



**Olefin skeletal isomerization of *n*-butene, *n*-hexene and
n-octene using alumina-based catalysts**

by

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Table of Contents

Table of Contents	i
List of Figures	iii
List of Tables	ix
List of Schemes	xi
Abbreviations	xii
Abstract	xvi
Opsomming	xvii
Acknowledgements	xviii
Chapter 1	1
Introduction	1
1.1 Introduction	1
1.2 Research aims	5
1.3 Research objectives	6
Chapter 2	7
Literature Review	7
2.1 Introduction	7
2.2 Fuel specifications for petrol	7
2.2.1 Sulphur	8
2.2.2 Research Octane Number (RON)	8
2.2.3 Benzene	8
2.2.4 Aromatics	8
2.2.5 Olefins	8
2.2.6 Reid Vapour Pressure (RVP)	9
2.3 Relationship between the compression ratio of an internal combustion engine and octane number	10
2.4 The Fischer-Tropsch Refinery and the use of butene, hexene and octene as feedstocks	13
2.4.1 Butene	13
2.4.2 Hexene	14
2.4.3 Octene	14
2.5 Isomerization	14
2.5.1 Paraffin isomerization via carbocation intermediates	15
2.5.2 Olefin isomerization via carbocation intermediates	18
2.5.3 Proposed reaction mechanisms for olefin skeletal isomerization	19
2.6 Feedstock for olefin isomerization	23
2.7 Thermodynamic equilibrium and operating conditions	23
2.8 Catalysts for olefin isomerization	25
2.9 Catalysts used for olefin skeletal isomerization based on feedstocks used in this study	25
2.9.1 Butene	25
2.9.2 Hexene	34
2.9.3 Octene	35
2.10 Catalysts for olefin skeletal isomerization used in this study	39
Chapter 3	40
Experimental Procedures	40
3.1 Catalysts	40
3.2 Catalyst preparation	40
3.3 Apparatus	40
3.3.1 Reactor	40
3.3.2 Determining the loading zone	41
3.3.3 Loading the reactor	41
3.3.4 Start up procedure for the various feeds	44
3.3.5 Chemical reagents and materials used	45
3.4 Product Characterization	46
3.4.1 Refinery Gas Analysis (RGA)	46
3.4.2 Gas Chromatography – Mass Spectrometer (MS)	47
3.4.3 Gas Chromatography – Flame Ionization Detector (FID)	48
3.4.4 Spiking with known compounds	48
3.4.5 Kováts indices	48
3.5 Catalyst Characterization	49

3.5.1	X-Ray Diffraction Analysis (XRD).....	49
3.5.2	Inductively Coupled Plasma Analysis (ICP)	49
3.5.3	Thermal Gravimetric Analysis (TGA)	49
3.5.4	Surface Area (SA) and Pore Volume (PV) Analysis	50
3.5.5	Surface Acidity	50
Chapter 4.....		52
Characterization of Reactants.....		52
4.1	X-Ray Diffraction (XRD) Analysis	52
4.2	Inductively Coupled Plasma (ICP) Analysis	56
4.3	Surface Acidity.....	57
4.4	Thermal Gravimetric Analysis (TGA).....	65
4.5	Surface Area (SA) and Pore Volume (PV) Analysis.....	67
4.6	Feed compositions.....	68
Chapter 5.....		71
Results of isomerization of 1-Butene		71
5.1	Conversion, selectivity, mass balances and steady state	71
5.2	Thermodynamic equilibrium.....	72
5.3	1-Butene reacted with Eta alumina catalyst	74
5.4	1-Butene reacted with ZSM-5 catalyst.....	82
5.5	1-Butene reacted with Siralox 40 catalyst	93
5.6	Surface acidity of the three catalysts.....	100
5.7	Comparisons of the three catalysts	104
Chapter 6.....		111
Results on isomerization of 1-Hexene		111
6.1	Confirmation on the mass balance and inertness of the reactor system	111
6.2	<i>n</i> -Hexene reacted over Eta alumina catalyst.....	113
6.3	1-Hexene reacted over ZSM-5 catalyst.....	121
6.4	1-Hexene reacted with Siralox 40 catalyst	127
6.5	Comparisons of the three catalysts	133
Chapter 7.....		137
Results on isomerization of 1-Octene		137
7.1	Spiking with known compounds	137
7.2	Kováts indices and retention time calculations.....	145
7.3	1-Octene reacted over Eta alumina catalyst	146
7.4	1-Octene reacted over ZSM-5 catalyst.....	150
7.5	1-Octene reacted over Siralox 40 catalyst.....	155
7.6	Comparisons of the three catalysts	159
Chapter 8.....		163
Impact of catalyst selection with respect to reaction observed.....		163
8.1	Isomerization, cracking, formation of heavier products and double bond shift reactions	163
8.1.1	Isomerization	163
8.1.2	Cracking	165
8.1.3	Formation of heavier products	167
8.1.4	Double bond shift reactions.....	169
8.2	Discussion	172
8.2.1	Diffusion	172
8.2.2	Acidity.....	179
Chapter 9.....		181
Conclusions and Future work.....		181
9.1	Conclusion	181
9.2	Future work.....	184
Annexures		186
Annexure A: Safety information on the different feedstocks used in this study		186
Annexure B: GC method used in product off-gas analysis		187
Annexure C: GC method used in liquid product analysis.....		189
Annexure D: GC method used in liquid product analysis.....		191
Annexure E: Selectivity, conversion and mass balance calculations.....		193
Bibliography		194

List of Figures

Figure 2.1: Illustration of the compression ratio [DE, 1993].....	10
Figure 2.2: Illustration of the engine cycle [Amsoil, 2001]	11
Figure 2.3: Octane numbers versus boiling point for hydrocarbon families [Albahri et al., 2002] .	12
Figure 2.4: High Temperature Fischer-Tropsch (FT) refinery design originally used at Secunda [Kamara et al., 2009].....	13
Figure 2.5: Classification of different types of isomerization processes	15
Figure 2.6: Carbocations' of which (A) is the carbenium ion of methane and (B) which is the carbonium ion of methane.....	16
Figure 2.7: Increasing stability of carbenium ions (R is an alkyl group)	16
Figure 2.8: Thermodynamic distribution of <i>n</i> -butene and 1-butene isomers versus temperature [Domokos, 2002].....	24
Figure 2.9: Micropores and mesopores of a zeolite crystal [Corma, 1997]	26
Figure 2.10: Surface area over volume ratio of shaped catalyst particles [Krishna et al., 1994]...	29
Figure 2.11: In zeolites and silica-alumina, Brønsted acid sites transform into Lewis acid sites [Waghmode et al., 2003].....	31
Figure 2.12: Relation between catalytic activity and strong acid sites with acid strength $H_0 \leq +2.27$ [Long et al., 2008b]	38
Figure 3.1: Process Flow Diagram of reactor system used in all experimental runs	41
Figure 3.2: Temperature profile and loading diagram for Eta alumina catalyst	43
Figure 3.3: Temperature profile and loading diagram for ZSM-5 catalyst	43
Figure 3.4: Temperature profile and loading diagram for Siralox 40 catalyst	44
Figure 3.5: Flow diagram of Refinery Gas Analyzer	47
Figure 3.6: Block diagram of GC-MS system [Kealy et al., 2002].....	47
Figure 3.7: Block diagram of thermogravimetric instrument [Kealy et al., 2002]	50
Figure 4.1: X-ray diffractogram of η -alumina	53
Figure 4.2: X-ray diffractogram of ZSM-5	54
Figure 4.3: The molecular structure of ZSM-5	55
Figure 4.4: The first 10-ring channel of ZSM-5 and the second 10-ring channel of ZSM-5	55
Figure 4.5: X-ray diffractogram of Siralox 40	56
Figure 4.6: TPD spectra of <i>n</i> -propylamine on fresh Eta-alumina (blue profile), fresh ZSM-5 (red profile) and fresh Siralox 40 (green profile).....	58
Figure 4.7: MS data of evolved propylene on fresh Eta-alumina (blue profile), fresh ZSM-5 (red profile) and fresh Siralox 40 (green profile).....	58
Figure 4.8: DRIFT spectra of fresh ZSM-5 in at different CO coverages. The insert shows changes in the OH region	61
Figure 4.9: DRIFT spectra of fresh Eta alumina at different CO coverages	63
Figure 4.10: DRIFT spectra of fresh Siralox 40 at different CO coverages	64
Figure 4.11: Typical TGA results sheet for fresh Eta alumina catalyst.....	66
Figure 4.12: Surface Area (m^2/g) results for fresh Eta alumina, fresh ZSM-5 and fresh Siralox 40 catalysts	67
Figure 4.13: Pore Volume (cm^3/g) results for fresh Eta alumina, fresh ZSM-5 and fresh Siralox 40 catalysts	68
Figure 5.1: Simulation of the composition (%) of 1-butene, <i>cis</i> -2-butene and <i>trans</i> -2-butene. This indicates the maximum conversion of 1-butene that can be reached at temperatures 350 °C, 400 °C and 450 °C at thermodynamic equilibrium	73
Figure 5.2: Conversion of 1-butene (%) at temperatures of 350 °C, 400 °C and 450 °C using the Eta alumina catalyst, indicating that steady state was obtained. The dotted lines are equilibrium as calculated with PSRK using Aspen software [Section 5.2]	74
Figure 5.3: Comparison between Eta alumina catalytic conversion of 1-butene (%) at steady state (filled data points) and the calculated thermodynamic equilibrium (open data points) at the temperatures of 350 °C, 400 °C and 450 °C.....	75
Figure 5.4: Composition (%) of desired products obtained at 350 °C over the Eta alumina catalyst	75
Figure 5.5: Composition (%) of desired products obtained at 400 °C over the Eta alumina catalyst	76
Figure 5.6: Composition (%) of desired products obtained at 450 °C over the Eta alumina catalyst	76
Figure 5.7: Butane content (mass %) of the total product obtained as a function of time on line (hours) at 350 °C, 400 °C and 450 °C over the Eta alumina catalyst. Butane formation is indicative of hydrogen transfer.....	77

List of Figures Continued

Figure 5.8: Average mass out (% normalized) of total product obtained at 350 °C, 400 °C and 450 °C over the Eta alumina catalyst. Butane formation is indicative of hydrogen transfer	78
Figure 5.9: Propene content (mass %) as a function of time on line (hours) at 350 °C, 400 °C and 450 °C formed over the Eta alumina catalyst. Propene formation is indicative of cracking	79
Figure 5.10: Carbon (%) of fresh Eta alumina and spent Eta alumina after reactions at temperatures of 350 °C, 400 °C and 450 °C.....	81
Figure 5.11: Pore volume (cm ³ /g) of fresh Eta alumina and spent Eta alumina and pore volume loss (%) of fresh Eta alumina and spent Eta alumina after reactions at temperatures of 350 °C, 400 °C and 450 °C	81
Figure 5.12: Surface area (m ² /g) of fresh Eta alumina and spent Eta alumina and surface area loss (%) of fresh Eta alumina and spent Eta alumina after reactions at temperatures of 350 °C, 400 °C and 450 °C	82
Figure 5.13: Conversion of 1-butene (%) after reaction at temperatures of 350 °C, 400 °C and 450 °C obtained over the ZSM-5 catalyst	83
Figure 5.14: Conversion of n-butene (%) after reaction at temperatures of 350 °C, 400 °C and 450 °C obtained over the ZSM-5 catalyst	84
Figure 5.15: Conversion of 1-butene (%) and n-butene at steady state after reactions at temperatures of 350 °C, 400 °C and 450 °C obtained over the ZSM-5 catalyst. The conversion is compared to the thermodynamic equilibrium data obtained from Figure 5.1	85
Figure 5.16: Selectivity of C ₅ ⁺ compounds on 1-butene (%) and n-butene (%) after reactions at temperatures of 350 °C, 400 °C and 450 °C obtained over the ZSM-5 catalyst	85
Figure 5.17: Selectivity (%) of iso-butene based on 1-butene at 350 °C, 400 °C and 450 °C over the ZSM-5 catalyst	87
Figure 5.18: Selectivity (%) of iso-butene based on n-butene at 350 °C, 400 °C and 450 °C over the ZSM-5 catalyst	87
Figure 5.19: Selectivity (%) of cis-2-butene, trans-2-butene and iso-butene based on 1-butene at 350 °C over the ZSM-5 catalyst	88
Figure 5.20: Selectivity (%) of cis-2-butene, trans-2-butene and iso-butene based on 1-butene at 400 °C over the ZSM-5 catalyst	88
Figure 5.21: Selectivity (%) of cis-2-butene, trans-2-butene and iso-butene based on 1-butene at 450 °C over the ZSM-5 catalyst	89
Figure 5.22: Butane content (mass %) as a function of time on line (hours) at temperatures of 350 °C, 400 °C and 450 °C over the ZSM-5 catalyst.....	89
Figure 5.23: Average mass percentage in terms (% normalized) of total side products obtained at temperatures of 350 °C, 400 °C and 450 °C over the ZSM-5 catalyst	90
Figure 5.24: Propene content (mass %) of the total product obtained as a function of time on line (hours) at 350 °C, 400 °C and 450 °C over the ZSM-5 catalyst	91
Figure 5.25: Carbon (%) of fresh ZSM-5 and spent ZSM-5 after reactions at temperatures of 350 °C, 400 °C and 450 °C	91
Figure 5.26: Pore volume (cm ³ /g) of fresh ZSM-5 and spent ZSM-5 and pore volume loss (%) of fresh ZSM-5 and spent ZSM-5 after reactions at temperatures of 350 °C, 400 °C and 450 °C	92
Figure 5.27: Surface area (m ² /g) of fresh ZSM-5 and spent ZSM-5 and surface area loss (%) of fresh ZSM-5 and spent ZSM-5 after reactions at temperatures of 350 °C, 400 °C and 450 °C	92
Figure 5.28: Conversion of 1-butene (%) after reaction at temperatures of 350 °C, 400 °C and 450 °C obtained over the Siralox 40 catalyst	93
Figure 5.29: Conversion of n-butene (%) after reaction at temperatures of 350 °C, 400 °C and 450 °C obtained over the Siralox 40 catalyst.....	94
Figure 5.30: Comparison between the conversion of 1-butene (%) at steady state and the thermodynamic equilibrium at temperatures of 350 °C, 400 °C and 450 °C obtained over the Siralox 40 catalyst	94
Figure 5.31: Total selectivity (%) of desired products obtained at 350 °C over the Siralox 40 catalyst	95
Figure 5.32: Total selectivity (%) of desired products obtained at 400 °C over the Siralox 40 catalyst	95
Figure 5.33: Total selectivity (%) of desired products obtained at 450 °C over the Siralox 40 catalyst	96
Figure 5.34: Conversion of 1-butene (%) after reaction at temperatures of 350 °C, 400 °C and 450 °C obtained over the Siralox 40 catalyst. The dotted lines are equilibrium data as calculated with PSRK using Aspen software	96

List of Figures Continued

Figure 5.35: Butane content (mass %) as a function of time on line (hours) at temperatures of 350 °C, 400 °C and 450 °C over the Siralox 40 catalyst	97
Figure 5.36: Propene content (mass %) as a function of time on line (hours) at temperatures of 350 °C, 400 °C and 450 °C over the Siralox 40 catalyst	98
Figure 5.37: Carbon (%) of fresh Siralox 40 and spent Siralox 40 after reactions at temperatures of 350 °C, 400 °C and 450 °C	98
Figure 5.38: Pore Volume (cm ³ /g) of fresh Siralox 40 and spent Siralox 40 and pore volume loss (%) of fresh Siralox 40 and spent Siralox 40 after reactions at temperatures of 350 °C, 400 °C and 450 °C	99
Figure 5.39: Surface Area (m ² /g) of fresh Siralox 40 and spent Siralox 40 and surface area loss (%) of fresh Siralox 40 and spent Siralox 40 after reactions at temperatures of 350 °C, 400 °C and 450 °C	99
Figure 5.40: The spectrum obtained after the adsorption of CO on Eta alumina (red), ZSM-5 (blue) and Siralox 40 (green)	101
Figure 5.41: TPD of <i>n</i> -propylamine on fresh Eta alumina (blue profile) and spent Eta alumina (red profile)	102
Figure 5.42: TPD of a <i>n</i> -propylamine on fresh ZSM-5 (blue profile) and spent ZSM-5 (red profile)	102
Figure 5.43: TPD of <i>n</i> -propylamine on pure Siralox 40 (blue profile) and spent Siralox 40 (red profile)	103
Figure 5.44: Number of Brønsted Acid Sites of fresh Eta alumina, ZSM-5 and Sirolox 40 compared to the spent Eta alumina, ZSM-5 and Siralox 40 at 400 °C	104
Figure 5.45: Simulation of the thermodynamic equilibrium (%) of desired products that can be reached between temperatures of 100 °C to 600 °C. The calculated maximum amount of <i>iso</i> -butene (%) to be obtained at 350 °C is 50%.....	105
Figure 5.46: Selectivity (%) <i>iso</i> -butene obtained at steady state for each experimental run over the three catalysts, compared to theoretical maximum amount of <i>iso</i> -butene that can be obtained (50%, 46% and 44%, respectively)	106
Figure 5.47: Conversion of 1-butene (%) at temperatures of 350 °C, 400 °C and 450 °C using the catalysts Eta alumina, ZSM-5 and Siralox 40 versus time on line.....	106
Figure 5.48: Comparison between carbon content (%) of the three fresh and spent catalysts at temperatures of 350 °C, 400 °C and 450 °C.....	108
Figure 5.49: Comparison between pore volume (cm ³ /g) of three fresh and spent catalysts at temperatures of 350 °C, 400 °C and 450 °C.....	109
Figure 5.50: Comparison between surface area (m ² /g) of three fresh and spent catalysts at temperatures of 350 °C, 400 °C and 450 °C.....	109
Figure 5.51: Comparison of the pore volume (cm ³ /g) between three spent catalysts and the spent catalysts after calcination (AC) at temperatures of 350 °C, 400 °C and 450 °C.....	110
Figure 5.52: Comparison of the surface area (m ² /g) between three spent catalysts and the spent catalysts after calcination (AC) at temperatures of 350 °C, 400 °C and 450 °C.....	110
Figure 6.1: Blank run with 1-hexene (%) as feedstock versus total mass out (gas+liquid) (%) as a function of time on line (hours). The mass balance over the time span is also included.....	112
Figure 6.2: Conversion of 1-hexene (%) versus time on line (hours) during a blank run done at 400 °C	113
Figure 6.3: Conversion of 1-hexene (%) after reaction at temperatures of 350 °C, 400 °C and 450 °C obtained over the Eta alumina catalyst.....	113
Figure 6.4: Conversion of <i>n</i> -hexene (%) after reaction at temperatures of 350 °C, 400 °C and 450 °C obtained over the Eta alumina catalyst.....	114
Figure 6.5: Conversion of <i>n</i> -hexene (%) at steady state versus temperatures of 350 °C, 400 °C and 450 °C obtained over the Eta alumina catalyst.....	114
Figure 6.6: Selectivity (%) based on <i>n</i> -hexene as feedstock, at 350 °C over the Eta alumina catalyst.....	115
Figure 6.7: Selectivity (%) based on <i>n</i> -hexene as feedstock, at 400 °C over the Eta alumina catalyst.....	116
Figure 6.8: Selectivity (%) based on <i>n</i> -hexene as feedstocks, at 450 °C over the Eta alumina catalyst.....	116
Figure 6.9: Selectivity of 2- and 3-hexene (%) as a function of time on line (hours) at temperatures of 350 °C, 400 °C and 450 °C over the Eta alumina catalyst. 2- and 3-hexene formation is indicative of double bond shifts	117

List of Figures Continued

Figure 6.10: Selectivity of compounds $<C_6$ (%) based on <i>n</i> -hexene as a function of time on line (hours) at temperatures of 350 °C, 400 °C and 450 °C over the Eta alumina catalyst. The formation of compounds of fewer than C_6 is indicative of cracking	118
Figure 6.11: Carbon (%) of fresh Eta alumina and spent Eta alumina after reactions at temperatures of 350 °C, 400 °C and 450 °C.....	119
Figure 6.12: Pore volume (cm^3/g) of fresh Eta alumina and spent Eta alumina and pore volume loss (%) of fresh Eta alumina and spent Eta alumina after reactions at temperatures of 350 °C, 400 °C and 450 °C	119
Figure 6.13: Surface area (m^2/g) of fresh Eta alumina and spent Eta alumina and surface area loss (%) of fresh Eta alumina and spent Eta alumina after reactions at temperatures of 350 °C, 400 °C and 450 °C	120
Figure 6.14: Conversion of <i>n</i> -hexene (%) after reaction at temperatures of 350 °C, 400 °C and 450 °C obtained over the Eta alumina catalyst.....	121
Figure 6.15: Conversion of <i>n</i> -hexene (%) at steady state after reaction at temperatures of 350 °C, 400 °C and 450 °C obtained over the ZSM-5 catalyst.....	122
Figure 6.16: Selectivity (%) based on <i>n</i> -hexene as feedstock, at 350 °C over the ZSM-5 catalyst	122
Figure 6.17: Selectivity (%) based on <i>n</i> -hexene as feedstock, at 400 °C over the ZSM-5 catalyst	123
Figure 6.18: Selectivity (%) based on <i>n</i> -hexene as feedstocks, at 450 °C over the ZSM-5 catalyst	123
Figure 6.19: Selectivity of 2- and 3-hexene (%) as a function of time on line (hours) at temperatures of 350 °C, 400 °C and 450 °C over the Eta alumina catalyst. 2- and 3-hexene formation is indicative of double bond shift.....	124
Figure 6.20: Selectivity of compounds $<C_6$ (%) based on <i>n</i> -hexene as a function of time on line (hours) at temperatures of 350 °C, 400 °C and 450 °C over the Eta alumina catalyst. The formation of compounds of fewer than C_6 is indicative of cracking	125
Figure 6.21: Carbon (%) of fresh ZSM-5 and spent ZSM-5 after reactions at temperatures of 350 °C, 400 °C and 450 °C	125
Figure 6.22: Pore volume (cm^3/g) of fresh ZSM-5 and spent ZSM-5 and pore volume loss (%) of fresh ZSM-5 and spent ZSM-5 after reactions at temperatures of 350 °C, 400 °C and 450 °C..	126
Figure 6.23: Surface area (m^2/g) of fresh ZSM-5 and spent ZSM-5 and surface area loss (%) of fresh ZSM-5 and spent ZSM-5 after reactions at temperatures of 350 °C, 400 °C and 450 °C..	126
Figure 6.24: Conversion of <i>n</i> -hexene (%) after reaction at temperatures of 350 °C, 400 °C and 450 °C obtained over the Siralox 40 catalyst, indicating that steady state was obtained.....	127
Figure 6.25: Conversion of <i>n</i> -hexene (%) at steady state after reaction at temperatures of 350 °C, 400 °C and 450 °C obtained over the Siralox catalyst.....	128
Figure 6.26: Selectivity (%) of desired products based on <i>n</i> -hexene obtained at 350 °C over the Siralox 40 catalyst	128
Figure 6.27: Selectivity (%) of desired products based on <i>n</i> -hexene obtained at 400 °C over the Siralox 40 catalyst	129
Figure 6.28: Selectivity (%) of desired products based on <i>n</i> -hexene obtained at 450 °C over the Siralox 40 catalyst	129
Figure 6.29: Selectivity of 2- and 3-hexene (%) based on 1-hexene as a function of time on line (hours) at temperatures of 350 °C, 400 °C and 450 °C over the Siralox 40 catalyst. 2- and 3-hexene formation is indicative of double bond shifts	130
Figure 6.30: Selectivity of compounds $<C_6$ (%) as a function of time on line (hours) at temperatures of 350 °C, 400 °C and 450 °C over the Siralox 40 catalyst. The formation of compounds less than C_6 is indicative of cracking	130
Figure 6.31: Carbon (%) of fresh Siralox 40 and spent Siralox 40 after reactions at temperatures of 350 °C, 400 °C and 450 °C	131
Figure 6.32: Pore volume (cm^3/g) of fresh Siralox 40 and spent Siralox 40 and pore volume loss (%) of fresh Siralox 40 and spent Siralox 40 after reactions at temperatures of 350 °C, 400 °C and 450 °C	132
Figure 6.33: Surface Area (m^2/g) of fresh Siralox 40 and spent Siralox 40 and surface area loss (%) of fresh Siralox 40 and spent Siralox 40 after reactions at temperatures of 350 °C, 400 °C and 450 °C	132
Figure 6.34: Conversion of <i>n</i> -hexene (%) at steady state after reactions at temperatures of 350 °C, 400 °C and 450 °C obtained over the three catalysts.....	133

List of Figures Continued

Figure 6.35: Simulation of the composition (%) of <i>n</i> -hexene and branched C ₆ components indicating the maximum conversion that can be reached between temperatures of 100 °C to 600 °C at thermodynamic equilibrium. The maximum amount of branched isomers (%) to be obtained at 350 °C is approximately 80%.....	134
Figure 6.36: Selectivity (%) based on <i>n</i> -hexene obtained at steady state for each experimental run over the three catalysts, compared to the simulated thermodynamic composition	135
Figure 6.37: Comparison between carbon content (%) of the three fresh and spent catalysts at temperatures of 350 °C, 400 °C and 450 °C.....	135
Figure 6.38: Comparison between pore volume (cm ³ /g) of three fresh and spent catalysts at temperatures of 350 °C, 400 °C and 450 °C.....	136
Figure 6.39: Comparison between surface area (m ² /g) of three fresh and spent catalysts at temperatures of 350 °C, 400 °C and 450 °C.....	136
Figure 7.1: Unspiked liquid reaction product of 1-octene over Siralox 40 catalyst at 350 °C	138
Figure 7.2: 1-Octene added to unspiked reaction product sample	139
Figure 7.3: <i>Trans</i> -2-octene added to unspiked reaction product sample	140
Figure 7.4: <i>Trans</i> -3-octene added to unspiked reaction product sample	142
Figure 7.5: <i>Trans</i> -4-octene added to unspiked reaction product sample	143
Figure 7.6: Identification of compounds with their respective retention times (min) as calculated (Table 7.1)	144
Figure 7.7: Conversion of 1-octene (%) after reaction at temperatures of 350 °C, 400 °C and 450 °C obtained over the Eta alumina catalyst.....	146
Figure 7.8: Selectivity (%) of desired products obtained at 350 °C over the Eta alumina catalyst	147
Figure 7.9: Selectivity (%) of desired products obtained at 400 °C over the Eta alumina catalyst	147
Figure 7.10: Selectivity (%) of desired products obtained at 450 °C over the Eta alumina catalyst	148
Figure 7.11: Carbon (%) of fresh Eta alumina and spent Eta alumina after reactions at temperatures of 350 °C, 400 °C and 450 °C.....	149
Figure 7.12: Pore volume (cm ³ /g) of fresh Eta alumina and spent Eta alumina and pore volume loss (%) of fresh Eta alumina and spent Eta alumina after reactions at temperatures of 350 °C, 400 °C and 450 °C	149
Figure 7.13: Surface area (m ² /g) of fresh Eta alumina and spent Eta alumina and surface area loss (%) of fresh Eta alumina and spent Eta alumina after reactions at temperatures of 350 °C, 400 °C and 450 °C	150
Figure 7.14: Conversion of 1-octene (%) after reaction at temperatures of 350°C, 400°C and 450°C obtained over the ZSM-5 catalyst	150
Figure 7.15: Selectivity (%) of desired products obtained at 350 °C over the ZSM-5 catalyst	151
Figure 7.16: Selectivity (%) of desired products obtained at 400 °C over the ZSM-5 catalyst	152
Figure 7.17: Selectivity (%) of desired products obtained at 450 °C over the ZSM-5 catalyst	152
Figure 7.18: Carbon (%) of fresh ZSM-5 and spent ZSM-5 after reactions at temperatures of 350°C, 400°C and 450°C	153
Figure 7.19: Pore volume (cm ³ /g) of fresh ZSM-5 and spent ZSM-5 and pore volume loss (%) of fresh ZSM-5 and spent ZSM-5 after reactions at temperatures of 350 °C, 400 °C and 450 °C ..	154
Figure 7.20: Surface area (m ² /g) of fresh ZSM-5 and spent ZSM-5 and surface area loss (%) of fresh ZSM-5 and spent ZSM-5 after reactions at temperatures of 350 °C, 400 °C and 450 °C ..	154
Figure 7.21: Conversion of 1-octene (%) after reaction at temperatures of 350 °C, 400 °C and 450 °C obtained over the Siralox 40 catalyst.....	155
Figure 7.22: Selectivity (%) of desired products obtained at 350 °C over the Siralox 40 catalyst	156
Figure 7.23: Selectivity (%) of desired products obtained at 400 °C over the Siralox 40 catalyst	156
Figure 7.24: Selectivity (%) of desired products obtained at 450 °C over the Siralox 40 catalyst	157
Figure 7.25: Carbon (%) of fresh Siralox 40 and spent Siralox 40 after reactions at temperatures of 350 °C, 400 °C and 450 °C.....	158
Figure 7.26: Pore volume (cm ³ /g) of fresh Siralox 40 and spent Siralox 40 and pore volume loss (%) of fresh Siralox 40 and spent Siralox 40 after reactions at temperatures of 350 °C, 400 °C and 450 °C	158
Figure 7.27: Surface area (m ² /g) of fresh Siralox 40 and spent Siralox 40 and surface area loss (%) of fresh and spent Siralox 40 after reactions at temperatures of 350 °C, 400 °C and 450 °C	159

List of Figures Continued

Figure 7.28: Conversion of 1-octene (%) at steady state after reaction at temperatures of 350 °C, 400 °C and 450 °C using the catalysts Eta alumina, ZSM-5 and Siralox 40	159
Figure 7.29: Selectivity (%) obtained at steady state for each experimental run over the three catalysts at temperatures of 350 °C, 400 °C and 450 °C	160
Figure 7.30: Comparison between carbon content (%) of the three fresh and spent catalysts at temperatures of 350 °C, 400 °C and 450 °C.....	161
Figure 7.31: Comparison between pore volume (cm ³ /g) of the three fresh and spent catalysts at temperatures of 350 °C, 400 °C and 450 °C.....	161
Figure 7.32: Comparison between surface area (m ² /g) of the three fresh and spent catalysts at temperatures of 350 °C, 400 °C and 450 °C.....	162
Figure 8.1: Isomerization (%) obtained between the three feeds using the Eta alumina catalyst at temperatures of 350 °C, 400 °C and 450 °C.....	163
Figure 8.2: Isomerization (%) obtained between the three feeds using the ZSM-5 catalyst at temperatures of 350 °C, 400 °C and 450 °C.....	164
Figure 8.3: Isomerization (%) obtained between the three feeds using the Siralox 40 catalyst at temperatures of 350 °C, 400 °C and 450 °C.....	165
Figure 8.4: Cracking (%) between the feeds using the Eta alumina catalyst at temperatures of 350 °C, 400 °C and 450 °C	166
Figure 8.5: Cracking (%) between the feeds using the ZSM-5 catalyst at temperatures of 350 °C, 400 °C and 450 °C	166
Figure 8.6: Cracking (%) between the feeds using the Siralox 40 catalyst at temperatures of 350 °C, 400 °C and 450 °C	167
Figure 8.7: Heavier products (%) between the feeds using the Eta alumina catalyst at temperatures of 350 °C, 400 °C and 450 °C.....	168
Figure 8.8: Heavier products (%) between the feeds using the ZSM-5 catalyst at temperatures of 350 °C, 400 °C and 450 °C	168
Figure 8.9: Heavier products (%) between the feeds using the Siralox 40 catalyst at temperatures of 350 °C, 400 °C and 450 °C	169
Figure 8.10: Comparison of double bond shift (%) between the feeds using the Eta alumina catalyst at temperatures of 350 °C, 400 °C and 450 °C	170
Figure 8.11: Comparison of double bond shift (%) between the feeds using the ZSM-5 catalyst at temperatures of 350 °C, 400 °C and 450 °C.....	171
Figure 8.12: Comparison of double bond shift (%) between the feeds using the Siralox 40 catalyst at temperatures of 350 °C, 400 °C and 450 °C.....	171
Figure 8.13: The catalytic cycle in zeolite catalysis: The zeolite pores are occupied by adsorption from the gas phase, after which the adsorbed species diffuse to the reactive centres [Schuring D., 2002]	172
Figure 8.14: Structure of 1-butene (indicated lengths are in Å)	173
Figure 8.15: Structure of 1-hexene (indicated lengths are in Å)	174
Figure 8.16: Structure of 1-octene (indicated lengths are in Å)	174
Figure 8.17: Structure of <i>iso</i> -butene (indicated lengths are in Å)	175
Figure 8.18: Structure of 3,3-dimethyl-1-butene (indicated lengths are in Å)	176
Figure 8.19: Structure of 2,4,4-trimethyl-2-pentene (indicated lengths are in Å).....	177
Figure 8.20: Structure of 4,4-dimethyl-2-hexene (indicated lengths are in Å)	177
Figure 8.21: Structure of 3-methyl-2-heptene (<i>cis</i>) (indicated lengths are in Å)	178
Figure 8.22: Number of Brønsted Acid Sites of fresh Eta alumina, ZSM-5 and Siralox 40 catalysts	180

List of Tables

Table 1.1	2
Oxygenates for Gasoline [Sheet, 2008]	2
Table 1.2	4
Research Octane Number (RON) and structure of four hydrocarbon compounds.....	4
Table 2.1	7
Gasoline Fuel specifications for South Africa [IFQC, 2012].....	7
Table 2.2	25
Octane numbers of Octene [Berg et al., 1946]	25
Table 2.3	27
Materials tested for Skeletal Isomerization of <i>n</i> -Butene [Houzvicka et al., 1997a].....	27
Table 2.4	28
Reaction and catalyst conditions used [Houzvicka et al., 1997b]	28
Table 2.5	29
Effect of crystal size on activity	29
Table 2.6	29
Differences in fresh and deactivated ZSM type catalysts [Byggningsbacka et al., 1998]	29
Table 2.7	32
Total acidity, expressed as mmol of ammonia per gram of catalyst desorbed within the 403 - 818K temperature range [Escalante et al., 1997].....	32
Table 2.8	33
Typical results of the effect of regenerating of eta and gamma alumina with wet or dry gas [Myers, 1979].	33
Table 2.9	34
The product composition of C ₄ skeletal isomerization for different operating temperature [Lin et al., 1994]	34
Table 2.10	36
Conversion of 1-octene on A-1 to A-4, B-1 to B-4, Al-ZSM-5 and B-MCM-41 catalysts at different temperatures [Sundaramurthy et al., 2003]	36
Table 2.11	38
Acid strength distribution of the potassium modified nanoscale HZSM-5 catalysts [Long et al., 2008b]	38
Table 3.1	45
Chemicals.....	45
Table 4.1	53
Alumina phases present at different temperatures [Bartholomew et al., 2006].	53
Table 4.2	56
Elemental analysis for the fresh catalysts.....	56
Table 4.3	57
Si/Al ratio for the fresh catalysts	57
Table 4.4	59
Number of Brønsted acid sites on the fresh catalysts	59
Table 4.5	67
Fixed Carbon analysis for the fresh catalysts	67
Table 4.6	67
Surface area and pore volume analysis of the fresh catalysts	67
Table 4.7	69
Feed composition of 1-butene	69
Table 4.8	69
Feed composition of 1-hexene.....	69
Table 4.9	70
Feed composition of 1-octene.....	70
Table 5.1	103
Number of Brønsted acid sites on the fresh catalysts [Chapter 4, section 4.3].....	103
Table 5.2	103
Number of Brønsted acid sites on the spent catalysts.....	103
Table 7.1	145
Calculated retention times (min)	145
Table 8.1	175
The estimated molecular volumes, lengths and diameters of feedstock (carbon numbers) used in this study	175

List of Tables Continued

Table 8.2	178
The estimated molecular volumes, lengths and diameters of the largest isomers formed in this study.....	178
Table 8.3	179
Diameter of the pores of the fresh catalysts used in this study	179

List of Schemes

Scheme 1.1: Typical dimerization and hydrogenation routes with and without skeletal isomerization	5
Scheme 2.1: Olefin isomerization showing double bond movement (a) and chain isomerization (b)	19
Scheme 2.2: A monomolecular rearrangement of butenes through a protonated cyclopropane intermediate [Domokos, 2002 and De Klerk, 2008]	20
Scheme 2.3: Classical bimolecular mechanism involving dimerization, isomerization and cracking [van Donk, 2002]	21
Scheme 2.4: Co-dimerization mechanism involving cracking [van Donk, 2002].	21
Scheme 2.5: Catalytic cycle in pseudo-monomolecular pathway [Domokos, 2002 and de Klerk, 2008]	22
Scheme 2.6: Reaction network of olefin reaction over acid catalyst [de Klerk, 2006]	23
Scheme 5.1: Isomerization of butene [Choudhary, 1974].....	73
Scheme 5.2: Reaction from 1-butene to butane	77
Scheme 5.3: Reaction from 1-butene to butane and 1,3-butadiene	78
Scheme 5.4: Reaction from 1-butene to butane, propene and coke	78
Scheme 5.5: Reaction mechanism for C_4^- isomerization	80
Scheme 5.6: Formation of ether as a secondary and tertiary carbenium ion [de Klerk, 2008].....	83
Scheme 5.7: Isomerization of butene and formation of C_5^+ compounds	86
Scheme 5.8: Reaction from 1-butene to butane	90
Scheme 6.1: Double bond shift from 1-hexene to 2- and 3-hexene	117
Scheme 6.2: Reaction indicating double bond shift, branched C_6 and other components occurring fast on the ZSM-5 catalyst	124

Abbreviations

AC	After calcination
Al	Aluminium
Al ₂ O ₃ / SiO ₂	Aluminium oxide to silica oxide
AlO (OH)	Boehmite
AlOH	Aluminium hydroxide
Å	Angstroms
Atm	Atmosphere/Atmospheric
Aux	Auxiliary
B	Boron
BET	Brunauer, Emmett and Teller
β-scission	Beta-scission
C	Cracks
Ca	Calcium
Cat/CAT	Catalyst
cm	Centimetre
cm ⁻¹	Reciprocal centimetre
cm ³ /g	Cubic centimetre to gram
CO	Carbon monoxide
CoAPO	Cobalt supported aluminophosphate
CFR	Cooperative Fuel Research
C _(s)	Solid coke
°C	Degree Celcius
°C/min	Degree Celcius per minute
D	Dimerize
Dim.	Dimension
dp	Particle size
DRIFT	Diffuse Reflectance Infrared Fourier Transform
DV	Dual View
e.g.	<i>exempli gratia for example</i>
EN	European National
et al.	<i>et alibi and elsewhere</i>
η – Al ₂ O ₃	Eta-alumina
ETBE	Ethyl Tertiary Butyl Ether
etc.	<i>et cetera and so forth</i>
FCC	Fluid Catalytic Cracker
Fe	Iron
FID	Flame Ionization Detector
FT	Fischer–Tropsch
g	Gram
Ga	Gallium
GC	Gas Chromatography
GC-FID	Gas Chromatography – Flame Ionization Detector
GC-MS	Gas Chromatography – Mass Spectrometer
GC-RGA	Gas Chromatography – Refinery Gas Analysis
H ⁻	Hydride
h ⁻¹	Reciprocal hour

H ₂	Hydrogen
H ₂ O	Water
He	Helium
H _o	Indicates acid strength
HC	Hydrocarbons
HPLC	High Performance Liquid Chromatography
HTFT	High-Temperature Fischer-Tropsch
I	Isomerization
ICP	Inductively Coupled Plasma Analysis
i.e.	Id est <i>for that is</i>
<i>i</i> -Paraffins	<i>Iso</i> -Paraffins
K	Kelvin
K	Potassium
kg	Kilogram
kPa	Kilopascal
L/Dp	Length to particle size ratio
L/h	Litres per hour
LHSV	Liquid Hour Space Velocity
LPG	Liquefied petroleum gas
LTFT	Low-Temperature Fischer-Tropsch
Mass %	Mass percentage
max.	Maximum
m ² /g	Square meter per gram
MCT	Mercury Cadmium Telluride
MFI	Mordenite framework inverted
mg	Milligram
Mg	Magnesium
MgAPSO	Magnesium supported silicoaluminophosphate
Mg/kg	Milligram per kilogram
min.	Minimum
min	Minute
ml	Millilitre
ml/min	Millilitre per minute
mm	Millimetre
mmol	Milli-mole
MnAPO	Manganese supported aluminophosphate
Mo	Molybdenum
Mol %	Mole percentage
MON	Motor Octane Number
MPa	Mega Pascal
MS	Mass Spectrometer
MSD	Mass Spectrometer Detector
MSDS	Material Safety Data Sheets
MTBE	Methyl Tertiary Butyl Ether
N ₂	Nitrogen
Na	Sodium
NH ₃	Ammonia
Ni	Nickel
nm	Nanometer
NO _x	Nitrogen Oxides
<i>n</i> -Paraffins	Normal Paraffins
NRTL	Non Random To Liquid
NV	Needle valve

O ₂	Oxygen
OH	Hydroxide
OMe	Ether
P	Phosphorus
PI	Pressure Indicator
ppm m/m	parts per million mass to mass
PSRK	Predictive Redich-Kwong-Soave
Pt	Platinum
PV	Pore Volume
%	Percent
R	Alkyl group
R16	Reactor 16
RGA	Refinery Gas Analysis
RON	Research Octane Number
Rpm	Revolution per minute
RVP	Reid vapour pressure
rxn	Reaction
S/SL	Split/Splitless
SA	Surface Area
SAPO	Silicoaluminophosphate
SAPIA	South African Petroleum Industry Association
SA/V	Surface Area to Volume Ratio
Si	Silica
Si/Al	Silica to Alumina Ratio
SiC	Silicon Carbide
SiO ₂ /B ₂ O ₃	Silica oxide to boron oxide
SiO ₂ /Al ₂ O ₃	Silica oxide to aluminium oxide
SLO	Stabilised Light Oil
SPA	Solid Phosphoric Acid
STP	Standard Temperature and Pressure
TAE	Tertiary Amyl Ethyl Ether
TAME	Tertiary Amyl Methyl Ether
TCD	Thermal Conductivity Detector
Temp.	Temperature
TGA	Thermal Gravimetric Analysis
θ- Al ₂ O ₃	Theta alumina
TMP	Trimethylphosphite
TPD	Temperature Programmed Desorption
μl	Micro-litres
μm	Micro-meter
μmole	Micro-mole
U.O.P	Universal Oil Products
US	United States
USA	United States of America
V	Valve
VICI	Valco Instruments Corporation Incorporated
vol%	Volume Percent
WHSV	Weight Hourly Space Velocity
Wt%	Weight percentage
XRD	X-Ray Diffraction Analysis

γ -Al₂O₃

Zn

ZnS

Zn/SAPO

ZSM

Gamma-Alumina

Zinc

Zinc sulphide

Zinc supported Silicoaluminophosphate

Zeolite Socony Mobil

Abstract

Stringent standards to improve air quality and to protect human health are continuously implemented due to the environmental impact of auto emissions. As a result, researching options for alternative components or alternative processes are very important to continuously improve the octane number in the fuel pool.

Therefore, by exploiting the high olefin (butene, hexene and octene) content part of the feedstocks, the overall aim of this study was to obtain olefin skeletal isomerization for the improvement of the RON in the refinery fuel pool. The influence of temperature variation (350 °C, 400 °C and 450 °C) on the performance of the different alumina catalysts (eta (η)-alumina, H-ZSM-5 and silicated alumina) was investigated. All experiments were performed using a fixed bed reactor at atmospheric pressure and a constant weight hourly space velocity of 5 h⁻¹. The effect of the different conditions and additions on conversion and selectivity was determined.

Eta alumina and the silicated alumina (Siralox 40) were proved to be the catalysts that were most prone to cause skeletal isomerization when in contact with longer carbon chains. Butene did not isomerize to a significant extent when contacted over either Eta alumina or Siralox 40. In the case of the zeolite catalyst (ZSM-5), none of the feeds isomerized and it was speculated that it could have been due to the high activity of ZSM-5 which made this catalyst more likely to cause side reactions rather than the preferred skeletal isomerization reaction.

Opsomming

As gevolg van die omgewingsimpak van voertuiguitlaatgasse word strenger brandstofstandaarde deurgaans ingestel om lugkwaliteit te verbeter en gesondheid te beskerm. Navorsing spruit uit die strenger ingestelde standaarde om alternatiewe opsies aan die besigheidseenhede te bied. Hierdie alternatiewe sluit moontlike veranderinge in voerstroombestanddeel in. Navorsing word gebou op die omskakeling van komponente na ander funksionele groepe in die voerstroombestanddeel.

Die vooraggaande alternatiewe word beklemtoon vir die omskakeling van sekere lae oktaan voerstroombestanddeel na hoë oktaan komponente vir die verkryging van oktaan getal in die totale brandstof opbrengs vanuit die raffinadery. Die oorkoepelende tema vir hierdie studie is; olefien isomerisasie van buteen, hekseen en okteen. Die teenwoordigheid van die komponente in die geselekteerde geraffineerde produkte word geteiken waar omskakeling bewerkstellig word vir die verkryging van hoë oktaan komponente. Alle eksperimente is uitgevoer deur gebruik te maak van 'n statiese bed reaktor by atmosferiese druk en 'n konstante reagensvoer snelheid van 5 h^{-1} . Die invloed van temperatuurverandering (350°C , 400°C en 450°C) op die verskillende alumina kataliste (eta (η)-alumina, H-ZSM-5 en silicated alumina), insluitend selektiwiteit en omskakeling van die verskillende kataliste was ondersoek.

Eta alumina en die silika alumina (Siralox 40) het getoon vanuit die eksperimentele resultate, die katalisators wat die meeste geneig was tot skeletale isomerisasie wanneer in kontak met langer koolstofkettings. Buteen het tot 'n groot mate nie ge-isomeriseer wanneer dit in kontak was met Eta alumina en Siralox 40 nie. In die geval van die zeoliet katalisator (ZSM-5), het nie een van die voere ge-isomeriseer nie en die hipotese wat gedeeltelik aanspreeklik vir die bevinding aangevoer kan word is dat ZSM-5 'n hoë aktiwiteit onder beryfskondisies het en dus meer geneig was om nuwe-reaksies eerder as skeletale isomerisasie teweeg te bring.

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