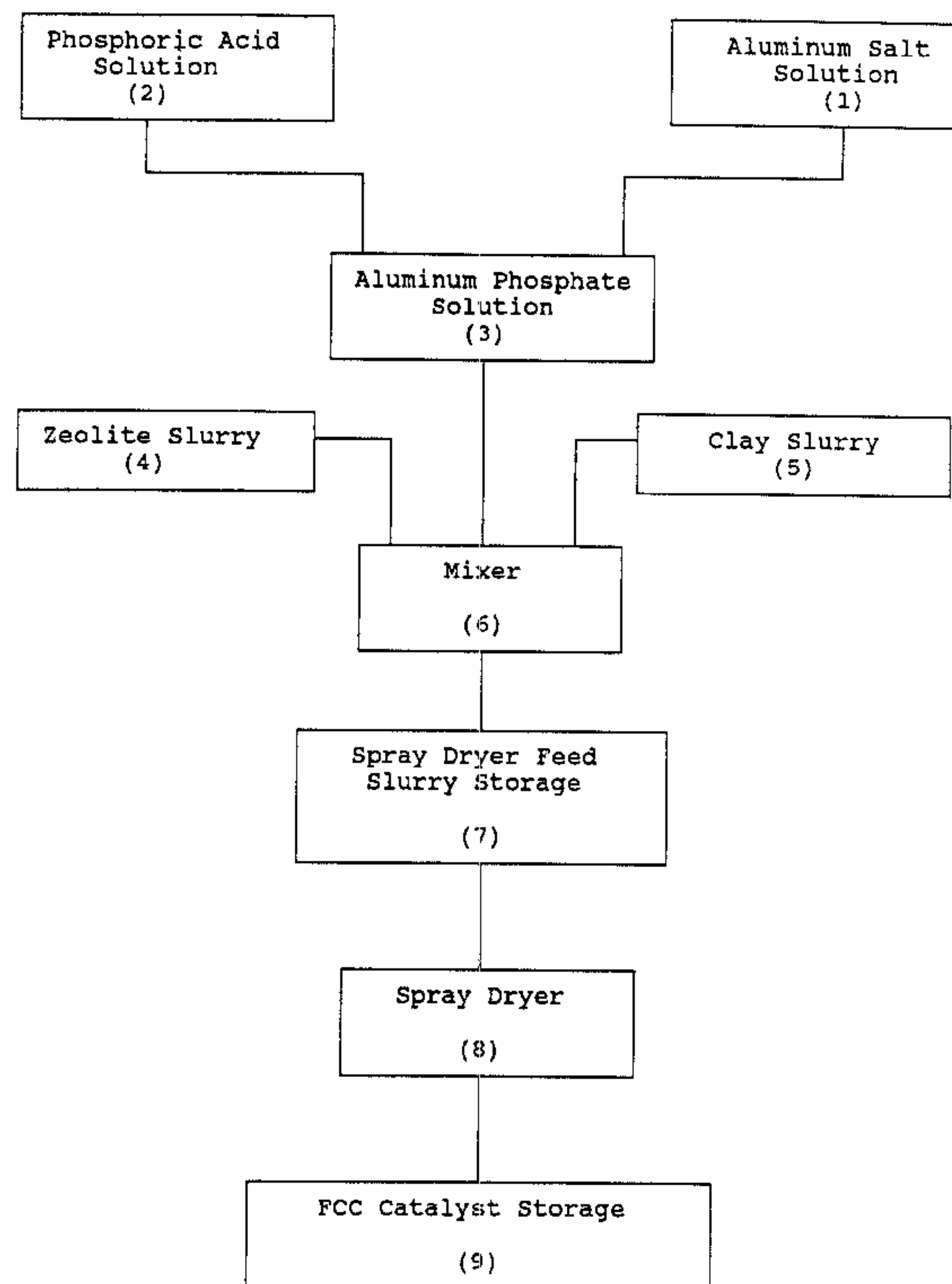




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(54) Titre : COMPOSITIONS CATALYTIQUES  
 (54) Title: CATALYTIC COMPOSITIONS



(57) Abrégé/Abstract:

Catalyst compositions are described which comprise crystalline molecular sieve zeolites and an aluminum phosphate component having a surface area of less than about 50 m<sup>2</sup>/g and a high degree of attrition resistance. The catalysts are particularly effective for the catalytic cracking of high molecular hydrocarbon feedstocks to obtain enhanced yields of C<sub>3</sub> and C<sub>4</sub> olefins such as isobutylene.

Abstract of the Invention

Catalyst compositions are described which  
comprise crystalline molecular sieve zeolites and an  
aluminum phosphate component having a surface area of  
5 less than about 50 m<sup>2</sup>/g and a high degree of attrition  
resistance. The catalysts are particularly effective  
for the catalytic cracking of high molecular  
hydrocarbon feedstocks to obtain enhanced yields of C<sub>3</sub>  
and C<sub>4</sub> olefins such as isobutylene.

The present invention relates to improved catalytic cracking catalysts, and more specifically to attrition resistant zeolite/aluminum phosphate ( $\text{AlPO}_4$ ) containing FCC catalysts that are particularly selective for the production of  $\text{C}_3$  and  $\text{C}_4$  olefins.

Catalysts and zeolites which include a phosphorus component are described in the following references.

U.S. 3,354,096 describes zeolite containing adsorbent and catalyst compositions which contain a phosphate binding agent to improve physical strength.

U.S. 3,649,523 describes hydrocracking catalysts which comprise a zeolite and an aluminum phosphate gel matrix.

U.S. 4,454,241, 4,465,780, 4,498,975 and 4,504,382 describe zeolite catalysts that are prepared from clay which are further modified by the addition of a phosphate compound to enhance catalytic activity.

U.S. 4,567,152, 4,584,091, 4,629,717 and 4,692,236 describe zeolite containing catalytic cracking catalysts that include phosphorus containing alumina.

U.S. 4,605,637, 4,578,371, 4,724,066 and 4,839,319 describe phosphorus and aluminum phosphate modified zeolites such as ZSM-5, Beta and ultrastable Y that are used in the preparation of catalytic compositions, including catalytic cracking catalysts.

U.S. 4,765,884 and U.S. 4,873,211 describe the preparation of cracking catalysts which consist of a zeolite and a precipitated alumina phosphate gel matrix.

While the prior art describes phosphorus modified zeolite and catalyst compositions which possess desirable catalytic or physical properties, highly

attrition resistant catalytic cracking catalysts that are capable of producing high yields of C<sub>3</sub> and C<sub>4</sub> olefins, and isobutylene in particular have not been described.

5           It is therefore an object of the present invention to provide improved catalytic compositions which include a zeolite and aluminum phosphate.

          It is a further object to provide a method for preparing zeolite/alumina phosphate catalytic cracking  
10 catalysts which are highly attrition resistant and selective for the production of C<sub>3</sub> and C<sub>4</sub> olefins.

          It is yet a further object to provide a fluid catalytic cracking (FCC) catalyst which is resistant to attrition and capable of producing enhanced yields  
15 of isobutylene.

          It is still a further object to provide an FCC process which is capable of producing high yields of isobutylene that may be used in the production of methyl tertiary butyl ether (MTBE).

20           These and still further objects will become apparent to one skilled-in-the-art from the following detailed description and drawing wherein Figure 1 is a flow diagram which illustrates a preferred process for preparing the novel catalysts of the present  
25 invention; and Figures 2 through 9 are graphic presentations of data obtained during evaluation of catalyst compositions of the present invention in which Figure 2 plots C<sub>3</sub> and C<sub>4</sub> olefin agent vs. conversion; Figure 3 plots C<sub>5</sub>+gasoline yield vs.  
30 conversion; Figure 4 plots PONA RON (the research octane number of the parafins, olefins, naphthenes and aromatics contained in the C<sub>5</sub>+gasoline fraction) vs. conversion; Figure 5 plots PONA MON (motor octane

number vs. conversion; Figure 6 plots isobutylene yields vs. wt.% Beta catalyst in catalyst blend; Figure 7 plots isobutylene selectivity vs. wt.% Beta catalyst in the catalyst blend; Figure 8 plots PONA aromatics vs. wt.% Beta catalyst in the catalyst blend; and Figure 9 plots PONA olefin yields vs. wt.% Beta catalyst in the catalyst blend.

Broadly, our invention contemplates a catalyst which comprises a zeolite and an aluminum phosphate component having a surface area of below about 50 m<sup>2</sup>g.

More specifically, we have found that highly active and attrition resistant catalysts may be prepared by mixing a solution of aluminum phosphate having a pH of about 0 to 1 and preferably 0.1 to 0.7, with a crystalline zeolite, and optionally a finely divided particulate inorganic oxide component such as clay, and with the resultant mixture having a pH of about 0 to 2, preferably 0.1 to 0.9, and forming/drying the mixture to obtain catalytic composites having desired shape and size.

A preferred method for preparing the FCC catalysts of the present invention is outlined in Figure 1 wherein an aluminum salt solution (1), preferably an aluminum nitrate solution containing 29 to 61 wt.% Al(NO<sub>3</sub>)<sub>3</sub>·9 H<sub>2</sub>O is combined with phosphoric acid solution (2) preferably containing 20 to 86 wt.% H<sub>3</sub>PO<sub>4</sub> to obtain an aluminum phosphate solution (3) having a pH of preferably 0.5 to 0.9 and an Al to PO<sub>4</sub> mol ratio of preferably 0.4 to 1.4. The aluminum phosphate solution is combined with aqueous slurries of (4) zeolite such as Beta and clay, (5) preferably kaolin, under high shear mixing conditions at (6) to obtain a spray drier feed slurry (7) that contains 20

to 45% solids which preferably comprises (dry basis) 8 to 25 wt.% aluminum phosphate, 10 to 40 wt.% zeolite and 35 to 82 wt.% kaolin.

5 The catalyst slurry is held in a spray dryer feed storage tank (8) under mixing conditions until spray dried at (9) at a temperature of 200 to 400°C. During the drying process the aluminum phosphate solution is converted into a binder. The particulate spray dried FCC catalyst has a particle size range of 20 to 150  
10 microns and is held in an FCC catalyst storage container prior to use.

The FCC catalyst may be used in a conventional FCC unit wherein the catalyst is reacted with a hydrocarbon feedstock at 400 to 700°C and regenerated  
15 at 500 to 850°C to remove coke. Typically, the catalyst possesses a Davison attrition index (DI) of 0 to 25, and preferably 0 to 7, as determined by the Davison Attrition Index Test described as follows.

A 7.0 gram sample of catalyst is screened to  
20 remove particles in the 0 to 20 micron size range. The particles above 20 microns are then subjected to a 1 hour test in a standard Roller Particle Size Analyzer using a hardened steel jet cup having a precision bored orifice. An air flow of 21 liters a  
25 minute is used. The Davison Index is calculated as follows:

$$\text{Davison Index} = \frac{\text{wt. \% 0-20 micron material formed during test}}{\text{wt. original 20 + micron fraction}}$$

The aluminum salt solution may contain aluminum  
30 nitrate, chloride, or other suitable soluble aluminum salts and is combined with phosphoric acid in amounts to obtain an Al to PO<sub>4</sub> ratio of 0.4 to 1.4 and

preferably 1 to 1, a pH of below 2 and preferably 0.1 to 0.9 and a solid concentration of 7 to 17 wt.% as aluminum phosphate. The zeolite component may comprise any acid resistant zeolite or molecular sieve having a silica to alumina molar ratio in excess of about 8 and preferably from about 15 to infinity. Particularly preferred zeolite/molecular sieves include zeolite Beta, ZSM zeolites such as ZSM-5, ZSM-11, ZSM-12, ZSM-20, ZSM-23, ZSM-35, ZSM-38, and ZSM-50, ultrastable Y zeolite (USY), mordenite, SAPO, aluminum phosphate and mixtures thereof. In particular, ZSM-5 is described in U.S. 3,702,886; zeolite Beta in U.S. 3,308,069; and ultrastable Y zeolite in U.S. 3,293,192 and 3,449,070.

While clay, such as kaolin, having a surface area of about 40 to 60 m<sup>2</sup>/g, is preferably included as a component of FCC catalyst prepared in accordance with the present invention, other finely divided inorganic components such as other types of clays, silica, alumina, silica-alumina gels and sols may be included.

The pH of the resulting mixture consisting of zeolite, aluminum phosphate binder, clay, other inorganic oxides, and water should have a pH of below 2 and preferably 0.1 to 0.9.

Typical FCC catalyst compositions will include the following range of ingredients:

Aluminum Phosphate:	10 to 44 wt.%
Zeolite/Molecular Sieve:	2 to 70 wt.%
Inorganic Solid:	0 to 88 wt%

While spray drying at gas inlet/outlet temperatures of 600 to 750°F/280-350°F is used in the

preparation of FCC catalysts, other forming/drying techniques such as pelletizing and extruding may be used to prepare catalysts/catalyst supports which are useful in catalytic processes such as hydrocracking, hydrotreating, isomerization, dewaxing, etc.

5 Preferred FCC catalysts which contain from about 5 to 60 wt.% Beta zeolite, 0 to 78 wt.% kaolin, and 12 to 46 wt.% aluminum phosphate are used to crack feedstocks such as gas-oil, residual oil and mixtures thereof which may contain up to 1.0 wt.% Conradson Carbon and 300 to 8000 ppm Ni & V. Based on MAT data, the anticipated cracked product stream obtained using these preferred catalysts will typically contain from 13 to 32 wt.% C<sub>3</sub> and C<sub>4</sub> olefins of which 2 to 6 wt.% comprises isobutylene which is particularly valuable for the production of MTBE.

10 It is found that the dried aluminum phosphate binder possesses a surface area of less than about 5 m<sup>2</sup>/g as determined by the nitrogen BET method, and a total pore volume of less than 0.10 cc/g as determined from the adsorption isotherm for nitrogen at liquid nitrogen temperatures and at a relative pressure (P/P<sub>0</sub>) of at least 0.97. When an additional matrix component such as silica, alumina, magnesia or silica-alumina sols or gels is added the matrix component of the catalyst may have a surface area of up to 300 m<sup>2</sup>/g and more preferably up to 100 m<sup>2</sup>/g.

25 Having described the basic aspect of our invention the following specific examples are given to illustrate specific preferred embodiments.

30

Example 1Preparation of Aluminum Phosphate Binder Solution  
with an  $\text{Al}_2\text{O}_3/\text{P}_2\text{O}_5$  ratio of 0.68

5 2439 g of a 60.2% (wt.)  $\text{Al}(\text{NO}_3)_3 \cdot 9\text{H}_2\text{O}$  solution  
were added to 758.7 g of 75% phosphoric acid solution  
and mixed well. The pH of the resulting solution was  
less than 0.5.

Example 2Preparation of Aluminum Phosphate Binder Solution  
10 with an  $\text{Al}_2\text{O}_3/\text{P}_2\text{O}_5$  ratio of 1.0

2548.8 g of a 60.2% (wt.)  $\text{Al}(\text{NO}_3)_3 \cdot 9\text{H}_2\text{O}$  solution  
were added 1004.7 g of 40% phosphoric acid solution  
and mixed well. The pH of the resulting solution was  
less than 0.5.

15 The procedures of Examples 1 and 2 illustrate the  
production of low pH aluminum phosphate binder  
solution at an  $\text{Al}_2\text{O}_3/\text{P}_2\text{O}_5$  molar ratio of 0.68 and 1.0,  
respectively. The material isolated from this binder  
system either by spray drying or by removing the water  
20 at  $110^\circ\text{C}$  is a highly crystalline, low surface area,  
low pore volume material. Table I below summarizes  
the typical chemical/physical and X-ray diffraction  
data of the aluminum phosphate of Example 2.

TABLE I

<u>Chemicals, wt.%</u>			
	Al <sub>2</sub> O <sub>3</sub>		41.80%
	P <sub>2</sub> O <sub>5</sub>		58.20%
5	Surface area	1 m <sup>2</sup> /g	_____
	Pore Volume (N <sub>2</sub> )	0.017 cc/g	_____
	X-Ray Diffraction Pattern (Example 2)		
	<u>d spacings</u>	<u>I/I<sub>0</sub></u>	<u>d spacing</u>
	4.362	100	2.511
10	4.122	97	2.409
	3.857	49	2.326
	3.376	10	2.143
	3.278	11	2.107
	3.205	5	2.063
15	3.156	6	
	2.998	11	
	2.867	7	

Example 3

20 Preparation of ZSM-5 Containing Catalyst using  
Aluminum Phosphate Binder

25 700 g of ZSM-5, 3258.4 g of kaolin clay and 3298.4 g of water were added to 3197.7 g of aluminum phosphate binder as prepared in Example 1. The resulting mixture (pH ~0.5) was mixed well before being spray dried. The chemical physical properties of three samples of catalyst prepared as above and designated as Catalyst A1, A2, and A3 are presented in Table 2.

TABLE II  
CHEMICAL/PHYSICAL PROPERTIES

Catalyst ID:	Catalyst A1	Catalyst A2	Catalyst A3	
<b>Chemical Properties, wt.%</b>				
5	Al <sub>2</sub> O <sub>3</sub>	37.24	37.36	37.04
	SiO <sub>2</sub>	49.98	49.37	50.80
	Na <sub>2</sub> O <sub>3</sub>	0.13	0.14	0.13
	SO <sub>4</sub>	0.41	0.43	0.30
	TiO <sub>2</sub>	1.82	1.77	1.85
10	Fe <sub>2</sub> O <sub>3</sub>	1.06	1.07	1.06
	P <sub>2</sub> O <sub>5</sub>	9.01	9.52	8.25
<b>Physical Properties</b>				
	ABD <sup>(1)</sup> , cc/g	0.82	0.81	0.81
	DI <sup>(2)</sup>	0	3	2
15	SA <sup>(3)</sup> , m <sup>2</sup> /g	53	52	55

(1) Average Bulk Density

(2) Davison Index

(3) BET Surface Area

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Example 4Preparation of ZSM-5 Containing Catalyst using  
Aluminum Phosphate Binder

1000 g of ZSM-5, 3706 g of kaolin clay, 3000 g of  
5 Ludox silica-sol AS-40, and 4900 g of water were added  
to 5320.4 g of aluminum phosphate binder as prepared  
in Example 2. The resulting mixture (pH ~0.5) was  
mixed well before being spray dried. The chemical  
physical properties of this catalyst, designated as  
10 Catalyst B, are presented in Table III.

Example 5Preparation of High Ratio ZSM-5 Containing Catalyst  
using Aluminum Phosphate Binder

1000 g of high ratio ( $\text{SiO}_2/\text{Al}_2\text{O}_3 = \sim 500$ ) ZSM-5,  
15 3706 g of kaolin clay, 3000 g of Ludox<sup>\*</sup> AS-40, and  
4900 g of water were added to 5320.4 g of aluminum  
phosphate binder as prepared in Example 2. The  
resulting mixture (pH ~0.5) was mixed well before  
being spray dried. The chemical physical properties  
20 of this catalyst, designated as Catalyst C, are  
presented in Table III.

Example 6Preparation of BETA Zeolite Containing Catalyst  
using Aluminum Phosphate Binder

25 A BETA zeolite slurry was made by mixing 1743 g  
of BETA zeolite powder and 3079 g of water. Dry  
powdered kaolin (1617 g) was added to 5655 g of an  
aluminum phosphate binder solution as prepared in

\* Trademark

Example 2 above. The BETA slurry was added to the aluminum phosphate/clay slurry and the resulting mixture was mixed well before being spray dried. The resulting catalyst had a formulation of 40% BETA, 22% aluminum phosphate, and 38% Clay. The chemical physical properties of this catalyst, designated as Catalyst D, are presented in Table III.

#### Example 7

Preparation of Low Cell Size USY Containing Catalyst  
10                    using Aluminum Phosphate Binder  
                         with  $\text{Al}_2\text{O}_3/\text{P}_2\text{O}_5$  ratio of 1.0

A slurry containing 1200 g of low soda, low cell size USY (24.39 Å, 0.53%  $\text{Na}_2\text{O}$ , 700  $\text{m}^2/\text{g}$ ) and 2800 g of water were added to a slurry containing 1482.4 g of kaolin clay and 3837.8 g of an aluminum phosphate binder solution prepared as in Example 2. The resulting slurry (pH ~0.6) was mixed well before being spray dried. The chemical physical properties of this catalyst, designated as Catalyst E, are presented in Table III.

#### Example 8

Preparation of Low Cell Size USY Containing Catalyst  
25                    using Aluminum Phosphate Binder

A slurry containing 1800 g of low soda, low cell size USY (24.39 Å, 0.53%  $\text{Na}_2\text{O}$ , 700  $\text{m}^2/\text{g}$ ) and 4200 g of water were added to a slurry containing 529.4 g of kaolin clay and 5330.5 g of an aluminum phosphate binder solution prepared as in Example 2. The resulting slurry (pH ~0.6) was mixed well before being

spray dried. The chemical physical properties of this catalyst, designated as Catalyst F, are presented in Table III.

#### Example 9

##### 5      Preparation of BETA Zeolite Catalyst with SiO<sub>2</sub> Sol

10      A slurry containing 2000 g of BETA zeolite (SiO<sub>2</sub>/Al<sub>2</sub>O<sub>3</sub> basis) and 4643 g of water was acidified to a pH of 4.0 with 20% H<sub>2</sub>SO<sub>4</sub>. To this slurry was added 10,000 g of silica sol (prepared from sodium silicate and acid alum) and 2353 g of kaolin clay (TV = 15%) and the resulting mixture was spray dried. The catalyst, which had a formulation of 40% BETA, 20% SiO<sub>2</sub> sol, and 40% Clay, was successfully ion-exchanged with 3% ammonium sulfate solution. The chemical physical  
15      properties of this catalyst, designated as Catalyst G, are presented in Table III.

#### Example 10

##### Preparation of BETA Zeolite Catalyst with Alumina Sol

20      2471 g of kaolin clay and 3830 g of aluminum chlorhydrol sol having 23% Al<sub>2</sub>O<sub>3</sub> and a Cl/Al mol ratio of 0.5 were mixed using a high shear mixer. To this was added 7143 g of a BETA zeolite slurry containing 2000 g of BETA zeolite and 4643 g of water. The mixture was spray dried and calcined for 2 hours at  
25      1000°F. The finished catalyst had the following composition: 40% BETA, 18% Al<sub>2</sub>O<sub>3</sub>, 42% Clay. The chemical physical properties of this catalyst, designated as Catalyst H, are presented in Table III.

Example 11Preparation of ZSM-5 Zeolite Catalyst with SiO<sub>2</sub> Sol

A slurry containing 1436.7 g of ZSM-5 and 2873.3 g of water was acidified to a pH of 4.0 with 20% H<sub>2</sub>SO<sub>4</sub>. To this slurry was added 11,000 g of silica sol (prepared from sodium silicate and acid alum) and 3116 g of kaolin clay (TV = 15%) and the resulting mixture was spray dried. The catalyst, which had a formulation of 25% ZSM-5, 22% SiO<sub>2</sub> sol, and 53% Clay, was successfully ion-exchanged with 3% ammonium sulfate solution. The chemical and physical properties of this catalyst, designated as Catalyst I, are presented in Table III.

Example 12

15 Preparation of High Ratio ZSM-5 Zeolite Catalyst  
with SiO<sub>2</sub> Sol

The catalyst was prepared as described in Example 11 with the exception that 1436.7 g of high ratio ZSM-5 was used. The chemical physical properties of this catalyst, designated as Catalyst J, are presented in Table III.

Example 13

25 Preparation of ZSM-5 Containing Catalyst using  
Aluminum Phosphate Binder and with  
Calcined Silica Replacing Clay

A slurry consisting of 1142.9 g of ZSM-5, 5523.4 g of a calcined silica gel, and 13,333.7 g of water was milled in a Drais Mill at a rate of 0.5

liters/minute. The resulting slurry was remilled at the same milling rate. To 12,500 g of this doubled milled ZSM-5/silica slurry was added 3553.6 g of aluminum phosphate binder as prepared in Example 2.

5 The resulting mixture (pH ~0.85) was mixed well before being spray dried. The chemical physical properties of this catalyst, designated as Catalyst K, are presented in Table III.

TABLE III

Properties of Catalysts

Catalyst ID (Example)	Catalyst B (4)	Catalyst C (5)	Catalyst D (6)	Catalyst E (7)	Catalyst F (8)
5	<b>Composition, wt.%</b>				
	28.70	28.33	28.57	35.73	31.90
	60.66	61.02	56.23	50.30	52.23
	0.25	0.28	0.18	0.33	0.39
	1.06	1.05	0.37	0.55	0.43
	7.23	7.20	13.01	11.53	14.30
10					
	<b>Physical Properties</b>				
	Davison Attrition Index (DI)	3	32	0	10
	Bulk Density (g/cm <sup>3</sup> )	0.92	0.87	0.66	0.71
15	Surface Area (m <sup>2</sup> /g)	-	291	238	339

TABLE III (Continued)

Properties of Catalysts

Catalyst ID (Example)	Catalyst G (9)	Catalyst H (10)	Catalyst I (11)	Catalyst J (12)	Catalyst K (13)
5	<b>Composition, wt.%</b>				
	Al <sub>2</sub> O <sub>3</sub>	39.91	26.64	25.51	7.57
	SiO <sub>2</sub>	57.22	69.86	71.07	84.43
	Na <sub>2</sub> O	0.19	0.11	0.13	0.26
	SO <sub>4</sub>	0.66	1.03	0.95	0.42
	P <sub>2</sub> O <sub>5</sub>	0.09	0.11	0.13	7.02
10	<b>Physical Properties</b>				
	Davison Attrition Index (DI)	5	5	10	>60
	Bulk Density (g/cm <sup>3</sup> )	0.76	0.85	0.79	0.32
15	Surface Area (m <sup>2</sup> /g)	257	113	115	-

The use of alumina phosphate binder compositions of Examples 1 and 2 for the production of enhanced activity, attrition resistant (low DI) catalysts containing ZSM-5 ( $\text{SiO}_2/\text{Al}_2\text{O}_3$  ratios of ~26 and ~500, kaolin clay and from 0 to 20% wt. of a highly reactive colloidal silica sol is shown in Examples 3-5. An example in which all of the kaolin clay diluent has been replaced with an unreactive, calcined silica gel is given in Example 13. In this case, the catalyst produced by spray drying the ZSM-5, the silica gel and the aluminum phosphate binder produced a soft (high DI, low attrition resistant) catalyst.

The use of the aluminum phosphate binder system for the production of enhanced activity catalysts containing BETA zeolite, and low cell size, low soda (~24.39 Å, 0.5%  $\text{Na}_2\text{O}$ ) USY (at 40% and 60% wt. in catalyst) in combination with kaolin clay are shown in Examples 6-8.

The procedure used in making comparison catalysts containing ZSM-5 and BETA bound using standard silica sol and alumina sol binders are given in Examples 9-12.

Chemical/physical properties of the above catalysts are presented in Tables II and III.

#### 25 Example 14

Data which illustrates the hydrocarbon cracking activity enhancement, after a steam deactivation, imparted to the catalysts by the low pH aluminum phosphate binder system of the present invention are presented in Tables IV to VIII and in Figures 2-8.

Catalysts of the invention and comparison catalysts were tested for cracking activity in a standard microactivity test (MAT) as described in *Oil and Gas Journal*, 1976, vol. 64, pages 7, 84, 85 and Nov. 22, 1971, pages 60-68. This same test is described in the ASTM standard microactivity test method D 3907-8. The characteristics of the feedstock used in the test are given in Table IV.

Before testing, all catalysts were steamed in a fluidized bed steamer for 4 hours at 815°C under 100% wt.% steam at 0 psig. In the examples illustrated below where the catalysts were tested as additives, the catalysts were blended on a wt.%/wt.% basis with OCTACAT®, a commercially available USY containing cracking catalyst manufactured by the Davison Chemical Company.

TABLE IV

Feedstock Characteristics

	API Gravity @ 60°F	22.5
	Specific Gravity @ 60°F	0.9186
5	Aniline Point:°F	163
	Sulfur:wt.%	2.59
	Total Nitrogen:ppm	860
	Basic Nitrogen:ppm	350
	Conradson Carbon:wt.%	0.25
10	Ni : ppm	0.8
	V : ppm	0.6
	Fe : ppm	0.6
	Cu: ppm	<0.1
	Na : ppm	0.6
15	Br : ppm	<5
	Cl : ppm	<20
	D-1160 Distillation	
	Vol.%, °F @ 1 atm.	
	IBP	423
20	5	585
	10	615
	20	649
	30	684
	40	720
25	50	755
	60	794
	70	834
	80	881
	90	932
30	95	976
	EP	1027 (99%)
	Watson "K-Factor"	11.52

TABLE V

## Interpolated Data MAT Product Distribution for Blends of OCTACAT and ZSM-5 Catalysts

5	Catalyst:		90% Octacat 10% Catalyst I (Comparison)		90% Octacat 10% Catalyst B (Invention)		90% Octacat 10% Catalyst J (Comparison)		90% Octacat 10% Catalyst C (Invention)		
	Octacat										
	As Synthesized SiO <sub>2</sub> /Al <sub>2</sub> O <sub>3</sub> Framework Ratios of ZSM-5 Zeolites: ~26:1 ~26:1 ~500:1 ~500:1										
10	Wt.% ZSM-5 Zeolite in Catalyst Additive:		25%		15%		25%		15%		
	Binder Type:		SiO <sub>2</sub> Binder		ALPO <sub>4</sub> Binder		SiO <sub>2</sub> Binder		ALPO <sub>4</sub> Binder		
	Yields (wt.%)										
15	Conv. (wt.%)	60.0	60.0	60.0	60.0	60.0	60.0	60.0	60.0	60.0	
	H <sub>2</sub>	0.085	0.094	0.090	0.094	0.094	0.094	0.094	0.094	0.094	
	C <sub>1</sub> +C <sub>2</sub>	1.60	1.70	1.70	1.70	1.70	1.75	1.75	1.75	1.75	
	C <sub>3</sub> =	3.8	5.8	8.1	5.8	8.1	5.2	5.8	5.8	5.8	
	Total C <sub>3</sub> 's	4.6	6.8	8.9	6.8	8.9	6.2	6.6	6.6	6.6	
	Total C <sub>3</sub> +C <sub>4</sub> =	9.2	12.7	16.2	12.7	16.2	12.0	13.1	13.1	13.1	
20	C <sub>4</sub> =	5.4	6.9	8.1	6.9	8.1	6.8	7.3	7.3	7.3	
	i-C <sub>4</sub>	2.4	2.9	3.1	2.9	3.1	2.3	2.5	2.5	2.5	
	n-C <sub>4</sub>	0.5	0.6	0.6	0.6	0.6	0.5	0.5	0.5	0.5	
	Total C <sub>4</sub> 's	8.3	10.4	11.8	10.4	11.8	9.9	10.3	10.3	10.3	
	C <sub>5</sub> +Gasoline	43.5	38.5	35.2	38.5	35.2	39.6	39.0	39.0	39.0	
	Coke	1.90	2.20	2.20	2.20	2.20	2.20	2.20	2.20	2.20	
25	PONA RON	90.9	91.9	93.1	91.9	93.1	91.8	92.3	92.3	92.3	
	PONA MON	79.9	80.6	81.0	80.6	81.0	80.6	81.0	81.0	81.0	

Table VI

Interpolated Data  
MAT Product Distribution

5	Catalyst:	OCTACAT	Catalyst H 40% BETA in Al <sub>2</sub> O <sub>3</sub> Matrix	Catalyst G 40% BETA in SiO <sub>2</sub> Matrix	Catalyst D 40% BETA in AlPO <sub>4</sub> Matrix
	C/O	3.9	4.2	5.2	3.7
	Conversion, wt. %	60	60	60	60
	<b>YIELDS, WT. %</b>				
10	H <sub>2</sub>	0.090	0.121	0.061	0.053
	Total C <sub>1</sub> +C <sub>2</sub>	1.75	2.10	2.60	1.76
	C <sub>3</sub> =	4.3	7.0	9.4	6.1
	Total C <sub>3</sub> 's	5.0	8.3	10.6	7.0
15	1-Butene	1.2	1.6	1.8	1.6
	Isobutylene	1.6	3.8	4.2	3.6
	trans-2-Butene	1.7	2.7	3.1	2.4
	cis-2-Butene	1.1	1.5	1.8	1.5
	Total C <sub>4</sub> =	5.7	9.7	10.9	9.1
20	i-C <sub>4</sub>	2.4	2.0	2.9	2.5
	n-C <sub>4</sub>	0.5	0.7	0.7	0.6
	Total C <sub>4</sub> 's	8.6	12.4	14.6	12.2
	C <sub>5</sub> +Gasoline	42.4	33.4	29.5	37.1
	Coke, wt. % Feed	2.20	3.65	2.66	1.91
25	PONA RON	91.2	94.1	95.4	93.6
	PONA MON	80.2	80.0	81.6	80.2
	<b>Wt. %C<sub>5</sub>+ Gasoline Fraction:</b>				
	iso-Paraffins	29.8	17.2	17.4	20.6
	Olefins	26.6	47.8	44.6	42.6
	Aromatics	29.7	22.1	26.1	23.7
30	<b>C<sub>4</sub> Olefin Selectivities:</b>				
	1-Butene/C <sub>4</sub> =	0.21	0.16	0.17	0.18
	Isobutylene/C <sub>4</sub> =	0.28	0.39	0.39	0.40
	trans-2-Butene/C <sub>4</sub> =	0.30	0.28	0.28	0.26
	cis-2-Butene/C <sub>4</sub> =	0.19	0.15	0.17	0.16

TABLE VII

Interpolated MAT Product Distribution Data

Catalyst I.D.	100% OCTACAT 10% Cat. D	80% OCTACAT 20% Cat. D	70% OCTACAT 30% Cat. D	60% OCTACAT 40% Cat. D	50% OCTACAT 50% Cat. D	100% Cat. D
5	Conversion, wt.% 60.0	60.0	60.0	60.0	60.0	60.0
	YIELDS, WT.%					
	H2 Total C1+C2	0.093 2.00	0.079 1.70	0.082 1.80	0.079 1.70	0.069 1.70
10	C3= Total C3's	4.3 5.1	4.3 5.1	4.7 5.2	4.7 5.6	6.3 7.1
	1-Butene	1.2	1.2	1.2	1.3	1.6
	Isobutylene	1.7	2.0	2.2	2.2	3.4
	trans-2-Butene	1.8	1.9	1.9	2.0	2.4
	cis-2-Butene	1.1	1.1	1.2	1.3	1.5
	Total C4=	5.8	6.2	6.4	7.0	8.9
15	Total C4's	8.7	9.1	9.4	9.8	12.3
	C5+Gasoline	41.9	41.8	41.2	40.6	36.5
	Coke, wt.% Feed	2.2	2.2	2.3	2.2	2.3
20	PONA RON	91.2	91.2	91.7	91.7	93.7
	PONA MON	80.3	79.8	80.1	80.0	80.3
	Wt. % C5+ Gasoline Fraction :					
	iso-Paraffins	30.4	28.2	27.4	27.0	21.8
	Olefins	26.7	30.2	31.6	31.6	41.4
	Aromatics	29.1	27.2	26.9	27.2	23.8
25	C4 Olefin Selectivities :					
	1-Butene/C4=	0.21	0.19	0.19	0.20	0.18
	Isobutylene/C4=	0.29	0.32	0.34	0.33	0.38
	trans-2-Butene/C4=	0.31	0.31	0.30	0.29	0.27
	cis-2-Butene/C4=	0.19	0.18	0.19	0.18	0.17

TABLE VIII

	Catalyst :	OCTACAT	Catalyst E (40% USY/ 18% AlPO <sub>4</sub> )	Catalyst F (60% USY/ 25% AlPO <sub>4</sub> )
5	C/O	4.6	4.0	2.8
	Conversion, wt. %	65	65	65
	YIELDS, WT. %			
	H <sub>2</sub>	0.113	0.062	0.062
	Total C <sub>1</sub> +C <sub>2</sub>	2.3	2.3	2.3
10	C <sub>3</sub> =	5.2	4.6	4.4
	Total C <sub>3</sub> 's	6.1	5.8	5.5
	1-Butene	1.4	1.2	1.1
	Isobutylene	1.7	1.2	1.0
	trans-2-Butene	2.0	1.8	1.6
15	cis-2-Butene	1.3	1.1	1.0
	Total C <sub>4</sub> =	6.4	5.2	4.7
	i-C <sub>4</sub>	2.9	3.4	3.4
	n-C <sub>4</sub>	0.6	0.8	0.8
	Total C <sub>4</sub> 's	9.9	9.4	8.9
20	C <sub>5</sub> +Gasoline	44.0	44.8	45.6
	Coke, wt. % Feed	2.6	2.6	2.6
	PONA RON	91.5	90.4	89.3
	PONA MON	80.8	80.8	80.8
	Wt. %			
25	C <sub>5</sub> + Gasoline Fraction:			
	iso-Paraffins	30.1	36.1	36.1
	Olefins	24.4	17.4	17.4
	Aromatics	32.3	33.2	33.2
	C <sub>4</sub> Olefin Selectivities:			
30	1-Butene/C <sub>4</sub> =	0.22	0.23	0.23
	Isobutylene/C <sub>4</sub> =	0.27	0.23	0.21
	trans-2-Butene/C <sub>4</sub> =	0.31	0.35	0.34
	cis-2-Butene/C <sub>4</sub> =	0.20	0.21	0.21

The micro activity test data plotted in Figures 2-5 illustrate the effect of the aluminum phosphate binder component on the activity of the ZSM-5 containing catalyst. Catalyst A1, with its aluminum phosphate binder, shows a substantial increase in activity over the standard catalyst, Catalyst 1, made the conventional route with standard silica sol. These results are quite impressive considering the fact that the sieve content of the Catalyst 1 blend is 2.5 wt.% where as Catalyst A1 blend contains only 1.5 wt.% zeolite. Based on these light olefin yield shifts, Catalyst A1 exhibits over four times the activity of Catalyst 1. Adjusting to activity per unit zeolite, Catalyst A1 provides a six fold activity increase. The MAT yield structure, at constant conversion, for blends containing catalysts of this invention and of comparison catalysts, is presented in Table V. Although the increase in activity of the higher silica alumina ratio ZSM-5 zeolite is not as great as the lower ratio material, the activity is directionally the same.

The advantages in hydrocarbon cracking activity and selectivity of the BETA Zeolite catalyst with its aluminum phosphate binder, Catalyst D, compared to BETA Zeolite bound by the conventional silica sol, Catalyst G, and alumina sol, Catalyst H, binders, are presented in Table VI. At a constant MAT conversion, Catalyst D is more active, as evidenced by the lower catalyst to oil ratio, and produces less hydrogen, total  $C_1+C_2$  hydrocarbons, and coke, but substantially more  $C_3$ +gasoline. Compared to OCTACAT®, Catalyst D has equivalent activity, produces lower hydrogen and coke and produces almost 2.5 times the isobutylene. In

addition, the C<sub>5</sub>+gasoline fraction produced is lower in aromatics and higher in olefins than that produced by OCTACAT. Table VII and Figures 6-9 show MAT results, at constant conversion, for blends of OCTACAT and Catalyst D. These results show an increase in isobutylene yield and selectivity and a shift to lower aromatics and higher olefins in the C<sub>5</sub>+gasoline fraction as the amount of Catalyst D in the blend increases.

Table VIII compares the MAT results, at constant conversion, for OCTACAT and aluminum phosphate bound USY catalysts, Catalyst E (40%USY/18%AlPO<sub>4</sub>) and Catalyst F (60%USY/25%AlPO<sub>4</sub>). These results show that, compared to OCTACAT, Catalysts E and F have higher activity, produce lower hydrogen and C<sub>3</sub>+C<sub>4</sub> hydrocarbons and have a higher C<sub>5</sub>+gasoline yield. The motor octanes for these C<sub>5</sub>+gasoline fractions, as determined by a gas chromatographic method, are all equivalent, indicating a greater octane barrel potential for Catalysts D and E over OCTACAT.

#### Example 15

The MAT data in Table IX listed below for steam deactivated silica sol (Ludox AS-40) bound clay and aluminum phosphate (of this invention) bound clay illustrate the lack of cracking activity for the crystalline low surface area aluminum phosphate binder of this invention and the lack of the ability of this aluminum phosphate binder system to impact any activity to an inert catalyst component such as clay.

TABLE IX

Catalyst Composition: (wt.%)		70% Clay 30% AlPO <sub>4</sub>	70% Clay 30% SiO <sub>2</sub>
	Catalyst to Oil	2.96	2.97
5	Conversion wt.%	11.0	12.4
	H <sub>2</sub>	0.02	0.05
	Total C <sub>1</sub> +C <sub>2</sub>	0.79	0.77
	Total C <sub>3</sub> 's	0.7	0.7
	Total C <sub>4</sub> Olefins	0.5	0.5
10	Total C <sub>4</sub> 's	0.6	0.6
	C <sub>5</sub> +Gasoline	8.1	9.2
	Coke, wt.% feed	0.70	0.9

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## WE CLAIM:

1           1. A catalyst composition comprising from 2 to 70 wt%  
of zeolite/molecular sieve, and from 10 to 46 wt% of  
3 aluminum phosphate containing binder, said binder having a  
surface area of less than 50 m<sup>2</sup>/g .

1           2. The composition of claim 1 wherein said catalyst  
has a Davison Attrition Index of 0 to 10.

1           3. The composition of claim 1 wherein the aluminum to  
phosphate ratio of the aluminum phosphate component is from  
3 0.65 to 1.1.

1           4. The composition of claim 1 wherein the aluminum  
phosphate is a crystalline material having a surface area  
3 less than 20 m<sup>2</sup>/g .

1           5. The composition of claim 1 wherein the aluminum  
phosphate is a crystalline material having a surface area  
3 less than 5 m<sup>2</sup>/g and a pore volume of less than 0.10 cc/g  
measured from the nitrogen adsorption isotherm.

1           6. The composition of claim 1 which contains clay.

1           7. The composition of claim 1 which includes an  
aluminum phosphate binder/matrix having a surface area of  
3 up to 300 m<sup>2</sup>/g .

1           8. The composition of claim 7 wherein said surface  
area is less than 100 m<sup>2</sup>/g .

1           9. The composition of claim 7 wherein said  
matrix includes a member selected from the group  
3 consisting of clay, alumina, silica, magnesia and  
mixtures thereof.

1           10. The composition of claim 1 wherein said  
zeolite/molecular sieve is selected from the group  
3 comprising zeolite Beta, ZSM, ALPO, SAPO, ultrastable  
Y zeolite and mixtures thereof.

1           11. An FCC catalyst which comprises 2 to 70 wt.%  
zeolite/molecular sieve, 0 to 88 wt.% clay and 10 to  
3 30 wt.% aluminum phosphate having a surface area of  
less than 50 m<sup>2</sup>/g and a Davison Attrition Index of 0 to  
5 10.

1           12. The composition of claim 11 wherein said  
zeolite/molecular sieve is zeolite Beta, ZSM-5,  
3 ultrastable Y zeolite and mixtures thereof.

1           13. A method for the catalytic conversion of  
hydrocarbons which comprises reacting hydrocarbons in  
3 the presence of the catalyst of claim 1.

1           14. A method for the FCC conversion of  
hydrocarbons which comprises reacting hydrocarbon  
3 under catalytic cracking, hydrocracking, isomerization  
or dewaxing conversion conditions in the presence of  
5 the catalyst of claim 1.

1           15. The method of claim 14 wherein the catalyst  
contains zeolite Beta, ZSM-5, ultrastable Y zeolite and  
3 mixtures thereof.

1           16. The method of claim 14 conducted in the presence  
of hydrogen wherein said catalyst contains a metal selected  
3 from Group VI and VIII of the Periodic Table.

1           17. A method for producing catalyst compositions which  
comprises mixing a zeolite/molecular sieve with a solution  
3 of aluminum phosphate having a pH of less than 2, and  
forming and drying the mixture to provide a catalyst  
5 composition containing from 2 to 70 wt% of a zeolite/  
molecular sieve and from 10 to 46 wt% of aluminum phosphate  
7 containing binder.

1           18. The method of claim 17 wherein the pH is from 0.1  
to 0.9.

1           19. The method of claim 17 wherein said mixture  
contains clay.

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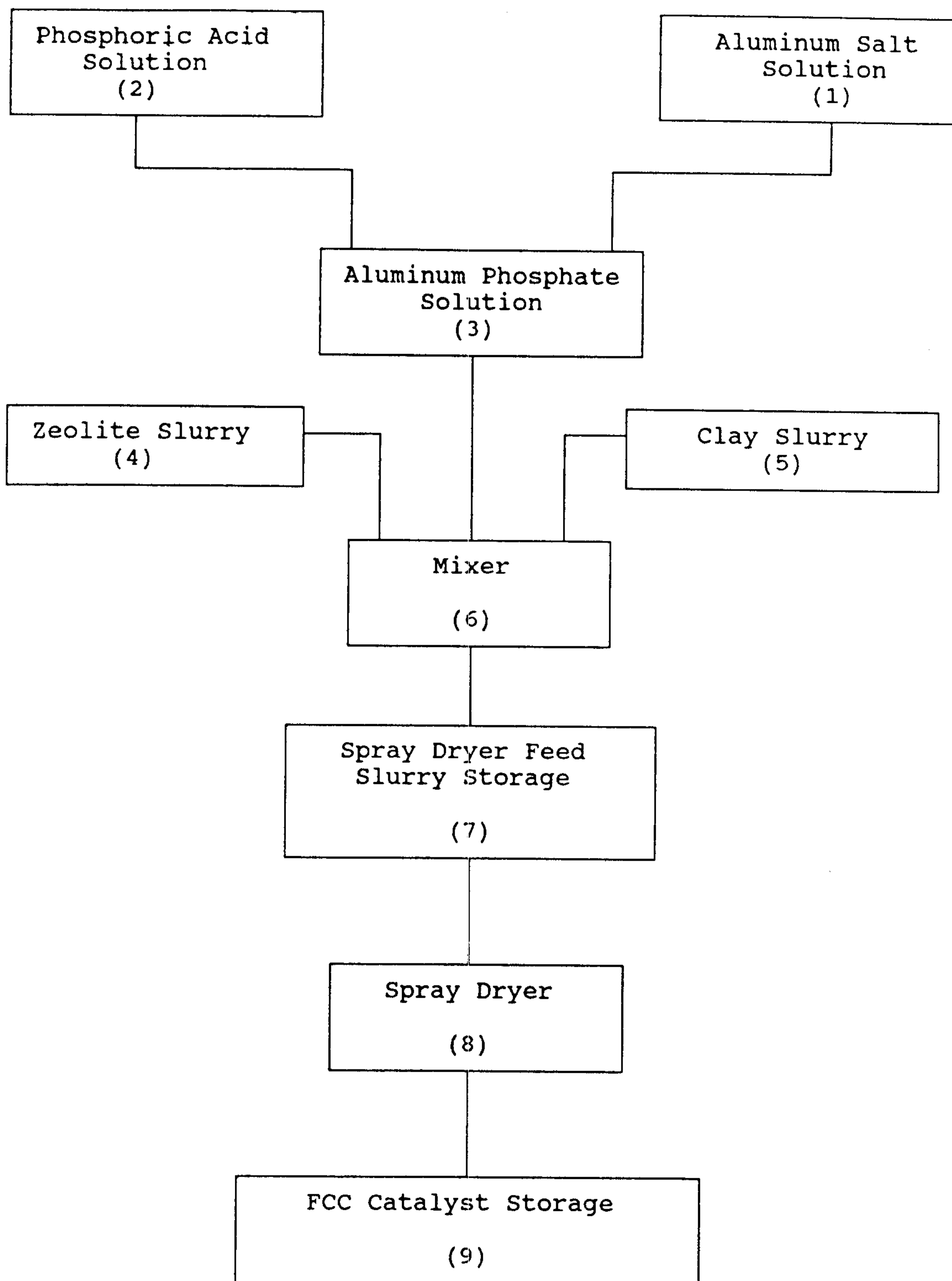


FIG. 1

# C3+C4 OLEFINS VS. CONVERSION

SIHGO FEED; 980°F; 3-5 C/O; 40-24 WHSV

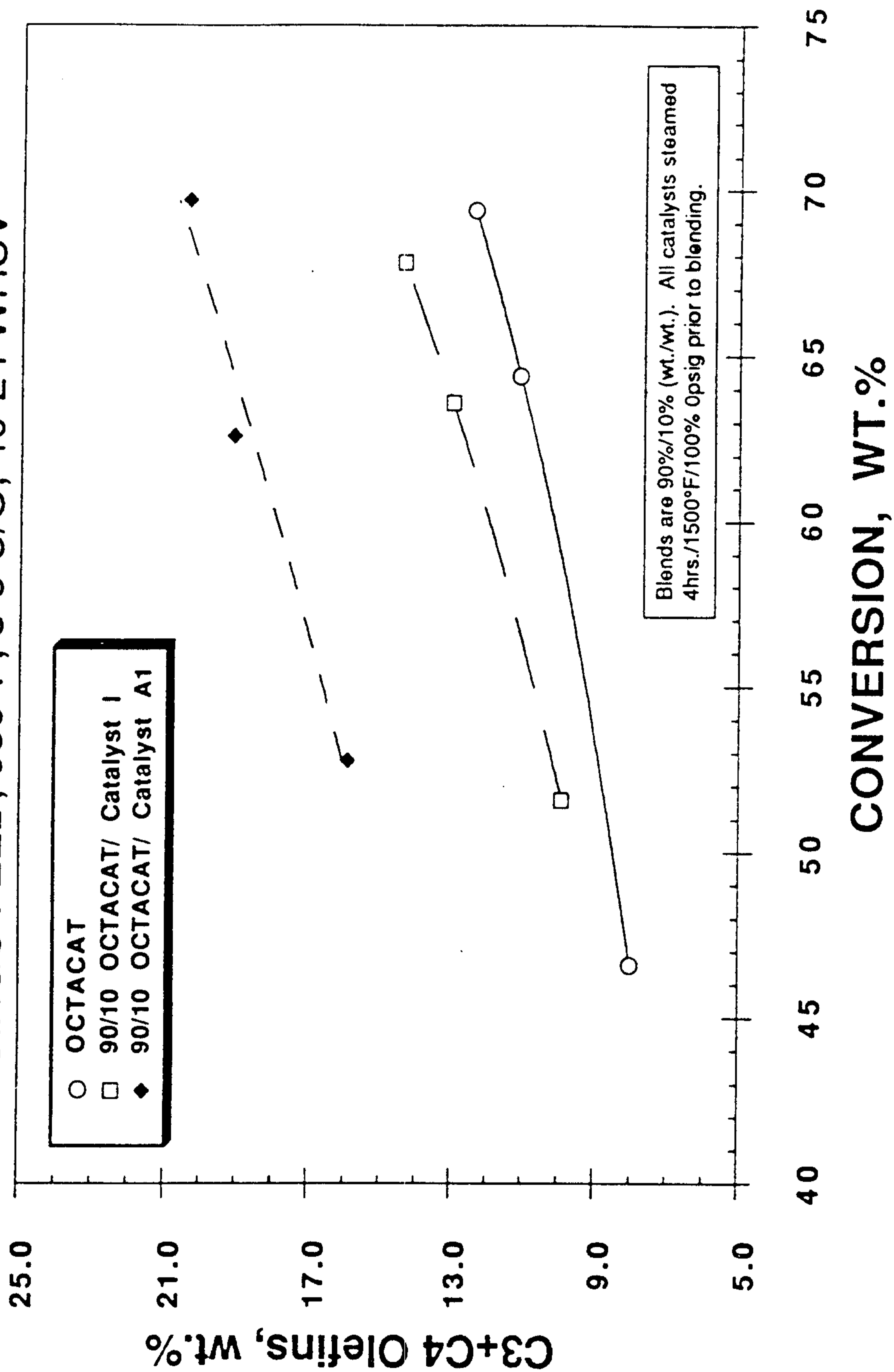


FIG. 2

# C5+GASOLINE VS. CONVERSION

SIHGO FEED; 980°F; 3-5 C/O; 40-24 WHSV

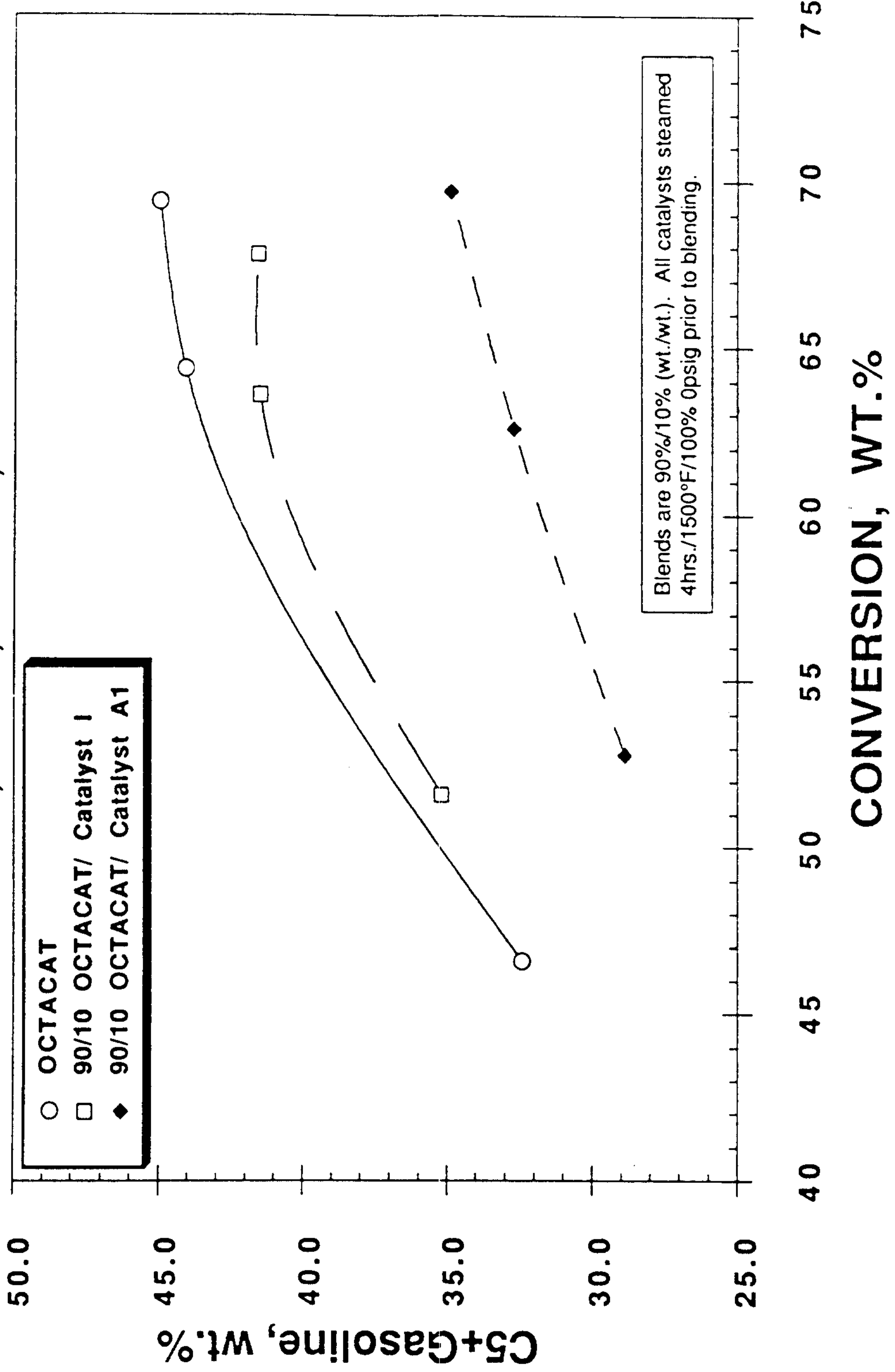


FIG. 3

# PONA RON VS. CONVERSION

SIHGO FEED; 980°F; 3-5 C/O; 40-24 WHSV

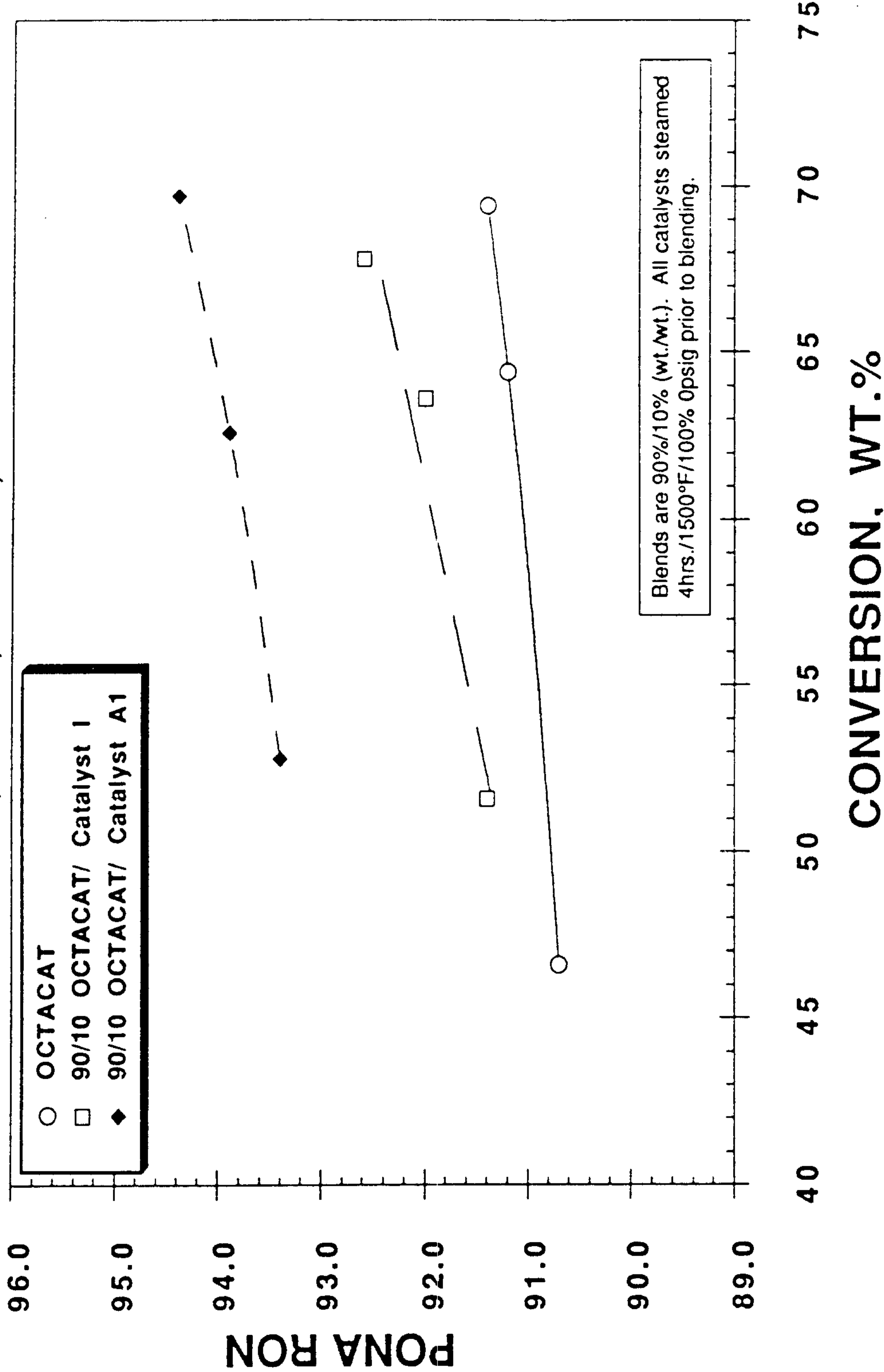
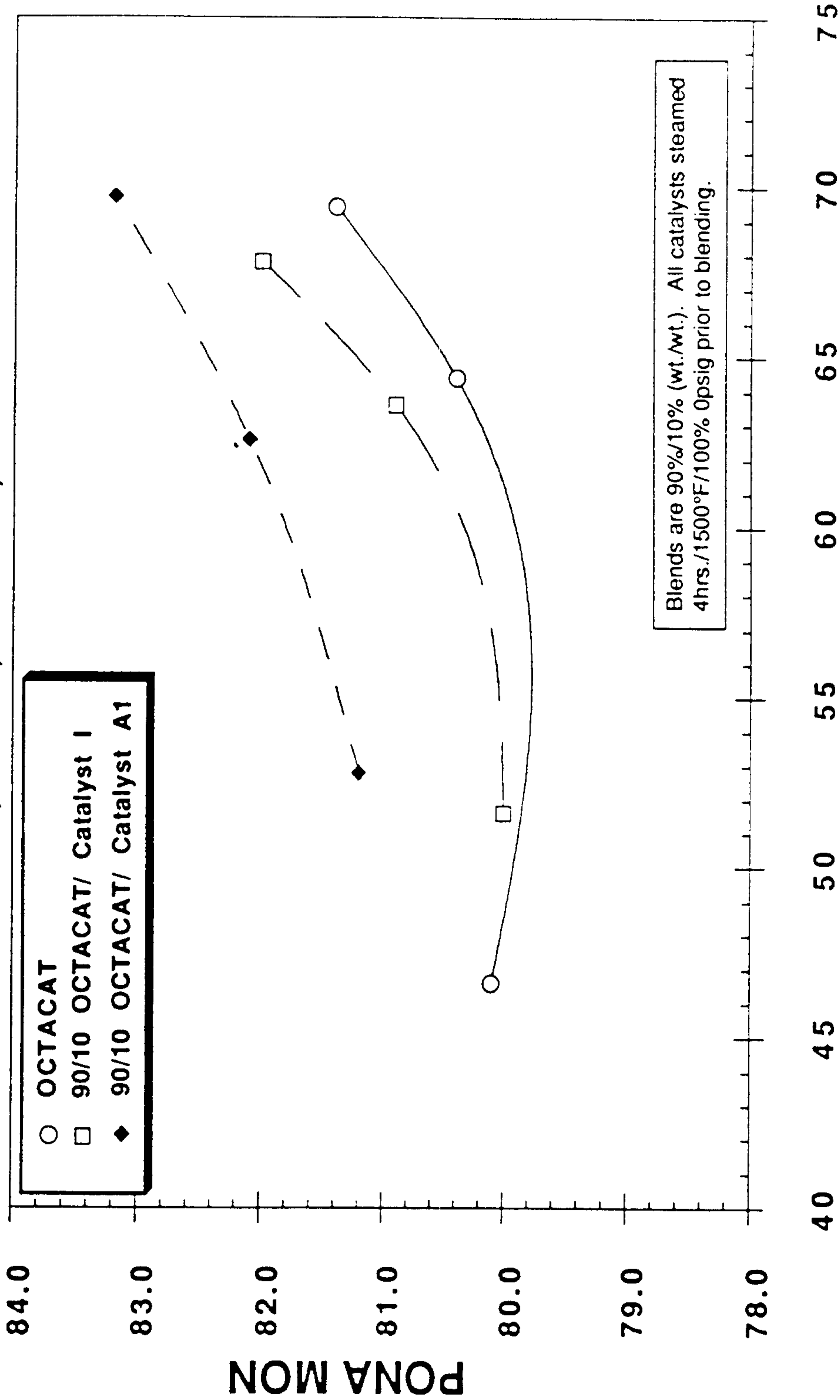


FIG. 4

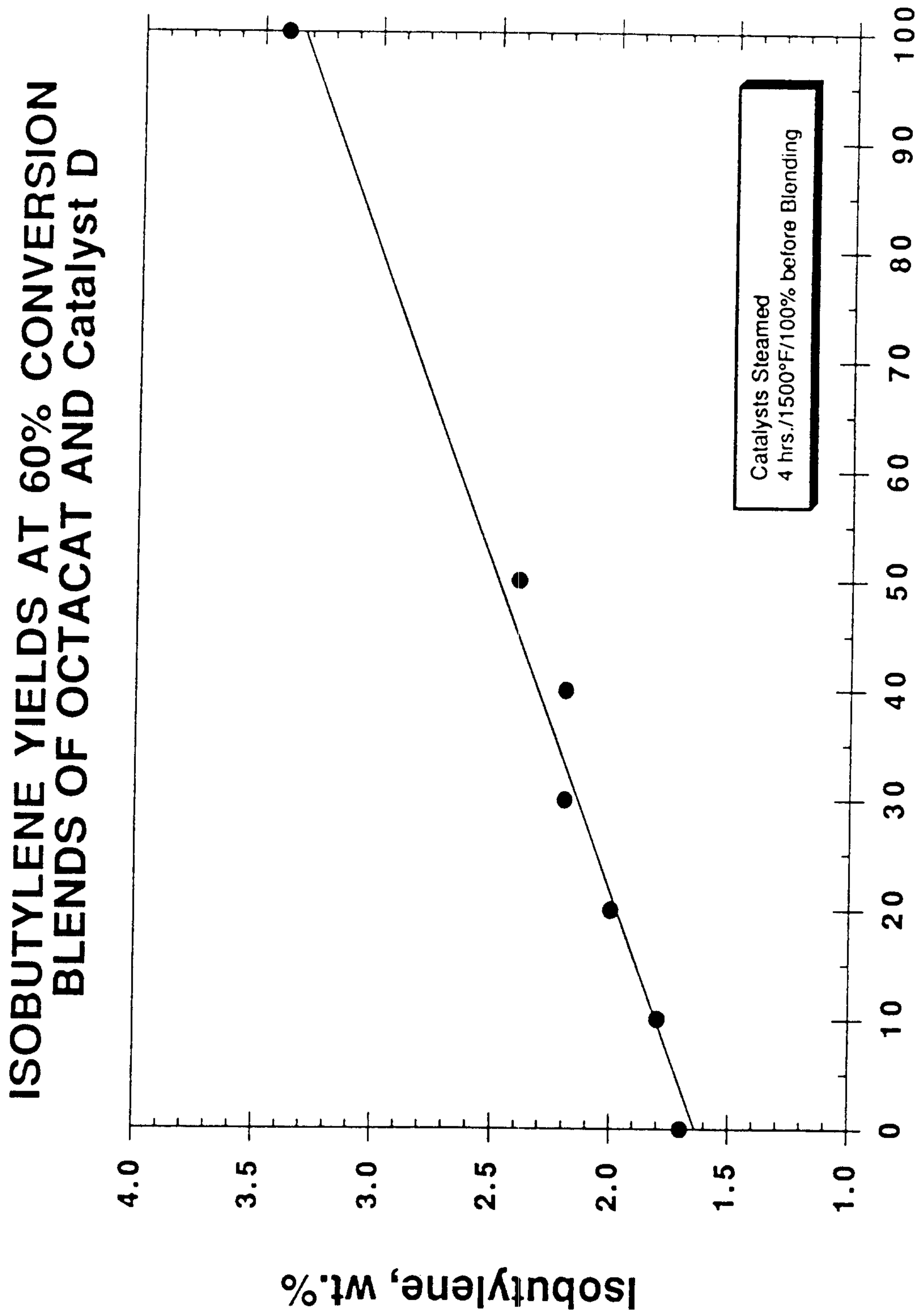
# PONA MON VS. CONVERSION

SIHGO FEED; 980°F; 3-5 C/O; 40-24 WHSV



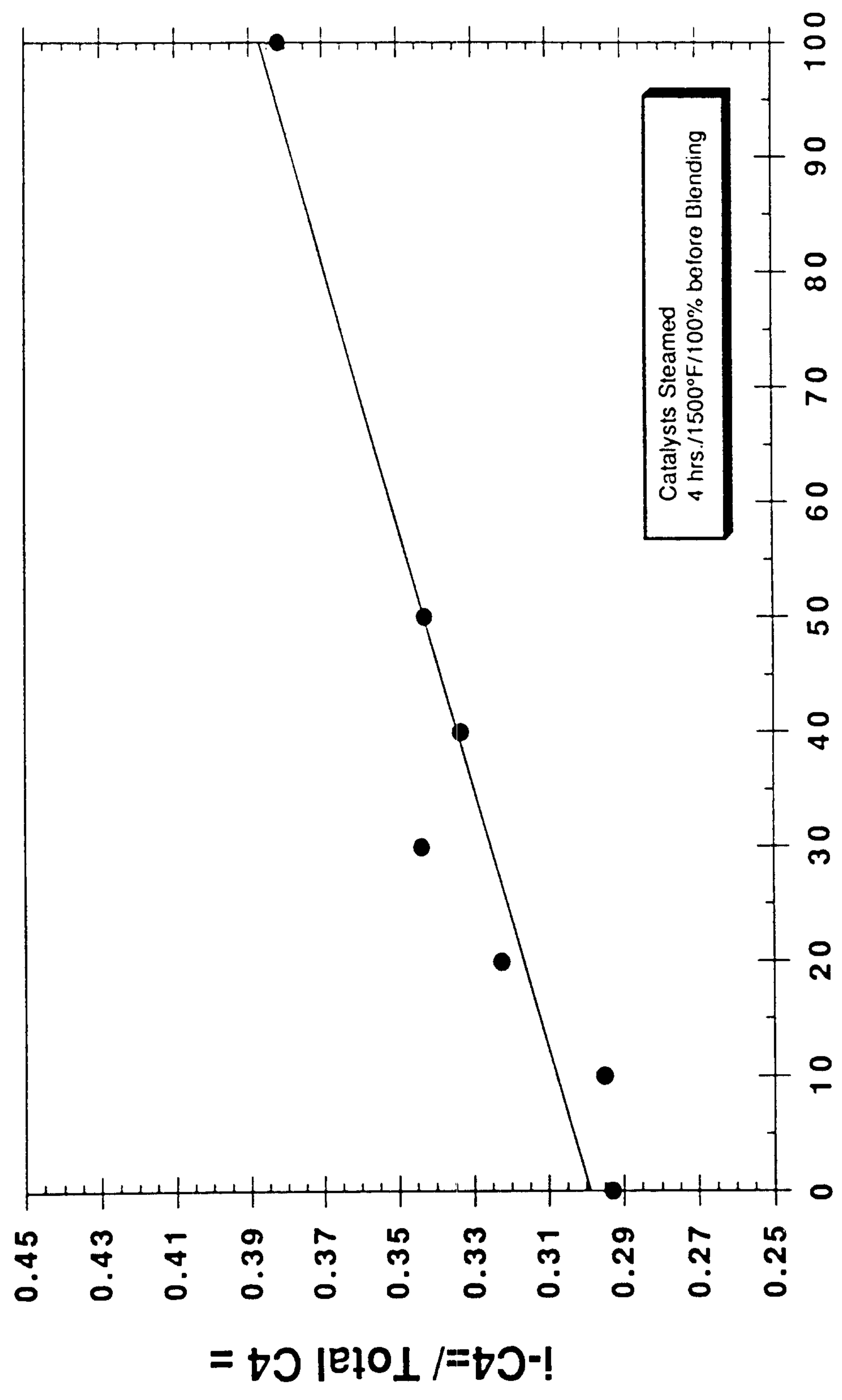
CONVERSION, WT. %

FIG. 5



**Wt. % BETA Catalyst in Blend**  
**FIG. 6**

# ISOBUTYLENE SELECTIVITY AT 60% CONVERSION BLENDS OF OCTACAT AND Catalyst D

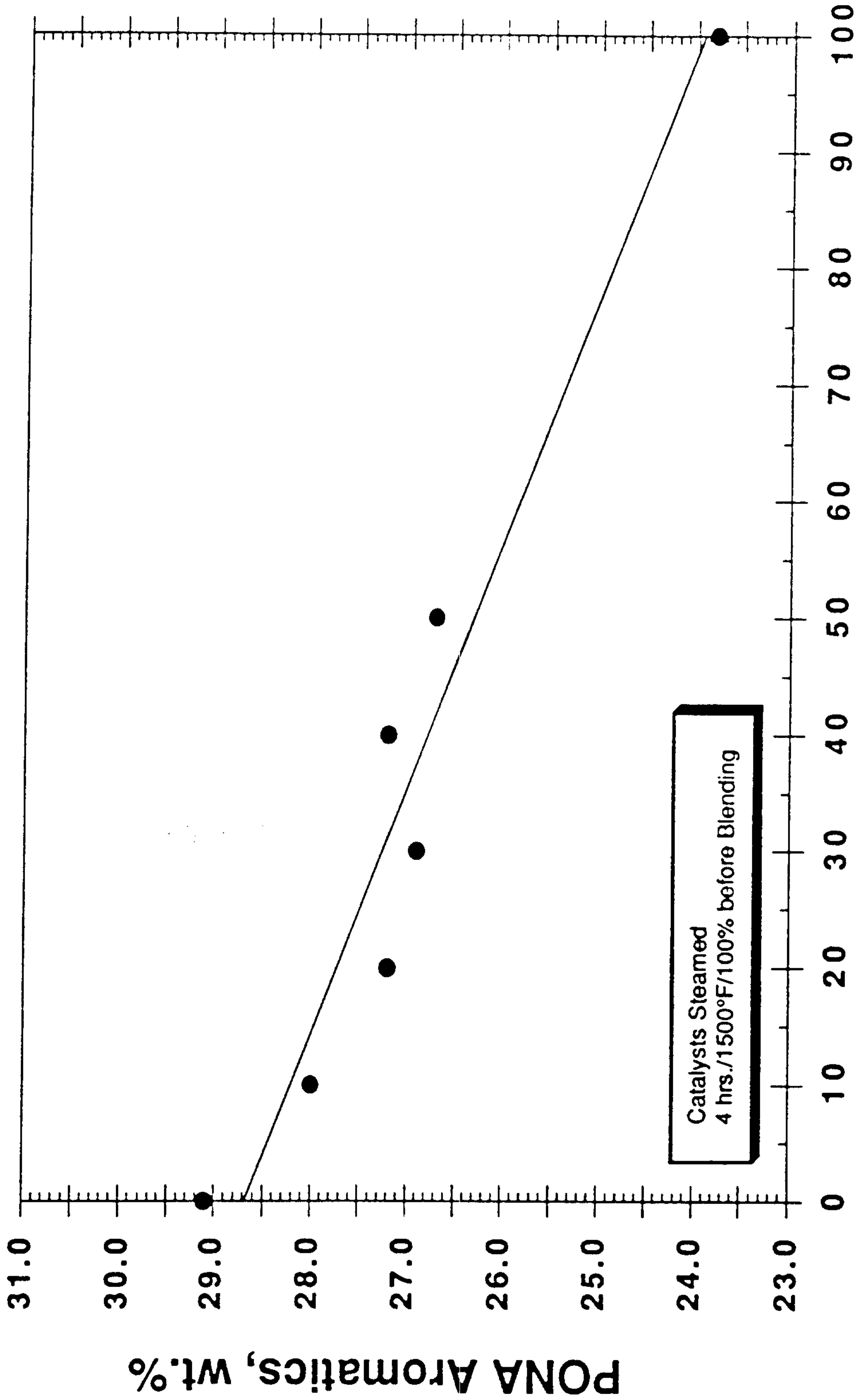


Wt. % BETA Catalyst in Blend

FIG. 7

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# PONA AROMATIC YIELDS of C5+ Gasoline Fraction For BLENDS of OCTACAT AND Catalyst D

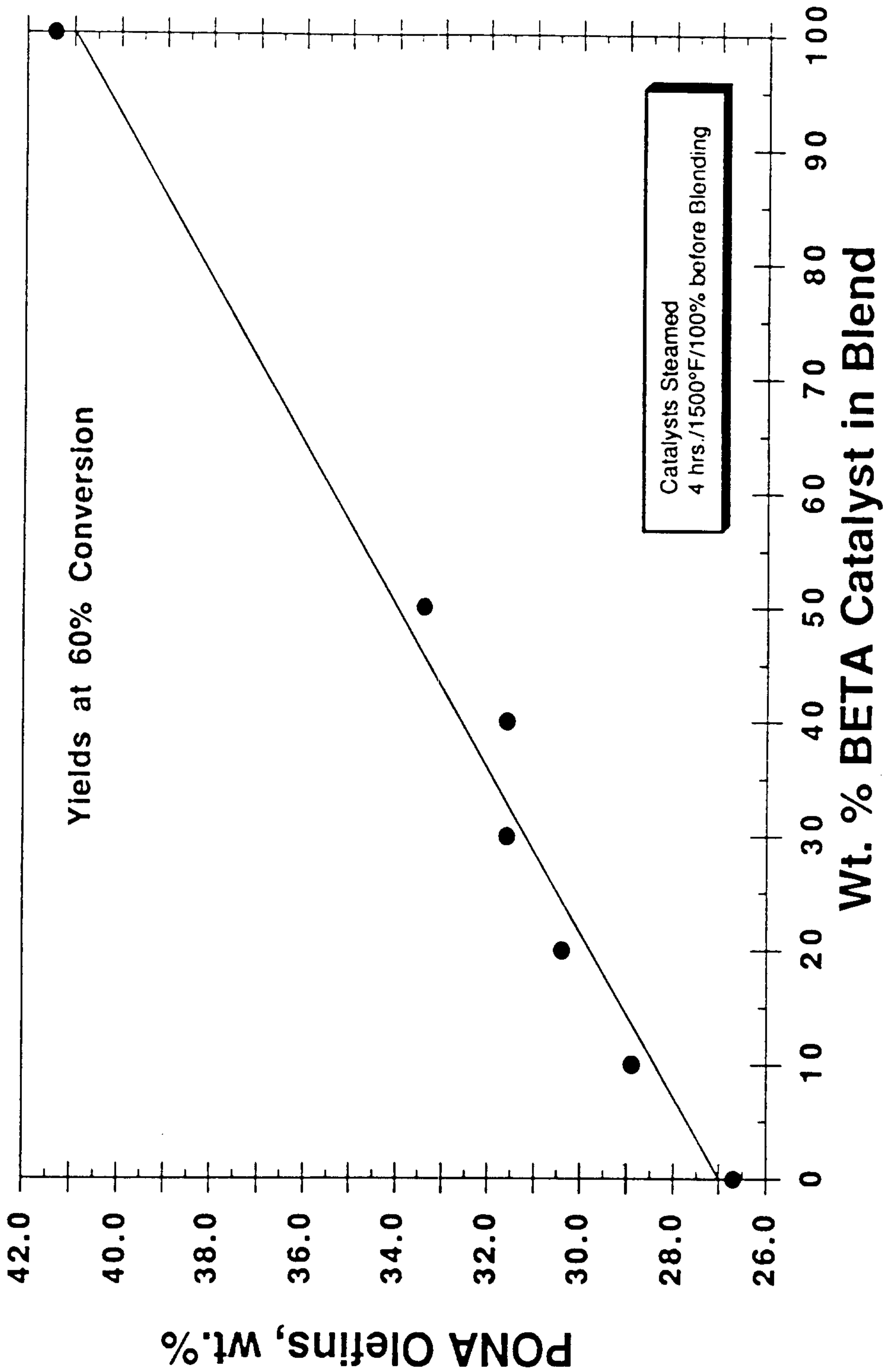


Wt. % BETA Catalyst in Blend

FIG. 8

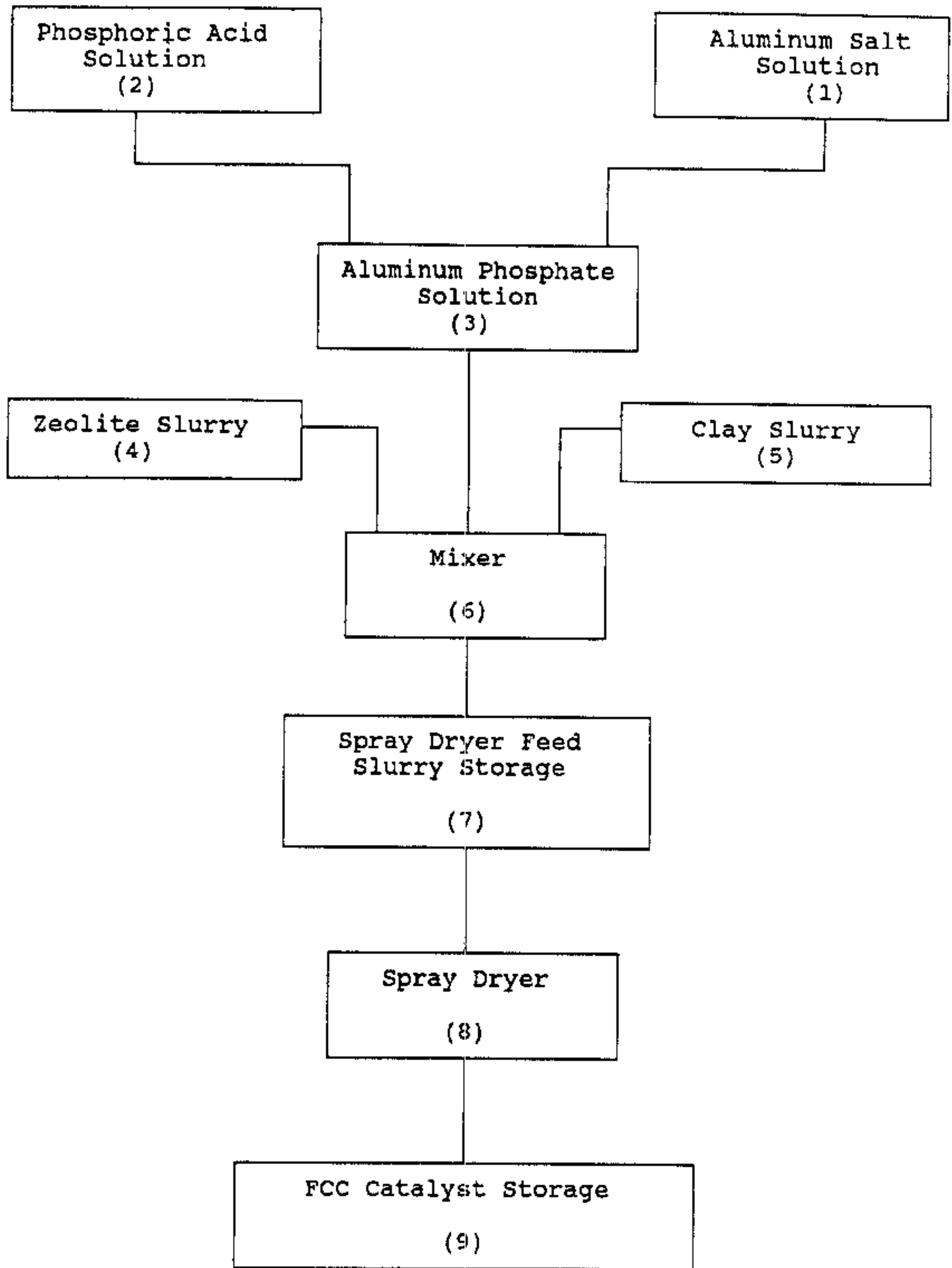
Catalysts Steamed  
4 hrs./1500°F/100% before Blending

**PONA OLEFIN YIELDS of C5+ Gasoline Fraction  
For BLENDS OF OCTACAT AND Catalyst D**



**Wt. % BETA Catalyst in Blend**

**FIG. 9**



Phosphoric Acid Solution  
(2)

Aluminum Salt Solution  
(1)

Aluminum Phosphate Solution  
(3)

Zeolite Slurry  
(4)

Clay Slurry  
(5)

Mixer  
(6)

Spray Dryer Feed Slurry Storage  
(7)

Spray Dryer  
(8)

FCC Catalyst Storage  
(9)