



(43) International Publication Date  
23 February 2017 (23.02.2017)

- (51) International Patent Classification:  
*C01B 39/48* (2006.01)
- (21) International Application Number:  
PCT/US2016/034236
- (22) International Filing Date:  
26 May 2016 (26.05.2016)
- (25) Filing Language: English
- (26) Publication Language: English
- (30) Priority Data:  
62/207,454 20 August 2015 (20.08.2015) US  
14/871,174 30 September 2015 (30.09.2015) US
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mon, California 94583-0806 (US).
- (81) Designated States (*unless otherwise indicated, for every  
kind of national protection available*): AE, AG, AL, AM,  
AO, AT, AU, AZ, BA, BB, BG, BH, BN, BR, BW, BY,  
BZ, CA, CH, CL, CN, CO, CR, CU, CZ, DE, DK, DM,

DO, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT,  
HN, HR, HU, ID, IL, IN, IR, IS, JP, KE, KG, KN, KP, KR,  
KZ, LA, LC, LK, LR, LS, LU, LY, MA, MD, ME, MG,  
MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM,  
PA, PE, PG, PH, PL, PT, QA, RO, RS, RU, RW, SA, SC,  
SD, SE, SG, SK, SL, SM, ST, SV, SY, TH, TJ, TM, TN,  
TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

(84) Designated States (*unless otherwise indicated, for every  
kind of regional protection available*): ARIPO (BW, GH,  
GM, KE, LR, LS, MW, MZ, NA, RW, SD, SL, ST, SZ,  
TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, RU,  
TJ, TM), European (AL, AT, BE, BG, CH, CY, CZ, DE,  
DK, EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU,  
LV, MC, MK, MT, NL, NO, PL, PT, RO, RS, SE, SI, SK,  
SM, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ,  
GW, KM, ML, MR, NE, SN, TD, TG).

**Declarations under Rule 4.17:**

- *as to applicant's entitlement to apply for and be granted a  
patent (Rule 4.17(ii))*
- *as to the applicant's entitlement to claim the priority of the  
earlier application (Rule 4.17(iii))*

**Published:**

- *with international search report (Art. 21(3))*

(54) Title: SYNTHESIS OF ALUMINOSILICATE LEV FRAMEWORK TYPE ZEOLITES

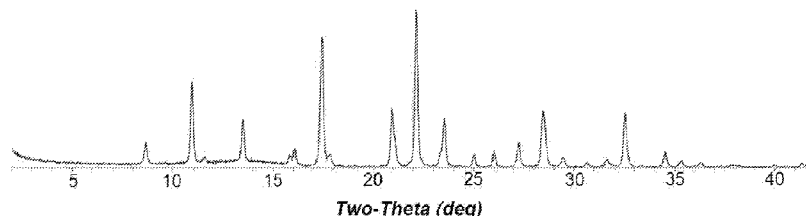


FIG. 1

(57) Abstract: A method is disclosed for making LEV framework type zeolites using N,N'-dimethyl-1,4-diazabicyclo[2.2.2]octane dications as a structure directing agent.



## SYNTHESIS OF ALUMINOSILICATE LEV FRAMEWORK TYPE ZEOLITES

### CROSS-REFERENCE TO RELATED APPLICATIONS

This application claims the priority benefit of U.S. Provisional Application No.  
5 62/207,454, filed August 20, 2015, which is incorporated herein by reference.

### TECHNICAL FIELD

[001] This disclosure relates generally to a method for preparing LEV  
framework type zeolites using N,N'-dimethyl-1,4-diazabicyclo[2.2.2]octane dications  
as a structure directing agent.

10

### BACKGROUND

[002] Molecular sieves are classified by the Structure Commission of the  
International Zeolite Association according to the rules of the IUPAC Commission on  
Zeolite Nomenclature. According to this classification, framework type zeolites and  
other crystalline microporous molecular sieves, for which a structure has been  
15 established, are assigned a three letter code and are described in the "*Atlas of Zeolite  
Framework Types*," Sixth Revised Edition, Elsevier, 2007.

[003] One known molecular sieve for which a structure has been established  
is the material designated as LEV, which is a molecular sieve characterized by  
heptadecahedral cavities to which LEV framework type materials owe their large  
20 micropore volume (about 0.3 cm<sup>3</sup>/g), although this structure only has small eight-  
membered ring (8MR) pore openings. Due to its unique structure, LEV framework  
type zeolites are of significant interest as catalysts for methanol-to-olefins (MTO)  
conversion and NO<sub>x</sub> reduction. Examples of LEV framework type materials include  
levyne, AIPO-35, CoDAF-4, LZ-132, NU-3, RUB-1, SAPO-35, ZK-20, and ZnAPO-35.

25 [004] Synthetic LEV framework zeolites are typically prepared using exotic  
organotemplates as structure directing agents, such as quinuclidine-based templates.  
The commercial development of LEV framework type zeolites has been hindered by  
the complexity of the structure directing agent required for its synthesis and hence  
there is significant interest in finding alternative structure directing agents for the

synthesis of aluminosilicate LEV framework type zeolites, particularly materials with  $\text{SiO}_2/\text{Al}_2\text{O}_3$  mole ratios that are suitable for MTO conversion and  $\text{NO}_x$  reduction applications.

[005] It has now been found that LEV framework type zeolites having  
 5  $\text{SiO}_2/\text{Al}_2\text{O}_3$  mole ratios ranging from 10 to 55 can be prepared using N,N'-dimethyl-1,4-diazabicyclo[2.2.2]octane dications as a structure directing agent. This cationic species can be produced conveniently and inexpensively from commercially available raw materials.

### SUMMARY

10 [006] In one aspect, there is provided a method of preparing LEV framework type zeolite by contacting under crystallization conditions (1) at least one source of silicon oxide; (2) at least one source of aluminum oxide; (3) at least one source of an element selected from Groups 1 and 2 of the Periodic Table; (4) N,N'-dimethyl-1,4-diazabicyclo[2.2.2]octane dications; and (5) hydroxide ions.

15 [007] In another aspect, there is provided a process for preparing an LEV framework type zeolite by: (a) preparing a reaction mixture containing: (1) at least one source of silicon oxide; (2) at least one source of aluminum oxide; (3) at least one source of an element selected from Groups 1 and 2 of the Periodic Table; (4) N,N'-dimethyl-1,4-diazabicyclo[2.2.2]octane dications; (5) hydroxide ions; and (6) water;  
 20 and (b) subjecting the reaction mixture to crystallization conditions sufficient to form crystals of the LEV framework type zeolite.

[008] In one aspect, there is provided an aluminosilicate LEV framework type zeolite containing N,N'-dimethyl-1,4-diazabicyclo[2.2.2]octane dications within its pore structure.

25 [009] In another aspect, there is also provided a crystalline LEV framework type zeolite having a composition, as-synthesized and in the anhydrous state, in terms of mole ratios, as follows:

	Broad	Exemplary
$\text{SiO}_2/\text{Al}_2\text{O}_3$	10 to 55	15 to 40
Q/ $\text{SiO}_2$	0.02 to 0.20	0.05 to 0.20

M/SiO <sub>2</sub>	0.01 to 0.20	0.02 to 0.15
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wherein Q represents N,N'-dimethyl-1,4-diazabicyclo[2.2.2]octane dications and M is selected from the group consisting of elements from Groups 1 and 2 of the Periodic Table.

### BRIEF DESCRIPTION OF THE DRAWINGS

5 [010] FIG. 1 is a powder X-ray diffraction (XRD) pattern of the as-synthesized zeolite prepared in Example 1.

[011] FIG. 2 is a scanning electron micrograph (SEM) image of the as-synthesized zeolite prepared in Example 1.

### DETAILED DESCRIPTION

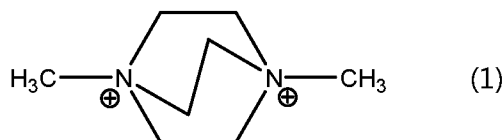
10 [012] The following terms will be used throughout the specification and will have the following meanings unless otherwise indicated.

[013] The term "zeolite" refers to crystalline aluminosilicate compositions which are microporous and which are formed from corner-sharing AlO<sub>2</sub> and SiO<sub>2</sub> tetrahedra.

15 [014] The term "framework type" is used in the sense described in the *Atlas of Zeolite Framework Types*, Sixth Revised Edition, Elsevier, 2007.

[015] As used herein, the numbering scheme for the Periodic Table Groups is as disclosed in *Chem. Eng. News*, 63(5), 26-27 (1985).

[016] In preparing LEV framework type zeolites, an N,N'-dimethyl-1,4-diazabicyclo[2.2.2]octane dication is used as a structure directing agent ("SDA"), also  
20 known as a crystallization template. The SDA useful for making LEV framework type zeolites is represented by the following structure (1):



N,N'-dimethyl-1,4-diazabicyclo[2.2.2]octane dication

[017] The SDA cation is associated with anions which can be any anion that is  
25 not detrimental to the formation of the zeolite. Representative anions include

elements from Group 17 of the Periodic Table (e.g., fluoride, chloride, bromide, and iodide), hydroxide, sulfate, tetrafluoroborate, acetate, carboxylate, and the like.

#### Reaction Mixture

[018] In general, the aluminosilicate LEV framework type zeolite is prepared by: (a) preparing a reaction mixture containing (1) at least one source of silicon oxide; (2) at least one source of aluminum oxide; (3) at least one source of an element selected from Groups 1 and 2 of the Periodic Table; (4) N,N'-dimethyl-1,4-diazabicyclo[2.2.2]octane dications; (5) hydroxide ions; and (6) water; and (b) subjecting the reaction mixture to crystallization conditions sufficient to form crystals of the LEV framework type zeolite.

[019] The composition of the reaction mixture from which the zeolite is formed, in terms of mole ratios, is identified in Table 1 below:

TABLE 1

	Broad	Exemplary
$\text{SiO}_2/\text{Al}_2\text{O}_3$	10 to 100	15 to 60
$\text{M}/\text{SiO}_2$	0.05 to 0.80	0.10 to 0.45
$\text{Q}/\text{SiO}_2$	0.10 to 0.80	0.15 to 0.30
$\text{OH}/\text{SiO}_2$	0.20 to 1.00	0.20 to 0.60
$\text{H}_2\text{O}/\text{SiO}_2$	10 to 50	15 to 50

wherein compositional variables M and Q are as described herein above.

[020] Sources useful herein for silicon oxide include fumed silica, precipitated silicates, silica hydrogel, silicic acid, colloidal silica, tetra-alkyl orthosilicates (e.g., tetraethyl orthosilicate), and silica hydroxides.

[021] Sources useful herein for aluminum oxide include aluminates, alumina, and aluminum compounds (e.g., aluminum chloride, aluminum hydroxide, and aluminum sulfate), kaolin clays, and other zeolites (e.g., zeolite Y).

[022] As described herein above, for each embodiment described herein, the reaction mixture can be formed using at least one source of an element selected from Groups 1 and 2 of the Periodic Table (referred to herein as M). In one sub-embodiment, the reaction mixture is formed using a source of an element from

Group 1 of the Periodic Table. In another sub-embodiment, the reaction mixture is formed using a source of sodium (Na). Any M-containing compound which is not detrimental to the crystallization process is suitable. Sources for such Groups 1 and 2 elements include oxides, hydroxides, nitrates, sulfates, halides, acetates, oxalates and  
5 citrates thereof.

[023] Optionally, the reaction mixture may contain seed crystals. In one embodiment, synthesis of the crystalline zeolite is facilitated by the presence of 0.05 to 10.0 wt. % (e.g., from 1 to 5 wt. %) seed crystals based on the total weight of the reaction mixture. The seed crystals can be isostructural with the desired zeolite,  
10 for example, the product of a previous synthesis.

[024] For each embodiment described herein, the reaction mixture can be supplied by more than one source. Also, two or more reaction components can be provided by one source.

[025] The reaction mixture can be prepared either batch wise or  
15 continuously. Crystal size, morphology and crystallization time of the crystalline zeolite described herein can vary with the nature of the reaction mixture and the crystallization conditions.

#### Crystallization and Post-Synthesis Treatment

[026] Crystallization of the LEV framework type zeolite described herein can  
20 be carried out under either static, tumbled or stirred conditions in a suitable reactor vessel, such as for example polypropylene jars or Teflon-lined or stainless steel autoclaves, at a temperature of from 125°C to 200°C for a time sufficient for crystallization to occur at the temperature used, e.g., from 1 day to 28 days.

[027] Once the zeolite crystals have formed, the solid product is separated  
25 from the reaction mixture by standard mechanical separation techniques such as centrifugation or filtration. The crystals are water-washed and then dried to obtain the as-synthesized zeolite crystals. The drying step is typically performed at a temperature of less than 200°C.

[028] As a result of the crystallization process, the recovered crystalline zeolite product contains within its pore structure at least a portion of the structure directing agent used in the synthesis.

[029] The structure directing agent is typically at least partially removed from the zeolite by calcination before use. Calcination consists essentially of heating the zeolite comprising the structure directing agent at a temperature of from 200°C to 800°C in the presence of an oxygen-containing gas, optionally in the presence of steam. The structure directing agent can also be removed by photolysis techniques as described in U.S. Patent No. 6,960,327.

[030] To the extent desired and depending on the composition of the zeolite, any cations in the as-synthesized or calcined zeolite can be replaced in accordance with techniques well known in the art by ion exchange with other cations. Preferred replacing cations include metal ions, hydrogen ions, hydrogen precursor, e.g., ammonium ions and mixtures thereof. Particularly preferred cations are those which tailor the catalytic activity for certain hydrocarbon conversion reactions. These include hydrogen, rare earth metals and metals of Groups 2 to 15 of the Periodic Table of the Elements. As used herein, the term "as-synthesized" refers to the zeolite in its form after crystallization, prior to removal of the SDA cation.

[031] The zeolite disclosed herein can be formulated with into a catalyst composition by combination with other materials, such as binders and/or matrix materials, which provide additional hardness or catalytic activity to the finished catalyst.

#### Characterization of the Zeolite

[032] The LEV framework type zeolites made by the process disclosed herein have a composition (in terms of mole ratios), as-synthesized and in the anhydrous state, as described in Table 2 below:

TABLE 2

	Broad	Exemplary
$\text{SiO}_2/\text{Al}_2\text{O}_3$	10 to 55	15 to 40
$\text{Q}/\text{SiO}_2$	0.02 to 0.20	0.05 to 0.20

M/SiO <sub>2</sub>	0.01 to 0.20	0.02 to 0.15
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wherein compositional variables Q and M are as described herein above.

[033] It should be noted that the as-synthesized form of the LEV framework type zeolite may have molar ratios different from the molar ratios of reactants of the reaction mixture used to prepare the as-synthesized form. This result may occur due to incomplete incorporation of 100% of the reactants of the reaction mixture into the crystals formed (from the reaction mixture).

[034] The LEV framework type zeolites synthesized by the process described herein are characterized by their X-ray diffraction pattern. X-ray diffraction patterns representative of LEV framework type zeolites can be referenced in the "*Collection of Simulated XRD Powder Patterns for Zeolites*," Fifth Revised Edition, Elsevier, 2007. Minor variations in the diffraction pattern can result from variations in the mole ratios of the framework species of the particular sample due to changes in lattice constants. In addition, sufficiently small crystals will affect the shape and intensity of peaks, leading to significant peak broadening. Minor variations in the diffraction pattern can result from variations in the organic compound used in the preparation. Calcination can also cause minor shifts in the X-ray diffraction pattern. Notwithstanding these minor perturbations, the basic crystal structure remains unchanged.

[035] The powder X-ray diffraction patterns presented herein were collected by standard techniques. The radiation was CuK<sub>α</sub> radiation. The peak heights and the positions, as a function of 2θ where θ is the Bragg angle, were read from the relative intensities of the peaks, and *d*, the interplanar spacing corresponding to the recorded lines, can be calculated.

### EXAMPLES

[036] The following illustrative examples are intended to be non-limiting.

#### EXAMPLE 1

[037] 1.30 g of deionized water, 4.70 g of sodium silicate solution (Sigma-Aldrich) and 5.95 g of a 19% N,N'-dimethyl-1,4-diazabicyclo[2.2.2]octane hydroxide



solution (SACHEM Inc.) were mixed together in a Teflon liner. Then, 1.00 g of LZ-210 Y-zeolite powder was added to the solution. The resulting gel was stirred until it became homogeneous. The liner was capped and placed within a Parr steel autoclave reactor. The autoclave was placed in an oven and heated at 135°C for 4 days. The solid products were recovered from the cooled reactor by centrifugation, washed with deionized water and dried at 95°C.

[038] The resulting product was analyzed by powder XRD and SEM. The powder XRD pattern is shown in FIG. 1 and indicates that the material is a pure LEV framework type zeolite. The SEM image is shown in FIG. 2 and indicates a uniform field of crystals.

[039] The product had a  $\text{SiO}_2/\text{Al}_2\text{O}_3$  mole ratio of 14.6, as determined by ICP elemental analysis.

#### EXAMPLE 2

[040] 4.03 g of deionized water, 19.32 g of sodium silicate solution (Sigma-Aldrich) and 22.33 g of a 19% N,N'-dimethyl-1,4-diazabicyclo[2.2.2]octane hydroxide solution (Sachem) were mixed together in a Teflon liner. Then, 3.00 g of LZ-210 Y-zeolite powder was added to the solution. The resulting gel was stirred until it became homogeneous. The liner was capped and placed within a Parr steel autoclave reactor. The autoclave was placed in an oven and heated at 150°C for 3 days. The solid products were recovered from the cooled reactor by centrifugation, washed with deionized water and dried at 95°C.

[041] The resulting product was identified by powder XRD and SEM to be pure LEV framework type zeolite.

[042] The product had a  $\text{SiO}_2/\text{Al}_2\text{O}_3$  mole ratio of 17.4, as determined by ICP elemental analysis.

#### EXAMPLE 3

[043] 14.10 g of sodium silicate solution (Sigma-Aldrich) and 26.80 g of 19% N,N'-dimethyl-1,4-diazabicyclo[2.2.2]octane hydroxide solution (Sachem) were mixed together in a Teflon liner. Then, 3.00 g of CBV720 Y-zeolite powder (Zeolyst

International, SiO<sub>2</sub>/Al<sub>2</sub>O<sub>3</sub> mole ratio = 30) was added to the solution. The resulting gel was stirred until it became homogeneous. The liner was capped and placed within a Parr steel autoclave reactor. The autoclave was placed in an oven and heated at 150°C for 3 days. The solid products were recovered from the cooled reactor by centrifugation, washed with deionized water and dried at 95°C.

[044] The resulting product was identified by powder XRD and SEM to be pure LEV framework type zeolite.

[045] The product had a SiO<sub>2</sub>/Al<sub>2</sub>O<sub>3</sub> mole ratio of 18.6, as determined by ICP elemental analysis.

10

#### EXAMPLE 4

[046] The as-synthesized zeolite product of Example 1 was calcined inside a muffle furnace under a flow of air heated to 540°C at a rate of 1°C/minute and held at 540°C for 5 hours, cooled and then analyzed by powder XRD. The powder XRD pattern indicated that the material remains stable after calcination to remove the organic SDA.

15

#### EXAMPLE 5

[047] The calcined product from Example 4 was subjected to a micropore volume analysis using N<sub>2</sub> as adsorbate and via the BET method. The zeolite exhibited a considerable void volume with a micropore volume of 0.25 cm<sup>3</sup>/g.

20

#### EXAMPLE 6

##### Methanol Conversion

[048] Ammonium-exchanged product was pelletized at 5 kpsi, crushed and meshed to 20-40. 0.20 g of catalyst (diluted 4:1 v/v with alundum) was centered in a stainless steel downflow reactor in a split tube furnace. The catalyst was pre-heated in-situ under flowing nitrogen at 400°C. A feed of 10% methanol in nitrogen was introduced into the reactor at a rate of 1.3 h<sup>-1</sup> WHSV.

25

[049] Reaction data was collected using a plug flow and an Agilent on-line gas chromatograph with an FID detector. Reaction products were analyzed at various time points on an HP-PLOT Q column. The results are summarized in Table 3.

TABLE 3

Product	0.4 Hour Data	0.7 Hour Data	1.1 Hour Data	1.5 Hour Data
Conversion	1.00	1.00	1.00	1.00
Sum C <sub>1</sub> -C <sub>3</sub> paraffins	0.18	0.16	0.10	0.09
Ethylene	0.50	0.60	0.59	0.55
Propylene	0.20	0.18	0.15	0.13
Summed Butanes/Butenes	0.06	0.02	0.02	0.03
Summed Pentanes/Pentenes	0.06	0.03	0.13	0.21
Ethylene/Propylene ratio	2.49	3.35	3.86	4.28

[050] The products shown in Table 3 are consistent with those for a small pore zeolite in terms of product shape-selectivity in the reaction of methanol being catalytically converted to olefins of mostly C<sub>2</sub>-C<sub>4</sub> size. No aromatic products were  
 5 observed.

[051] As used herein, the term "comprising" means including elements or steps that are identified following that term, but any such elements or steps are not exhaustive, and an embodiment can include other elements or steps.

[052] Unless otherwise specified, the recitation of a genus of elements,  
 10 materials or other components, from which an individual component or mixture of components can be selected, is intended to include all possible sub-generic combinations of the listed components and mixtures thereof.

[053] All documents cited in this application are herein incorporated by reference in their entirety to the extent such disclosure is not inconsistent with this  
 15 text.

### CLAIMS

1. A method of preparing an LEV framework type zeolite, comprising:

(a) preparing a reaction mixture containing:

(1) at least one source of silicon oxide;

5 (2) at least one source of aluminum oxide;

(3) at least one source of an element (M) selected from Groups 1 and 2 of the Periodic Table;

(4) N,N'-dimethyl-1,4-diazabicyclo[2.2.2]octane dications (Q);

(5) hydroxide ions; and

10 (6) water; and

(b) subjecting the reaction mixture to crystallization condition sufficient to form crystals of the zeolite.

2. The method of claim 1, wherein the zeolite is prepared from a reaction

15 mixture comprising, in terms of mole ratios, the following:

$\text{SiO}_2/\text{Al}_2\text{O}_3$	10 to 100
$\text{M}/\text{SiO}_2$	0.05 to 0.80
$\text{Q}/\text{SiO}_2$	0.10 to 0.80
$\text{OH}/\text{SiO}_2$	0.20 to 1.00
$\text{H}_2\text{O}/\text{SiO}_2$	10 to 50

3. The method of claim 1, wherein the zeolite is prepared from a reaction comprising, in terms of mole ratios, the following:

$\text{SiO}_2/\text{Al}_2\text{O}_3$	15 to 60
$\text{M}/\text{SiO}_2$	0.10 to 0.45
$\text{Q}/\text{SiO}_2$	0.15 to 0.30
$\text{OH}/\text{SiO}_2$	0.20 to 0.60
$\text{H}_2\text{O}/\text{SiO}_2$	15 to 30

20 4. The method of claim 1, wherein the zeolite has a composition, as-synthesized and in the anhydrous state, in terms of mole ratios, as follows:

$\text{SiO}_2/\text{Al}_2\text{O}_3$	10 to 55
--------------------------------------	----------

Q/SiO <sub>2</sub>	0.02 to 0.20
M/SiO <sub>2</sub>	0.01 to 0.20

5. The method of claim 1, wherein the zeolite has a composition, as-synthesized and in the anhydrous state, in terms of mole ratios, as follows:

SiO <sub>2</sub> /Al <sub>2</sub> O <sub>3</sub>	15 to 40
Q/SiO <sub>2</sub>	0.05 to 0.20
M/SiO <sub>2</sub>	0.02 to 0.15

5 6. An aluminosilicate LEV framework type zeolite comprising N,N'-dimethyl-1,4-diazabicyclo[2.2.2]octane dications within in its pore structure.

7. The zeolite of claim 6, wherein the zeolite has a SiO<sub>2</sub>/Al<sub>2</sub>O<sub>3</sub> mole ratio of from 10 to 55.

10

8. The zeolite of claim 6, wherein the zeolite has a SiO<sub>2</sub>/Al<sub>2</sub>O<sub>3</sub> mole ratio of from 15 to 40.

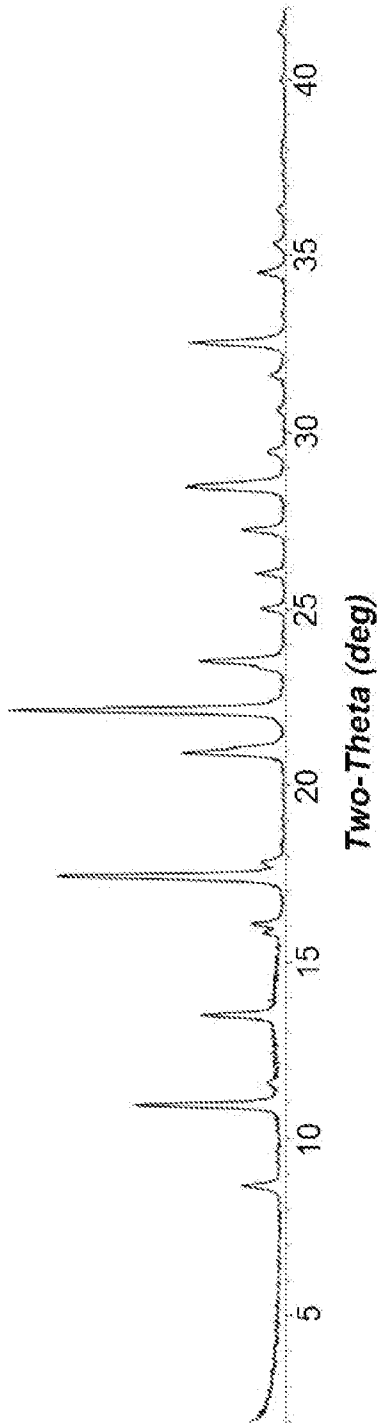


FIG. 1

2/2

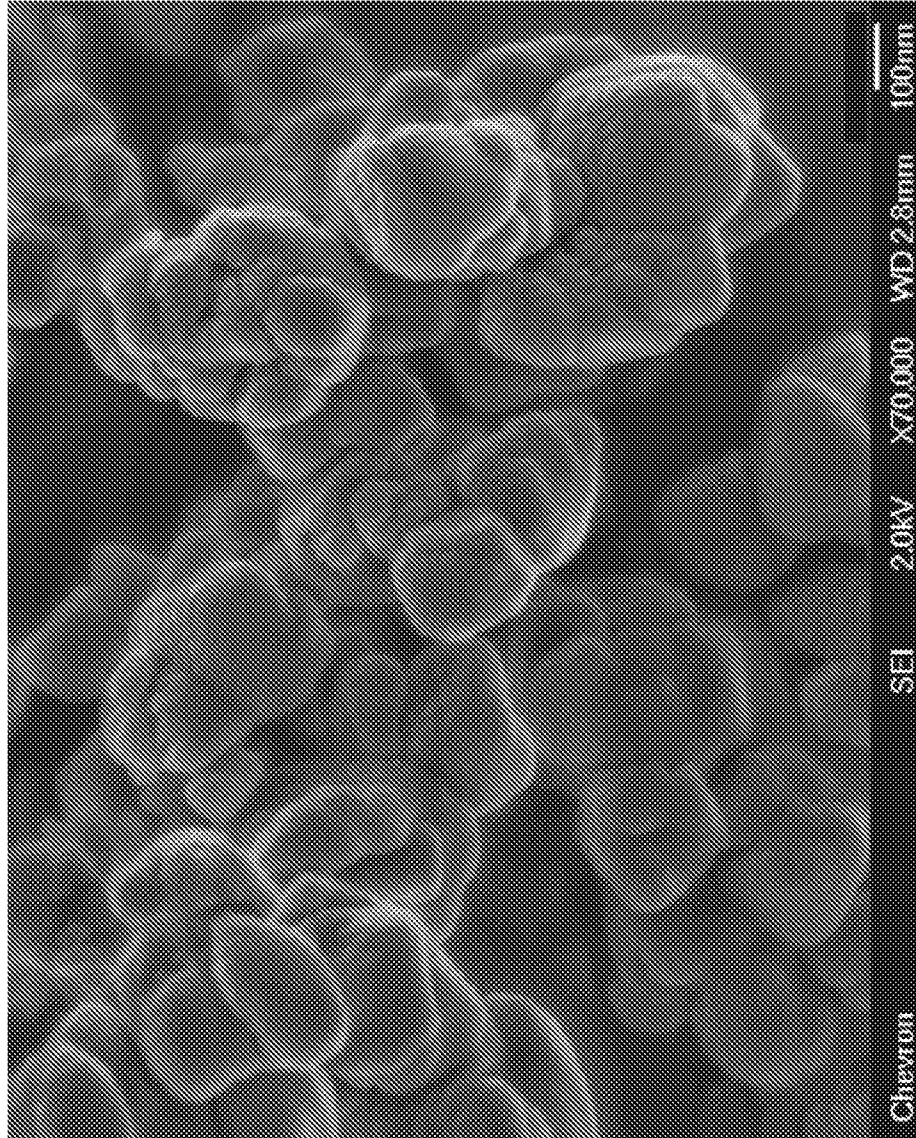


FIG. 2

**INTERNATIONAL SEARCH REPORT**

International application No  
PCT/US2016/034236

**A. CLASSIFICATION OF SUBJECT MATTER**  
 INV. C01B39/48  
 ADD.

According to International Patent Classification (IPC) or to both national classification and IPC

**B. FIELDS SEARCHED**

Minimum documentation searched (classification system followed by classification symbols)  
 C01B

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)  
 EPO-Internal, COMPENDEX, INSPEC, WPI Data

**C. DOCUMENTS CONSIDERED TO BE RELEVANT**

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 3 692 470 A (CIRIC JULIUS) 19 September 1972 (1972-09-19) column 1, lines 10-17 column 2, line 33 - column 3, line 20 column 7, line 56 - column 8, line 26; example 1; table 2 claims 1-6 the whole document ----- -/--	1-8

Further documents are listed in the continuation of Box C.

See patent family annex.

\* Special categories of cited documents :

<p>"A" document defining the general state of the art which is not considered to be of particular relevance</p> <p>"E" earlier application or patent but published on or after the international filing date</p> <p>"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</p> <p>"O" document referring to an oral disclosure, use, exhibition or other means</p> <p>"P" document published prior to the international filing date but later than the priority date claimed</p>	<p>"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</p> <p>"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone</p> <p>"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art</p> <p>"&amp;" document member of the same patent family</p>
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Date of the actual completion of the international search  12 August 2016	Date of mailing of the international search report  24/08/2016
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Name and mailing address of the ISA/ European Patent Office, P.B. 5818 Patentlaan 2 NL - 2280 HV Rijswijk Tel. (+31-70) 340-2040, Fax: (+31-70) 340-3016	Authorized officer  Follens, Lana
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## INTERNATIONAL SEARCH REPORT

International application No  
PCT/US2016/034236

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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