
X4500 SERIES HYDROPROCESSING



THE HIGH THROUGHPUT
EXPERIMENTATION
COMPANY



APPLICATIONS

- **Bottom of the Barrels Upgrading**
- **Hydrocracking**
- **Hydrotreating (HDS, HDN, HDM, HDO, HDA)**
- **Wax Upgrading, Dewaxing, Hydroisomerization**
- **Bio Feedstock Conversion**

hte's X4500 is designed to bring parallel catalyst testing and optimization to a range of hydroprocessing applications.

It is optimized for high-pressure applications in trickle-bed and up-flow processes, handling highly viscous feedstocks, e.g. HVGO or vacuum residue.

The system allows a special mode of pretreatment and hydrocracking reaction at different temperatures with in-series operation.

It increases productivity in the evaluation of heterogeneous catalysts while delivering high-quality data by matching the online and offline analysis.

BENEFITS

- Reliable, turnkey ready system following international industrial standards, developed over several years in hte's contract research programs.
- Complete lab-in-lab solution validated with your chemistry and immediately operational at your site.
- Proven, fully integrated workflow including on- and offline analytics, reactor loading, and data integration.
- Highly flexible system with online GC systems optimized for your application in high throughput experimentation.
- Sustainable investment covering a broad range of catalyst volumes from small amounts of powder to large amounts of shaped materials.

TECHNICAL FEATURES | X4500

Feed Section

- Mass-flow controlled dosing of feed gases. Total number of feed gases depending on customer requirement.
- Dosing of demanding feed stock at up to 150 °C for highly viscous feeds, e.g. vacuum residue
- Weighed feed container for immediate mass balancing
- Stirred liquid feed to avoid demixing
- Inbuilt catalyst activation with, e.g. DMDS
- Equal feed distribution in between reactors

Reactor Section

- Multi temperature zone oven to avoid cold spots without time-consuming and erroneous usage of heat tapes, allowing easy access, e.g. during maintenance
- Four different temperatures among the 16 reactors, temperature difference between reactors < 1 °C
- Reactor temperature up to 500 °C
- Reactor pressure up to 200 barg
- High flexibility of reactor dimensions with various inner diameters suitable for reactor volumes within the isothermal zone up to 10 ml

Gas Liquid Separation and Sampling

- Gas and liquid products are separated under reaction pressure
- Inbuilt online stripping of volatile components into gas phase, prevents clogging through by-products, e.g. ammonium polysulfide
- Automated sampling of gas and liquid products
- hte proprietary pressure control system to stabilize the reactor pressure during liquid product sampling
- Integrated liquid product sampling robot with multi-sampling rows allowing unattended liquid sampling over several days

Online Analytics

- Active reactor off-gas measurement for mass balancing
- Online analysis, e.g. GC or IR for determination of hydrocarbons and permanent gases
- Highly efficient analytical methods optimized for measurement of high throughput experiments, e.g. PIONA

Automatization

- hteControl™ for fully automated experiment control
- myhte™ for storage and processing of all data generated within the catalyst testing workflow
- Integration of liquid sample data generated from offline analysis, e.g. S/N, density, SIMDIST, MOC, metal components, etc.

Safety

- Concept according to international standards (equipment and product safety legislation, CE)
- Designed for automated 24/7 operation with controlled shutdown
- Complete enclosure with sensors (LEL, TOX, Smoke, Exhaust Flow, etc.) as ready-to-use system (hte's lab-in-lab solution)

Engineering Services

- Engineering services under one roof from design, assembly, validation to delivery of the test rig
- Global one-year warranty and further customer care through our dedicated service group

Validation

- Fully validated ready-to-use system. Usage of high-quality parts from well-known manufacturers, e.g. Swagelok, Bronkhorst, Brooks, VICI, WIKA, Emmerson, etc.
- Chemical validation at hte and at customer's site for FAT and SAT
- Dedicated training concept for unit operation

ENHANCEMENTS | X4500

- Advanced workflows and tools for faster and improved operation of the test rig
- Feed filtration workflow
- Reactor loading workflow
- Offline data integration workflow
- Second liquid feed available
- In-series reactors in up-flow and down-flow mode of operation
- Individual heaters for each reactor, for e.g. iso-conversion
- Status notification of test unit via mobile network, e.g. SMS, email
- Caustic scrubber or H₂S absorber technology available
- UL, NACE, Japanese High Pressure Gas Safety Act compliance, and many other certifications available

INFRASTRUCTURE REQUIREMENTS

Laboratory:

- Air-conditioned laboratory environment
- Floor loading capacity 500 kg/m²
- Typical footprint of test rig 3.8 m x 2.6 m x 1.1 m (WxHxD)
- Typical footprint of electrical cabinet 1.6 m x 2.3 m x 1 m (WxHxD)

Ventilation:

- Approx. 1,000 m³/h

Gas Supply (recommended):

- Feed gas with constant primary pressure (30 barg above reactor pressure)
- Analytical gas supply of 8 barg
- Instrument air of 6.5 barg

Power Supply:

- 230/400 VAC; 3-phase/neutral/PE; 5-wire system; other power supply, e.g. 110/208 VAC available upon request
- Energy demand approx. 10 kVA (stationary)
- UPS available

FOR BASIC TEST SYSTEM. FIGURES CAN VARY DEPENDING ON CUSTOMER REQUIREMENTS