## CONTENTS

			f	Page	Review of literature—Con.	T1
n	tro	ducti	on	1	Engineering development C.	Page
١,	ekrl	owie	gments	$\frac{1}{2}$	Engineering development—Con.	
ã	evib	w of	literature	$\tilde{2}$	Direct heat-transfer reac-	
Ĭ	Int	radu	ction	$\tilde{2}$	tors—Continued	
ı		913-	28	$\frac{2}{2}$	Solid heat-transfer opera-	
Ì	ir	928-	32	$\frac{2}{3}$	tion	25
H	rnh	netri	al development		Catalysts	26
f		dim	an expansion of com-	6	Nickel catalysts	26
I		4111	not expansion of com-		Cobalt-nickel catalysts	27
ı	İ	100	reial plants using		Cobalt catalysts	28
I		118	cher-Tropsch synthe-		Fischer's cobalt catalysts.	28
l	6	818_		6	German commercial nor-	
ı	Р	Hecil	d application of	Į	mal cobalt catalyst	28
ı	- 1	1	ischer-Tropsch re-	i	Other cobalt catalysts	$\overline{28}$
l		્રિથ	ction in Germany	8	Preparation of cobalt cata-	
ı		Бyп	thesis of isoparallins	ار	lysts	29
ĺ		l ai	nd aromatic hydrocar-	-	Conditioning of nickel and	20
		L_\$	ons	8	cobalt catalysts	32
		lvi a	nutacture of higher al-	· 1	Reactivation of cohalt cat.	02
	ĺ	1 4	phols in Germany by		alvsts	33
		1 1/1	odified Fischer-		alysts	99
		1 7	ropsch synthesis	9	eatalysts	34
	JF	iķch≰	er-Tropsch plants in		Analysis of cobalt cata-	0.1
		աստ	an	10	lysts	35
	- G	reat	Britain	10	Iron catalysts	35
	J1	aivi	Australia, Scotland.	- "	Iron-copper catalysts	35
	- 1	Sph	in, and Canada	111	Sintered-iron catalysts	- 38 38
	U	throde	1 States	12	Effect of alkali addition in	മര
	- IU	ener	al reviews	13	precipitated-iron cata-	
]	$\mathbb{E} hg$	ilneer	ring development	15	Two-to	90
	Ĥ	ikline	et heat-transfer re-		lysts Conditioning of iron cata-	38
		ala	tors	15	lyete	90
	1	$[\mathbf{M}_{\mathbf{P}}]$	tistage operation	15	lysts Ruthenium catalysts	39
		Mdr	mal-pressure opera-	- "	Effect of carrier on catalysts	39
	1	l ti	on	19	Effect of sulfur compounds	39
	1	Med	lium-pressure opera-	- "	on catalyst activity	40
		1 1/1	on	20	Pressure, diluents, hydrogen:	40
		Flhi	dized fixed bed, in-	-"	earbon monoxide ratio	
	İ	le	rnal heat exchanger	21		
	1	Ligh	nt - hydrocarbon - prod-	~	throughput, temperature,	
	ł	l lie	et recovery	21	adsorption, and probable	40
	İ	Rec	vele operations	$\frac{21}{21}$	reaction mechanism	42
	1	r	obalt catalysts	21	Effect of pressure	42
	1	Ír	on catalysts	22	Effect of diluents Hydrogen : carbon monox-	45
	D	reet	heat-transfer reac-	- [	ide matic	
		10	PS	23	ide ratio	45
		Greco	eous heat-transfer op-	20	Throughput	46
		1	eration	23	T CHIDEFILLIE	49
	i	<b>87</b> .	of-gas recycle	$\frac{23}{23}$	Adsorption	50
		Fi	uidized fixed bed, ex-	40	Discussion of reaction mech-	
	ĺ	[ '	ternal heat exchanger_	24	anism	51
	}	بيطنيا	id heat-transfer oper-	44:	Energy of activation	55
	Ì			24	Properties of Fischer-Tropsch	
		F	ationam process		synthesis products	56
i		1.1	adified from present	24	Primary products	56
ļ		17:	odified foam process_	24	Kogasin	56
			sadvantages of foam	0.4	Diesel oil	57
1	i	n.	process	24	raralin wax	58
		ا م	iftsehmid process	25	Fatty acids	59
Ì					116	

Review of literature—Con.	Page	Bureau of Mines, etc.—Con.	
Properties of Fischer-Tropech	 L	Effect of varieties Con.	Page
synthesis products—Con-		Effect of variations, etc.—Con.	
secondary products	50	INTERESTANCE CONSIL, etc.—Con	
Gasol	50	Latter tests on promoted	
Gasonne	FΛ	Codait catalysts: Repro-	
neining of primary	១ម	queibility of catalyst	
		preparations and tests	
Cracking of primary		l comparison of 30- and	
liquid products.		i 90-cm, catalyst denthe	
Storage teets	60	enect of different induc-	
Storage tests	61	tion procedures offici	
Determination of oc-		ciencies of different kie-	
tane number	62	selgubrs as carriers	
Lubricating oil	62	seiguirs as carriers, space-time yield at dif-	
ratty acids and related	j	ferent space velocities,	
products	65	and variation of	
wiscenaneous products	67	and variation of reac-	
Fischer-Tropsch cost estimates		tion temperature with	
Bureau of Minas	68	flow at constant con-	
Bureau of Mines research on		traction Characteristics of prod-	112
effect of catalyst preparation,		onaracteristics of prod-	
requesion, and induction pro-		. Webs HOR CODER POTO	
cedures on activity	71	IVETE	129
Catalyst-testing experiments	71	TO THE OWNER OF THE PROPERTY O	
introduction and summary	$7\overline{1}$	Con Of Catalysts With their ea.	
Preparation of catalyst	75	61 V 4 L V	131
Description of apparatus	77	-x-ing unitaction patterns and	101
Synthesis-one manufacture		magnetic properties of iron	
Collaidaning proceedings	88 88	catalysts	131
Reactivation procedures		introduction	
Effect of variations	90	Experimental methods	131
Effect of variations in methods		- ray dillraction studios	132
OI Catalyst preparation		Niagnetic studios	132
reduction, induction and		Ferric oxides and ferric ox-	132
synthesis conditions on		ide hydrates	105
activity and durability	91	X-ray diffraction studies of	137
tron_catalysts	91	unpromoted iron catalysts.	
Deleterious effect of chlo-	01	Magnetic studios of	144
rides on unpromoted iron		Magnetic studies of unpro-	1
catalysts prepared from	İ	Magnetic and V	151
ferrie salts	0-	Magnetic and X-ray diffrac-	Š.
left and a final tr	97	tion studies of promoted	
Effect of alkali on activity		iron catalysts	156
of unpromoted fron est-	[	That are properties of Fischer	4
atysts	97	Tropsch catalysts	158
Pillect of conditions of pro-		Cobalt Fischer-Tropsch cata-	3
cipitation of active un-		lystslron Fischer-Tropsch cata-	159
promoted iron catalysts.	98	busts busts	4
Effect of different induc-		11000	171
tion procedures and op-	I A	Product on preparation of cata_	
eration processing for			173
erating pressures for un-	0.5	Treparation of purposed	
promoted iron catalysts_	98	non cataivsts	173
Tests on promoted iron		* ' \ '	1
catalysts	103	lysts Preparation of No. 47 cata-	174
Nickel and cobalt catalysts	- 1	Preparation of No. 47 cata-	- 1 T
Proliminary 4.	108	lysts	175
Preliminary tests using		lysts Preparation of No. 50 cata-	175
11 vito Super-Cel as ear-		lysts	175
rier; durability test at		Preparation of No. 68 cata-	175
100 p. s. i. and effect of		lysts	
nitrogen in the synthesis		lysts Preparation of other un-	176
	108	promoted from setal-	·
	1	promoted iron catalysts	177

Appendix on preparation, etc.—Con. Preparation of promoted iron catalysts Preparation of Ruhrchemie iron catalysts Preparation of cobalt and nickel catalysts	178	Author index	Page 184 187 187 190 195
---	-----	--------------	---

## ILLUSTRATIONS

į.	Fig	
	1.	100- to 150-pound per square inch Fischer-Tropsch tube.
3	2.	Normal-pressure Fischer-Tropsch tube  Yield and character of products at 180° C. and various pressures  Intermediate-pressures synthesis yields and various pressures
	3.	Yield and character of products at 180° C, and various processing
		throughput. Single-tube converter (modified Downs type) January 1944.
ï	.5	Single-tube converter (modified Downs type) January 1014
	6	Flow diagram for first series of establish tests
	7	Flow diagram for first series of catalyst tests
	ί,	Product recovery system in first series of catalyst tests
	٥.	Flow diagram for "X" series of catalyst tests.
	10.	Charcoal trap for "X" series of catalyst tests
	11.	Charcoal trap for "X" series of catalyst tests  Pressure controller for liquid-vapor bath in "X" series of catalyst tests
	12.	Assembly of 12 [aboratory-scale   Fischer-Tropoch units
		and flow recorders in foreground
	14.	Assembly of 12 laboratory-scale Fischer-Tropsch units; flow meters and flow recorders in foreground.  Assembly of 12 laboratory-scale Fischer-Tropsch units; rear view, showing end-gas meters.  Vertical temperature gradient in 30-centimeter catalyst had
		showing end-gas meters showing end-gas meters
	15.	Vertical temperature gradient in 30-centimeter catalyst bed
	10.	- Vertical temperature gradient in the continuous cotal antiscal
.:	16.	DEDFOULEDING VOL COLOUSE DEGISSIONS and feet.
	18.	- Comparison of operations with an-continuous and on continuous documents
	19.	Comparison of induction at atmospheric pressure with that at 100
	20	
	21	Relative efficiency of Eiller Col and Cally (T.)
	<i>41.</i>	Relative efficiency of Filter-Cel and Celite (Johns-Manville Co.
	22	H. S. C.)  Relative efficiency of Portuguese kieselguhr and Filter-Cel  Relative entirity of polymers.
	92	Relative entirity of pollute (classes and Pilter-Cel
	0.4	Capacities with the 190
	24.	(about 0.3 bulk density) and granules (about 0.5 bulk density) and granules (about 0.6 bulk density) Space-time yield at different space velocities for Co: ThO <sub>2</sub> : MgO: kieselgubr at 18522002 C
	Z5.	- 1 101Q Of Off DOUGHT Weight Of Catalyst her hour of different continue at
		Dues for Co : Into : Mac : Kieseloning at 1859—9009 C
	26,	variation of temperature with flow of 2H <sub>s</sub> ± 1CO at constant and
	27.	Trandrigating rotalisations of santhesis on solut
	30.	
	31	X-ray diffraction patterns of some crystalline iron oxides and iron
	91,	TETAL CONTROLLED DUDICIES OF SOME CEVERALING FROM Oxides and Inc.
	04. 99	FACCION INCOMPADOS OF ICALGO DAMA PARA POR CONTROL PARA PARA PARA PARA PARA PARA PARA PAR
	ου,	25" OF UNITEDIAGE DELECTES OF HENDYOMOTOG Prop. on to broke
	υ	A-TRIV UIR FRELION DELECTES OF HUNDROIDGE divon antaleate
		A TRY CHITACLOR DELLCTOS OF Inpromotod iron cotalwate
	o.,	23°14 Y UNITECTION DELICENS OF INDEPENDING FOR Antalysis
	υ,,	racewon antrographs of unreduced-from calalysts
	38,	ANTIMY MILLIACTION HOWOUT DESTROYING OF VARIOUS INCO. Evanbour Distriction 1.
		catalysts and the crystalline ferric oxides and ferric oxide hydrates
		" The same to the Oxide Hydraues

## CONTENTS

Pig.		-
39.	Thermomagnetic curve for an iron Fischer-Tropsch catalyst	Page
		155
		157
	tobalite tobalite	160
43,		162
. , ,	pelleted catalysts 89H and 801 and reduced as 195° C. on reduced,	163
	catalyst 89.1	166
46.	Variation of activity of reduced-cobalt catalysts of the 89-series with surface areas of the unreduced catalysts	167
47.		170
	195° C	171