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## PROCESS FOR THE SEPARATION OF OLEFINS AND PARAFFINS

Field of the Invention

The present invention relates to the separation of olefinic hydrocarbons from a liquid feedstock composition comprising at least one olefinic hydrocarbon and at least one  
5 paraffinic hydrocarbon.

Background of the Invention

Olefinic hydrocarbons are frequently used in many industrial applications, including the manufacture of polymers such as polyethylene, as drilling mud additives, and  
10 as intermediates for the production of detergents. There exists many industrial processes for the manufacture of olefins, however many of these processes produce hydrocarbon streams that are mixtures of olefinic hydrocarbons, paraffinic hydrocarbons and often other impurities such as  
15 oxygenates and aromatics.

One such process for the production of olefins is the partial dehydrogenation of paraffinic hydrocarbons, which produces olefinic hydrocarbons and some unreacted paraffinic hydrocarbons. Another such process is the dehydration of  
20 alcohols, which produces an olefinic hydrocarbon composition as well as paraffinic hydrocarbons and unreacted alcohol feedstock.

A further industrial process which may be used for the manufacture of olefins is the so-called Fischer-Tropsch (FT)  
25 hydrocarbon synthesis process. The feedstock for this process is syngas, a mixture of carbon monoxide and hydrogen, which is generally inexpensive and can be readily derived from natural gas, coal, coke, and other carbonaceous compounds.

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Unfortunately, however, the FT process is not always selective towards the production of olefins. The product stream derived from the Fischer-Tropsch process typically contains a mixture of olefins, saturated hydrocarbons, aromatics and oxygenates. While reaction conditions and catalysts can be tuned to manufacture streams rich in a desired species (e.g. olefinic hydrocarbons), the FT product stream can also contain a significant percentage of the other types of compounds produced by the FT process (e.g. paraffinic hydrocarbons).

Clearly, olefinic hydrocarbon compositions produced from the processes mentioned hereinabove need to be purified, by separation of the desired olefinic products from the other products produced, before they can be sold commercially. However, conventional distillation techniques are frequently inadequate to separate olefinic hydrocarbons and paraffinic hydrocarbons which have similar molecular weights since they frequently have closely related boiling points.

Various processes for separating olefinic hydrocarbons from paraffinic hydrocarbons are taught in the prior art documents mentioned hereinbelow.

US 6,339,182 and divisional application US 6,623,659, describe the use of an ionic liquid composition comprising a metal salt dissolved or dispersed in the ionic liquid solution, for the separation of olefinic hydrocarbons from paraffinic hydrocarbons, wherein the metal salt/ionic liquid forms a complex with the olefinic hydrocarbon. The separation process can be described by the following general scheme: firstly, a two-phase composition of the olefin/paraffin composition and the metal salt/ionic liquid composition is formed; secondly, the olefins are absorbed and

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complexed with the metal salt/ionic liquid composition;  
thirdly, the resultant paraffinic composition is  
separated from the metal salt/ionic liquid composition;  
and finally, the olefins are isolated from the metal  
5 salt/ionic liquid composition by desorption at increased  
temperature and/or reduced pressure.

The use of membranes for the separation of olefinic  
hydrocarbons from paraffinic hydrocarbons has been  
achieved with varying degrees of success. However,  
10 membrane separation processes have only regularly been  
reported for the purification of gaseous olefinic  
hydrocarbon feedstocks having a narrow distribution of  
carbon numbers, typically a single carbon number, e.g. C<sub>2</sub>  
or C<sub>3</sub>.

15 One technique employed in the membrane separation of  
olefinic hydrocarbons from paraffinic hydrocarbons is  
pervaporation. Pervaporation involves contacting a multi  
component liquid feed with a non-porous membrane, which  
selectively absorbs one of the feed species. These  
20 sorbed species permeate across the membrane under the  
influence of a concentration gradient that is produced by  
evaporating the sorbed species from the product side of  
the membrane by vacuum or a sweep gas. WO02/078821  
relates to a membrane pervaporation system in which  
25 olefinic hydrocarbons may be separated from paraffinic  
hydrocarbons by pervaporation through a membrane. The  
vacuum which drives the pervaporation is created by a  
working fluid passing through a venturi-type nozzle, said  
working fluid being a solvent having an affinity for the  
30 permeate species. Ionic liquids are disclosed as  
potential working fluids due to their negligible vapour  
pressure.

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DE19929482A1 describes a membrane separation process for separating olefinic hydrocarbons and paraffinic hydrocarbons. The separation occurs through a polymer membrane incorporating transition metal salts capable of forming complexes with the olefinic hydrocarbon in order to facilitate the transport of olefinic hydrocarbon compounds.

Separations of gaseous olefinic hydrocarbons and paraffinic hydrocarbons across polymer membranes containing copper and silver salts have also been reported in Chem. Commun., 2000, 1261-1262 and Chem. Commun., 2000, 195-196, respectively. The separation of gaseous feed streams comprising ethylene and ethane, and propylene and propane is effected by means of a dry polymer membrane containing the respective metal salts, wherein the selective transport of the olefinic hydrocarbon through the membrane is facilitated by the formation of reversible complexes between the gaseous olefinic hydrocarbons and the metal salts.

Supported liquid membranes have also been reported for the separation of olefinic hydrocarbons and paraffinic hydrocarbons, however, thus far, the separation of olefinic hydrocarbons and paraffinic hydrocarbons has been limited to gaseous feedstock compositions. EP0458598 describes the use of an aqueous supported liquid membrane, wherein the aqueous liquid membrane solution contained within the pores of the membrane comprises a metal salt capable of complexing with an olefin and an alkyl carbonate co-solvent. An alkyl carbonate is incorporated into the aqueous solution to help prevent the supported liquid membrane drying out and reduce the need to humidify the gaseous feedstock composition. GB2169301 describes a supported liquid

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membrane for the separation of gaseous olefinic hydrocarbons and paraffinic hydrocarbons, wherein the liquid membrane solution is an organic solution containing metal salts. In EP0311903, a supported liquid membrane comprising a molten salt hydrate as the liquid membrane solution is employed for the separation of olefinic hydrocarbons from paraffinic hydrocarbons in a gaseous feedstock composition.

As mentioned above, supported liquid membranes have only regularly been reported for the separation of olefinic hydrocarbons and paraffinic hydrocarbons in the gas phase. It is believed that this has been due to problems of solubilisation or dispersion, commonly referred to as leaching, of the liquid membrane solution in the feedstock composition or product composition.

Supported ionic liquid membranes have recently been reported for the separation of gases. Supported ionic liquid membranes are membranes wherein an ionic liquid compound is immobilised in the pores of the membrane. Since ionic liquids have negligible vapour pressure, supported ionic liquid membranes do not suffer from the problem of the membrane drying out to the same extent as supported liquid membranes comprising other immobilised liquid membrane solutions.

US 6,579,343 describes a method for the use of a supported ionic liquid membrane for the removal of impurities in gas streams. In particular, US 6,579,343 describes the use of a supported ionic liquid membrane for the separation of carbon dioxide from a gaseous nitrogen stream. A similar process, also employing the use of an ionic liquid compound for the removal of carbon dioxide from nitrogen streams, has been presented by R.

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Baltus et al. at the North American Membrane Society (NAMS) annual meeting of 2002.

Recent research publications by L.C. Branco, J.G. Crespo and C.A.M. Afonso describe the use of supported ionic liquid membranes for the separation of organic compounds. In particular, Angew. Chem. Int. Ed., 2002, 41, No. 15 P.2771 - 2773, describes the use of a supported liquid membrane based on room temperature ionic liquids, for the separation of isomers of polar organic amines, namely hexylamine, diisopropylamine and triethylamine. A supported liquid membrane consisting of 1-n-butyl-3-methylimidazolium hexafluorophosphate immobilised in the pores of a polyvinylidene fluoride membrane is employed for the separation.

Chem. Eur. J., 2002, 8, No. 17, P.3865 - 3871, also by Branco et al., describes the use of supported liquid membranes based upon room temperature ionic liquids for the separation of the polar components of an organic oxygenate solution and solutions of organic amines. The membrane material in which the room temperature ionic liquid is immobilised is selected from polyvinylidene fluoride, polyethersulfone, hydrophilic polypropylene, nylon and non-hydrophilic polypropylene. The room temperature ionic liquid on which the supported liquid membrane is based is selected from 1-n-butyl-3-methylimidazolium hexafluorophosphate, 1-n-butyl-3-methylimidazolium tetrafluoroborate, 1-n-octyl-3-methylimidazolium hexafluorophosphate and 1-n-decyl-3-methylimidazolium hexafluorophosphate.

Despite there being processes available for separating liquid olefinic hydrocarbons and liquid paraffinic hydrocarbons, there is still a need to provide an improved process for the separation of olefinic

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hydrocarbons from paraffinic hydrocarbons. In particular, there is a need to provide a process which will not only provide olefinic compositions of sufficient purity to be commercially useful but which will also be highly energy efficient. It would also be desirable to provide a process which is capable of separating olefinic hydrocarbons from paraffinic hydrocarbons in a liquid feedstock composition having a broad spectrum of average carbon numbers (e.g. C<sub>5</sub> - C<sub>40</sub>).

It has now surprisingly been found that olefinic hydrocarbons can be separated from paraffinic hydrocarbons in a liquid feedstock containing liquid olefinic hydrocarbons and liquid paraffinic hydrocarbons, by the use of a supported liquid membrane based upon a membrane which has been impregnated with an ionic liquid composition. It has also been surprisingly found that such supported ionic liquid membrane separation processes can be carried out in the liquid phase with no loss of the membrane solution into either the feedstock composition or the olefinic hydrocarbon product composition.

#### Summary of the Invention

The present invention relates to a process for the separation of olefinic hydrocarbons from a liquid feedstock composition comprising at least one olefinic hydrocarbon and at least one paraffinic hydrocarbon, said process comprising contacting the liquid feedstock with a supported ionic liquid membrane, wherein the supported ionic liquid membrane comprises a membrane impregnated with an ionic liquid composition.

Since the separation of olefinic hydrocarbons from paraffinic hydrocarbons using supported ionic liquid membranes can operate under ambient conditions, the

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process is highly energy efficient and produces very little waste product.

Detailed Description of the Invention

5       The term "hydrocarbon" as used herein, relates to a compound in which the dominant constituent elements are carbon and hydrogen. The term "paraffinic hydrocarbon" as used herein, refers to a hydrocarbon compound wherein all carbon-carbon bonds are fully saturated. The term "olefinic hydrocarbon" as used herein, refers to a  
10       hydrocarbon compound wherein at least one carbon-carbon bond is a carbon-carbon double bond.

      The process of the present invention produces an "olefinic hydrocarbon product composition" which comprises the olefinic hydrocarbon(s) which has been  
15       separated from the feedstock composition by the process of the present invention.

      The feedstock composition used in the process of the present invention is a liquid hydrocarbon composition comprising at least one olefinic hydrocarbon and at least  
20       one paraffinic hydrocarbon. A solvent may optionally be incorporated into the feedstock composition. It is preferred that the feedstock composition does not comprise an added solvent.

      The feedstock composition as used herein must be  
25       liquid at the operating temperature and pressure of the separation process of the present invention. Typically, the separation process of the present invention is carried out at room temperature (25 °C) and at atmospheric pressure (1 atm).

30       The olefinic hydrocarbons present in the feedstock composition are preferably C<sub>5</sub> - C<sub>40</sub> olefinic hydrocarbons, more preferably C<sub>6</sub> - C<sub>18</sub> olefinic hydrocarbons. The olefinic hydrocarbons used herein are even more

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preferably olefins in the detergent range ( $C_8 - C_{16}$ ). The olefinic hydrocarbons present in the feedstock composition may contain more than one olefinic bond. Preferably the olefinic hydrocarbons in the feedstock composition of the process of the present invention are

5 mono-olefinic hydrocarbons.

The olefinic hydrocarbons present in the feedstock composition are preferably selected from linear or branched internal-olefins, linear or branched alpha-olefins, ( $C_1 - C_4$  alkyl-) substituted or unsubstituted

10 cyclic olefins, and mixtures thereof. More preferably the olefinic hydrocarbons present in the feedstock composition are selected from linear or branched alpha-olefins, linear or branched internal-olefins and mixtures thereof.

15

The olefinic hydrocarbons present in the feedstock composition may optionally contain one or more functional groups, provided that the functional groups do not react with the ionic liquid composition or the membrane used in

20 the process of the present invention. Preferably the olefinic hydrocarbons present in the feedstock composition do not contain any functional groups. The olefinic hydrocarbons may also contain a heteroatom (i.e. an atom other than carbon) in the hydrocarbon chain.

25 Examples of suitable heteroatoms include oxygen, nitrogen, sulfur and phosphorus. Preferably, however, the hydrocarbon chain does not contain any heteroatoms.

The paraffinic hydrocarbons present in the feedstock composition are preferably  $C_5 - C_{40}$  paraffinic hydrocarbons, more preferably  $C_6 - C_{18}$  paraffinic hydrocarbons, especially  $C_8 - C_{16}$  paraffinic hydrocarbons.

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The paraffinic hydrocarbons present in the feedstock composition are preferably selected from linear or

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branched non-cyclic paraffins, (C<sub>1</sub> - C<sub>4</sub> alkyl-)  
substituted or unsubstituted cyclic paraffins, (C<sub>1</sub> - C<sub>4</sub>  
alkyl-) substituted or unsubstituted polycyclic paraffins  
and mixtures thereof. More preferably the paraffinic  
5 hydrocarbons present in the feedstock composition are  
selected from linear paraffins, branched paraffins and  
mixtures thereof.

Other compounds may optionally be present in the  
feedstock composition. Typically, these include  
10 aromatics, oxygenates, and sulfur, nitrogen and  
phosphorous containing hydrocarbons. The type of these  
optional compounds will depend on the origin of the  
feedstock composition, e.g. Fischer-Tropsch, or  
otherwise.

15 The feedstock composition may be derived from any  
industrial process which produces a mixture of olefinic  
hydrocarbons and paraffinic hydrocarbons. In a preferred  
embodiment, the feedstock composition is derived from a  
Fischer-Tropsch process.

20 The "Fischer-Tropsch" hydrocarbon synthesis involves  
the reaction of carbon monoxide and hydrogen ("synthesis  
gas") in the presence of a Fischer-Tropsch catalyst, e.g.  
a cobalt or iron based Fischer-Tropsch catalyst, to  
produce hydrocarbons. The synthesis gas used in the  
25 Fischer-Tropsch hydrocarbon synthesis is derived from  
cheap, abundantly available natural gas or coal.

Typically, Fischer-Tropsch processes produce a  
hydrocarbon product stream comprising paraffinic  
hydrocarbons, olefinic hydrocarbons (including internal-  
30 and alpha-olefins), aromatics and oxygenates (commonly  
alcohols, but may also include ethers, esters, acids,  
aldehydes, acid anhydrides, and ketones).

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The process of the present invention comprises contacting the feedstock composition described hereinabove with a supported ionic liquid membrane. The supported ionic liquid membrane comprises a membrane  
5 impregnated with an ionic liquid composition.

Supported ionic liquid membranes are generally prepared by the immersion of a suitable membrane in an ionic liquid composition, such that substantially all of the pores are filled with the ionic liquid composition.  
10 Optionally, the membrane may be immersed in the ionic liquid composition under vacuum. In this context, the term "substantially all" means that preferably 95 % or more of the pores of the membrane are filled with the ionic liquid composition, more preferably 99 % or more,  
15 especially 100 % of the pores of the membrane are filled with the ionic liquid composition. The membrane is then removed from the ionic liquid composition, and any excess surface liquid is removed. The ionic liquid composition is drawn into and held within the pores of the membrane  
20 by capillary forces.

Any type of membrane suitable for use with an ionic liquid composition may be used in the process of the present invention to form the supported ionic liquid membrane. The material of the membrane is not critical,  
25 however, the membrane should not be reactive with the ionic liquid composition or the feedstock and product compositions. The physical properties of the membrane which is to be impregnated with the ionic liquid composition are not critical, as long as the capillary  
30 forces acting within the membrane pores are sufficiently high to prevent the ionic liquid composition leaching out into either the feedstock composition or the olefinic hydrocarbon product composition. The membrane used may

be isotropic or anisotropic, hydrophilic or hydrophobic. However, the membrane should have an affinity for the ionic liquid composition which is to be immobilised within its' pore structure. Preferably, the membrane is hydrophilic.

Suitable materials for the membrane are known to those skilled in the art in the field of membrane separation. Examples of types of suitable membranes include mesoporous and macroporous polymer membranes, ceramic membranes, zeolite membranes and porous alumina and steel membranes. Preferably the membrane is a mesoporous or a macroporous polymer membrane.

The polymer material for use in the polymer membrane is not critical. Suitable polymer materials are known to those skilled in the art in the field of membrane separation. Examples of suitable materials for polymer membranes include: polysulfone; cellulose acetate; regenerated cellulose; polyamide; polycarbonates; polyimides; polyvinylidene fluoride; polyethersulfone; hydrophilic polypropylene; nylon; polyacrylate; polyetherimide; and non-hydrophilic polypropylene.

Preferably the membrane is a polyvinylidene fluoride, polyethersulfone, polyacrylate, polyetherimide or a polycarbonate membrane.

The configuration of the membrane is not critical. The membrane may be of a flat sheet, tubular, spiral wound or a hollowfibre configuration.

The ionic liquid composition used in the process of the present invention preferably comprises one or more ionic liquids, wherein the one or more ionic liquids comprise a large organic cation with a weakly coordinating anion. The ionic liquids used herein are preferably room temperature ionic liquids.

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Room temperature ionic liquids as used herein are organic salt compounds with very low melting points and are liquid at a temperature of 25 °C and a pressure of 1 atmosphere. Ionic liquids generally remain in the liquid phase over a wide temperature range. Ionic liquids also have essentially no vapour pressure, and most ionic liquids are air and water stable at room temperature. Furthermore, certain ionic liquids are insoluble in water and in hydrocarbon solvents.

The properties of ionic liquids can be tailored according to their intended use. This can be achieved by varying the cation and anion of the ionic liquid compound. For examples of this see J. Chem. Tech. Biotechnol., 68, 1997, 351 - 356; J. Phys. Condensed Matter, 5 (Supp 34B), 1993, B99 - B106; Chemical and Engineering News, Mar. 30, 1998, 32 - 37; J. Mater. Chem., 8, 1998, 2627 - 2636; and Chem. Rev., 99, 1999, 2071 - 2084, the contents of which are incorporated herein by reference.

Ionic liquids may be bought commercially or can be synthesised by techniques well known to those skilled in the art of synthetic chemistry. One type of ionic liquid may be formed by reacting a nitrogen-containing heterocyclic ring, preferably a heteroaromatic ring, with an alkylating agent (e.g. an alkyl halide). The resultant quaternary ammonium salt may subsequently be subjected to an ion exchange reaction, or other suitable reaction with various Lewis acids or their conjugate bases, thus forming an ionic liquid. Suitable heteroaromatic rings include optionally substituted pyridines, imidazoles, pyrroles, pyrrolidines, thiazoles, oxazoles, isooxazoles and pyrazoles. These rings can be alkylated with virtually any linear, branched or cyclic

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C<sub>1</sub> - C<sub>20</sub> alkyl group, preferably C<sub>1</sub> - C<sub>16</sub> alkyl groups since groups larger than this may form low melting solids as opposed to ionic liquids.

5 Various trialkylphosphines, thioethers, cyclic and non-cyclic quaternary ammonium salts have also been used to form ionic liquids.

10 Ionic liquids can be neutral, Lewis-basic or Lewis-acidic. Neutral pH ionic liquids are preferable if it is desired not to isomerise the olefinic hydrocarbons which are to be separated. However, if it is not a concern whether the olefinic hydrocarbon composition is isomerised, i.e. if the olefinic hydrocarbons in the feedstock composition are already isomerised, or the focus of the separation is the removal of olefinic hydrocarbons from a paraffinic hydrocarbon stream, then 15 Lewis-acidic ionic liquids can be employed.

Any weakly coordinating anion may be employed as the counterion in the ionic liquids herein. Suitable counterions for the ionic liquids herein include gallium tetrachloride, tetrafluoroborate, tetrachloroborate, 20 hexafluorophosphate, tris(perfluoroalkyl)trifluorophosphate, nitrate, trifluoromethylsulfonate (triflate), methylsulfonate, methylsulfate, p-toluenesulfonate, octylsulfate, bis(trifluoromethylsulfonyl)imide, 25 tris(trifluoromethylsulfonyl)methide, bis(trifluoromethyl)imide, hydrogensulfate, dicyanamide, bis(pentafluoroethylsulfonyl)imide, formate, acetate, (mono- or di-hydrogen)-phosphate, phosphate, 30 trifluoroacetate, hexafluoroantimonate, hexafluoroarsenate, tetrachloroaluminate, tetrabromoaluminate, perchlorate, hydroxide anion, copper dichloride anion, iron trichloride anion, zinc

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trichloride anion, as well as various borate anions and various lanthanum, nickel, cobalt, manganese, and other metal containing anions.

The anion of the ionic liquid(s) for use herein is not critical, provided that the anion used forms an ionic liquid with the cation employed. The preferred anions for use in the ionic liquids herein are selected from tetrachloroaluminate, tetrafluoroborate, hexafluorophosphate, nitrate, trifluoromethylsulfonate (triflate), methylsulfonate, methylsulfate, p-toluenesulfonate, bis(trifluoromethylsulfonyl)imide, hydrogensulfate, dicyanamide, (bis(pentafluoroethylsulfonyl)imide, acetate, (mono-or dihydrogen)-phosphate, phosphate, trifluoroacetate, copper dichloride anion, iron trichloride anion, and zinc trichloride anion.

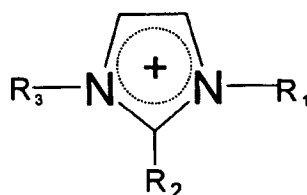
More preferably the anions of the ionic liquids of the process of the present invention are selected from bis(trifluoromethylsulfonyl)imide, tetrafluoroborate, nitrate, trifluoroacetate, methylsulfonate, trifluoromethylsulfonate, and dicyanamide.

Preferably the ionic liquid comprises a nitrogen-containing heterocyclic cation. The nitrogen-containing heterocyclic cation may optionally be a nitrogen-containing heteropolycyclic cation or a heteropolyaromatic cation. Suitable nitrogen-containing heterocyclic cations include optionally substituted imidazolium, pyridinium, pyrrolinium, pyrrolidinium, thiazolium, quinolinium, oxazolium, isoxazolium, pyrazolium, piperidinium, morpholinium, pyrimidinium, pyrazinium, indolium, isoquinolinium and cations of 1,4-diazabicyclo[2.2.2]octane, 1,8-diazabicyclo[5.4.0]undec-7-ene and 1,5-diazabicyclo[4.3.0]non-5-ene. All of the

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above cations may be substituted with any linear, branched or cyclic C<sub>1</sub> - C<sub>20</sub> alkyl group. More preferably the ionic liquid comprises a nitrogen-containing heteroaromatic cation. Most preferably, the cations used in the ionic liquids of the process of the present invention are optionally substituted imidazolium and pyridinium cations.

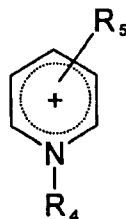
Preferred imidazolium cations for use herein are those having the formula (I) below:



(I)

wherein R<sub>1</sub>, R<sub>2</sub> and R<sub>3</sub> are independently selected from hydrogen, C<sub>1</sub> - C<sub>20</sub> alkyl groups, and C<sub>1</sub> - C<sub>20</sub> alkoxyalkyl groups. In preferred embodiments herein, R<sub>1</sub> and R<sub>3</sub> are independently selected from hydrogen and C<sub>1</sub> - C<sub>16</sub> alkyl groups, more preferably hydrogen and C<sub>1</sub> - C<sub>8</sub> alkyl groups. In particular preferred embodiments herein, R<sub>1</sub> and R<sub>3</sub> are independently selected from hydrogen, methyl, ethyl, propyl, butyl, hexyl and octyl. In an especially preferred embodiment, R<sub>1</sub> is hydrogen or methyl and R<sub>3</sub> is selected from ethyl, propyl, butyl, hexyl and octyl. In another preferred embodiment herein, R<sub>2</sub> is hydrogen or methyl.

Preferred pyridinium cations for use herein are those having the formula (II) below:



(II)

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wherein  $R_4$  and  $R_5$  are independently selected from hydrogen,  $C_1 - C_{20}$  alkyl groups, and  $C_1 - C_{20}$  alkoxyalkyl groups. In preferred embodiments herein,  $R_4$  and  $R_5$  are independently selected from  $C_1 - C_{16}$  alkyl groups. More preferably  $R_4$  and  $R_5$  are independently selected from  $C_1 - C_8$  alkyl groups. In an especially preferred embodiment herein,  $R_4$  and  $R_5$  are independently selected from methyl, ethyl, propyl, butyl, hexyl and octyl.

In one preferred embodiment, the cations of the ionic liquid for use herein are selected from the cations of 1-methyl-3-H-imidazolium, 1-ethyl-3-H-imidazolium, 1-propyl-3-H-imidazolium, 1-butyl-3-H-imidazolium, 1-hexyl-3-H-imidazolium, 1-octyl-3-H-imidazolium, 1-ethyl-3-methyl-imidazolium, 1-propyl-3-methyl-imidazolium, 1-butyl-3-methyl-imidazolium, 1-hexyl-3-methyl-imidazolium, 1-octyl-3-methyl-imidazolium, 1-ethyl-3-methyl-pyridinium, 1-propyl-3-methyl-pyridinium, 1-butyl-3-methyl-pyridinium, 1-hexyl-3-methyl-pyridinium, 1-octyl-3-methyl-pyridinium, 1-ethyl-4-methyl-pyridinium, 1-propyl-4-methyl-pyridinium, 1-butyl-4-methyl-pyridinium, 1-hexyl-4-methyl-pyridinium and 1-octyl-4-methyl-pyridinium.

Preferred ionic liquids for use herein are selected from any combination of optionally substituted imidazolium or pyridinium cations having the formulae (I) or (II) above with any of the anions selected from tetrachloroaluminate, tetrafluoroborate, hexafluorophosphate, nitrate, trifluoromethylsulfonate (triflate), methylsulfonate, methylsulfate, p-toluenesulfonate, bis(trifluoromethylsulfonyl)imide, hydrogensulfate, dicyanamide, (bis(pentafluoroethylsulfonyl)imide, acetate, (mono-or dihydrogen)-phosphate, phosphate, trifluoroacetate,

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copper dichloride anion, iron trichloride anion, and zinc trichloride anion.

In a preferred embodiment, the ionic liquids for use herein are selected from a combination of an anion and a cation wherein the cation is selected from 1-methyl-3-H-imidazolium, 1-ethyl-3-H-imidazolium, 1-propyl-3-H-imidazolium, 1-butyl-3-H-imidazolium, 1-hexyl-3-H-imidazolium, 1-octyl-3-H-imidazolium, 1-ethyl-3-methyl-imidazolium, 1-propyl-3-methyl-imidazolium, 1-butyl-3-methyl-imidazolium, 1-hexyl-3-methyl-imidazolium, 1-octyl-3-methyl-imidazolium, 1-ethyl-3-methyl-pyridinium, 1-propyl-3-methyl-pyridinium, 1-butyl-3-methyl-pyridinium, 1-hexyl-3-methyl-pyridinium, 1-octyl-3-methyl-pyridinium, 1-ethyl-4-methyl-pyridinium, 1-propyl-4-methyl-pyridinium, 1-butyl-4-methyl-pyridinium, 1-hexyl-4-methyl-pyridinium or 1-octyl-4-methyl-pyridinium, and the anion is selected from bis(trifluoromethylsulfonyl)imide, tetrafluoroborate, nitrate, trifluoroacetate, methylsulfonate, trifluoromethylsulfonate and dicyanamide.

A particularly preferred ionic liquid for use herein is selected from 1-butyl-3-methyl-imidazolium nitrate, 1-ethyl-3H-imidazolium nitrate, and 1-ethyl-3-methyl-imidazolium triflate.

Certain low melting solids can be used in place of room temperature ionic liquids, depending upon the particular separation to be effected. Low melting solids are generally very similar to ionic liquids, but they have melting points in the range from room temperature (25 °C) to 100 °C, or are liquid under the conditions of the process of the present invention.

It has further been found that the introduction of metal salts capable of forming complexes with olefinic

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hydrocarbons increases the selectivity of the supported ionic liquid membrane in the separation of olefinic hydrocarbons from paraffinic hydrocarbons, without the need for increased temperature and/or reduced pressure to facilitate separation of the olefinic hydrocarbons from the ionic liquid composition.

Hence, in a preferred embodiment herein, the ionic liquid composition comprises a metal salt dissolved, dispersed or suspended in the ionic liquid composition.

The metal salt used herein should be capable of forming a complex with an olefinic hydrocarbon. Preferred metal salts for use herein are selected from the salts of silver, copper, manganese, zinc, platinum, palladium, nickel, cobalt, iron, gold, ruthenium, rhodium, chromium and molybdenum, and mixtures thereof.

The anion of the metal salts are known to those skilled in the art.

Typical metal salts capable of forming a complex with an olefin include AgCl, AgF, AgNO<sub>3</sub>, AgCF<sub>3</sub>SO<sub>2</sub>NSO<sub>2</sub>CF<sub>3</sub>, AgCH<sub>3</sub>SO<sub>3</sub>, AgCF<sub>3</sub>SO<sub>3</sub>, AgBF<sub>4</sub>, AgPF<sub>6</sub>, AgClO<sub>4</sub>, Ag(CF<sub>3</sub>CO<sub>2</sub>), CuCl, CuBr, CuNO<sub>3</sub>, Ni(BF<sub>4</sub>)<sub>2</sub>, Ni(CH<sub>3</sub>CO<sub>2</sub>)<sub>2</sub>, Ni(NO<sub>3</sub>)<sub>2</sub>, and PtCl<sub>2</sub>. More preferably, the metal salts are silver or copper salts, especially silver salts. Particularly preferred metal salts for use herein are selected from AgNO<sub>3</sub>, AgCH<sub>3</sub>SO<sub>3</sub>, AgCF<sub>3</sub>SO<sub>3</sub>, AgCF<sub>3</sub>SO<sub>2</sub>NSO<sub>2</sub>CF<sub>3</sub>, AgBF<sub>4</sub>, Ag(CF<sub>3</sub>CO<sub>2</sub>), CuCl, CuNO<sub>3</sub>, CuBr and mixtures thereof. In an especially preferred embodiment herein, the metal salt is AgNO<sub>3</sub>.

Preferably, the ionic liquid composition used herein is non-aqueous, i.e. the ionic liquid composition comprises less than about 5 %, preferably less than about 1 %, especially 0 %, by weight, of water.

The process for the separation of olefinic hydrocarbons from a liquid feedstock composition

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comprising at least one olefinic hydrocarbon and at least one paraffinic hydrocarbon, comprises contacting the liquid feedstock composition with a supported ionic liquid membrane under conditions suitable to selectively  
5 separate olefins from paraffins.

In particular, the process for the separation of olefinic hydrocarbons from a liquid feedstock composition comprising at least one olefinic hydrocarbon and at least one paraffinic hydrocarbon, comprises contacting the  
10 liquid feedstock composition with a supported ionic liquid membrane under conditions suitable to selectively separate olefins from paraffins, wherein the olefinic hydrocarbons separated are collected in a receiving phase.

15 While not wishing to be bound by theory, it is believed that the process of the present invention occurs as follows. The olefinic hydrocarbons and paraffinic hydrocarbons present in the feedstock composition partition between the ionic liquid composition within the  
20 pores of the membrane and the feedstock composition. The olefinic hydrocarbons partitioned into the ionic liquid composition within the pores of the membrane form reversible complexes in equilibrium with the metal salt present in the ionic liquid composition. The olefinic  
25 hydrocarbons, paraffinic hydrocarbons and the reversible metal salt olefinic hydrocarbon complex diffuse to the permeate side of the supported ionic liquid membrane due to the concentration gradient within the supported ionic liquid membrane. The olefinic hydrocarbons and  
30 paraffinic hydrocarbons partition between the ionic liquid composition within the pores of the membrane and the receiving phase solvent, thus driving the equilibrium of the reversible metal salt olefinic hydrocarbon complex

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in favour of generating more non-complexed olefinic hydrocarbons in the ionic liquid composition at the permeate side of the supported ionic liquid membrane.

5 The conditions for the process of the present invention are not critical, provided that the temperature and pressure are such that the ionic liquid composition is in the liquid phase when the process is carried out.

10 The temperature of the process of the present invention should be below the temperature at which the membrane becomes deformed and/or melted. The temperature for the process of the present invention should also be such that the feedstock composition is a liquid feedstock composition when the separation process is carried out. The temperature for the process of the present invention  
15 should preferably be such that the receiving phase is liquid when the separation process is carried out. Typically, the temperature used in the process of the present invention is in the range from -50 °C to 300 °C, preferably in the range from 0 °C to 200 °C, and more  
20 preferably in the range from 25 °C to 150 °C.

For economic and environmental reasons, it may be desirable to perform the process of the present invention at room temperature, or at the temperature at which the liquid feedstock composition emerges as a product stream  
25 from its' process of manufacture (e.g. a Fischer-Tropsch product stream).

The pressure for the process of the present invention is not critical, provided that the feedstock composition is a liquid feedstock composition at the  
30 pressure employed. Typically the pressure for the process of the present invention is in the range from 1 bar to 30 bar. A pressure difference may exist across the membrane, provided that the pressure difference is

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not so large that the ionic liquid composition is expelled from the pores of the membrane.

For economic and environmental reasons, it may be desirable to perform the process of the present invention at atmospheric pressure, or at the pressure at which the liquid feedstock composition emerges as a product stream from its' process of manufacture.

The olefinic hydrocarbon product composition can be collected in a receiving phase by any technique known in the art. Preferably, the receiving phase of the process of the present invention is a solvent.

The receiving phase solvent is typically any suitable solvent which is inert to the olefinic hydrocarbon product composition and in which the olefinic hydrocarbon product composition is soluble. The receiving phase solvent should also be inert to the ionic liquid composition and is chosen such that the ionic liquid composition is not soluble in the receiving phase solvent. The olefinic hydrocarbon product composition may optionally be separated from the receiving phase solvent at the end of the process and before the olefinic hydrocarbon product composition is used as a feedstock for further reactions. The receiving phase solvent of the present invention may be chosen such that the boiling point(s) and melting point(s) of the solvent(s) and the separated olefinic hydrocarbon product composition(s) are sufficiently different that recovery of the olefinic hydrocarbon product may be performed by conventional separation techniques, e.g. distillation.

In a preferred embodiment herein, the receiving phase solvent is a paraffinic hydrocarbon or an oxygenate. The receiving phase solvent is preferably selected from pentane, hexane, heptane, octane, decane,

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dodecane, tetradecane, diisobutyl carbinol, methyltertiarybutyl ether (MTBE) and diethyl ether.

The process of the present invention may be performed as a batch, semi-continuous or continuous phase operation. Preferably the process of the present invention is performed as a continuous phase operation.

The process of the present invention produces an olefinic hydrocarbon product composition and a retentate composition. As mentioned hereinabove, the olefinic hydrocarbon product composition comprises the olefinic hydrocarbon(s) which has been separated from the feedstock composition. The olefinic hydrocarbon product composition is enriched in olefinic hydrocarbons over the feedstock composition. The olefinic hydrocarbon product composition may also comprise small amounts of paraffinic hydrocarbons, excluding any paraffinic hydrocarbons present in the receiving phase solvent, which may be transferred concurrently with the olefinic hydrocarbons. Preferably, the amount of paraffinic hydrocarbons in the olefinic hydrocarbon product composition is less than 20 %wt., more preferably less than 10 %wt., especially less than 5 %wt., excluding any paraffinic hydrocarbons present in the receiving phase solvent.

The retentate composition is the stream which is left behind after the feedstock composition has been subjected to the process of the present invention, and which contains the compounds which are not preferentially separated from the feedstock composition by the supported ionic liquid membrane used in the process of the present invention (e.g. paraffins). The retentate composition is enriched in paraffinic hydrocarbons over the feedstock composition. The retentate composition can also comprise olefinic hydrocarbons which have not passed through the

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supported ionic liquid membrane. Preferably, the amount of olefinic hydrocarbons present in the retentate composition is reduced by 20 %wt. or more, more preferably 30 %wt. or more, especially 40 %wt. or more relative to the initial amount of olefinic hydrocarbons in the feedstock composition.

The process of the present invention may also be used for the purification of a paraffinic hydrocarbon feedstock composition comprising at least one paraffinic hydrocarbon and at least one olefinic hydrocarbon impurity, wherein the concentration of the olefinic hydrocarbon impurity in the retentate composition is reduced over the concentration of olefinic hydrocarbon impurity in the feedstock composition.

The separation process of the present invention can be repeated more than once on the feedstock composition and/or the olefinic hydrocarbon product composition in order to obtain the desired purity of the olefinic hydrocarbon product composition and/or the retentate composition.

The invention will be further illustrated by the following examples, however, without limiting the invention to these specific embodiments.

#### Examples

The examples described hereinbelow were all performed using a glass transport cell based upon the experimental set-up used in De Jong, F.; Visser, H.C. in *Comprehensive Supramolecular Chemistry*, eds. Atwood, J.L.; Davies, J.E.D.; MacNicol, D.D.; Vogtle, F.; Lehn, J.-M.; Reinhoudt, D.N. Elsevier Science, Oxford, 1996, vol.10, Chapter 2, p.13-46. The glass transport cell of the examples is set up as follows.

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A schematic diagram of the glass transport cell is given in Figure 1. The glass transport cell comprises two compartments (1 and 2), with the overall glass transport cell constructed from two separate cell halves (3 and 4). The two cell halves (3 and 4) are identical cylindrical glass units. The cell halves are sealed at one end and open at the other end. Each of the cell halves comprises a magnetically controlled impeller for stirring (5 and 6) and a fill aperture (7 and 8).

The supported ionic liquid membrane (9) is positioned on the open end of one cell half. The supported ionic liquid membrane is then sandwiched between the open ends of the two cell halves (3 and 4). The two cell halves are clamped together inside a metal framework (10) in order to form a liquid-tight seal between the two compartments (1 and 2). The glass transport cell is then mounted horizontally between two mechanical stirrers bearing magnets (not shown), which are positioned to drive the magnetically controlled impellers.

The supported ionic liquid membranes used for the examples hereinbelow are formed by the immersion of the membrane into the ionic liquid composition with which it is to be impregnated. The membrane is immersed in the ionic liquid composition until the entire membrane acquires a transparent appearance, after which the membrane is removed from the ionic liquid composition and any excess ionic liquid composition is removed from the surface of the supported ionic liquid membrane.

The separation process is performed by first charging one of the compartments of the glass transport cell with the receiving phase solvent for receiving the olefinic hydrocarbon product composition. This is

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designated the permeate side. The receiving phase solvent also comprises an internal standard, which is used for gas chromatography analysis of the olefinic hydrocarbon product composition. The glass transport cell is allowed to stir for 5 minutes to check for any membrane leakage. The other compartment of the glass transport cell is then charged with the feedstock composition. This is designated the feedstock side. The feedstock composition also comprises an internal standard, which is used for gas chromatography analysis of the feedstock composition prior to the separation process and retentate composition after the separation process. Both compartments of the glass transport cell are allowed to stir at approximately 100 rpm for a period of 24 hours at room temperature. Samples are then taken from both the permeate side and the feedstock side after 24 hours, and are analysed by gas chromatography. The gas chromatograph used is an Agilent 6850 gas chromatograph and chemstation with autosampler and flame ionisation detector. The column is a 60 m, 0.32 mm diameter, film 0.50  $\mu\text{m}$ , J&W Scientific DB-1 column (all commercially available from Agilent Technologies, 395 Page Mill Rd., P.O. Box #10395, Palo Alto, CA 94303, USA). The temperature program of the gas chromatograph includes an initial temperature of 50 °C, an initial time of 8 minutes, a rate of 10 °C min<sup>-1</sup> and a final temperature of 325 °C. The calculation of the quantities of the components was performed using a calibrated ISTD program.

For each component of the feedstock composition, the average flux through the supported ionic liquid membrane is calculated according to the following equations:

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$$J = \frac{P}{A_m} \times t$$

where

$J$  = average flux over time period  $t$  ( $\text{kg m}^{-2} \text{ h}^{-1}$ ).

$P$  = amount of the component in the receiving phase  
(permeate side), determined by gas chromatography (kg).

$A_m$  = surface area of the supported ionic liquid membrane  
( $\text{m}^2$ ).

$t$  = time period of the separation (h).

For comparison purposes, the flux through the  
supported ionic liquid membrane is normalised to 1.0 M  
feedstock component concentration.

The selectivity of the supported ionic liquid  
membrane for each olefin over its' analogous paraffin is  
calculated according to:

$$S = \frac{J_o}{J_p}$$

where

$S$  = selectivity.

$J_o$  = average normalised flux of the olefinic hydrocarbon.

$J_p$  = average normalised flux of the analogous paraffinic  
hydrocarbon.

#### Example 1

The glass transport cell is assembled as described  
above. The membrane used is a polycarbonate membrane  
(Isopore (trade mark) membrane commercially available  
from Millipore, 290 Concord Rd., Billerica, MA 01821,  
USA, having an average pore diameter of  $0.4 \mu\text{m}$  and a  
membrane thickness of  $10 \mu\text{m}$ ). The ionic liquid  
composition is a 40 %mol solution of silver nitrate  
(commercially available from Sigma-Aldrich, 3050 Spruce  
St., St. Louis, MO 63103, USA) in 1-butyl-3-methyl-  
imidazolium nitrate.

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The 1-butyl-3-methyl-imidazolium nitrate is synthesised by addition of an aqueous solution of silver nitrate (0.25 Mol in 100 ml water) to a stirring aqueous solution of 1-butyl-3-methyl-imidazolium chloride  
 5 (commercially available from Solvent Innovation GmbH, Alarichstraße 14-16, 50679 Köln, Germany) (0.25 Mol in 100 ml water) at room temperature and allowed to react for one hour. The silver chloride formed is removed by filtration over a glass filter (porosity: P4). The water  
 10 is removed from the 1-butyl-3-methyl-imidazolium nitrate solution by evaporation. The 1-butyl-3-methyl-imidazolium nitrate product is then dried in vacuo for three hours at 70 °C.

The receiving phase solvent employed is tetradecane  
 15 (commercially available from Sigma-Aldrich, 3050 Spruce St. St. Louis, MO 63103, USA) and the feedstock composition is derived from a Fischer-Tropsch synthesis, and has the composition set out in Table 1.

Table 1. Feedstock composition for Example 1.

| Compound   | %wt. of the feedstock composition |
|------------|-----------------------------------|
| 1-Pentene* | 1.4                               |
| Pentane    | 3.1                               |
| 1-Hexene*  | 5.8                               |
| Hexane     | 8.8                               |
| 1-Heptene* | 8.8                               |
| Heptane    | 12.0                              |
| 1-Octene*  | 9.9                               |
| Octane     | 14.1                              |
| 1-Nonene*  | 11.3                              |
| Nonane     | 18.6                              |
| 1-Decene*  | 3.2                               |
| Decane     | 3.0                               |

20 \* contains up to 2 %wt. isomeric impurities based upon the weight of each individual component.

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The average flux of the compounds through the supported ionic liquid membrane over a 24 hour period is disclosed in Table 2 below.

5 Table 2. Average flux over a 24 hour period for the compounds of Example 1.

| Compound   | Flux (kg/m <sup>2</sup> h) |
|------------|----------------------------|
| 1-Pentene* | $3.7 \times 10^{-02}$      |
| Pentane    | $2.2 \times 10^{-03}$      |
| 1-Hexene*  | $2.8 \times 10^{-02}$      |
| Hexane     | $1.4 \times 10^{-03}$      |
| 1-Heptene* | $2.0 \times 10^{-02}$      |
| Heptane    | $8.3 \times 10^{-04}$      |
| 1-Octene*  | $1.3 \times 10^{-02}$      |
| Octane     | $5.8 \times 10^{-04}$      |
| 1-Nonene*  | $8.0 \times 10^{-03}$      |
| Nonane     | $3.1 \times 10^{-04}$      |
| 1-Decene*  | $5.3 \times 10^{-03}$      |
| Decane     | $2.0 \times 10^{-03}$      |

\* contains up to 2 %wt. isomeric impurities based upon the weight of each individual component.

10 The selectivity of the supported ionic liquid membrane for olefinic hydrocarbons over their analogous paraffinic hydrocarbons over a 24 hour period is disclosed Table 3 below.

Table 3. Average selectivity over a 24 hour period for Example 1.

| Compounds            | Selectivity |
|----------------------|-------------|
| 1-Pentene* / Pentane | 16.8        |
| 1-Hexene* / Hexane   | 20.0        |
| 1-Heptene* / Heptane | 24.1        |
| 1-Octene* / Octane   | 22.4        |
| 1-Nonene* / Nonane   | 25.8        |
| 1-Decene* / Decane   | 2.7         |

15 \* contains up to 2 %wt. isomeric impurities based upon the weight of each individual component.

Example 2

The glass transport cell is assembled as described above. The membrane used is a polycarbonate membrane (Isopore (trade mark) membrane commercially available from Millipore, having an average pore diameter of 0.4  $\mu\text{m}$  and a membrane thickness of 10  $\mu\text{m}$ ). The ionic liquid composition is a 40 %mol solution of silver nitrate (commercially available from Sigma-Aldrich) in 1-butyl-3-methyl-imidazolium nitrate. The receiving phase solvent employed is heptane (commercially available from Merck KgaA, Frankfurter Str. 250, D-64293 Darmstadt, Germany) and the feedstock composition is derived from a Fischer-Tropsch synthesis, and has the composition set out in Table 4.

Table 4. Feedstock composition for Example 2.

| Compound    | %wt. of the feedstock composition |
|-------------|-----------------------------------|
| 1-Undecene* | 11.8                              |
| Undecane    | 37.6                              |
| 1-Dodecene* | 11.3                              |
| Dodecane    | 39.3                              |

\* contains up to 2 %wt. isomeric impurities based upon the weight of each individual component.

The average flux of the compounds through the supported ionic liquid membrane over a 24 hour period is disclosed in Table 5 below.

Table 5. Average flux over a 24 hour period for the compounds of Example 2.

| Compound    | Flux ( $\text{kg}/\text{m}^2\text{h}$ ) |
|-------------|-----------------------------------------|
| 1-Undecene* | $3.2 \times 10^{-03}$                   |
| Undecane    | $1.4 \times 10^{-04}$                   |
| 1-Dodecene* | $1.8 \times 10^{-03}$                   |
| Dodecane    | $7.5 \times 10^{-05}$                   |

\* contains up to 2 %wt. isomeric impurities based upon the weight of each individual component.

The selectivity of the supported ionic liquid membrane for olefinic hydrocarbons over their analogous paraffinic hydrocarbons over a 24 hour period is disclosed in Table 6 below.

5 Table 6. Average selectivity over a 24 hour period for Example 2.

| Compounds              | Selectivity |
|------------------------|-------------|
| 1-Undecene* / Undecane | 22.9        |
| 1-Dodecene* / Dodecane | 24.0        |

\* contains up to 2 %wt. isomeric impurities based upon the weight of each individual component.

#### Example 3

10 The glass transport cell is assembled as described above. The membrane used is a polycarbonate membrane (Isopore (trade mark) membrane commercially available from Millipore, having an average pore diameter of 0.4  $\mu\text{m}$  and a membrane thickness of 10  $\mu\text{m}$ ). The ionic liquid  
 15 composition is a 40 %mol solution of silver nitrate (commercially available from Sigma-Aldrich) in 1-butyl-3-methyl-imidazolium nitrate. The receiving phase solvent employed is heptane (commercially available from Merck kgaA) and the feedstock composition is derived from a  
 20 Fischer-Tropsch synthesis, and has the composition set out in Table 7.

Table 7. Feedstock composition for Example 3.

| Compound       | %wt. of the feedstock composition |
|----------------|-----------------------------------|
| 1-Tridecene*   | 9.3                               |
| Tridecane      | 44.8                              |
| 1-Tetradecene* | 7.6                               |
| Tetradecane    | 38.3                              |

\* contains up to 2 %wt. isomeric impurities based upon the weight of each individual component.

The average flux of the compounds through the supported ionic liquid membrane over a 24 hour period is disclosed in Table 8 below.

5                      Table 8. Average flux over a 24 hour period for the compounds of Example 3.

| Compound       | Flux (kg/m <sup>2</sup> h) |
|----------------|----------------------------|
| 1-Tridecene*   | $6.8 \times 10^{-03}$      |
| Tridecane      | $6.0 \times 10^{-04}$      |
| 1-Tetradecene* | $9.0 \times 10^{-03}$      |
| Tetradecane    | $4.8 \times 10^{-04}$      |

\* contains up to 2 %wt. isomeric impurities based upon the weight of each individual component.

10                      The selectivity of the supported ionic liquid membrane for olefinic hydrocarbons over their analogous paraffinic hydrocarbons over a 24 hour period is disclosed in Table 9 below.

Table 9. Average selectivity over a 24 hour period for Example 3.

| Compounds                    | Selectivity      |
|------------------------------|------------------|
| 1-Tridecene* / Tridecane     | 11.3 Not changed |
| 1-Tetradecene* / Tetradecane | 18.5 Not changed |

15                      \* contains up to 2 %wt. isomeric impurities based upon the weight of each individual component.

#### Example 4

20                      The glass transport cell is assembled as described above. The membrane used is a polycarbonate membrane (Isopore (trade mark) membrane commercially available from Millipore, having an average pore diameter of 0.4  $\mu$ m and a membrane thickness of 10  $\mu$ m). The ionic liquid composition is a 40 %mol solution of silver nitrate (commercially available from Sigma-Aldrich) in 1-butyl-3-methyl-imidazolium nitrate. The receiving phase solvent

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employed is tetradecane (commercially available from Sigma-Aldrich) and the feedstock has the composition set out in Table 10.

Table 10. Feedstock composition for Example 4.

| Compound                    | %wt. of the feedstock composition |
|-----------------------------|-----------------------------------|
| 1-Hexene                    | 3.1                               |
| Hexane                      | 3.2                               |
| 1-Octene                    | 4.2                               |
| Octane                      | 4.2                               |
| 1-Decene                    | 5.2                               |
| Decane                      | 5.3                               |
| 1-Dodecene                  | 6.2                               |
| Dodecane                    | 6.3                               |
| 1-Hexadecene                | 8.3                               |
| Hexadecane                  | 8.4                               |
| Heptane (internal standard) | 3.7                               |
| Tetradecane (solvent)       | to 100 %wt.                       |

- 5 The average flux of the compounds through the supported ionic liquid membrane over a 24 hour period is disclosed in Table 11 below.

Table 11. Average flux over a 24 hour period for the compounds of Example 4.

| Compound     | Flux (kg/m <sup>2</sup> h) |
|--------------|----------------------------|
| 1-Hexene     | $2.6 \times 10^{-6}$       |
| Hexane       | $1.3 \times 10^{-7}$       |
| 1-Octene     | $1.1 \times 10^{-6}$       |
| Octane       | $3.7 \times 10^{-8}$       |
| 1-Decene     | $3.6 \times 10^{-7}$       |
| Decane       | $1.3 \times 10^{-8}$       |
| 1-Dodecene   | $1.3 \times 10^{-7}$       |
| Dodecane     | $1.2 \times 10^{-8}$       |
| 1-Hexadecene | $3.1 \times 10^{-8}$       |
| Hexadecane   | $2.0 \times 10^{-8}$       |

The selectivity of the supported ionic liquid membrane for olefinic hydrocarbons over their analogous paraffinic hydrocarbons over a 24 hour period is disclosed in Table 12 below.

5      Table 12. Average selectivity over a 24 hour period for Example 4.

| Compounds                 | Selectivity |
|---------------------------|-------------|
| 1-Hexene / Hexane         | 20.0        |
| 1-Octene / Octane         | 29.7        |
| 1-Decene/ Decane          | 27.7        |
| 1-Dodecene / Dodecane     | 10.8        |
| 1-Hexadecene / Hexadecane | 1.6         |

Example 5

10      The glass transport cell is assembled as described above. The membrane used is a polycarbonate membrane (Isopore (trade mark) membrane commercially available from Millipore, having an average pore diameter of 0.4  $\mu\text{m}$  and a membrane thickness of 10  $\mu\text{m}$ ). The ionic liquid composition is a 40 %mol solution of silver nitrate  
15      (commercially available from Sigma-Aldrich) in 1-ethyl-3H-imidazolium nitrate (Synthesised according to: Ching K. Lee, Hsin W.Huang and Ivan J.B.Lin Chem.Comm., 2000, pages 1911-1912). The receiving phase solvent employed is tetradecane (commercially available from Sigma-  
20      Aldrich) and the feedstock has the composition set out in Table 10 above.

The average flux of the compounds through the supported ionic liquid membrane over a 24 hour period is disclosed in Table 13 below.

Table 13. Average flux over a 24 hour period for the compounds of Example 5.

| Compound     | Flux (kg/m <sup>2</sup> h) |
|--------------|----------------------------|
| 1-Hexene     | $3.1 \times 10^{-6}$       |
| Hexane       | $9.4 \times 10^{-8}$       |
| 1-Octene     | $1.1 \times 10^{-6}$       |
| Octane       | $1.6 \times 10^{-8}$       |
| 1-Decene     | $3.1 \times 10^{-7}$       |
| Decane       | $4.6 \times 10^{-9}$       |
| 1-Dodecene   | $7.7 \times 10^{-8}$       |
| Dodecane     | $9.0 \times 10^{-9}$       |
| 1-Hexadecene | $6.1 \times 10^{-9}$       |
| Hexadecane   | $3.2 \times 10^{-9}$       |

5 The selectivity of the supported ionic liquid membrane for olefinic hydrocarbons over their analogous paraffinic hydrocarbons over a 24 hour period is disclosed in Table 14 below.

Table 14. Average selectivity over a 24 hour period for Example 5.

| Compounds                 | Selectivity |
|---------------------------|-------------|
| 1-Hexene / Hexane         | 33.0        |
| 1-Octene / Octane         | 68.8        |
| 1-Decene / Decane         | 67.4        |
| 1-Dodecene / Dodecane     | 8.6         |
| 1-Hexadecene / Hexadecane | 1.9         |

10

#### Example 6

The glass transport cell is assembled as described above. The membrane used is a polycarbonate membrane (Isopore (trade mark) membrane commercially available from Millipore, having an average pore diameter of 0.4  $\mu$ m and a membrane thickness of 10  $\mu$ m). The ionic liquid composition is a 20 %mol solution of silver triflate (commercially available from Sigma-Aldrich) in 1-ethyl-3-methyl-imidazolium triflate (commercially available from

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Fluka, Industriestrasse 25, CH-9471 Buchs SG, Switzerland). The receiving phase solvent employed is tetradecane (commercially available from Sigma-Aldrich) and the feedstock has the composition set out in Table 10.

The average flux of the compounds through the supported ionic liquid membrane over a 24 hour period is disclosed in Table 15 below.

Table 15. Average flux over a 24 hour period for the compounds of Example 6.

| Compound     | Flux (kg/m <sup>2</sup> h) |
|--------------|----------------------------|
| 1-Hexene     | $7.8 \times 10^{-6}$       |
| Hexane       | $9.5 \times 10^{-7}$       |
| 1-Octene     | $4.6 \times 10^{-6}$       |
| Octane       | $3.0 \times 10^{-7}$       |
| 1-Decene     | $2.1 \times 10^{-6}$       |
| Decane       | $1.0 \times 10^{-7}$       |
| 1-Dodecene   | $8.4 \times 10^{-7}$       |
| Dodecane     | $4.3 \times 10^{-8}$       |
| 1-Hexadecene | $1.1 \times 10^{-7}$       |
| Hexadecane   | $5.4 \times 10^{-9}$       |

The selectivity of the supported ionic liquid membrane for olefinic hydrocarbons over their analogous paraffinic hydrocarbons over a 24 hour period is disclosed in Table 16 below.

Table 16. Average selectivity over a 24 hour period for Example 6.

| Compounds                 | Selectivity |
|---------------------------|-------------|
| 1-Hexene / Hexane         | 8.2         |
| 1-Octene / Octane         | 15.3        |
| 1-Decene / Decane         | 21.0        |
| 1-Dodecene / Dodecane     | 19.5        |
| 1-Hexadecene / Hexadecane | 20.3        |

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It is evident from the above examples that the process of the present invention results in the separation of olefinic hydrocarbons from paraffinic hydrocarbons in a liquid feedstock composition comprising  
5 olefinic hydrocarbons and paraffinic hydrocarbons with a high degree of selectivity. Further, it is evident from the above examples that the process of the present invention can separate olefinic hydrocarbons in the detergent range (e.g. C<sub>8</sub> - C<sub>16</sub>) from paraffinic  
10 hydrocarbons in a liquid feedstock composition. It is also evident from the above examples that the process of the present invention can selectively separate olefinic hydrocarbons from paraffinic hydrocarbons in a liquid feedstock composition having a broad spectrum of average  
15 carbon numbers.

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C L A I M S

1. A process for the separation of olefinic hydrocarbons from a liquid feedstock composition comprising at least one olefinic hydrocarbon and at least one paraffinic hydrocarbon, said process comprising contacting the liquid feedstock with  
5 a supported ionic liquid membrane, wherein the supported ionic liquid membrane comprises a membrane impregnated with an ionic liquid composition.
2. The process of claim 1, wherein said membrane is a mesoporous or macroporous polymer type membrane.
- 10 3. The process according to any one of claims 1 or 2, wherein the ionic liquid composition comprises an ionic liquid, the ionic liquid comprising a nitrogen-containing heterocyclic or heteroaromatic cation.
4. The process of any one of the preceding claims, wherein  
15 the nitrogen-containing heterocyclic or heteroaromatic cation is an optionally substituted imidazolium cation.
5. The process of any one of the preceding claims, wherein the ionic liquid composition comprises a metal salt capable of forming a complex with an olefin dissolved, dispersed or  
20 suspended in the ionic liquid compound.
6. The process of claim 5, wherein the metal salt comprises at least one salt selected from the salts of silver, copper, manganese, zinc, platinum, palladium, nickel, cobalt, iron, gold, ruthenium, rhodium, chromium, molybdenum, and mixtures  
25 thereof.
7. The process of any one of claims 5 or 6, wherein the metal salt is a silver or copper salt.

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8. The process of any one of claims 5 to 7, wherein the metal salt is selected from  $\text{AgNO}_3$ ,  $\text{AgCH}_3\text{SO}_3$ ,  $\text{AgCF}_3\text{SO}_3$ ,  $\text{AgCF}_3\text{SO}_2\text{NSO}_2\text{CF}_3$ ,  $\text{AgBF}_4$ ,  $\text{AgCF}_3\text{CO}_2$ , and mixtures thereof.

9. The process of any one of the preceding claims, wherein  
5 the liquid feedstock composition comprises at least one olefinic hydrocarbon which contains from 6 to 18 carbon atoms.

10. The process of any one of the preceding claims, wherein the liquid feedstock composition is derived from a Fischer-  
10 Tropsch process.