

TABLE V. - LEUNA D.H.D. PLANT PROPERTIES OF FEED AND PRODUCTS

	0-85°C Light Petrol	85°-180°C Naphtha feed to D.H.D. Process	Stabilised D.H.D. Product	Final DHD Petrol Blend
Aniline Point	52	45	1.6	6.9
Aniline Point after treatment with sulphuric acid	55.4	-	63.2	61.0
Wt.% aromatics	4.5	9.5	66.0	52.0
Wt.% Naphthenes	46.2	51.2	7.9	14.4
Wt.% Paraffins	48.7	38.1	25.9	33.0
Wt.% Olefines	0.6	1.2	0.6	0.6
Motor Method Octane No.	73.5	52.0	82.5	80.5
Motor Method Octane No. with 0.12% by vol. TEL.	-	-	-	91.5

(ii) Costs

Dr. Pichler provided the following cost data for the DHD process.

The basic flowsheet assumed for the cost calculation is shown in Fig. XIII.

Table VI analyses the cost of manufacture of DHD gasoline in terms of raw material charges and operating costs and shews the credit for hydrocarbon gas.

Table VII gives a breakdown of the operating costs and provides the data on labour requirements, utilities consumption, etc., for calculation of the costs of the process if operated in U.S.A. or Britain.