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(71) Applicant: **DOW GLOBAL TECHNOLOGIES LLC**
[US/US]; 2040 Dow Center, Midland, Michigan 48674
(US).

(72) Inventors: **GOODMAN, Amanda M.**; 230 Abner Jackson
Pkwy, Lake Jackson, Texas 77566 (US). **ZENG, Jianping**;

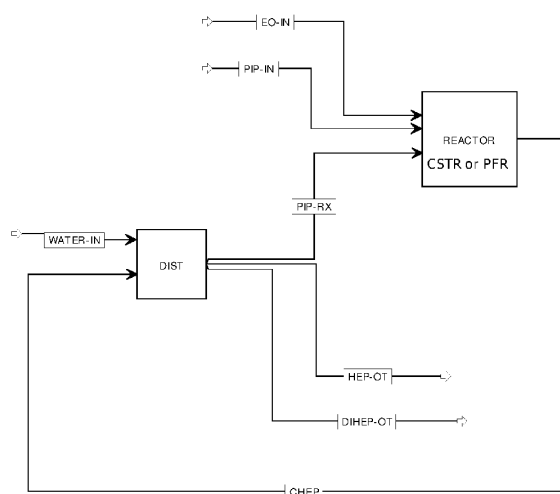
230 Abner Jackson Pkwy, Lake Jackson, Texas 77566 (US).
ARCHER, Barry; 230 Abner Jackson Pkwy, Lake Jackson,
Texas 77566 (US). **LAROCHE, Christophe R.**; 230
Abner Jackson Pkwy, Lake Jackson, Texas 77566 (US).

(74) Agent: **THEKDI, Amy**; The Dow Chemical Company,
Intellectual Property, P.O. Box 1967, Midland, Michigan
48641-1967 (US).

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(54) Title: PRODUCTION OF HYDROXYETHYLPIPERAZINE

FIG. 1



(57) Abstract: Embodiments relate to a continuous process for the production of hydroxyethylpiperazine that includes feeding neat piperazine, recycled piperazine, and ethylene oxide to a reactor to form crude hydroxyethylpiperazine, in which the reactor is a continuous stirred tank reactor or a plug flow reactor. The process further includes continuously feeding the crude hydroxyethylpiperazine from the reactor to a distillation system that includes at least one distillation column, the distillation system produces at least a recycled piperazine stream and a hydroxyethylpiperazine stream, the recycled piperazine stream includes the recycled piperazine that is fed to the reactor to form the crude hydroxyethylpiperazine, and the hydroxyethylpiperazine stream includes at least 60 wt% of hydroxyethylpiperazine based on a total weight of the hydroxyethylpiperazine stream.

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