659778

AUSTRALIA

CONVENTION

Patents Act 1990

REQUEST FOR A STANDARD PATENT

AND NOTICE OF ENTITLEMENT

The Applicant identified below requests the grant of a patent to the nominated person identified below for an invention described in the accompanying standard complete patent specification.

[70,71]Applicant and Nominated Person:

Phillips Petroleum Company
Bartlesville, Oklahoma 74004, UNITED STATES OF AMERICA

[54]Invention Title:

~~A PROCESS FOR THE~~ **ALKYLATION OF AMYLENES BY ISOPARAFFINS WITH AN HF CATALYST.**

[72]Actual Inventors:

Richard Lee Anderson
Ronald Gordon Abbott
Bruce B. Randolph

[74]Address for Service:

PHILLIPS ORMONDE & FITZPATRICK
367 Collins Street
Melbourne 3000 AUSTRALIA

[31,33,32]

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Applicant states the following:

1. The nominated person is the assignee of the actual inventor(s)

2. The nominated person is
   - ~~the applicant~~
   - the assignee of the applicant
   - ~~authorised to make this application by the applicant~~

   of the basic application.

3. The basic application~~(s)~~ was/~~were~~ the first made in a convention country in respect of the invention.

The nominated person is not an opponent or eligible person described in Section 33-36 of the Act.

5 July 1994

Phillips Petroleum Company
By PHILLIPS ORMONDE & FITZPATRICK
Patent Attorneys
By

M057527 050794

David B Fitzpatrick

Our Ref : 374046

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ALKYLATION OF AMYLENES WITH ISOPARAFFINS USING AN HF CATALYST

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(71) Applicant(s)
PHILLIPS PETROLEUM COMPANY

(72) Inventor(s)
RICHARD LEE ANDERSON; RONALD GORDON ABBOTT; BRUCE B. RANDOLPH

(74) Attorney or Agent
PHILLIPS ORMONDE & FITZPATRICK , 367 Collins Street, MELBOURNE VIC 3000

(56) Prior Art Documents
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(57) Claim

1. A process for the alkylation of amylenes by isoparaffins, which comprises:

contacting within a reaction zone an alkylation catalyst and a mixture comprising amylenes and isobutane, said mixture further comprising isopentane in an amount that is effective for suppressing the production of synthetic isopentane to a desired amount; and

producing in said reaction zone a reaction product which comprises an alkylate product having a reduced concentration of synthetic isopentane below that which would result when said mixture, having substantially no isopentane concentration, is contacted with said alkylation catalyst.

2. A process according to claim 1, wherein said amount of isopentane in said mixture that is effective for suppressing the production of synthetic isopentane exceeds 2:1 as determined by the ratio of the weight of isopentane in said mixture to the weight of amylenes in said mixture.

3. A process according to claim 2, wherein said amount of isopentane in said mixture is in the range of from ~~about~~ 2:1 to ~~about~~ 10:1 as determined by the ratio of the weight of

.../2

isopentane in said mixture to the weight of amylenes in said mixture.

4. A process according to any one of claims 1-3, wherein said desired amount of synthetic isopentane production is less than ~~about~~ 0.8:1 as determined by the ratio of the weight of said synthetic isopentane production to the weight of amylenes in said mixture.

5. A process according to any one of the preceding claims, wherein said alkylation catalyst comprises hydrogen fluoride.

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Name of Applicant:

Phillips Petroleum Company

Actual Inventor(s):

Richard Lee Anderson
Ronald Gordon Abbott
Bruce B. Randolph

Address for Service:

PHILLIPS ORMONDE & FITZPATRICK
Patent and Trade Mark Attorneys
367 Collins Street
Melbourne 3000 AUSTRALIA

Invention Title:

~~**A PROCESS FOR THE**~~ **ALKYLATION OF AMYLENES BY ISOPARAFFINS** WITH AN HF CATALYST.

Our Ref : 374046
POF Code: 1422/50647

The following statement is a full description of this invention, including the best method of performing it known to applicant(s):

This invention relates generally to the alkylation of hydrocarbons. More specifically, however, the invention relates to the control or suppression of the production of synthetic isopentane during the alkylation of amylenes.

Recently promulgated federal regulations have placed new vapor pressure limitations on motor fuels resulting in the need to remove from gasoline certain quantities of lighter, relatively high vapor pressure components, such as, for example, butanes and isopentane. One problem, however, which results from the removal of such compounds from the gasoline pool is the need to find some other use for the butanes and isopentane. This is a particular problem with isopentane since it can be produced concurrently with the production of gasoline. Therefore, it is generally required for the butanes or isopentanes removed from gasoline to be consumed as a feedstock to certain other processes in order to eliminate the volume of such compounds in the gasoline pool.

A recent new concern that has arisen due to the new federal vapor pressure limitations placed on gasoline is the formation or production of synthetic isopentane during the hydrogen fluoride catalyzed alkylation of amylene olefin compounds. Traditionally, the production of synthetic isopentane has not been much of a concern; but, instead, it has been desirable

because of the relatively high octane value of isopentane. However, due to the aforementioned regulatory changes, the commercial trend is now towards the removal of isopentane from the gasoline pool. It has been suggested by those skilled in the art, e.g. U.S. 4,429,173, that one means by which synthetic isopentane is removed from a product of a hydrogen fluoride catalyzed amylene alkylation process is to separate the isopentane, which can include synthetic isopentane, from the alkylate product and charge it to a separate dehydrogenation step to produce olefins which can suitably be used as an alkylation process feed. While these additional process steps can effectively assist in the removal of isopentane contained in an alkylate product stream, they do have numerous drawbacks. For instance, the separate dehydrogenation step requires additional capital to be invested in costly new equipment. Furthermore, there are operating costs associated with the dehydrogenation of isopentane. Finally, because of the separate and distinct process steps associated with the separation and dehydrogenation of isopentane contained in an alkylate product, it becomes difficult to control the net amount of isopentane produced synthetically during the alkylation reaction of amylenes.

In accordance with the present invention there is provided a method of controlling the amount of synthetic isopentane produced during the catalytic alkylation of amylenes.

The invention also provides an alkylation process that has a suppressed ability to produce synthetic isopentane during the alkylation of amylene compounds.

The invention further provides an alkylation process that operates such that there is a net consumption of isopentane when amylenes are being alkylated.

The invention includes a method of controlling synthetic isopentane production during the alkylation of amylenes by isobutane. When language referring to amylene alkylation or the alkylation of amylenes is used herein, it shall mean that amylene olefins are reacted with isobutane to nominally form a paraffin compound having nine carbon atoms. The first step of the inventive method includes contacting within a reaction zone a mixture where said mixture comprises amylenes and isobutane, with an alkylation catalyst. A reactor effluent is produced from the reaction zone and comprises an alkylate product and a synthetic isopentane product. Synthetic isopentane is controlled by adding a controlled amount of isopentane to said mixture in an amount effective for producing said desired amount of synthetic isopentane production.

The invention further includes an alkylation process for the alkylation of amylenes by isoparaffins, wherein said alkylation process has a suppressed ability to produce synthetic isopentane. The first step of this process includes contacting within a reaction zone a mixture with an alkylation catalyst, said mixture comprising amylenes, isobutane, and isopentane in an amount that is effective for suppressing the production of synthetic isopentane. The contacting step is followed by recovering from said reaction zone a reaction zone product which comprises an alkylate product having a reduced concentration of synthetic isopentane below that which would result when said mixture, having substantially no isopentane concentration, is contacted with said alkylation catalyst.

The invention also deals with a method of suppressing the production of synthetic isopentane during the alkylation of amylenes by isobutane. The method includes contacting within a reaction zone a mixture of said amylenes and said isobutane with an

alkylation catalyst and in the presence of a controlled amount of isopentane wherein said controlled amount of isopentane is such that the molar ratio of isopentane to amylene in said mixture exceeds 2 to 1 and producing a reaction zone effluent.

One of the important aspects of the inventive process is its ability to suppress, inhibit or eliminate the production of synthetic isopentane when amylenes are alkylated with isobutane in the presence of a hydrogen fluoride catalyst. A further important aspect of the process is its ability under certain precise process conditions to consume isopentane during the HF catalyzed alkylation reaction of amylenes with isobutane. In view of the ability of the process to suppress, inhibit or eliminate synthetic isopentane production and in certain circumstances to provide for isopentane consumption, a capability is provided for controlling, within certain limitations, the amount of isopentane that can be contained in an alkylation reaction effluent stream. Certain of the inventive process characteristics and attributes can be expressed or represented quantitatively by the selectivity or negative selectivity of the process toward the production of isopentane. The term "selectivity", as used herein, shall mean the ratio of the net synthetic isopentane produced to the amylene contained in the process feedstock. In the case where there is iC_5 consumption during the alkylation reaction, this may be referred to herein as "negative selectivity". The term "negative selectivity", shall mean the ratio of isopentane contained in a process feedstock that is consumed to the amylene contained in said feedstock.

As used herein, the term "synthetic isopentane" shall mean the net isopentane produced during a hydrogen fluoride catalyzed alkylation reaction of olefin compounds with isoparaffin compounds. Thus, the synthetic isopentane produced

during an alkylation reaction step shall be the difference between the total mass of isopentane con[illegible]ed in an alkylate product effluent leaving an alky[illegible]ation reaction zone and the total mass of isopentane contained in the feedstock to the alkylation reaction zone. It is theorized that the reaction mechanism by which synthetic isopentane is produced is the result of a hydrogen transfer reaction which is a chain initiated reaction in which tertiary butyl carbonium ions are formed and are involved in the chain reaction to form the ultimate products of isopentane and a paraffin hydrocarbon. One theorized mechanism for the hydrogen transfer reaction which occurs when amylene is alkylated with isobutane is as follows. See, Rosenwald, R.H., Kirk-Othmer Encyclopedia of Chemical Technology, 3rd Ed. (1978), 2, 50.

$$C_5H_{10} + H^+ \longrightarrow C_5H_{11}^+$$
$$C_5H_{11}^+ + iC_4H_{10} \longrightarrow C_5H_{12} + iC_4H_9^+$$
$$iC_4H_9^+ \longrightarrow iC_4H_8 + H^+$$
$$iC_4H_8 + iC_4H_9^+ \longrightarrow iC_8H_{17}^+$$
$$iC_8H_{17}^+ + iC_4H_{10} \longrightarrow iC_5H_{18} + iC_4H_9^+$$

$$\text{NET:}\quad C_5H_{10} + 2\ iC_4H_{10} \longrightarrow iC_5H_{12} + iC_8H_{18}$$

It is also theorized that certain of the physical phenomena relating to the features of inventive process can be attributed to various competing reactions which include the disproportionation reaction that involves the reaction of two intermediate molecules of a paraffin hydrocarbon compound each having an identical number of carbon atoms to form two separate paraffin hydrocarbon compounds one of which has fewer carbon atoms than the intermediate molecules and one of which has more carbon atoms than the intermediate molecules. One particularly important disproportionation reaction can be represented by the reaction formula as follows.

$$2\ iC_5 \rightleftharpoons iC_4 + C_6$$

The inventive method is generally described as including the process step of contacting a feedstock with a catalyst within a reaction zone and producing, recovering or withdrawing a reaction zone product or effluent from the reaction zone. The feedstock can comprise a mixture of olefin hydrocarbons and isoparaffin hydrocarbons. The olefin hydrocarbons which can be used in the practice of the invention can include the monoolefins containing at least three carbon atoms per molecule. Presently preferred olefins for use in the practice of the invention are those monoolefins containing three to six carbon atoms per molecule. Thus, olefin hydrocarbons of the reactor feedstock mixture can include monoolefins selected from the group consisting of propene, butenes, pentenes, hexenes and mixtures of any two or more thereof. The isoparaffin hydrocarbons which can be used in the practice of the invention can include those having at least four carbon atoms per molecule and, preferably, the isoparaffins can be selected from the group consisting of isobutane, isopentane, and mixtures thereof.

It is one function of the inventive process or method to provide means for controlling the amount of synthetic isopentane produced during the catalyzed alkylation of amylenes by isobutane. As earlier described herein, during the hydrogen fluoride catalyzed alkylation of amylenes by isobutane, often, undesirable hydrogen transfer side reactions occur by which synthetic isopentane is produced. Isopentane has increasingly become an undesired gasoline component primarily because of its high volatility or high Reid vapor pressure as compared to other gasoline components having comparable octane values. Thus, it is desirable to remove by any suitable means isopentane from

gasoline blending components such as an alkylation reaction product or alkylate or, in the case where there is a net isopentane production, it is desirable to inhibit, suppress or eliminate such synthetic isopentane production.

It has been discovered that if suitable proportions of isopentane are employed as a portion of an alkylation reaction zone feed mixture, which can also include amylenes and isobutane, the tendency of the alkylation reaction to produce synthetic isopentane is inhibited or suppressed. Thus, a controlled amount of isopentane can be added to an alkylation reaction zone feed mixture such that it is effective for suppressing the production of synthetic isopentane and for providing a reaction zone effluent product or alkylate having a reduced concentration of synthetic isopentane below that which would result when the alkylation reaction zone feed mixture, having substantially no isopentane concentration, is contacted with an alkylation catalyst within the alkylation reaction zone.

The weight ratio of isopentane to amylene in the alkylation reaction zone feed that has been found to be effective in suppressing the hydrogen transfer side reactions that produce synthetic isopentane generally can exceed ~~about~~ 1.5, but a more effective ratio is that which exceeds ~~about~~ 2.0. An upper limit for an effective ratio of isopentane to amylene in the alkylation reaction zone feed is primarily set by other factors relating to the ability of the process system to handle the additional volume of isopentane rather than by the inhibiting effect of the presence of the isopentane in the reaction zone or feed. Thus, the upper limit for the weight ratio of isopentane to amylene in the alkylation reaction zone feed is around 12:1 thereby giving a desired range for the ratio of isopentane to amylene in the reaction zone feed of from

~~about~~ 1.5:1 to 12:1 and preferably, from ~~about~~ 2:1 to ~~about~~ 11:1. A more preferred range for the ratio of isopentane to amylene in the alkylation reactor feed is from 2.5:1 to 10:1.

It has also been discovered that, within the aforementioned ratios of isopentane to amylene in an alkylation reaction zone feed, there is a certain ratio of isopentane to amylene which effectively provides for a net consumption of isopentane as determined by the difference in the mass of isopentane in the reaction zone effluent and the mass of isopentane in the reaction zone feed being a negative value. The weight ratio of isopentane to amylene found to provide for a net consumption of isopentane in the alkylation reaction is in the range of from ~~about~~ 4.5:1 to ~~about~~ 6.5:1. Preferably, the weight ratio of isopentane to amylene in the alkylation reaction zone feed necessary to provide a net consumption of isopentane is from ~~about~~ 5:1 to ~~about~~ 6:1 and, most preferably, it is from 5.2:1 to 5.8:1. Thus, within a certain broad range for the weight ratio of isopentane to amylene in an alkylation reaction zone feed, it has been found that synthetic isopentane production during the alkylation reaction is inhibited or suppressed as the given isopentane-to-amylene ratio is increased but only up to a given point where no synthetic isopentane is produced, above such ratio, a net reduction of isopentane is achieved.

Because of the above-described physical impact that the presence of isopentane has upon the alkylation of amylenes in an alkylation reaction zone, the benefit from having the ability to control the amount of synthetic isopentane contained in an amylene alkylate product can be controlled within certain broad ranges is achieved. Furthermore, when one considers an alkylation process in terms of its relationship with other refinery processes for the production of gasoline

and gasoline components, isopentane that has previously been a component of a gasoline pool can potentially be removed therefrom and utilized as a feedstock to an alkylation process whereby it is consumed during the alkylation reaction.

If the appropriate amount of isopentane is contained in an alkylation zone feedstock or added to such feedstock, the amount of synthetic isopentane produced can be such that the amount of synthetic isopentane product contained in the reactor effluent is less than ~~about~~ 0.8:1 as determined by the ratio of the weight of synthetic isopentane product in the reactor effluent to the weight of amylenes in the alkylation reaction zone feed mixture. Preferably, the amount of isopentane contained in an alkylation reactor feed can be controlled such that the ratio of the weight of synthetic isopentane product to the weight of amylenes contained in the alkylation reaction zone feed mixture is less than ~~about~~ 0.6:1; but, preferably, it is less than 0.3:1.

The catalyst used in the process or method can be any compound, composition or material that suitably provides for the alkylation reaction of olefins with isoparaffins. The alkylation catalyst can be a liquid catalyst or a solid catalyst which is either supported or unsupported. Presently, commercial alkylation catalysts include sulfuric acid and hydrogen fluoride. The preferred alkylation catalyst of the present invention includes hydrogen fluoride which can be used in any form suitable for achieving the objectives of the inventive method or process. Of the suitable hydrogen fluoride catalysts, it is preferred for the acid to be in substantially anhydrous form, although small quantities of water can be present. The liquid hydrogen fluoride catalyst, when it is not in the substantially anhydrous form, can have water present in the range from ~~about~~ 0.1 weight percent to

~~about~~ 5 weight percent and, preferably, the water will be present in the range from 0.5 weight percent to 4 weight percent. It is preferred for the hydrofluoric acid catalyst to contain at least ~~about~~ 86 weight percent HF. Thus, a convenient and commercially practical range for the HF content of the catalyst is from 86 to 97 weight percent HF.

To improve selectivity of the alkylation reaction of the present invention toward the production of the desirable highly branched aliphatic hydrocarbons having seven or more carbon atoms, a substantial stoichiometric excess of isoparaffin hydrocarbon is desirable in the reaction zone. Molar ratios of isoparaffin hydrocarbon to olefin hydrocarbon of from ~~about~~ 2:1 to ~~about~~ 25:1 are contemplated in the present invention. Preferably, the molar ratio of isoparaffin-to-olefin will range from ~~about~~ 5 to ~~about~~ 20; and, most preferably, it shall range from 8 to 15. It is emphasized, however, that the above recited ranges for the molar ratio of isoparaffin-to-olefin are those which have been found to be commercially practical operating ranges; but, generally, the greater the isoparaffin-to-olefin ratio in an alkylation reaction, the better the resultant alkylate quality.

Alkylation reaction temperatures within the contemplation of the present invention are in the range of from ~~about~~ 0°F. to ~~about~~ 150°F. Lower temperatures favor alkylation reaction of isoparaffin with olefin over competing olefin side reactions such as polymerization. However, overall reaction rates decrease with decreasing temperatures. Temperatures within the given range, and preferably in the range from ~~about~~ 30°F. to ~~about~~ 130°F., provide good selectivity for alkylation of isoparaffin with olefin at commercially attractive reaction rates. Most preferably, however, the alkylation temperature should range from 50°F. to 120°F.

Reaction pressures contemplated in the present invention may range from pressures sufficient to maintain reactants in the liquid phase to fifteen (15) atmospheres of pressure. Reactant hydrocarbons may be normally gaseous at alkylation reaction temperatures, thus reaction pressures in the range of from 40 pounds gauge pressure per square inch (psig) to 160 psig are preferred. With all reactants in the liquid phase, increased pressure has no significant effect upon the alkylation reaction.

Contact times for hydrocarbon reactants in an alkylation reaction zone, in the presence of the alkylation catalyst generally should be sufficient to provide for essentially complete conversion of olefin reactant in the alkylation zone. Preferably, the contact time is in the range from 0.05 minute to 60 minutes. In the alkylation process of the present invention, employing isoparaffin-to-olefin molar ratios in teh range of 2:1 to 25:1, wherein the alkylation reaction mixture comprises 40-90 volume percent catalyst phase and 60-10 volume percent hydrocarbon phase, and wherein good contact of olefin with isoparaffin is maintained in the reaction zone, essentially complete conversion of olefin may be obtained at olefin space velocities in the range of 0.01 to 200 volumes olefin per hour per volume catalyst (v/v/hr.). Optimum space velocities will depend upon the type of isoparaffin and olefin reactants utilized, the particular compositions of alkylation catalyst, and the alkylation reaction conditions. Consequently, the preferred contact times are sufficient for providing an olefin space velocity in the range of 0.01 to 200 (v/v/hr.) and allowing essentially complete conversion of olefin reactant in the alkylation zone.

In one embodiment of the alkylation process, the reactants can be maintained at sufficient pressures

and temperatures to maintain them substantially in the liquid phase and then continuously forced through dispersion devices into the reaction zone. The dispersion devices can be jets, nozzles, porous thimbles and the like. The reactants are subsequently mixed with the catalyst by conventional mixing means such as mechanical agitators or turbulence of the flow system. After a sufficient time, the product can then be continuously separated from the catalyst and withdrawn from the reaction system while the partially spent catalyst is recycled to the reactor. A portion of the catalyst can continuously be regenerated or reactivated as described herein, or by any other suitable treatment, and returned to the alkylation reactor.

The following examples will serve to further illustrate the invention.

EXAMPLE I

The data presented in Example II were obtained using a 300 mL continuous stirred tank reactor (CSTR) with hydrocarbon feed rates of 600 mL per hour, using an HF catalyst containing approximately 7% acid soluble oils and 2% water. The temperature of the reactor contents were maintained at 90°F. while stirring at a rate of 2000 rpm. The acid recirculation rate was 700 mL/hour. Samples were taken at specified intervals and analyzed by gas chromatography. In cases where peak identity confirmation was required, gas chromatographic and mass spectral methods were employed.

EXAMPLE II

Shown in Table I are the data obtained from the alkylation of a feed containing a weight ratio of isobutane to 2-methyl-2-butene (2MB2) of 10:1. Shown are the isopentane selectivities at the indicated time intervals into the reaction and other information. The average selectivity of 2MB2 to form isopentane is 74.2

percent on a molar basis. This indicates that, on the average, approximately 74 mole percent of the 2MB2 fed into the reactor is converted to isopentane on a mole-to-mole basis. This can be an indication that relatively large concentration levels of C_8 material is produced via the hydrogen transfer mechanism. Table II presents the data from the more complete analyses of the alkylates corresponding those shown in Table I for the given time intervals into the reaction. These data suggest that the major products of the alkylation reaction are C_8 and iC_5.

Shown in Table III are data obtained from the alkylation of a feed containing a weight ratio of iC_4/iC_5/2MB2 of 13:5:1. It is significant that the isopentane selectivity has been reduced by approximately 80% over that of the Table I feed, which did not contain iC_5. Table IV presents the data from the more complete analyses of the alkylates corresponding to those shown in Table III for the given time intervals into the reaction. A comparison of the compositions of the alkylates presented in Table II with those of Table IV indicates that the concentrations of C_6 and C_9+ in the Table IV alkylates are significantly greater than those concentrations of the Table II alkylates while the concentrations of C_8 material are lower. The nearly doubled increase in production of C_9+ material can be attributed to the direct alkylation of amylene with isobutane. The increase in C_6 production is believed to be due to the disproportionation of iC_5 to 2- and 3-methyl pentanes. The comparison of the data shows that there is a dramatic impact upon isopentane selectivity that results from adding isopentane to an alkylation reactor feedstock. The hydrogen transfer reaction is believed to be suppressed by adding suitable quantities of iC_5 to an alkylation reactor feedstock as evidenced by the suppression of the production of synthetic isopentane

and an increase in the production of C_9+ alkylate.

The data presented in Tables V and VI demonstrate that, at certain effective concentration levels of isopentane in an alkylation reactor feedstock, the hydrogen transfer reaction is suppressed to such an extent as to provide greater quantities of alkylation and disproportionation reaction products than that produced by having a lower concentration of iC_5 in the alkylation reactor feed. As shown in Table V, when there is an effective ratio of iC_5 to amylene in the alkylation reactor feedstock, a quantity of the iC_5 in the feedstock is actually consumed thereby providing a "negative selectivity" toward the production of iC_5.

Shown in Table V are data taken from the alkylation of a feed containing a weight ratio of iC_5/2MB2 of 10:1. On average, there is a net consumption of isopentane, or a "negative isopentane selectivity". This "negative isopentane selectivity" indicates the possibility that disproportionation of iC_5 to 2- and 3-methyl pentanes (and iC_4) is concurrently with the alkylation reaction. Table VI gives the results from a more complete analysis of the alkylates that correspond to those shown in Table V for the given time intervals into the reaction. A comparison of the C_6 and C_9+ concentrations presented in Tables II, IV and VI shows that both increase with an increasing ratio of isopentane to amylene in the alkylation reactor feed. This is most likely due to an increased disproportionation of iC_5 to iC_4 and methylpentanes. The amount of C_8 material in the alkylate is significantly below that which results when a lower iC_5/2MB2 feed ratio is utilized, indicating that the hydrogen transfer reaction is suppressed.

The data presented in Tables VII and VIII demonstrate the effect of having an iC_4/iC_5 ratio in the feeds of less than 1. In Table VII, the data

indicate a very large, negative value for synthetic isopentane, which is indicative of enhanced iC_5 consumption. The iC_5 consumption is believed to be the result of disproportionation of iC_5 to methylpentanes and iC_4.

Table VIII presents the results of alkylate analyses that correspond to those shown in Table VII for the given time intervals into the reaction. A comparison of the data of Table VI with the data of Table VIII shows that the concentration of C_9+ materials in the alkylates are substantially the same, but the concentration of C_6 material in the alkylate of Table VIII is substantially greater than that of Table VI. This differential is believed to be due to the disproportionation of iC_5 to iC_4 and methylpentanes. The concentration of C_8 material in the alkylate of Table VIII is about 60% lower than that of the alkylate of Table VI, thus, indicating that an increasing iC_5 concentration in the alkylation reactor feedstock suppresses the hydrogen transfer reaction.

When alkylation reaction zone feeds contain more iC_5 than iC_4, there does not appear to be any gains in direct alkylation products, but an increased concentration of iC_5 above certain critical concentration levels result in a net reduction of iC_5 or, in other words, a net consumption of iC_5 due to competing disproportionation reactions.

Table I

Determination of Isopentane Selectivity for iC_4/2MB2 Feed

	Time, hrs.	2	4	6	8
	% Conversion 2MB2	100.0	100.0	100.0	100.0
	Feed Rate, (mL/hr)	600	600	600	600
	g Feed/hr	336	336	336	336
	Feed Composition				
	% Isobutane	87.1	87.1	87.1	87.1
	% 2MB2	12.9	12.9	12.9	12.9
	Wt. Fraction 2MB2 Feed/hr	0.129	0.129	0.129	0.129
	g 2MB2/hr	43.3	43.3	43.3	43.3
	Moles 2MB2 Feed/hr	0.618	0.618	0.618	0.618
	Product Analysis				
	% iC_5 in Product	9.231	9.859	10.106	10.195
	g iC_5 Produced/hr	31.016	33.126	33.96	34.26
	Moles iC_5 Produced/hr	0.430	0.459	0.471	0.475
	Moles Synthetic iC_5 (per hour)	0.430	0.430	0.430	0.430
	iC_5 Selectivity, (%)	69.6	74.3	76.2	76.8
	(Average) %	74.2			
	Ratio iC_5/2MB2 (Feed)	0			

Table II

Alkylate from iC_4/2MB2 Feed

	TOS, hrs.	2	4	6	8	Average
	% Conversion	100.0	99.70	100.00	100.00	100.00
	Lights	10.52	10.28	9.85	9.80	10.11
	C_5+ Material (on iC_4-Free Basis)					
	iC_5	30.94	31.99	32.33	32.38	31.91
	nC_5	0.07	0.00	0.00	0.00	0.02
	C_6	2.38	2.16	2.23	2.25	2.26
	C_7	1.45	1.22	1.23	1.23	1.28
	C_8	45.79	45.73	45.69	45.87	45.77
	C_9+	8.85	8.62	8.69	8.43	8.65
	C_6+ Material (on iC_4/iC_5-Free Basis)					
	nC_5	0.10	0.00	0.00	0.00	0.03
	C_6	3.45	3.18	3.30	3.33	3.32
	C_7	2.10	1.79	1.82	1.82	1.88
	C_8	66.30	67.24	67.52	67.83	67.22
	C_9+	12.81	12.67	12.84	12.47	12.70
	Lights	15.23	15.12	14.56	14.49	14.85

Feed: 10/1 iC_4/2MB2

Lights = All material $\leq C_4$ except isobutane

Table III

Determination of Isopentane Selectivity for iC_4/iC_5/2MB2 Feed No. 1

	Time, hrs:	2	4	6	8
	% Conversion 2MB2	99.48	99.29	99.53	99.47
	Feed Rate, (mL/hr)	600	600	600	600
	g Feed/hr.	336	336	336	336
	Feed Composition				
	% Isobutane	68.14	68.14	68.14	68.14
	% Isopentane	26.04	26.04	26.04	26.04
	% 2MB2	5.03	5.03	5.03	5.03
	Wt. % 2MB2/hr	0.05	0.05	0.05	0.05
	g 2MB2/hr	16.88	16.88	16.88	16.88
	Moles 2MB2 reacted/hr	0.241	0.241	0.241	0.241
	g iC_5 added/hr	87.5	87.5	87.5	87.5
	Moles iC_5 added/hr	1.213	1.213	1.213	1.213
	Product Analysis				
	% iC_5 in Product/hr	26.145	26.701	26.697	27.017
	g iC_5 in Product/hr	87.85	89.71	89.70	90.78
	Moles iC_5 in Product/hr	1.218	1.244	1.243	1.258
	Moles Synthetic iC_5/hr	0.005	0.031	0.030	0.045
	iC_5 Selectivity (%)	2.01%	12.8%	12.7%	18.9%
	Average (4-8 hrs) = 14.8%				
	Ratio iC_5/2MB2 (Feed) = 5.18				

Table IV

Alkylate From iC_4/iC_5/2MB2 Feed No. 1

	TOS, hrs.	2	4	6	8	Average
	% Conversion	99.48	99.29	99.53	99.47	99.44
	Lights	0.53	0.46	0.39	0.40	0.45
	C_5+ Material (on iC_4-Free Basis)					
	iC_5	73.04	74.31	75.17	74.69	74.30
	nC_5	0.42	0.44	0.43	0.42	0.43
	C_6	2.74	2.46	2.44	2.45	2.52
	C_7	0.70	0.45	0.45	0.45	0.51
	C_8	14.39	15.24	14.98	15.21	14.96
	C_9+	8.21	6.64	6.14	6.42	6.85
	C_6+ Material (on iC_4/iC_5-Free Basis)					
	nC_5	1.56	1.71	1.73	1.66	1.67
	C_6	10.16	9.58	9.83	9.68	9.81
	C_7	2.60	1.73	1.80	1.79	1.98
	C_8	53.38	59.32	60.33	60.09	58.28
	C_9+	30.45	25.85	24.73	25.37	26.60
	Lights	1.96	1.71	1.43	1.48	1.65

Feed: 68.14% iC_4, 26.04% iC_5, 5.03% 2MB2
Lights = All material $\leq C_4$ except isobutane
iC_5/2MB2 Ratio (feed) = 5.18

Table V

Determination of Isopentane
Selectivity for iC_4/iC_5/2MB2 Feed No. 2

	Time, hrs.	2	4	6	8
	% Converted	99.34	99.38	99.50	99.15
	Feed Rate, mL/hr	600	600	600	600
	g Feed/hr.	336	336	336	336
	Feed Composition				
	% iC_4	52.57	52.57	52.57	52.57
	% iC_5	42.48	42.48	42.48	42.48
	% 2MB2	4.21	4.21	4.21	4.21
	Wt. % 2MB2/hr	0.042	0.042	0.042	0.042
	g 2MB2/hr	14.15	14.15	14.15	14.15
	Moles 2MB2 reacted/hr	0.202	0.202	0.202	0.202
	g iC_5 added/hr	142.7	142.7	142.7	142.7
	Moles iC_5 added/hr	1.978	1.978	1.978	1.978
	Product Analysis				
	% iC_5 in Product/hr	40.658	41.741	42.147	42.550
	g iC_5 in Product/hr	136.6	140.2	141.6	143.0
	Moles iC_5 in Produced/hr	1.893	1.944	1.963	1.982
	Moles Synthetic iC_5/hr	-0.085	-0.034	-0.015	0.003
	iC_5 Selectivity (%)	-41.98	-16.97	-7.60	1.71
	Average (4-8 hrs)	-7.62			
	Ratio iC_5/2MB2 (Feed)	10.09			

Table VI

Alkylate From iC_4/iC_5/2MB2 Feed No. 2

TOS, hrs.	2	4	6	8	Average
% Conversion	99.34	99.38	99.50	99.19	99.35
Lights	0.30	0.27	0.23	0.32	0.28
C_5+ Material (on iC_4-Free Basis)					
iC_5	80.93	80.67	80.71	80.67	80.75
nC_5	0.59	0.58	0.59	0.58	0.59
C_6	4.21	4.34	4.42	4.45	4.36
C_7	0.55	0.58	0.60	0.61	0.59
C_8	7.13	6.76	6.67	6.71	6.82
C_9+	6.30	6.79	6.78	6.65	6.63
C_6+ Material (on iC_4/iC_5-Free Basis)					
nC_5	3.08	3.01	3.07	3.02	3.05
C_6	22.07	22.47	22.91	23.02	22.62
C_7	2.87	3.02	3.09	3.13	3.03
C_8	37.37	34.98	34.59	34.74	35.42
C_9+	33.05	35.14	35.16	34.41	34.44
Lights	1.59	1.39	1.18	1.68	1.46

Feed: 52.47% iC_4, 42.48% iC_5, 4.2% 2MB2
Lights = All material $\leq C_4$ except isobutane
iC_5/2MB2 Ratio (Feed) = 10.1

Table VII

Determination of Synthetic Isopentane Selectivity for iC_4/iC_5/2MB2 Feed No. 3

	Time, hrs.	2	4	6	8
	% Conversion	99.68	99.66	99.61	99.56
	Feed Rate, mL/hr	600	600	600	600
	g Feed/hr	336	336	336	336
	Feed Composition				
	% iC_4	33.16	33.16	33.16	33.16
	% iC_5	63.03	63.03	63.03	63.03
	% 2MB2	3.00	3.00	3.00	3.00
	Wt. % 2MB2/hr	0.030	0.030	0.030	0.030
	g 2MB2/hr	10.093	10.093	10.093	10.093
	Moles 2MB2/hr	0.144	0.144	0.144	0.144
	g iC_5 added/hr	211.8	211.8	211.8	211.8
	Moles iC_5 added/hr	2.94	2.94	2.94	2.94
	Product Analysis				
	Wt.% iC_5 in Product	55.73	57.66	58.43	58.36
	g iC_5 in Product	187.3	193.7	196.3	196.1
	Moles iC_5 in Product	2.60	2.69	2.73	2.72
	Moles Synthetic iC_5/hr	-0.34	-0.25	-0.21	-0.22
	iC_5 Selectivity (%)	-236.1	-173.6	-145.8	-150.9
	Average (4-8 hrs)	157.8			
	Ratio iC_5/2MB2 (Feed)	21.01			

Table VIII

Alkylate From iC_4/iC_5/2MB2 Feed No. 3

TOS, hrs.	2	4	6	8	Average
% Conversion	99.68	99.66	99.61	99.56	99.63
Lights	0.12	0.11	0.11	0.12	0.12
C_5+ Material (on iC_4-Free Basis)					
iC_5	84.29	85.03	84.80	85.14	84.82
nC_5	0.80	0.82	0.82	0.82	0.82
C_6	5.88	5.92	6.02	5.82	5.91
C_7	0.94	0.96	0.96	0.98	0.96
C_8	2.62	2.00	1.97	1.93	2.13
C_9+	5.36	5.16	5.32	5.19	5.26
C_5+ Material (on iC_4/iC_5-Free Basis)					
nC_5	5.07	5.48	5.37	5.54	5.37
C_6	37.39	39.52	39.60	39.18	38.92
C_7	5.99	6.41	6.33	6.57	6.33
C_8	16.67	13.38	12.97	13.00	14.01
C_9+	34.13	34.48	34.98	34.90	34.62
Lights	0.76	0.73	0.74	0.81	0.76

Feed: 33.16% iC_4, 63.03% iC_5, 3.00% 2MB2
Lights = All material $\leq C_4$ except isobutane
iC_5/2MB2 Ratio (Feed) = 21.01

EXAMPLE III

The data presented in Example IV were obtained using a 300 mL riser-type reactor with the feeds sprayed into a non-circulated layer of catalyst (300 ml). The feed rates were 300 mL per hour throughout the experimental run, and the temperature was held constant at 90°F. (±3°F.). The catalyst was composed of 92% HF, 2% water, and 6% acid soluble oils generated by the addition of pure 2-butenes to the HF/water catalyst mixture. Samples were taken at different times on stream and analyzed as described above.

EXAMPLE IV

Table IX presents the data resulting from the alkylation of a feed containing of 64.6% iC_4, 29.2% iC_5, and 5.4% 2MB2. Comparing these data to that of a similar feed presented in Table III, it is immediately apparent that a much higher level of iC_5 consumption is achieved. This is evidenced by the large, negative values for isopentane selectivity. In contrast, the alkylation of a feed containing a ratio of iC_5 to 2MB2 of 5.18 in a CSTR reactor led to an average value for iC_5 selectivities of 14.8%.

Table X presents further data from the analyses of alkylates presented in Table IX. A comparison of these results with those in Table IV indicates that the concentration levels of C_6 material in the alkylates are similar. However, the amounts of C_8 and C_9+ material are reversed relative to Table IV data. These data indicate a possibility of a suppressed hydrogen transfer reaction since the amount of C_8 material in the alkylate is reduced. The concentration of C_9+ material in the alkylates indicates that the direct alkylation reaction is favored under these conditions. Some of these differences can be explained by the differences in contact time of hydrocarbon with the acid between the CSTR and the riser-reactor. In the CSTR, the contact time is on the order of several minutes greater than the hydrocarbon residence time within the riser reactor. These data suggest that short residence times may favor production of direct alkylation products and that longer residence times may allow for the disproportionation reaction to proceed to a greater degree. The data presented in Tables IX and IV illustrate that as the residence time is shortened, the extent of disproportionation is reduced.

Table IX

Determination of iC_5 Selectivity for iC_4/iC_5/2MB2 Feed No. 4 (Riser Reactor)

	Time, hrs.	2	4	6	10
	% Conversion	100.0	100.0	100.0	100.0
	Feed Rate, mL/hr	300	300	300	300
	g Feed/hr	171.3	171.3	171.3	171.3
	Feed Composition				
	% iC_4	64.62	64.62	64.62	64.62
	% iC_5	29.24	29.24	29.24	29.24
	% 2MB2	5.366	5.366	5.366	5.366
	Wt. Fraction 2MB2/hr	0.0537	0.0537	0.0537	0.0537
	g 2MB2/hr	9.192	9.192	9.192	9.192
	Moles 2MB2/hr	0.131	0.131	0.131	0.131
	g iC_5 added/hr	50.09	50.09	50.09	50.09
	Moles iC_5 added/hr	0.696	0.696	0.696	0.696
	Product Analysis				
	g iC_5 in Product	46.445	49.456	43.932	47.51
	% iC_5 in Product	27.113	28.871	25.646	27.736
	Moles iC_5 in Product	0.644	0.685	0.609	0.659
	Moles Synthetic iC_5	-0.052	-0.011	-0.087	-0.037
	iC_5 Selectivity (%)	-39.7	-8.39	-66.4	-28.24
	Average (2-10 hrs.)	-35.7			
	Ratio iC_5/2MB2 (Feed)	5.6			

Table X

Alkylate From iC_4/iC_5/2MB2 Feed No. 4 (Riser Reactor)

TOS, hrs.	2	4	6	8
% Conversion	100.00	100.00	100.00	100.00
Lights	0.62	0.36	1.88	3.67
C_5+ Material (on iC_4-Free Basis)				
iC_5	62.45	62.40	64.56	45.00
nC_5	0.30	0.31	0.32	0.26
C_5	3.18	3.19	3.17	2.71
C_7	1.49	1.48	1.24	1.77
C_8	13.74	16.79	13.67	23.72
C_9+	17.46	15.36	14.92	22.87
C_6+ Material (on iC_4/iC_5-Free Basis)				
nC_5	0.80	0.82	0.89	0.47
C_6	8.47	8.48	8.95	4.93
C_7	3.97	3.94	3.49	3.22
C_8	36.57	44.65	38.56	43.12
C_9+	46.48	40.84	42.10	41.58
Lights	1.65	0.95	5.29	6.68

Feed: 64.62% iC_4, 29.24% iC_5, 52.7% 2MB2
Lights = All material $\leq C_4$ except isobutane

While certain embodiments of the invention have been described for illustrative purposes, the invention is not limited thereto. Various other modifications or embodiments of the invention will be apparent to those skilled in the art in view of this disclosure. Such modifications or embodiments are within the spirit and scope of the disclosure.

The claims defining the invention are as follows:

1. A process for the alkylation of amylenes by isoparaffins, which comprises:

contacting within a reaction zone an alkylation catalyst and a mixture comprising amylenes and isobutane, said mixture further comprising isopentane in an amount that is effective for suppressing the production of synthetic isopentane to a desired amount; and

producing in said reaction zone a reaction product which comprises an alkylate product having a reduced concentration of synthetic isopentane below that which would result when said mixture, having substantially no isopentane concentration, is contacted with said alkylation catalyst.

2. A process according to claim 1, wherein said amount of isopentane in said mixture that is effective for suppressing the production of synthetic isopentane exceeds 2:1 as determined by the ratio of the weight of isopentane in said mixture to the weight of amylenes in said mixture.

3. A process according to claim 2, wherein said amount of isopentane in said mixture is in the range of from ~~about~~ 2:1 to ~~about~~ 10:1 as determined by the ratio of the weight of isopentane in said mixture to the weight of amylenes in said mixture.

4. A process according to any one of claims 1-3, wherein said desired amount of synthetic isopentane production is less than ~~about~~ 0.8:1 as determined by the ratio of the weight of said synthetic isopentane production to the weight of amylenes in said mixture.

5. A process according to any one of the preceding claims, wherein said alkylation catalyst comprises hydrogen fluoride.

6. A process according to any one of the preceding claims, wherein the weight ratio of the isobutane to the amylenes in said mixture exceeds 2:1.

7. A process for the alkylation of amylenes by isoparaffins substantially as herein described with reference to any of the Examples.

8. An alkylation product produced by a process according to any one of the preceding claims.

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PHILLIPS ORMONDE & FITZPATRICK

Attorneys for:

PHILLIPS PETROLEUM COMPANY

David B Fitzpatrick

Abstract of the Disclosure

A method of minimizing or controlling the production of synthetic isopentane during the catalyzed alkylation reaction of amylenes and isoparaffins by providing a concentration of isopentane in the alkylation reactor feed material.