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MAATSCHAPPIJ B.V. [NL/NL]; Carel van Bylandtlaan
30, NL-2596 HR The Hague (NL).Published:
— With international search report.(72) Inventors: BLACKBOURN, Robert, Lawrence; 16410
Battlecreek Drive, Houston, TX 77095 (US). MULLIN,
Stephen, Blake; 18318 Autumn Trails, Katy, TX 77449
(US). POWELL, Joseph, Brown; 10506 Normont Drive,
Houston, TX 77070 (US). WEIDER, Paul, Richard;
15014 Tramore, Houston, TX 77083 (US).(48) Date of publication of this corrected version:
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ance Notes on Codes and Abbreviations" appearing at the begin-
ning of each regular issue of the PCT Gazette.(54) Title: PROCESS FOR REMOVING A COBALT OR RHODIUM CARBONYL COMPOUND FROM AN AQUEOUS 3-HY-
DROXYPROPANAL SOLUTION

(57) Abstract: Cobalt or rhodium carbonyl compounds are removed from an aqueous solution of 3-hydroxypropanal by a process comprising the steps of: (a) contacting the 3-hydroxypropanal solution with oxygen under acidic conditions at a temperature within the range of about 5 to about 45 °C to produce an oxidation product mixture comprising an aqueous solution of 3-hydroxypropanal, one or more water-soluble cobalt or rhodium species, and byproduct carbon monoxide; (b) removing byproduct carbon monoxide from the oxidation product mixture as it is generated; and (c) passing the oxidation product mixture in contact with an acidic ion exchange resin maintained at a temperature less than about 45 °C and removing at least a portion of the soluble metal compounds from the oxidation product mixture. Such a process is useful in, for example, the manufacture of 1,3-propanediol from ethylene oxide via an intermediate 3-hydroxypropanal solution containing residual carbon dioxide and insoluble cobalt or rhodium catalyst compounds.

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