Preface by the Author

Chapter I. Phenol Production Process: Brief History and Trends

Chapter II. Phenol and Acetone Production Using a Cumene Method

II.1 Cumene to Cumene Hydroperoxide Oxidation

II.1.1 In Search of the Means for Improving the Commercial Process for Cumene Oxidation
II.1.1.1 The Chemical Approach
II.1.1.2 The Physical Approach. The Mass Transfer Effect on the Performance of a Commercial Process
II.1.2 Inhibition of Cumene to CHP Oxidation -- Problems and Solutions
II.1.3 Reactor Types and Optimum CHP Output Rate per Unit Volume of Reactors
II.1.4 Temperature, Pressure, Oxidizer Volume, and Cumene Conversion as Performance Factors
II.1.5 Oxygen Concentration in the Oxidizing Agent and Off-Gas
II.1.6 Safety Aspects of Cumene Oxidation Processes
II.1.7 Process Selectivity
II.1.8 Water-Emulsion Technology for Cumene Oxidation
II.1.9 “Dry” Technology for Cumene Oxidation
II.1.10 Off-Gas Treatment Stage
II.1.11 Cumene Stripping Stage

II.2 Technical Grade CHP Cleavage Technologies

II.2.1 General Overview
II.2.2 A One-Step Homogeneous CHP Cleavage Process
II.2.3 A One-Step “Boiling” CHP Cleavage Process
II.2.4 A Two-Step “Boiling” CHP Cleavage Process
II.2.4.1 Causes of Unstable and Hazardous Operation of Commercial Reactors
II.2.4.2 The Effect of Reflux Acetone on a “Boiling” Process Safety Level
II.2.4.3 Selectivity of a Two-Step “Boiling” Process
II.2.4.4 $\text{H}_2\text{SO}_4$ Concentration as a Process Stabilizing Factor
II.2.5 A Heterophase CHP Cleavage Process in Water-$\text{H}_2\text{SO}_4$
Table of Contents

II.2.6 A Two-Step Homogeneous CHP Cleavage Process
   II.2.6.1 Feed Composition
   II.2.6.2 Heat Removal and Safety
   II.2.6.3 Selectivity
   II.2.6.4 Process Operation in an Equimolar Phenol-Acetone Mixture
   II.2.6.5 Addition of a “Diluent”
II.2.7 Revamp of Obsolete Technologies and Plants
II.2.8 Capital Investment
II.2.9 Conclusions

II.3 Neutralization of CHP Cleavage Product

II.4 Separation and Purification of Products in a Phenol Process
   II.4.1 Technologies for Product Fractionation
   II.4.2 Quality of Phenol and Acetone
      II.4.2.1 Acetone Quality
      II.4.2.2 Phenol Quality
      II.4.2.3 The Problem of ortho-Cresol
      II.4.2.4 The Problem of Hydroxyacetone
   II.4.3 Hydrogenation of AMS into Cumene and Recovery of AMS Product
      II.4.3.1 Hydrogenation of AMS into Cumene
      II.4.3.2 Recovery of Target AMS
   II.4.4 Conclusions

II.5 Treatment of Phenol Tar as Waste Product

References

Глава III. Kinetics and Mechanism of Major Reactions in Phenol Production

III.1 Mechanism of Hydrocarbon Oxidation
   III.1.1 General Overview
   III.1.2 Radical Chain Propagation in Stable Cumene Oxidation
   III.1.3 The Role of Oxygen -- State of Knowledge
   III.1.4 The State of Oxygen in a Reaction Medium
   III.1.5 The Contributions of \( \text{O}_2^{\text{liquid}} \) and \( \text{O}_2^{\text{gas}} \) into a Cumene Oxidation Reaction
   III.1.6 Variable Concentration of Oxygen in the Oxidizing Agent
   III.1.7 Oxidation at a Variable Air Rate
**Table of Contents**

**III.1** Oxidation under Varying Pressure

**III.1.8** Oxidation under Varying Pressure

**III.1.9** The Roles of $O_2^{\text{gas}}$ and $O_2^{\text{liquid}}$ in the Mechanism of Cumene Oxidation Reaction

**III.1.10** Process Selectivity, in Regard to Contributions of $O_2^{\text{liquid}}$ and $O_2^{\text{gas}}$

**III.1.11** Orders of Reactions and Activation Parameters

**III.1.12** Termination of Reaction Chains

**III.1.13** Conclusions

**III.2** Mechanism and Kinetics of Acid-Catalyzed Cumene Hydroperoxide Cleavage

**III.3** Formation of $\alpha$-Methylstyrene Dimers and ortho- and para-Cumylphenols

**III.3.1** General Overview

**III.3.2** Structure of AMS Dimers

**III.3.3** Mechanism of Formation of AMS Dimers and Cumylphenols

**III.3.4** Conclusions

**III.4** Mechanism and Kinetics of Formation and Hydrolytic Conversion of DCP

**III.5** Formation of Diacetone Alcohol and Mesityl Oxide

**III.6** Hydroxyacetone Formation Routes in a Phenol Process

**III.6.1** Mechanism of HA Formation

**III.6.2** Conversions of Hydroxyacetone

**III.6.2.1** Alkaline Conversion of Hydroxyacetone

**III.6.2.2** Oxidative Conversion with NaOH Present

**III.6.3** Hydroxyacetone Oxidation by Permanganates

**III.6.4** HA Oxidation by KMnO$_4$ at Lower pH

**III.6.5** Hydroxyacetone Oxidation by $H_2O_2$

**III.6.6** Hydroxyacetone Oxidation by Air with Heterogeneous Catalyst

**III.7** Formation of ortho- and para-Cresols

**III.7.1** Cresol Formation at the Acetone/Phenol Fractionation Stage

**III.7.2** Cresol Formation in a Phenol Tar Cracker System

**III.8** Reaction Medium of a Phenol Process
Table of Contents

III.8.1 Reaction Medium of Cumene Oxidation
III.8.2 Reaction Medium of CHP/DCP Decomposition and DMBA Dehydration
  III.8.2.1 Water-Acid Solvent
  III.8.2.2 Organic Solvent: Phenol-Acetone-Cumene
III.8.3 Reaction Medium of the Neutralization Stage
III.8.4 Acetone as a Reaction Medium
III.8.5 Phenol as a Reaction Medium

References

Глava IV. Alternative Technologies for Phenol Production

IV.1 Benzene to Phenol Oxidation
  IV.1.1 Benzene to Phenol Oxidation With N₂O (The BTOP Process)
  IV.1.2 Technical Aspects of Oxidation With N₂O
  IV.1.3 Capital Investment Needs for Benzene Oxidation With N₂O
  IV.1.4 Manufacturing Cost for Benzene Oxidation With N₂O
  IV.1.5 Environmental Issues of Benzene Oxidation With N₂O
  IV.1.6 Conclusions regarding Benzene Oxidation With N₂O

IV.2 Joint Production of Phenol and Methyl Ethyl Ketone (MEK)
  IV.2.1 sec-Butylbenzene Oxidation
  IV.2.2 sec-Butylbenzene Hydroperoxide Cleavage
  IV.2.3 Fractionation and Purification of Target Products

IV.3 Cumene-Based Phenol and Acetone Production

IV.4 Wasteless Cumene-Based Process for Phenol-Acetone Production (WEPP)

IV.5 Conclusions

References