

PROCESS FOR PRODUCING MOLECULAR SIEVE MATERIALS

PRIORITY CLAIM

5 [0001] This application claims the benefit of and priority to Provisional patent application No. 61/475,688, filed April 15, 2011, and European Application No. 11171342.6, filed June 24, 2011.

FIELD OF THE INVENTION

[0002] This disclosure relates to a process for producing molecular sieve materials.

BACKGROUND OF THE INVENTION

10 [0003] Molecular sieve materials, both natural and synthetic, have been demonstrated to have catalytic properties for various types of hydrocarbon conversion. Examples of molecular sieve materials include zeolites, SAPOs, AIPOs, and mesoporous materials. Typically molecular sieve materials are ordered, porous crystalline compositions having a definite crystalline structure as evidenced by their X-ray diffraction pattern. The pores in
15 crystalline molecular sieve materials may vary in cross sectional dimensions from about 2 Å to about 1000 Å.

[0004] One particularly important class of molecular sieve materials are the aluminosilicate zeolites, which are described in "Atlas of Zeolite Framework Types", eds. W. H. Meier, D. H. Olson and Ch. Baerlocher, Elsevier, Fifth Edition, 2001, which is hereby
20 incorporated by reference. Such zeolites generally are generally described as microporous materials in that they have a pore size between about 2 and about 13 Å and are usually subdivided into large, medium and small pore materials. A large pore zeolite generally has a pore size of at least about 7 Å and includes LTL, VFI, MAZ, FAU, OFF, BEA, and MOR framework type zeolites (IUPAC Commission of Zeolite Nomenclature). Examples of large
25 pore zeolites include mazzite, offretite, zeolite L, VPI-5, zeolite Y, zeolite X, omega, and Beta. An intermediate pore size zeolite generally has a pore size from about 5 Å to less than about 7 Å and includes, for example, MFI, MEL, EUO, MTT, MFS, AEL, AFO, HEU, FER, MWW, and TON framework type zeolites (IUPAC Commission of Zeolite Nomenclature). Examples of intermediate pore size zeolites include ZSM-5, ZSM-11, ZSM-22, MCM-22,
30 silicalite 1, and silicalite 2. A small pore size zeolite has a pore size from about 3 Å to less than about 5.0 Å and includes, for example, CHA, ERI, KFI, LEV, SOD, and LTA framework type zeolites (IUPAC Commission of Zeolite Nomenclature). Examples of small

pore zeolites include ZK-4, ZSM-2, SAPO-34, SAPO-35, ZK-14, SAPO-42, ZK-21, ZK-22, ZK-5, ZK-20, zeolite A, chabazite, zeolite T, gmelinite, ALPO-17, and clinoptilolite.

[0005] In addition to the microporous zeolites, another class of molecular sieve materials of increasing importance is the mesoporous materials, which typically have a pore diameter within the range of from about 13 Angstroms to about 200 Angstroms. Among this broad class of molecular sieve materials, particular attention has been focused on a family of materials, the M41S materials, which are similar to zeolites in that they have pores of uniform, albeit in the mesoporous range. The M41S family of mesoporous molecular sieves is described in *J. Amer. Chem. Soc.*, 1992, 114, 10834.

[0006] Synthetic molecular sieves are often prepared from aqueous reaction mixtures (synthesis mixtures) comprising sources of appropriate oxides. Organic directing agents (also referred to as structure directing agents or templates) may also be included in the synthesis mixture for the purpose of influencing the crystallization of a molecular sieve having the desired structure. The use of such directing agents is discussed in an article by Lok et al., entitled "The Role of Organic Molecules in Molecular Sieve Synthesis" appearing in *Zeolites*, Vol. 3, October, 1983, pp. 282-291.

[0007] After the components of the synthesis mixture are properly mixed with one another, the synthesis mixture is subjected to appropriate crystallization conditions, such as for example in an autoclave. Such conditions usually involve heating of the synthesis mixture to an elevated temperature possibly with stirring, and possibly under pressure. When crystallization of the synthesis mixture is complete, the crystalline product is recovered from the remainder of the synthesis mixture and especially the liquid contents thereof. Such recovery may involve filtering the crystals and washing the crystals to remove the mother liquor and other residual synthesis mixture components. The crystals are then normally dried and subjected to high temperature calcination, e.g., at 540°C, particularly to remove any organic directing agent which may otherwise block the pores of the molecular sieve.

[0008] Synthetic molecular sieves are expensive, in part, because their production can generate wastewater streams from crystallization and post-crystallization treatment that contain organic directing agents, e.g., surfactants, which are expensive to remediate. Thus, a need exists for a highly efficient process of manufacturing molecular sieves which reduces both the amount of water used and wastewater produced. This disclosure provides a process of manufacturing molecular sieves from forming mixtures of high solids content, using a reactor having a high intensity mixer. In some cases, the process does not require filtering

the reaction mixture after crystallization or washing the molecular sieve product before calcinations. Accordingly, the process combines the advantages of reduced cost, shorter crystallization time and higher yield with the minimization of wastewater generated during the molecular sieve manufacture.

5 [0009] WO 2005/066068 discloses a continuous or semi-continuous process for the hydrothermal manufacture of a microporous or mesoporous composition comprising feeding solid and liquid reagents into a heated reactor zone at a temperature between 200°C and 500°C with a residence time less than 24 hours wherein said solid reagents have a weight percent between 45% and 98% of said reagents. In the Examples, the solid and liquid
10 reagents are generally mixed in a mixing device and then transferred to a separate reactor for hydrothermal crystallization.

[0010] WO 2009/055215 teaches making M41S materials from mixtures having a high solids content (20% to 50 wt% solids) by a process that allows the M41S product to be recovered without a purification step (filtration and/or washing). Crystallization can be
15 carried out under static or agitated conditions in a conventional autoclave. However, this document does not disclose or suggest the use of a reactor capable of high intensity mixing to carry out molecular sieve crystallization. Moreover, in the Examples, crystallization is conducted without stirring on reaction mixtures which are apparently prepared outside the autoclave.

20 [0011] U.S. 6,664,352 to Fredriksen teaches preparing metallocene catalysts by mixing catalyst and porous particulate support in a mechanically fluidized state with a catalyst material. The process uses a mixer having horizontal axis counter-rotating interlocking mixing paddles where paddles on different but preferably parallel rotational axes pass through a common mixing zone. The mixer can have a Froude number of from 1.05 to 2.2.
25 No suggestion or disclosure is made for using this mixer in the crystallization of molecular sieves.

[0012] U.S. 6,521,585 to Yamashita et al. discloses the production of crystalline alkali metal silicate granules which are stably formulated in detergents. Temperature-controllable agitating mixers carry out mixing of the crystalline alkali metal silicate with detergent at a
30 Froude number of 1 to 12 to control particle size distribution of granules. Mixers include horizontal, cylindrical blending vessels having agitating impellers on an agitating shaft.

[0013] Various mixers useful to mix slurries, pastes, and plastic bodies are described in "Principles of Ceramics Processing", Second Edition, James S. Reed, John Wiley & Sons, Inc., 1995, pp. 347-354.

5 **SUMMARY OF THE INVENTION**

[0014] In one aspect, the invention resides in a process for producing a molecular sieve material, said process comprising the steps:

(a) mixing water, at least one source of an oxide of a tetravalent and/or a trivalent element and at least one structure directing agent in a reactor equipped with a mixer having a
10 Froude number of at least 1, to produce a molecular sieve synthesis mixture having a solids content of at least 20 wt%;

(b) heating the molecular sieve synthesis mixture in the reactor while agitating the mixture with said mixer to form crystals of said molecular sieve material; and then

(c) recovering the molecular sieve crystals from the reactor.

15 [0015] Conveniently, said mixing produces a synthesis mixture having a solids content of about 20 wt% to about 50 wt%.

[0016] In one embodiment, the process further comprises the step:

(d) prior to recovering the molecular sieve crystals from the reactor, removing water from the mixture in said reactor by the application of heat and/or reduced pressure
20 while agitating the mixture with the mixer so as to decrease the water content of mixture inside the reactor by at least 5 wt% and produce a partially dried mixture.

[0017] Conveniently, said removing step (d) is conducted after formation of the crystals of said molecular sieve material in step (b).

[0018] Conveniently, the process further comprises the step:

25 (e) mixing said partially dried mixture with an additional particulate material, either in the reactor or in a separate mixer, to produce a product mixture.

[0019] Conveniently, said additional particulate material is a catalyst formulation component, such as a binder or matrix material.

[0020] Conveniently, the process further comprises extruding said recovered product
30 mixture into a shaped body.

[0021] Conveniently, the process further comprises calcining the recovered molecular sieve crystals without subjecting the crystals to an initial filtration and/or washing step.

[0022] In one embodiment, the reactor has a capacity of at least 5 liters, such as at least 20 liters, for example at least 200 liters.

[0023] In one embodiment, the mixer comprises at least one blade located on a shaft rotatable about an axis oriented at no more than 10° from horizontal.

[0024] Conveniently, the molecular sieve material comprises ZSM-5 or MCM-41.

BRIEF DESCRIPTION OF THE DRAWINGS

[0025] Figures 1 and 2 show a 5 gallon commercial pilot-scale horizontal plough shear mixer/dryer/reactor having a top mount charge opening used in the synthesis process of the Examples.

[0026] Figure 3 is an X-ray diffraction (XRD) pattern of the as-synthesized ZSM-5 material from Example 1.

[0027] Figure 4 is a scanning electron micrograph (SEM) of the as-synthesized ZSM-5 material of Example 1.

[0028] Figure 5 is an X-ray diffraction (XRD) pattern of the as-synthesized ZSM-5 material from Example 2.

[0029] Figure 6 is a scanning electron micrograph (SEM) of the as-synthesized ZSM-5 material of Example 2.

[0030] Figure 7 is an X-ray diffraction (XRD) pattern of the as-synthesized Si-MCM-41 material from Example 3.

[0031] Figure 8 is an X-ray diffraction (XRD) pattern of the as-synthesized Al-MCM-41 material of Example 5.

DETAILED DESCRIPTION OF THE EMBODIMENTS

[0032] Described herein is a process for producing microporous and mesoporous molecular sieve materials in which an aqueous synthesis mixture having a high solids content of at least 20 wt% is produced and crystallized under agitation in the same reactor equipped with a high-intensity mixer capable of operating at a Froude number of at least 1, such as from 1 to 12, for example from 2 to 10. In this process, the Froude number of an impeller of a high-speed mixer is used as a measure of the resistance of the impeller moving through a fluid medium. In this respect, the Froude number (Fr) of a mixer having an impeller of diameter (d) in meters and rotating at N revolutions per second is defined by the following equation:

$$Fr = N^2 d / g$$

where g is acceleration due to gravity (9.81 m/s^2). Conveniently, the reactor employed in the present process is configured so that the impeller of the high-intensity mixer is mounted on a shaft rotatable about an axis oriented at no more than 10° from horizontal. Typically, the reactor has a length to diameter ratio greater than 0.75, for example greater than 1.0, such as
 5 greater than 1.5 and a capacity of at least 5 liters, such as at least 20 liters, for example at least 200 liters.

[0033] The synthesis mixture used in the present process is produced by adding water, at least one source of an oxide of a tetravalent element (X) and/or a trivalent element (Y), at least one structure directing agent and generally a source of an alkali metal or alkaline earth
 10 metal compound M to the reactor. The contents of the reactor are then mixed using the high-intensity mixer until a homogeneous slurry having the desired solids content is produced. Typically, mixing is effected at a temperature of about 20°C to about 50°C for a time of about 30 minutes to about 2 hours.

[0034] Generally, the synthesis mixture has a solids content of at least 20 wt%, such as
 15 from about 20 wt% to about 50 wt%, preferably at least 25 wt%, such as from about 25 wt% to about 45 wt%, and most preferably at least 30 wt%, such as from about 30 wt% to about 40 wt%. As used herein, the term "solids content" is defined as the percentage by weight of the tetravalent and trivalent element oxides to the total weight of the synthesis mixture (excluding any seeds) and is calculated as follows:

20

$$\text{Solids content} = \frac{\text{weight of oxides in synthesis mixture} \times 100}{\text{Total weight of synthesis mixture}}$$

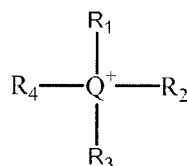
[0035] Typically, the reaction mixture has an apparent viscosity of at least 10^5 MPa sec , such as about 10^6 to about 10^9 MPa sec .

[0036] Examples of suitable oxides of tetravalent elements that can be included in the
 25 synthesis mixture include oxides of silicon, germanium, and tin, with silicon being preferred. Suitable sources of silicon oxides include colloidal silica, precipitated silica, potassium silicate, sodium silicate, and fumed silica. Preferred sources of silica include those containing at least about 30 wt% solid silica, e.g., silica sold by Evonik Degussa under the trade names Aerosil, Ultrasil or Sipernat (a precipitated, spray dried silica containing about
 30 90 wt% silica) and silica sold under the trade name Ludox (available from Grace Davison), or

HiSil (a precipitated hydrated SiO₂ containing about 87 wt% silica, available from PPG Industries).

[0037] Examples of suitable oxides of trivalent elements that can be included in the synthesis mixture include oxides of aluminum, boron, iron, and/or gallium, especially aluminum. Suitable sources of alumina include hydrated aluminum oxides, such as boehmite, gibbsite, and pseudoboehmite, sodium aluminate and oxygen-containing aluminum salts, such as aluminum nitrate.

[0038] The synthesis mixture also includes at least one structure directing agent effective under the crystallization conditions to direct the synthesis of the desired molecular sieve composition. The particular structure directing agent employed, which is normally an organic nitrogen or phosphorus compound, will therefore depend on the target molecular sieve. In one preferred embodiment, where the target molecular sieve is ZSM-5, the directing agent may include an amino acid, such as glutamic acid, a tetrapropylammonium compound, a dimethylethylpropylammonium compound, 1,2-diaminocyclohexane, an ethanoltripropylammonium compound, an alkyldiamines, 1,6-hexanediol, poly(ethylene glycol), triethylene-tetramine and a primary monoalkylamine having 2 to 9 carbon atoms in the alkyl portion, particularly n-propylamine (n-PA). In a further preferred embodiment, where the target molecular sieve is MCM-41, the directing agent may include a quaternary ammonium or phosphonium ion of the formula:



wherein Q is nitrogen or phosphorus and wherein at least one of R₁, R₂, R₃, and/or R₄ is aryl or alkyl having from 6 to about 36 carbon atoms, preferably wherein at least one of R₁, R₂, R₃, and/or R₄ comprises -C₆H₁₃, -C₁₀H₂₁, -C₁₆H₃₃, -C₁₈H₃₇, or combinations comprising at least one of the foregoing. The remainder of R₁, R₂, R₃, and/or R₄ preferably comprises hydrogen, alkyl of from 1 to 5 carbon atoms, and combinations comprising at least one of the foregoing. Conveniently, the quaternary ammonium or phosphonium ion is derived from the corresponding hydroxide, halide, or silicate.

[0039] The relative amounts of water, tetravalent and/or trivalent element oxide and structure directing agent added to the reactor to form the synthesis mixture will also vary in known manner according to the target molecular sieve. Thus, in said one preferred

embodiment, where the target molecular sieve is ZSM-5, the synthesis mixture will typically have the following molar composition, where R designates the organic directing agent:

Molar Ratio	Broad	Preferred
OH ⁻ /SiO ₂	0.05 – 0.5	0.1 – 0.3
R/SiO ₂	0.05 – 1.00	0.10 – 0.30
H ₂ O/SiO ₂	2 - 30	5 - 15
SiO ₂ /Al ₂ O ₃	20 - 500	20 - 150
M/SiO ₂	0.05 – 0.5	0.1 – 0.3

- 5 **[0040]** Similarly, in said further preferred embodiment, where the target molecular sieve is MCM-41, the synthesis mixture will typically have the following molar composition, where R again designates the organic directing agent:

Molar Ratio	Broad	Preferred
Al ₂ O ₃ /SiO ₂	0 to 0.5	0.001 to 0.05
H ₂ O/SiO ₂	2 to 10	4 to 8
OH ⁻ /SiO ₂	0 to 10	0.05 to 5
M _{2/e} O/(SiO ₂ + Al ₂ O ₃)	0 to 5	0.005 to 3
R ₂ O/(SiO ₂ + Al ₂ O ₃)	0.01 to 2.0	0.03 to 1.0

where e is the valence of the metal M.

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[0041] To facilitate crystallization process, the synthesis mixture may contain seeds, typically seeds of the target molecular sieve, in amount sufficient to provide at least 500 ppm, for example at least 1,000 ppm, such as at least 10,000 ppm seeds by weight of the overall synthesis mixture.

- 15 **[0042]** When the formation of the synthesis mixture is complete, the temperature of the mixture in the reactor is raised to the desired crystallization temperature, generally in the range of about 80°C to about 200°C, such as from about 100°C to about 160°C, and maintained at this temperature for about 6 to about 150 hours, such as about 12 to about 72 hours. During the crystallization process, the synthesis mixture is continuously agitated with
 20 the high intensity mixer. In addition, the reactor is normally sealed during the crystallization process so that there is an autogenous rise in pressure in the reactor during the process.

[0043] Especially in the synthesis of mesoporous molecular sieves, such as MCM-41, it may be desirable, during or, more preferably, after the crystallization process to remove at least part of the water from the synthesis mixture. Typically, such water is removed by either the application of heat to the mixture or by reducing the pressure in the reactor, while continuing to agitate the mixture with the high intensity mixer. Water removal is generally continued until the water content of the mixture has been decreased by at least 5 wt%, such as by at least 10%, for example from about 10 to about 20 wt%. The excess water is removed prior to recovering the molecular sieve crystals from the reactor. By removing the excess water, the partially dried molecular sieve crystals can be recovered from the reactor and then subjected to calcination to remove the organic directing agent without an initial filtration or washing step.

[0044] Alternatively, when crystallization is complete and the mixture in the reactor has been partially dried, it may also be desirable to add an additional particulate material to the reactor and then employ the high intensity mixer to admix the additional particulate material with the crystalline molecular sieve and the mother liquor remaining after the drying process. For example, the additional particulate material could be a catalyst formulation component, such as a binder or matrix material, in which case the product mixture recovered from the reactor after addition of the additional particulate material could be extruded into a shaped catalyst body. After calcination to remove the organic directing agent and, if necessary ammonium exchange/calcination to convert the molecular sieve to the hydrogen form, the shaped body could be used directly as a catalyst in an organic conversion reaction.

[0045] As a further alternative, after crystallization and partial drying, the product mixture can be removed from the reactor and mixed with the additional particulate material, such as a binder or matrix material, in a separate mixer before being extruded into a shaped catalyst body.

[0046] The invention will now be more particularly described with reference to the following non-limiting Examples and the accompanying drawings.

[0047] In the Examples, the XRD diffraction patterns of the as-synthesized materials were recorded on a Bruker D4 X-Ray Powder Diffractometer using copper K α radiation in the 2 θ range of 2 to 40 degrees.

[0048] The SEM images were obtained on a HITACHI S4800 Field Emission Scanning Electron Microscope (SEM).

[0049] The BET surface area was measured by Micromeritics TriStar 3000 V6.05A (Micromeritics Corporation, Norcross, GA) with sample pretreated at 350°C in air.

[0050] The reactor employed in the Examples is depicted in Figures 1 and 2 and comprises a 5 gallon commercial pilot-scale horizontal plough shear mixer/dryer, M/DVT-22 Lab Mixer available from Littleford, Day, Inc. of Florence, Kentucky, USA. The reactor comprises a horizontal cylinder having a length of about 10 inch (25.4 cm) and a diameter of about 12 inch (30 cm). The reactor has a top mounted charge opening and a bottom mounted discharge opening, both of which can be sealed during operation of the reactor. Mounted within the reactor is a horizontally disposed rotatable shaft which, as shown in Figure 2, supports four internal heat-transfer plough blades. Each plough blade is V-shaped so that, as it rotates, it splits the reaction mixture into separate streams and lifts and rolls the split streams on either side of the blade, resulting in efficient mixing of even high viscosity slurries. The vessel is jacketed and can be sealed, pressurized, and heated with hot water or steam. The vessel can be equipped with a condenser to remove and condense off-gas from the vessel that is produced during the drying process.

Example 1

[0051] A reaction mixture with about 20 wt% solids was prepared from 10480 g of deionized water, 370 g of 50 wt% NaOH aqueous solution, 611 g of 45 wt% sodium aluminate solution, 365 g of n-propyl amine 100% solution, 30 g of ZSM-5 seed crystals and 3082 g of Sipernat silica (a precipitated silica powder from Evonik Degussa). The components of the mixture were charged directly into the mixer/dryer shown in Figure 1 and mixed with the mixer rotating at 220 rpm for about 20 minutes. The resultant mixture had an apparent viscosity greater than 10^6 MPa x sec and the following molar composition:

	$\text{SiO}_2/\text{Al}_2\text{O}_3$	~ 30
25	$\text{H}_2\text{O}/\text{SiO}_2$	~ 13
	OH/SiO_2	~ 0.18
	Na/SiO_2	~ 0.18
	n-PA/Si	~ 0.13

[0052] The mixture was then reacted at 280°F (138°C) with stirring at 220 rpm for 24 hours. The resulting reaction slurry was discharged and stored in a five gallon container. The XRD pattern of the as-synthesized material (Figure 3) showed the typical pure phase of ZSM-5 topology. The SEM of the as-synthesized material (Figure 4) shows that the material was composed of agglomerates of small crystals of about 0.05 micron in diameter. The Si/Al₂

ratio of the resultant crystals was about 24.5/1. The crystals were washed, dried, and then calcined in air at 1000°F (540°C) for four hours and then converted into the hydrogen form by ion-exchanging with ammonium nitrate solution at room temperature, followed by drying at 250°F (120°C) and calcination at 1000°F (540°C) for four hours. The resulting product had an alpha value of about 1500, surface area of 435 m²/g [360 mg/g (micro pore surface area) + 75 mg/g (external surface area)], and 2,2-DMB sorbate diffusivity $D/r^2 = 39000$.

Example 2

[0053] A reaction mixture with about 25 wt% solids was prepared from 9415 g of deionized water, 463 g of 50 wt% NaOH aqueous solution, 764 g of 45 wt% sodium aluminate solution, 456 g of n-propyl amine 100% solution, 30 g of ZSM-5 seed crystals, and 3852 g of Sipernat silica (a precipitated silica powder from Evonik Degussa). The components of the mixture were charged directly into the reactor used in Example 1 and mixed with the mixer rotating at 220 rpm for 20 minutes. The resultant mixture had an apparent viscosity greater than 10⁶ MPa x sec and the following molar composition:

15	SiO ₂ /Al ₂ O ₃	~ 30
	H ₂ O/SiO ₂	~ 10
	OH ⁻ /SiO ₂	~ 0.18
	Na/SiO ₂	~ 0.18
	n-PA/Si	~ 0.13

[0054] The mixture was then reacted at 310°F (154°C) with stirring at 220 rpm for 24 hours. The resulting reaction slurry was discharged and stored in a five gallon container. The XRD pattern of the as-synthesized material (Figure 5) showed the typical pure phase of ZSM-5 topology. The SEM of the as-synthesized material (Figure 6) shows that the material was composed of agglomerates of small crystals of about 0.05 micron in diameter. The Si/Al₂ ratio of the resultant crystals was about 24.7/1. The crystals were washed, dried, and then calcined in air at 1000°F (540°C) for four hours and then converted into the hydrogen form by ion-exchanging with ammonium nitrate solution at room temperature, followed by drying at 250°F (120°C) and calcination at 1000°F (540°C) for four hours. The resulting product had an alpha value of about 1700, a surface area of 443 m²/g [381 mg/g (micro pore surface area) + 62 mg/g (external surface area)], and 2,2-DMB sorbate diffusivity $D/r^2 = 29200$.

[0055] The results of Examples 1 and 2 show that good quality ZSM-5 crystals with desirable properties can be successfully produced through a high solids synthesis route at

high reaction pressure in a commercial pilot-scale horizontal ploughshear mixer/dryer. The horizontal ploughshare mixer/dryer provided significant advantages over a conventional vertical, stirred reactor for meeting process demands including viscous mixing, reaction, uniform heat-up, and discharging application.

5 **Example 3**

[0056] A mixture with about 24 wt% solids was prepared from 3954 g of tetraethylammonium hydroxide (TEAOH), as a 35 wt% solution supplied by Aldrich, 15 g of a diluted antifoam solution prepared from Dow Corning 62 antifoam solution, 6978 g of a C₁₂ surfactant solution supplied by Akzo Nobel as ARQUAD 12/37, and 3650 g of Sipernat
10 silica supplied by Evonik Degussa. The components of the mixture were charged directly into the reactor used in Example 1 and mixed with the mixer rotating at 110 rpm for 20 minutes. The resultant mixture had an apparent viscosity greater than 10⁶ MPa x sec and the following molar composition:

	SiO ₂ /Al ₂ O ₃	> 800/1
15	H ₂ O/ SiO ₂	~ 7.2
	TEAOH/ Surfactant	~ 1
	SiO ₂ / Surfactant	~ 5.8.

[0057] The mixture was then reacted at 240°F (116°C) with agitation at 20 rpm for 24 hours. The resulting high viscosity product slurry was then discharged from the reactor and
20 stored in a five gallon container. The XRD pattern of the as-synthesized product (Figure 7) showed the typical pure phase of MCM-41 topology. The SEM of the as-synthesized product showed that the material was composed of agglomerates of small crystals. The calcined washed product showed a surface area of about 1050 m²/g.

Example 4

25 [0058] The process of Example 4 was repeated but, after reaction at 240°F (116°C) for 24 hours, the product slurry was removed from the reactor and heated in a separate oven at 250°F (121°C) to remove greater than 10 wt% of water providing a solids of greater than 30 wt% for extrusion. The resultant partially-dried product was then used to produce a 80/20 (wt%) MCM-41/alumina catalyst by adding the product and Versal 300 alumina (available
30 from UOP) to a separate muller, mixing the alumina with the partially-dried product in the muller and then feeding to mixture to an extruder. The mixture was formed in the extruder into one-sixteenth inch (1.6 mm) cylindrical extrudates, which were then dried at 250°F (121°C) and subsequently calcined in air at 1000°F (538°C) for four hours. The final catalyst

showed a high surface area of about 830 m²/g and Na content of about 0.38 wt%. Portions of the extrudate were precalcined at about 800°F (427°C) in nitrogen, washed with water, and then completed with final calcination in air at 1000°F (538°C) for four hours. The resulting product had a sodium content of about 0.22 wt%.

5 **Example 5**

[0059] A mixture with about 27 wt% solids was prepared from 3203 g of tetraethylammonium hydroxide (TEAOH) 35% solution, 405 g of sodium aluminate 45% solution, 15 g of a diluted antifoam solution prepared from Dow Corning 62 antifoamant solution, 5651 g of ARQUAD 12/37 solution, and 3677 g of Sipernat silica. The components
10 of the mixture were charged directly into the reactor used in Example 1 through the top mount opening and mixed with the mixer rotating at 110 rpm for 20 minutes. The mixture had the following molar composition:

	SiO ₂ /Al ₂ O ₃	~ 50/1
	H ₂ O/ SiO ₂	~ 7.2
15	TEAOH/ Surfactant	~ 1
	SiO ₂ / Surfactant	~ 5.8.

[0060] The reactor was sealed and mixture reacted at 240°F (116°C) with agitation at 20 rpm for 24 hours. One gallon of the resulting high viscosity slurry product was then
20 discharged and stored in a 5-gallon pail container for later use. The charge valve was then opened to allow water to escape from the reactor to reduce the water content of the slurry and produce a partially dried product with a solids content of 33.2%. The XRD pattern, see Figure 8, of the as-synthesized material showed the typical pure phase of MCM-41 topology. The SEM of the as-synthesized material showed that the material was composed of
25 agglomerates of small crystals. The calcined washed product had a surface area of about 950 m²/g.

[0061] The results of Examples 3 and 5 show that good quality MCM-41 crystals with high desired properties including high surface area can be successfully produced through a high solids synthesis route at high reaction pressure in a commercial pilot-scale horizontal
30 ploughshare mixer/dryer. The horizontal ploughshare mixer/dryer provided significant advantages over a conventional vertical, stirred reactor for meeting process demands including viscous mixing, reaction, uniform heat-up, and discharging application. The reactor comprising horizontal mixer equipped with heat-transfer V-shaped plow blades and double

mechanical seals effectively handled mixing and agitation of high viscosity reaction mixtures of MCM-41 crystallizations at high pressures and temperatures.

Example 6

5 [0062] Samples of the partially dried product from Example 5 were mixed in a separate muller with different amounts of Versal 300 alumina to produce mixtures containing MCM-41/alumina ratios of 95/5 (sample A), 90/10 (sample B), and 80/20 (sample C). The resulting mixtures were then formed into 1/16" cylindrical extrudates and dried at 250°F (120°C) before use. The dried extrudates were then calcined in air at 1000°F (540°C) for 4 hrs. The final catalyst showed a high surface area of ~ 620 m²/g and Na content of ~ 1 wt%. The
10 calcined extrudates were then converted into the hydrogen form by ion exchange with ammonium nitrate solution at room temperature and 60°C, followed by drying at 250°F (120°C) and calcination at 1000°F (540°C) for 6 hours. The resulting treated extrudates showed very low Na levels as set out below below.

Sample A (95/5): SA = 620 m²/g; Na ~ 0.18 % (vs 1.06% before exchange)
15 Sample B (90/10): SA = 620 m²/g; Na ~ 0.15 % (vs. 1.02% before exchange)
Sample C (80/20): SA = 625 m²/g; Na ~ 0.13 % (vs. 0.91 % before exchange).

[0063] The above data demonstrated that the Na level of the catalyst can be lowered by ion-exchange from the calcined product.

20 [0064] While the present invention has been described and illustrated by reference to particular embodiments, those of ordinary skill in the art will appreciate that the invention lends itself to variations not necessarily illustrated herein. For this reason, then, reference should be made solely to the appended claims for purposes of determining the true scope of the present invention.

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CLAIMS

We claim:

1. A process for producing a molecular sieve material, said process comprising the steps:

(a) mixing water, at least one source of an oxide of a tetravalent element, and optionally a trivalent element, and at least one structure directing agent in a plough shear mixer/dryer/reactor equipped with a mixer having a Froude number of at least 1, to produce a molecular sieve synthesis mixture having a solids content of at least 20 wt%;

(b) heating the molecular sieve synthesis mixture in the plough shear mixer/dryer/reactor while agitating the mixture with said mixer to form crystals of said molecular sieve material; and then

(c) recovering the molecular sieve crystals from the plough shear mixer/dryer/reactor.

2. The process of claim 1 and further comprising the step:

(d) prior to step (c), removing water from the mixture in the plough shear mixer/dryer/reactor while agitating the mixture with the mixer so as to decrease the water content of the mixture inside the plough shear mixer/dryer/reactor by at least 5 wt% and produce a partially dried mixture.

3. The process of claim 2, wherein said removing step (d) is conducted after formation of the crystals of said molecular sieve material.

4. The process of claim 2, wherein said removing step (d) is conducted by applying heat to said molecular sieve synthesis mixture.

5. The process of claim 2, wherein said removing step (d) is conducted by reducing the pressure in said plough shear mixer/dryer/reactor.

6. The process of claim 3 and further comprising the step:

(e) mixing said partially dried mixture with an additional particulate

material to produce a product mixture.

7. The process of claim 6, wherein said additional particulate material is a catalyst formulation component.

8. The process of claim 7, wherein said additional particulate material is a binder or matrix material.

9. The process of claim 6, wherein said mixing step (e) is conducted in the plough shear mixer/dryer/reactor.

10. The process of claim 6, wherein said mixing step (e) is conducted in a separate mixer.

11. The process of claim 6 and further comprising the step:

(f) extruding said recovered product mixture into a shaped body.

12. The process of claim 1 and further comprising the step:

(d) calcining the recovered molecular sieve crystals without subjecting the crystals to an initial filtration and/or washing step.

13. The process of claim 1, wherein the plough shear mixer/dryer/reactor has a capacity of at least 5 liters.

14. The process of claim 1, wherein the mixer comprises at least one blade located on a shaft rotatable about an axis oriented at no more than 10° from horizontal.

15. The process of claim 1, wherein the molecular sieve material comprises ZSM-5 or MCM-41.