

## Typical Composition Of 1,3-Butadiene Product

The PLANT shall be designed to produce a 1,3-Butadiene product meeting the following specifications:

S.N	Properties	Unit	Limit	Spec.	Note
1.	1,3-Butadiene as Received	wt. %	min.	99.7	
2.	1,2-Butadiene	wppm	max.	20	
3.	Butadiene Dimer as	wt. %	max.	0.005	
4.	C5's	wppm	max.	50	
5.	Isoprene	wppm	max.	10	
6.	Total Acetylene	wppm	max.	20	All acetylenes
7.	Vinyl Acetylene	wppm	max.	5	
8.	Non Volatile Residue	wt. %	max.	0.01	
9.	Carbonyls as Acetaldehyde	wppm	max.	10	Note 1
10.	Peroxides as H <sub>2</sub> O <sub>2</sub>	wppm	max.	5	
11.	Inhibitor	wppm	max.	50~150	As treatment
12.	Oxygen in vapor	vol. %	max.	0.1	
13.	Water	wppm	max.	150	
14.	Solvent	wppm	max.	5	
15.	Appearance	wppm		Clear	

Note: 1. Assumes the carbonyls in the Design Feed (Case 1A) are 100 wppm or Less.