment.

#### DETAILED DESCRIPTION

[0015] The present specification provides certain definitions and methods to better define the present invention and to guide those of ordinary skill in the art in the practice of the present invention. Provision, or lack of the provision, of a definition for a particular term or phrase is not meant to imply any particular importance, or lack thereof. Rather, and unless otherwise noted, terms are to be understood according to conventional usage by those of ordinary skill in the relevant art.

[0016] The terms “first”, “second”, and the like, as used herein do not denote any order, quantity, or importance, but rather are used to distinguish one element from another. Also,

the terms “a” and “an” do not denote a limitation of quantity, but rather denote the presence of at least one of the referenced item, and the terms “front”, “back”, “bottom”, and/or “top”, unless otherwise noted, are merely used for convenience of description, and are not limited to any one position or spatial orientation.

[0017] If ranges are disclosed, the endpoints of all ranges directed to the same component or property are inclusive and independently combinable (e.g., ranges of “up to 25 wt.%, or, more specifically, 5 wt.% to 20 wt.%,” is inclusive of the endpoints and all intermediate values of the ranges of “5 wt.% to 25 wt.%,” etc.). As used herein, percent (%) conversion is meant to indicate change in molar or mass flow of reactant in a reactor in ratio to the incoming flow, while percent (%) selectivity means the change in molar flow rate of product in a reactor in ratio to the change of molar flow rate of a reactant.

[0018] Reference throughout the specification to “one embodiment” or “an embodiment” means that a particular feature, structure, or characteristic described in connection with an embodiment is included in at least one embodiment. Thus, the appearance of the phrases “in one embodiment” or “in an embodiment” in various places throughout the specification is not necessarily referring to the same embodiment. Further, the particular features, structures or characteristics may be combined in any suitable manner in one or more embodiments.

[0019] In some instances, “TCP” may be used herein as an abbreviation for 1,2,3-trichloropropane, “ACL” may be used as an abbreviation for allyl chloride or 3-chloropropene, and “TCPE” may be used as an abbreviation for 1,1,2,3-tetrachloropropene. The terms “cracking” and “dehydrochlorination” are used interchangeably to refer to the same type of reaction, i.e., one resulting in the creation of a double bond typically via the removal of a hydrogen and a chlorine atom from adjacent carbon atoms in chlorinated hydrocarbon reagents.

[0020] The present invention provides efficient processes for the production of chlorinated propenes from a feedstream comprising TCP, either alone, or in some embodiments, in combination with one or more other chlorinated alkanes or alkenes, e.g., allyl chloride. At least a portion of the 1,1,2,3-tetrachloropropane generated by the process is directly chlorinated, i.e., is subjected to a chlorination step prior to being subjected to a dehydrochlorination step. Conventional processes have typically called for the immediate

dehydrochlorination of 1,1,2,3-tetrachloropropane as it is generated in order to avoid the production of the less desirable penta-isomer 1,1,2,3,3-pentachloropropene.

[0021] Furthermore, the aforementioned conventional processes have utilized liquid caustic in this immediate dehydrochlorination, resulting in the production of sodium chloride. The present inventors have surprisingly discovered that the 1,1,2,3-tetrachloropropane generated by the process can instead be chlorinated to provide the more desirable 1,1,1,2,3 and 1,1,2,2,3 pentachloropropane isomers. By avoiding the immediate dehydrochlorination of 1,1,2,3-tetrachloropropane, the present processes minimize the production of the low-value by-product sodium chloride. Yield and efficiency of the present processes are thus improved as compared to conventional processes.

[0022] Catalysts are not required for the chlorination steps of the present process, but can be used, if desired, in order to increase the reaction kinetics. For example, free radical catalysts or initiators may be used to enhance the present process. Such catalysts may typically comprise one or more chlorine, peroxide or azo- ( $R-N=N-R'$ ) groups and/or exhibit reactor phase mobility/activity. As used herein, the phrase "reactor phase mobility/activity" means that a substantial amount of the catalyst or initiator is available for generating free radicals of sufficient energy which can initiate and propagate effective turnover of the product, the chlorinated and/or fluorinated propene(s), within the design limitations of the reactor.

[0023] Furthermore, the catalyst/initiator should have sufficient homolytic dissociation energies such that the theoretical maximum of free radicals is generated from a given initiator under the temperature/residence time of the process. It is especially useful to use free radical initiators at concentrations where free radical chlorination of incipient radicals is prevented due to low concentration or reactivity. Surprisingly, the utilization of the same, does not result in an increase in the production of impurities by the process, but does provide selectivities to the chlorinated propenes of at least 50%, or up to 60%, up to 70%, and in some embodiments, up to 80% or even higher.

[0024] Such free radical initiators are well known to those skilled in the art and have been reviewed, e.g., in "Aspects of some initiation and propagation processes," Bamford, Clement H. Univ. Liverpool, Liverpool, UK., Pure and Applied Chemistry, (1967), 15(3-4),333-48

and Sheppard, C. S.; Mageli, O. L. "Peroxides and peroxy compounds, organic," Kirk-Othmer Encycl. Chem. Technol., 3rd Ed. (1982), 17, 27-90.

[0025] Taking the above into consideration, examples of suitable catalysts/initiators comprising chlorine include, but are not limited to carbon tetrachloride, hexachloroacetone, chloroform, hexachloroethane, phosgene, thionyl chloride, sulfuryl chloride, trichloromethylbenzene, perchlorinated alkylaryl functional groups, or organic and inorganic hypochlorites, including hypochlorous acid, and t-butylhypochlorite, methylhypochlorite, chlorinated amines (chloramine) and chlorinated amides or sulfonamides such as chloroamine-T<sup>®</sup>, and the like. Examples of suitable catalysts/initiators comprising one or more peroxide groups include hydrogen peroxide, hypochlorous acid, aliphatic and aromatic peroxides or hydroperoxides, including di-t-butyl peroxide, benzoyl peroxide, cumyl peroxide and the like. Diperoxides offer an advantage of not being able to propagate competitive processes (e.g., the free radical chlorination of PDC to TCP (and its isomers) and tetrachloropropanes). In addition, compounds comprising azo- groups, such as azobisisobutyronitrile (AIBN), 1,1'-azobis(cyclohexanecarbonitrile (ABCN), 2,2'-azobis(2,4-dimethyl valeronitrile), and dimethyl 2,2'-azobis(2-methylpropionate), may have utility in effecting the chlorination of PDC to trichloropropanes and tetrachloropropanes under the conditions of this invention. Combinations of any of these may also be utilized.

[0026] The process or reactor zone may be subjected to pulse laser or continuous UV/visible light sources at a wavelength suitable for inducing photolysis of the free radical catalyst/initiator, as taught by Breslow, R. in *Organic Reaction Mechanisms* W.A. Benjamin Pub, New York p 223-224. Wavelengths from 300 to 700 nm of the light source are sufficient to dissociate commercially available radical initiators. Such light sources include, .e.g., Hanovia UV discharge lamps, sunlamps or even pulsed laser beams of appropriate wavelength or energy which are configured to irradiate the reactor chamber. Alternatively, chloropropyl radicals may be generated from microwave discharge into a bromochloromethane feedsource introduced to the reactor as taught by Bailleux et al., in *Journal of Molecular Spectroscopy*, 2005, vol. 229, pp. 140-144.

[0027] In some embodiments, ionic chlorination catalysts may be utilized in one or more chlorination steps. The use of ionic chlorination catalysts in the present process is particularly advantageous since they dehydrochlorinate and chlorinate alkanes at the same time. That is, ionic chlorination catalysts remove a chlorine and hydrogen from adjacent

carbon atoms, the adjacent carbon atoms form a double bond, and HCl is released. A chlorine molecule is then added back, replacing the double bond, to provide a higher chlorinated alkane.

[0028] Ionic chlorination catalysts are well known to those of ordinary art and any of these may be used in the present process. Exemplary ionic chlorination catalysts include, but are not limited to, aluminum chloride, ferric chloride ( $\text{FeCl}_3$ ) and other iron containing compounds, iodine, sulfur, antimony pentachloride ( $\text{SbCl}_5$ ), boron trichloride ( $\text{BCl}_3$ ), lanthanum halides, metal triflates, and combinations thereof. If catalysts are to be utilized in one or more of the chlorination steps of the present process, the use of ionic chlorination catalysts, such as  $\text{AlCl}_3$  and  $\text{I}_2$ , can be preferred.

[0029] The dehydrochlorination steps of the present process may similarly be conducted without a catalyst, in the presence of a liquid caustic. Although vapor phase dehydrochlorinations advantageously result in the formation of a higher value byproduct than liquid phase dehydrochlorinations, liquid phase dehydrochlorination reactions can provide cost savings since evaporation of reactants is not required. The lower reaction temperatures used in liquid phase reactions may also result in lower fouling rates than the higher temperatures used in connection with gas phase reactions, and so reactor lifetimes may also be optimized when at least one liquid phase dehydrochlorination is utilized.

[0030] Many chemical bases are known in the art to be useful for this purpose, and any of these can be used. For example, suitable cracking bases include, but are not limited to, alkali metal hydroxides, such as sodium hydroxide, potassium hydroxide, calcium hydroxide; alkali metal carbonates such as sodium carbonate; lithium, rubidium, and cesium or combinations of these. Phase transfer catalysts such as quaternary ammonium and quaternary phosphonium salts can also be added to improve the dehydrochlorination reaction rate with these chemical bases.

[0031] Alternatively, in some embodiments, one or more of the dehydrochlorination steps of the present process may be carried out in the presence of a catalyst so that the reaction rate is enhanced and also use of liquid caustic is reduced, or even eliminated, from the process. If the use of catalysts is desired, suitable dehydrochlorination catalysts include, but are not limited to, ferric chloride ( $\text{FeCl}_3$ ). Other suitable examples of vapor phase

dehydrochlorination catalysts known to those of ordinary skill in the art are disclosed in International Patent Application No. WO 2009/015304 A1.

[0032] Any or all of the chlorination and/or dehydrochlorination catalysts can be provided either in bulk or in connection with a substrate, such as activated carbon, graphite, silica, alumina, zeolites, fluorinated graphite and fluorinated alumina. Whatever the desired catalyst (if any), or format thereof, those of ordinary skill in the art are well aware of methods of determining the appropriate concentration and method of introduction thereof. For example, many catalysts are typically introduced into the reactor zone as a separate feed, or in solution with other reactants, e.g., TCP.

[0033] The amount of any chlorination catalyst and/or dehydrochlorination catalyst utilized will depend upon the particular catalyst chosen as well as the other reaction conditions. Generally speaking, in those embodiments of the invention wherein the utilization of a catalyst is desired, enough of the catalyst should be utilized to provide some improvement to reaction process conditions (e.g., a reduction in required temperature) or realized products, but yet not be more than will provide any additional benefit, if only for reasons of economic practicality.

[0034] For purposes of illustration only then, it is expected, that useful concentrations of an ionic chlorination catalyst or free radical initiator will range from 0.001% to 20% by weight, or from 0.01% to 10%, or from 0.1% to 5 wt.%, inclusive of all subranges therebetween. If a dehydrochlorination catalyst is utilized for one or more dehydrochlorination steps, useful concentrations may range from 0.01 wt.% to 5 wt.%, or from 0.05 wt.% to 2 wt.% at temperatures of from 70°C to 200°C. If a chemical base is utilized for one or more dehydrochlorinations, useful concentrations of these will range from 0.01 to 20 gmole/L, or from 0.1 gmole/L to 15gmole/L, or from 1 gmole/L to 10 gmole/L, inclusive of all subranges therebetween. Concentrations of each catalyst/base are given relative to the feed, e.g., 1,2,3-trichloropropane.

[0035] The present process can make use of a feedstock comprising 1,2,3-trichloropropane to produce the desired chlorinated propenes. The process feedstock may also comprise recycled alkanes, including recycled 1,1,2,3-tetrachloropropane, or other chlorinated alkanes, if desired. And, the 1,2,3-trichloropropane may be generated within, or

upstream of, the process, if desired, by any methods known to those of ordinary skill in the art.

[0036] The chlorination steps of the process may be carried out using any chlorination agent, and several of these are known in the art. For example, suitable chlorination agents include, but are not limited to chlorine, and/or sulfuryl chloride ( $\text{SO}_2\text{Cl}_2$ ). Combinations of chlorinating agents may also be used. Either or both  $\text{Cl}_2$  and sulfuryl chloride may be particularly effective when aided by the use of the aforementioned ionic chlorination catalysts.

[0037] Any chlorinated propene may be produced using the present method, although those with 3-5 chlorine atoms are particularly commercially attractive, and production of the same may thus be preferred in some embodiments. In some embodiments, the process may be used in the production of 1,1,2,3-tetrachloropropene, which may be preferred as a feedstock for refrigerants, polymers, biocides, etc.

[0038] In additional embodiments, one or more reaction conditions of the process may be optimized, in order to provide even further advantages, i.e., improvements in selectivity, conversion or production of reaction by-products. In certain embodiments, multiple reaction conditions are optimized and even further improvements in selectivity, conversion and production of reaction by-products produced can be seen.

[0039] Reaction conditions of the process that may be optimized include any reaction condition conveniently adjusted, e.g., that may be adjusted via utilization of equipment and/or materials already present in the manufacturing footprint, or that may be obtained at low resource cost. Examples of such conditions may include, but are not limited to, adjustments to temperature, pressure, flow rates, molar ratios of reactants, etc.

[0040] That being said, the particular conditions employed at each step described herein are not critical, and are readily determined by those of ordinary skill in the art. What is important is that at least a portion of any 1,1,2,3-tetrachloropropane generated by the process is directly chlorinated prior to being subjected to a dehydrochlorination step. It is also advantageous that at least one dehydrochlorination step be conducted catalytically, rather than by using liquid caustic, so that anhydrous  $\text{HCl}$  is produced and the production of sodium chloride is minimized. Those of ordinary skill in the art will readily be able to determine suitable equipment for each step, as well as the particular conditions at which the

chlorination, dehydrochlorination, separation, drying and isomerization steps may be conducted.

[0041] In the present process, 1,2,3-trichloropropane is converted to TCPE. Importantly and advantageously, at least a portion of any 1,1,2,3-tetrachloropropane generated by the process is directly chlorinated, rather than being directly dehydrochlorinated. Surprisingly, the production of the less desirable 1,1,2,3,3-pentachloropropane isomer is minimized.

[0042] More specifically, and in one exemplary embodiment, a feed stream comprising TCP is fed to a liquid phase chlorination reactor, e.g., such as a batch or continuous stirred tank autoclave reactor with an internal cooling coil. A shell and multitube reactor followed by vapor liquid disengagement tank or vessel can also be used. Suitable reaction conditions include, e.g., temperatures of from ambient temperature (e.g., 20°C) to 200°C, or from 30°C to 150°C, or from 40°C to 120°C or from 50°C to 100°C. Ambient pressure may be used, or pressures of from 100 kPa to 1000 kPa, or from 100 kPa to 500 kPa, or from 100kPa to 300 kPa. At such conditions, the TCP is chlorinated to tetra- and penta-chlorinated propanes at per pass conversions of greater than 10%, or 30%, or 50%, or 60%, or even up to 80% can be seen. The per pass conversion and reaction conditions are chosen or optimized such that the products of the first chlorination step consist of a mixture of tetrachloropropane and pentachloropropane while minimizing the formation of hexachloropropane to less than 10%.

[0043] The chlorination(s) may be conducted neat, i.e., in the absence of solvent, or, one or more solvents may be provided to the chlorination reactor, and may be provided as a component of the feedstock, or, recycled from one or more separation columns operatively disposed to receive streams from the chlorination reactor. For example, chloropropane intermediates may be recycled back to the chlorination reactor from one separation column, tri- and tetrachloropropane intermediates may be recycled from another separation column. In addition, or as an alternative, the chlorination reactor may be provided with a feed of any solvent appropriate for chlorination reactions, such as, e.g., carbon tetrachloride, sulfuryl chloride, 1,1,2,3,3-pentachloropropane, 1,1,2,2,3,3-hexachloropropane, other hexachloropropane isomers, or a combination of these.

[0044] The overhead vapor from the chlorination reactor, is cooled, condensed and fed to a first separation column, e.g., a distillation column that may be used to recover anhydrous

HCl from an overhead stream thereof. This separation column is operated at conditions effective to provide anhydrous HCl to an overhead line thereof and chlorine through a bottom recycle line.

[0045] More particularly, the top temperature of separation column can typically be set below 0°C or more preferably, can be set at a temperature of from -70°C to -10°C. The bottom temperature of this separation column is desirably set at from 10°C to 150°C or from 30°C to 100°C, with the exact temperature dependent to some degree on the bottom mixture composition. The pressure of this separation column is desirably set above 200 kPa or preferably, from 500 kPa to 2000 kPa, or more preferably from 500kPa to 1000kPa. The bottom stream of a distillation column operated at such conditions would be expected to contain excess chlorine while the overhead stream would be expected to comprise anhydrous HCl.

[0046] The bottoms liquid product stream from the first chlorination reactor may be fed to a second separation column operated at conditions effective to separate the unreacted TCP and tetrachloropropane isomers from the pentachloropropane isomers and heavier byproducts. Such a separation may be achieved, e.g., by feeding the bottoms liquid stream to a distillation column operating with a reboiler temperature lower than 180°C and at a pressure less than atmospheric.

[0047] The tetrachloropropane isomers are then desirably separated into at least two streams – one stream comprising 1,2,2,3-tetrachloropropane (having a boiling point of 163°C) and unreacted TCP (having a boiling point of 157°C) and the other comprising 1,1,2,3-tetrachloropropane (having a boiling point of 179°C). The stream of TCP and 1,2,2,3-tetrachloropropane may then be recycled to the first chlorination reactor, or, separated to provide streams comprising TCP and 1,2,2,3-tetrachloropropane, e.g., via a separation column operating with a bottoms temperature of lower than 165°C and at a pressure at or less than atmospheric. In the latter embodiment, the separated TCP is then recycled to the first chlorination reactor and the 1,2,2,3-tetrachloropropane further chlorinated to provide 1,1,2,2,3-pentachloropropane, or dehydrochlorinated and chlorinated to provide 1,1,2,2,3-pentachloropropane.

[0048] Advantageously, in the present process, the separated 1,1,2,3-tetrachloropropane is desirably then directly chlorinated to provide the desirable 1,1,1,2,3 and 1,1,2,2,3

pentachloropropane isomers and to minimize, or even prevent, the production of the less desirable penta-isomer, 1,1,2,3,3-pentachloropropane. Such a chlorination may desirably be carried out in a liquid phase chlorination reactor separate from, and operated at different conditions than, the first chlorination reactor. More specifically, 1,1,2,3-tetrachloropropane may be chlorinated to provide 1,1,1,2,3 and 1,1,2,2,3-pentachloropropane by feeding the same to a continuous stirred tank reactor operated at conditions sufficient to provide from 10% to 60% or more preferably from 10% to 40% per pass conversion of 1,1,2,3-tetrachloropropane at the reactor effluent, e.g., at a temperature of from 30°C to 120°C and at pressures of ambient pressure or higher. When so operated, this chlorination reaction would be expected to provide per pass conversions of 1,1,2,3-tetrachloropropane of 60% or lower with selectivity to 1,1,1,2,3 and 1,1,2,2,3-pentachloropropane of from 80% to 95%.

[0049] The output from the second chlorination reactor may then be fed to a separation column operated at conditions effective to separate the second chlorination reaction stream into an overhead stream comprising chlorine and HCl and a bottoms stream comprising unreacted 1,1,2,3-tetrachloropropane, the desired pentachloropropane isomers and heavier by-products. The overhead stream may be further separated and purified to provide a stream of chlorine, which may be recycled to the first chlorination reactor, if desired, and a stream of HCl, which may be provided to the first separation column for the recovery of anhydrous HCl, as described above.

[0050] The bottoms stream from the second chlorination reactor may be fed to the second separation column to recover the unconverted 1,1,2,3-tetrachloropropane intermediate in the overhead stream. The bottom stream of this separation column is provided to another separation column operated at conditions effective to provide a bottom stream comprising the less desirable pentachloropropane isomer, 1,1,2,3,3-pentachloropropane, and heavier chlorinated reaction products, which is purged, and an overhead stream comprising the desirable pentachloropropane isomers, 1,1,1,2,3-pentachloropropane and 1,1,2,2,3-pentachloropropane. This overhead stream is expected to comprise pentachloropropane isomers that can be dehydrochlorinated to tetrachloropropane isomers.

[0051] The stream comprising 1,1,1,2,3-pentachloropropane and 1,1,2,2,3-pentachloropropane is then desirably catalytically dehydrochlorinated, e.g., using iron or an iron containing catalyst, such as FeCl<sub>3</sub>. More specifically, dehydrochlorination reactor may typically be a batch or a continuous stirred tank reactor. The mixing can be done, e.g., by

mechanical or jet mixing of feed streams. Those of ordinary skill in the art are readily able to determine the appropriate conditions at which to run a dehydrochlorination reactor in order to conduct the aforementioned dehydrochlorination. This catalytic dehydrochlorination provides 2,3,3,3-tetrachloropropene and 1,1,2,3-tetrachloropropene, as well as HCl that may advantageously be recovered by recycling the waste stream from the reactor to the initial separation column.

[0052] The reaction stream from the catalytic dehydrochlorination reactor is then fed to a further distillation column to separate the desired chlorinated propene, e.g., 1,1,2,3-TCPE, from the remaining stream, which is expected to comprise mostly 1,1,2,2,3-pentachloropropane. This stream of 1,1,2,2,3-pentachloropropane is then caustic cracked to provide a mixture of 1,1,2,3-TCPE and 2,3,3,3-TCPE. The reaction stream from the caustic dehydrochlorination reactor may optionally be provided to a drying column, and the dried stream therefrom provided to a further reactor to isomerize the 2,3,3,3-tetrachloropropene to 1,1,2,3-tetrachloropropene under the appropriate conditions.

[0053] For example, catalysts may be utilized to assist in the isomerization, in which case, suitable catalysts include, but are not limited to (i) siliceous granules having a polar surface including kaolinite, bentonite, and attapulgite; (ii) other mineral salts of silica such as saponite, quartz, (iii) siliceous non-mineral substance such as silica gel, fumed silica, and glass, or combinations of any of these. Suitable conditions for drying columns for such reaction streams are also known to those of ordinary skill in the art, as evidenced by US Patent No. 3,926,758.

[0054] A schematic illustration of such a process is shown in Figure 1. As shown in Figure 1, process 100 would make use of chlorination reactors 102 and 110, separation columns 104, 106, 108, 112 and 116, dehydrochlorination reactors 114 and 118, dryer 120 and isomerization reactor 122. In operation, 1,2,3-trichloropropane (alone or, in some embodiments, in combination with allyl chloride) and the desired chlorination agent (e.g., chlorine,  $\text{SO}_2\text{Cl}_2$ , or combinations of these) are fed to chlorination reactor 102, which may be operated at any set of conditions operable to provide for the chlorination of allyl chloride to TCP and/or the chlorination of TCP to tetra- and pentachlorinated propanes.

[0055] The overhead stream of chlorination reactor 102 is provided to separation column 104, which may desirably be a distillation column. The feed to the separation column 104 is

preferably totally condensed liquid at temperature  $-40^{\circ}\text{C}$  to  $0^{\circ}\text{C}$  made by applying a fractionation method such as that described in US Patent No. 4,010,017. Separation column 104 is operated at conditions effective to provide anhydrous HCl through an overhead line thereof and chlorine and unreacted TCP to the first chlorination reactor 102.

[0056] The bottom stream of reactor 102 is provided to separation column 106, which is operated at conditions effective to provide a bottoms stream comprising 1,1,2,3-tetrachloropropane, pentachloropropanes and heavier reaction by-products, and an overhead stream comprising TCP and other tetrachloropropane isomers. This overhead stream may be recycled to first chlorination reactor 102, while the bottoms stream from separation column 106 is fed to further separation column 108.

[0057] Separation column 108 serves to separate 1,1,2,3-tetrachloropropane from the remaining penta-chloropropane isomers and provides it to second chlorination reactor 110. Second chlorination reactor 110 is desirably operated at conditions effective to maximize the production of the desirable penta- isomers, 1,1,1,2,3 and 1,1,2,2,3, while minimizing the production of the less desirable 1,1,2,3,3 pentachloropropane isomer. The product stream of reactor 110, comprising unreacted 1,1,2,3-tetrachloropropanes and the desired pentachloropropane isomers, is recycled back to separation column 108. Anhydrous HCl and excess  $\text{Cl}_2$  is fed to column 104 to purify the HCl.

[0058] The bottoms stream from separation column 108 is provided to separation column 112 that separates the stream into an overhead stream comprising the desirable pentachloropropane isomers (1,1,2,2,3-pentachloropropane and 1,1,1,2,3-pentachloropropane) and a bottom stream comprising the less desirable 1,1,2,3,3-pentachloropropane, hexachloropropane and heavier by-products. The overhead stream is fed to catalytic dehydrochlorination reactor 114, while the bottoms stream is appropriately disposed of.

[0059] Within dehydrochlorination reactor 114, the desirable pentachloropropane isomers are catalytically dehydrochlorinated to provide 2,3,3,3-tetrachloropropene and 1,1,2,3-tetrachloropropene. More specifically, dehydrochlorination reactor may be charged with, e.g., iron or an iron containing catalyst such as  $\text{FeCl}_3$  and operated at pressures of from ambient to 400kPa, at temperatures of from  $40^{\circ}\text{C}$  to  $150^{\circ}\text{C}$  and with a residence time of less than 3 hours.

[0060] The bottom reaction stream from dehydrochlorination reactor 114 is fed to separation column 116, while the overhead stream, comprising anhydrous HCl, is provided to separation column 104 for separation and recovery of anhydrous HCl. The bottom reaction stream from catalytic dehydrochlorination reactor 114, comprising tetrachloropropene products and unreacted pentachloropropanes, is then fed to separation column 116.

[0061] Separation column 116 is operated at conditions effective to separate the desired chlorinated propene, e.g., 1,1,2,3-TCPE, as an overhead stream from the remaining by-products, e.g., 1,1,2,2,3-pentachloropropane. The bottoms stream from separation column 116 is fed to caustic dehydrochlorination reactor 118, and the product stream thereof provided to drying column 120. The dried stream from drying column 120 is provided to isomerization reactor 122 to isomerize the 2,3,3,3-tetrachloropropene to 1,1,2,3-tetrachloropropene under the appropriate conditions.

[0062] The chlorinated propenes produced by the present process may typically be processed to provide further downstream products including hydrofluoroolefins, such as, for example, 1,3,3,3-tetrafluoroprop-1-ene (HFO-1234ze). Since the present invention provides an improved process for the production of chlorinated propenes, it is contemplated that the improvements provided will carry forward to provide improvements to these downstream processes and/or products. Improved methods for the production of hydrofluoroolefins, e.g., such as 2,3,3,3-tetrafluoroprop-1-ene (HFO-1234yf), are thus also provided herein.

[0063] The conversion of chlorinated propenes to provide hydrofluoroolefins may broadly comprise a single reaction or two or more reactions involving fluorination of a compound of the formula  $C(X)_mCCl(Y)_n(C)(X)_m$  to at least one compound of the formula  $CF_3CF=CHZ$ , where each X, Y and Z is independently H, F, Cl, I or Br, and each m is independently 1, 2 or 3 and n is 0 or 1. A more specific example might involve a multi-step process wherein a feedstock of a chlorinated propene is fluorinated in a catalyzed, gas phase reaction to form a compound such as 1-chloro-3,3,3-trifluoropropene (1233zd). The 1-chloro-2,3,3,3-tetrafluoropropane is then dehydrochlorinated to 2,3,3,3-tetrafluoroprop-1-ene or 1,3,3,3-tetrafluoroprop-1-ene via a catalyzed, gas phase reaction.

[0064] Example 1.

[0065] 50 mL 1,2,3-trichloropropane and 500 mg dimethyl 2,2'-azobis(2-methylpropionate) are added to a tubular reactor at a pressure of 150 psig. The reactor is

sealed and Cl<sub>2</sub> flow started (30% v/v, 200 sccm). The reactor is then heated to 70°C. After 200 min at 70°C, 23% conversion of the TCP is observed, with the product stream comprising 1,1,2,3-tetrachloropropane, 1,2,2,3-tetrachloropropane, 1,1,2,2,3-pentachloropropane, and 1,1,2,3,3-pentachloropropane, with selectivities of 59.7%, 37.2%, 2.0%, and 1.2% respectively. The 1123-tetrachloropropane is then separated from the product mixture, and the reactor purged.

[0066] Carbon tetrachloride (45 mL) is then added to the reactor and the reactor sealed. Cl<sub>2</sub> (30% in N<sub>2</sub>, v/v) is added (5 minutes at 240 sccm, 20 minutes at 200 sccm). The reactor is heated to 70°C and then sealed (reactor pressure ~150 psig). A mixture of the 1,1,2,3-tetrachloropropane provided as described above (3 mL) CCl<sub>4</sub> (7 mL) and dimethyl 2,2'-azobis(2-methylpropionate) (20 mg) is added (t = 0). Samples are taken periodically. After the third sample, an additional shot of dimethyl 2,2'-azobis(2-methylpropionate) (20 mg) in CCl<sub>4</sub> (5 mL) is added. Table 1, below, shows the product distribution, expressed as molar% of the total product stream, as a function of time. As shown by Table 1, chlorination of 1,1,2,3 tetrachloropropane, at a conversion of less than 40%, prior to a dehydrochlorination of the same provides for the minimized production, i.e., less than 10%, or 8%, or 5%, of the hexachloropropane isomers 112233, 111233, and 111223.

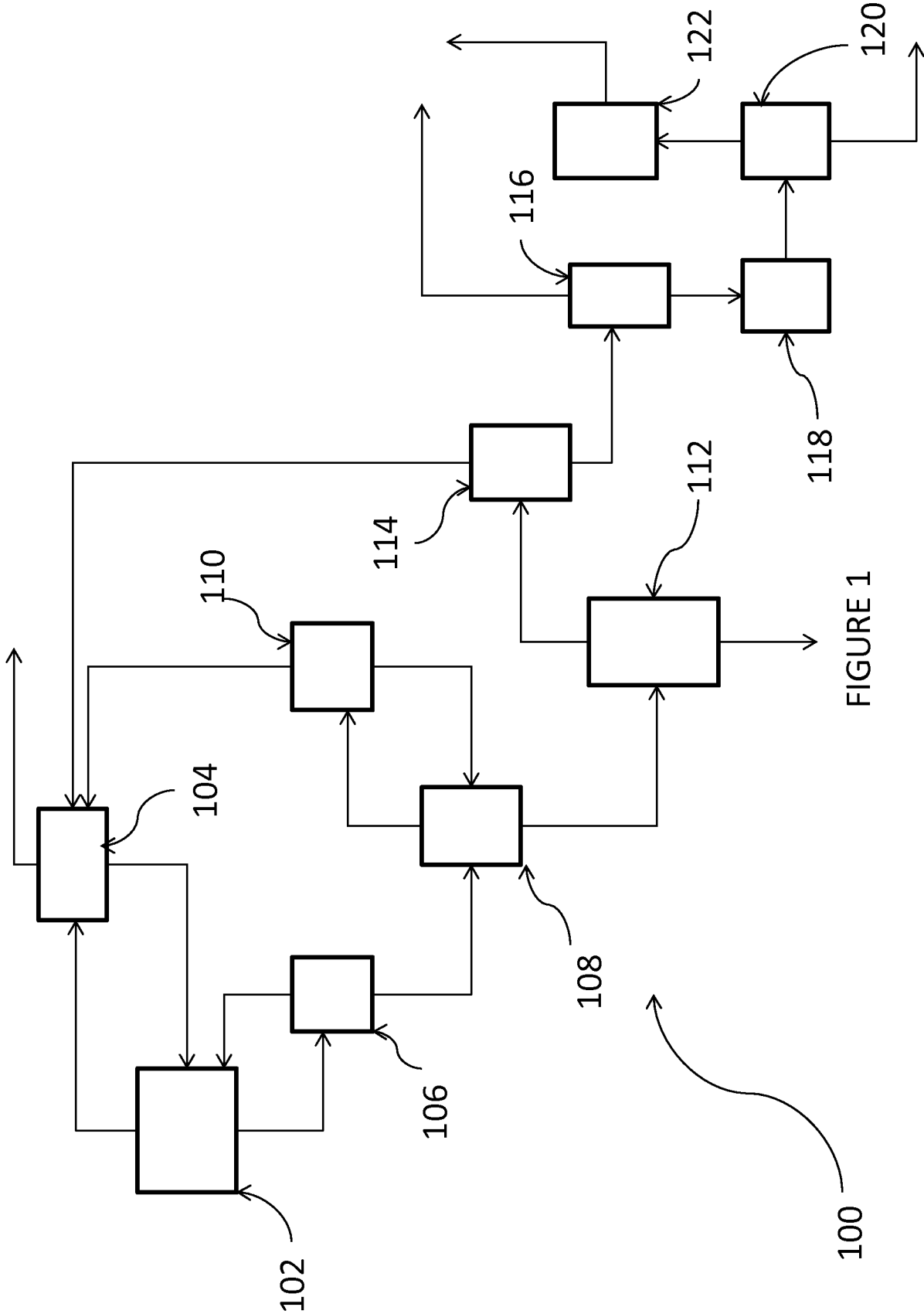
TABLE 1

Time (min)	6	18	63	125
1123-tetrachloropropane	91.46	87.92	70.49	61.61
11223-pentachloropropane	3.66	4.90	11.71	14.79
11123-pentachloropropane	1.81	2.49	5.23	6.73
11233-pentachloropropane	3.07	4.59	11.34	14.46
112233-hexachloropropane	0.00	0.09	0.63	1.19
111233-hexachloropropane	0.00	0.00	0.34	0.72
111223-hexachloropropane	0.00	0.00	0.26	0.50

## CLAIMS:

1. A process for the production of chlorinated propenes from a feedstream comprising 1,2,3-trichloropropane, wherein at least a portion of the 1,1,2,3-tetrachloropropane produced by a first chlorination step is subjected to a second chlorination step prior to a first dehydrochlorination step.
2. The process of claim 1, wherein the first chlorination step produces a mixture comprising tetrachloropropanes and pentachloropropanes.
3. The process of claim 2, wherein the mixture is separated to provide a stream comprising the 1,1,2,3-tetrachloropropane.
4. The process of claim 3, wherein the 1,1,2,3-tetrachloropropane is chlorinated in the second chlorination step to provide a mixture comprising 1,1,1,2,3-pentachloropropane and 1,1,2,2,3-pentachloropropane.
5. The process of claim 1 or 4, wherein the first or second chlorination step is conducted in the presence of a free radical initiator comprising azobisisobutyronitrile, 1,1'-azobis(cyclohexanecarbonitrile), 2,2'-azobis(2,4-dimethyl valeronitrile), and dimethyl 2,2'-azobis(2-methylpropionate), or a combination of these.
6. The process of claim 1 or 4, wherein the first or second chlorination step is conducted in the presence of an ionic chlorination catalyst.
7. The process of claim 2, wherein the mixture further comprises unreacted 1,2,3-trichloropropane that is separated and recycled to the first chlorination step.
8. The process of claim 2, wherein the mixture further comprises HCl that is separated and recovered from the process as anhydrous HCl.
9. The process of claim 4, wherein the remainder of the mixture is dehydrochlorinated in the first dehydrochlorination step.
10. The process of claim 9, wherein the dehydrochlorination is conducted using caustic or in the presence of a dehydrochlorination catalyst.

11. The process of claim 9, wherein the dehydrochlorination step produces a mixture comprising 1,1,2,3-tetrachloropropene, HCl and unreacted pentachloropropanes.
12. The process of claim 11, wherein the unreacted pentachloropropanes are separated and dehydrochlorinated to provide a mixture comprising 1,1,2,3-tetrachloropropene and 2,3,3,3-tetrachloropropene.
13. The process of claim 1 or 4, wherein  $\text{Cl}_2$ ,  $\text{SO}_2\text{Cl}_2$  or combinations of these is/are used as a chlorinating agent in the first and/or second chlorinating steps.
14. The process of claim 4, wherein the second chlorination step also produces HCl and chlorine.
15. A process for preparing 2,3,3,3-tetrafluoroprop-1-ene or 1,3,3,3- tetrafluoroprop-1-ene comprising converting a chlorinated propene prepared by the process of claim 1 into 2,3,3,3-tetrafluoroprop-1-ene or 1,3,3,3- tetrafluoroprop-1-ene.



## INTERNATIONAL SEARCH REPORT

International application No  
PCT/US2012/049204

<b>A. CLASSIFICATION OF SUBJECT MATTER</b> INV. C07C17/06 C07C17/25 C07C19/01 C07C21/04 C07C17/20 C07C21/08 ADD. According to International Patent Classification (IPC) or to both national classification and IPC		
<b>B. FIELDS SEARCHED</b> Minimum documentation searched (classification system followed by classification symbols) C07C 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, CHEM ABS Data, WPI Data		
<b>C. DOCUMENTS CONSIDERED TO BE RELEVANT</b>		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	DATABASE WPI Week 198247 Thomson Scientific, London, GB; AN 1982-01735J XP002684194, & SU 899 523 B (UFA PETROLEUM INST) 23 January 1982 (1982-01-23)	1
Y	abstract -----	2-15
Y	US 2011/155942 A1 (PIGAMO ANNE [FR] ET AL) 30 June 2011 (2011-06-30) abstract -----	2-15
<input type="checkbox"/> Further documents are listed in the continuation of Box C. <input checked="" type="checkbox"/> 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  28 September 2012		Date of mailing of the international search report  08/10/2012
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  Delanghe, Patrick

# INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/US2012/049204

Patent document cited in search report		Publication date	Patent family member(s)	Publication date
SU 899523	B	23-01-1982	-----	
US 2011155942	A1	30-06-2011	US 2011155942 A1	30-06-2011
			US 2012172637 A1	05-07-2012
			WO 2011077191 A1	30-06-2011
			-----	