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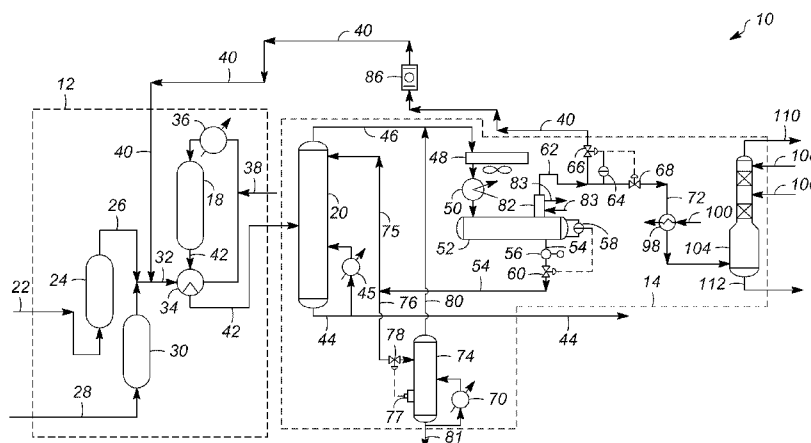


FIG. 1

(57) Abstract: Embodiments of methods and apparatuses for isomerization of paraffins are provided. In one example, a method comprises the steps of separating an isomerization effluent into a product stream that comprises branched paraffins and a stabilizer vapor stream that comprises HCl, H₂, and C₆- hydrocarbons. C₆- hydrocarbons are removed from the stabilizer overhead vapor stream to form a HCl and H₂-rich stream. An isomerization catalyst is activated using at least a portion of the HCl and H₂-rich stream to form a chloride-promoted isomerization catalyst. A paraffin feed stream is contacted with the chloride-promoted isomerization catalyst in the presence of hydrogen for isomerization of the paraffins.