



EPA

United States
Environmental Protection
Agency

The Presidential Green Chemistry Challenge

*Award Recipients
1996–2008*



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Environmental Protection
Agency

744F08008
June 2008
www.epa.gov/greenchemistry

Office of Pollution Prevention and Toxics (7406M)

***The Presidential
Green Chemistry Challenge***

Award Recipients
1996—2008

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Introduction

The Presidential Green Chemistry Challenge Awards Program is an opportunity for individuals, groups, and organizations to compete for annual awards in recognition of innovations in cleaner, cheaper, smarter chemistry. The Program provides national recognition for outstanding chemical technologies that incorporate the principles of green chemistry into chemical design, manufacture, and use. In addition, winning technologies have been or can be used by industry to achieve its pollution prevention goals. The U.S. EPA typically honors five winners each year, one in each of the following categories:

- **Academia**
- **Small business**
- **Greener Synthetic Pathways**, such as the use of innocuous and renewable feedstocks (e.g., biomass, natural oils); novel reagents or catalysts including biocatalysts and microorganisms; natural processes including fermentation and biomimetic syntheses; atom-economical syntheses; or convergent syntheses
- **Greener Reaction Conditions**, such as the replacement of hazardous solvents with greener solvents; solventless or solid-state reactions; improved energy efficiency; novel processing methods; or the elimination of energy- and material-intensive separations and purifications
- **Designing Greener Chemicals**, such as chemicals that are less toxic than current alternatives; inherently safer chemicals with regard to accident potential; chemicals recyclable or biodegradable after use; or chemicals safer for the atmosphere (e.g., do not deplete ozone or form smog)

Award Winners

This booklet presents the 1996 through 2008 Presidential Green Chemistry Challenge Award recipients and describes their award-winning technologies. Each winner demonstrates a commitment to designing, developing, and implementing a green chemical technology that is scientifically innovative, economically feasible, and less hazardous to human health and the environment.

Environmental Results

Collectively, these award-winning technologies have:

- Eliminated more than 1.1 billion pounds of hazardous chemicals and solvents,
- Saved over 21 billion gallons of water, and
- Eliminated nearly 400 million pounds of carbon dioxide releases to air.

The Presidential Green Chemistry Challenge Program is looking forward to adding future years' winners to the growing list of scientists and companies who are on the cutting edge of pollution prevention.

2008 Winners

Academic Award

Professors Robert E. Maleczka, Jr. and Milton R. Smith, III
Michigan State University

Green Chemistry for Preparing Boronic Esters

Innovation and Benefits

One way to build complex molecules, such as pharmaceuticals and pesticides, is with a Suzuki "coupling" reaction. This versatile coupling reaction requires precursors with a carbon-boron bond. Making these precursors, however, typically requires harsh conditions and generates significant amounts of hazardous waste. Professors Maleczka and Smith developed a new catalytic method to make these compounds under mild conditions and with minimal waste and hazard. Their discovery allows the rapid, green manufacture of chemical building blocks, including some that had been commercially unavailable or environmentally unattractive.

"Coupling" reactions are one way to build valuable molecules, such as pharmaceuticals, pesticides and similar complex substances. Coupling reactions connect two smaller molecules, usually through a new carbon-carbon (C-C) bond. A particularly powerful coupling reaction is the Suzuki coupling, which uses a molecule containing a carbon-boron bond to make a larger molecule through a new C-C bond. In fact, the Suzuki coupling is a well-established, mild, versatile method for constructing C-C bonds and has been reported to be the third most common C-C bond-forming reaction used to prepare drug candidates.

Chemical compounds with a carbon-boron bond are often prepared from the corresponding halides by Grignard or lithiate formation followed by reaction with trialkyl borate esters and hydrolytic workup. Miyaura improved this reaction with a palladium catalyst, but even this new reaction requires a halide precursor.

Several years ago, Professors Milton R. Smith, III and Robert E. Maleczka, Jr. began collaborating to find a “halogen-free” way to prepare the aryl and heteroaryl boronic esters that are the key building blocks for Suzuki couplings. Their collaboration builds upon Smith’s invention of the first thermal, catalytic arene carbon–hydrogen bond (C–H) activation/borylation reaction. This led to transformations using iridium catalysts that are efficient, have high yields, and are tolerant of a variety of functional groups (alkyl, halo-, carboxy, alkoxy-, amino, etc.). Sterics, not electronics dictate the regiochemistry of the reactions. As a consequence, 1,3-substituted arenes give only 5-boryl (i.e., *meta*-substituted) products, even when both the 1- and 3-substituents are ortho/para directing. Just as significantly, the reactions are inherently clean as they can often be run without solvent, and they occur with hydrogen being the only coproduct. The success of these reactions has led Miyaura, Ishiyama, Hartwig, and others to use them as well.

In brief, catalytic C–H activation/borylation allows the direct construction of aryl boronic esters from hydrocarbon feedstocks in a single step, without aryl halide intermediates, without the limitations of the normal rules of aromatic substitution chemistry, and without many common functional group restrictions. Moreover, due to its mildness, the borylation chemistry combines readily *in situ* with subsequent chemical reactions.

This technology allows rapid, low-impact preparations of chemical building blocks that currently are commercially unavailable or only accessible by protracted, costly, and environmentally unattractive routes. Indeed, most recently, Michigan State University licensed the nominated technology to BoroPharm, Inc., which is using these catalytic borylations to produce much of the company’s product line. Thus, the nominated technology is proving to be practical green chemistry beyond the laboratory bench.

Small Business Award

SiGNa Chemistry, Inc.

New Stabilized Alkali Metals for Safer, Sustainable Syntheses

Innovation and Benefits

Alkali metals, such as sodium and lithium, are powerful tools in synthetic chemistry because they are highly reactive. However, unless they are handled very carefully, their reactivity also makes them both flammable and explosive. SiGNa Chemistry developed a way to stabilize these metals by encapsulating them within porous, sand-like powders, while maintaining their usefulness in synthetic reactions. The stabilized metals are much safer to store, transport, and handle. They may also be useful for removing sulfur from fuels, storing hydrogen, and remediating a variety of hazardous wastes

Alkali metals have a strong propensity for donating electrons, which makes these metals especially reactive. That reactivity has enormous potential for speeding chemical reactions throughout science and industry, possibly including new pathways to clean energy and environmental remediation. Unfortunately, that same reactivity also makes them highly unstable and dangerous to store and handle. In addition, increased risk of supply-chain interruption and the expense of handling these metals have made them unattractive to the chemical industry. Industries from pharmaceutical to petroleum have developed alternative synthetic routes to avoid using alkali metals, but these alternates require additional reactants and reaction steps that lead to inefficient, wasteful manufacturing processes.

SiGNa Chemistry addresses these problems with its technology for nanoscale absorption of reactive alkali metals in porous metal oxides. These new materials are sand-like powders. SiGNa's materials eliminate the danger and associated costs of using reactive metals directly but retain the utility of the alkali metals. Far from their hazardous precursors, SiGNa's materials react controllably with predictable activa-

tion that can be adapted to a variety of industry needs. By enabling practical chemical shortcuts and continuous flow processes, the encapsulated alkali metals create efficiencies in storage, supply chain, manpower, and waste disposal.

For the pharmaceutical, petrochemical, and general synthesis industries, SiGNa's breakthrough eliminates the additional steps that these industries usually take to avoid using the alkali metals and produces the desired reaction in 80–90 percent less time. For the pharmaceutical industry in particular, the materials can accelerate drug discovery and manufacturing while bolstering worker safety.

Beyond greening conventional chemical syntheses, SiGNa's materials enable the development of entirely new areas of chemistry. In clean-energy applications, the company's stabilized alkali metals safely produce record levels of pure hydrogen gas for the nascent fuel cell sector. With yield levels that already exceed the U.S. Department of Energy's targets for 2015, SiGNa's materials constitute the most effective means for processing water into hydrogen. SiGNa's materials also allow alkali metals to be safely applied to environmental remediation of oil contamination and the destruction of PCBs and CFCs.

SiGNa's success in increasing process efficiencies, health, and environmental safety and in enabling new chemical technologies has helped it attract more than 50 major global pharmaceutical, chemical, and energy companies as customers.

Greener Synthetic Pathways Award

Battelle

Development and Commercialization of Biobased Toners

Innovation and Benefits

Laser printers and copiers use over 400 million pounds of toner each year in the United States. Traditional toners fuse so tightly to paper that they are difficult to remove from waste paper for recycling. They are also made from petroleum-based starting materials. Battelle and its partners, Advanced Image Resources and the Ohio Soybean Council, have developed a soy-based toner that performs as well as traditional ones, but is much easier to remove. The new toner technology can save significant amounts of energy and allow more paper fiber to be recycled.

More than 400 million pounds of electrostatic dry toners based on petroleum-derived resins are used in the United States annually to make more than 3 trillion copies in photocopiers and printers. Conventional toners are based on synthetic resins such as styrene acrylates and styrene butadiene. These conventional resins make it difficult to remove the toner during recycling, a process called de-inking. This makes paper recycling more difficult. Although others have developed de-inkable toners, none of the competing technologies has become commercial due to high costs and inadequate de-inking performance.

With early-stage funding from the Ohio Soybean Council, Battelle and Advanced Image Resources (AIR) formed a team to develop and market biobased resins and toners for office copiers and printers. This novel technology uses soy oil and protein along with carbohydrates from corn as chemical feedstocks. Battelle developed bioderived polyester, polyamide, and polyurethane resins and toners from these feedstocks through innovative, cost-effective chemical modifications

and processing, with the de-inking process in mind. By incorporating chemical groups that are susceptible to degradation during the standard de-inking process, Battelle created new inks that are significantly easier to remove from the paper fiber. AIR then scaled up the process with proprietary catalysts and conditions to make the new resins.

The new technology offers significant advantages in recycling waste office paper without sacrificing print quality. Improved de-inking of the fused ink from waste copy paper results in higher-quality recovered materials and streamlines the recycling process. Preliminary life-cycle analysis shows significant energy savings and reduced carbon dioxide (CO₂) emissions in the full value chain from resin manufacture using biobased feedstocks to toner production and, finally, to the recovery of secondary fibers from the office waste stream. At 25 percent market penetration in 2010, this technology could save 9.25 trillion British thermal units per year (Btu/yr) and eliminate over 360,000 tons of CO₂ emissions per year.

Overall, soy toner provides a cost-effective, systems-oriented, environmentally benign solution to the growing problem of waste paper generated from copiers and printers. In 2006, AIR, the licensee of the technology, successfully scaled up production of the resin and toners for use in HP LaserJet 4250 Laser Printer cartridges. Battelle and AIR coordinated to move from early-stage laboratory development to full-scale manufacturing and commercialization. Their efforts have resulted in a cost-competitive, highly marketable product that is compatible with current hardware. The new toner will be sold under trade names BioRez® and Rezilution®. Once commercial, it will provide users with seamless, environmentally friendly printing and copying.

Greener Reactions Conditions Award

Nalco Company

3D TRASAR® Technology

Innovation and Benefits

Cooling water touches many facets of human life, including cooling for comfort in commercial buildings and cooling industrial processes. Cooling systems require added chemicals to control microbial growth, mineral deposits, and corrosion. Nalco developed 3D TRASAR® technology to monitor the condition of cooling water continuously and add appropriate chemicals only when needed, rather than on a fixed schedule. The technique saves water and energy, minimizes the use of water-treatment chemicals, and decreases environmental damage from discharged water.

Most commercial buildings, including offices, universities, hospitals, and stores, as well as many industrial processes, use cooling systems based on water. These cooling systems can consume vast quantities of water. Also, unless mineral scale and microbes are well-controlled, several problems can arise leading to increased water and energy consumption and negative environmental impacts.

Mineral scale, which consists mostly of carbonates of calcium and magnesium, forms on heat-exchange surfaces; this makes heat transfer inefficient and increases energy use. Similarly, microbial growth can lead to the formation of biofilms on heat-exchange surfaces, decreasing exchange efficiency. Conversely, high levels of biocide intended to prevent biofilm cause several adverse effects including increased corrosion of system components. Gradually, the integrity of the system becomes compromised, increasing the risk of system leaks. The material from these leaks, along with metal-containing byproducts of corrosion and the additional biocide, are ultimately discharged with the cooling water. Every time water is discharged, called "blowdown", pollutants are released in the wastewater, and fresh water is used to

replace the blowdown. Traditionally, antiscalants and antimicrobials are added at regular intervals or, at best, after manual or indirect measurements show scale or microbial buildup.

In 2004, Nalco commercialized its 3D TRASAR® Cooling System Chemistry and Control technology. By detecting scaling tendency early, cooling systems with Nalco's technology can operate efficiently; in addition, they can use less water or use poor-quality water.

3D Scale Control, part of the 3D TRASAR® system, prevents the formation of mineral scale on surfaces, maintaining efficient heat transfer. The system monitors antiscalant levels using a fluorescent-tagged, scale-dispersant polymer and responds quickly when conditions favor scale formation. In addition, 3D Bio-control, also part of the 3D TRASAR® system, is the only online, real-time test for measuring planktonic and sessile bacteria. It uses resazurin, another fluorescent molecule, which changes its fluorescent signature when it interacts with respiring microbes. By adding an oxidizing biocide in response to microbial activity, 3D Bio-control generally reduces the use of biocide and also prevents biofilm from building up on surfaces, maintaining efficient heat transfer.

A proprietary corrosion monitor and a novel corrosion inhibitor, phosphino succinic oligomer, provide improved corrosion protection. In 2006, the 2,500 installations using the 3D TRASAR® system saved approximately 21 billion gallons of water. These installations have also significantly reduced the discharge of water-treatment chemicals to water-treatment plants or natural waterways.

Designing Greener Chemicals Award

Dow AgroSciences LLC

Spinetoram: Enhancing a Natural Product for Insect Control

Innovation and Benefits

Spinosad biopesticide from Dow AgroSciences controls many insect pests on vegetables, but is not particularly effective against certain key pests of tree fruits. To solve this problem, Dow AgroSciences used an “artificial neural network” to identify analogous molecules that might be more effective against fruit-tree pests. They then developed a green chemical synthesis for the new insecticide, called spinetoram. Spinetoram retains the favorable environmental benefits of spinosad while replacing organophosphate pesticides for tree fruits, tree nuts, small fruits, and vegetables.

Spinosad biopesticide won the Presidential Green Chemistry Challenge Award for Designing Greener Chemicals in 1999. Spinosad, a combination of spinosyns A and D, is effective against insect pests on vegetables, but there have been few green chemistry alternatives for insect-pest control in tree fruits and tree nuts. Dow AgroSciences has now developed spinetoram, a significant advancement over spinosad that extends the success of spinosad to new crops.

The discovery of spinetoram involved the novel application of an artificial neural network (ANN) to the molecular design of insecticides. Dow AgroSciences researchers used an ANN to understand the quantitative structure-activity relationships of spinosyns and to predict analogues that would be more active. The result is spinetoram, a mixture of 3'-*O*-ethyl-5,6-dihydro spinosyn J and 3'-*O*-ethyl spinosyn L. Dow AgroSciences makes spinetoram from naturally occurring fermentation products spinosyns J and L by modifying them with a low-impact synthesis in which catalysts and most reagents and solvents are recycled. The biology and chemistry of spinetoram have been exten-

sively researched; the results have been published in peer-reviewed scientific journals and presented at scientific meetings globally.

Spinetoram provides significant and immediate benefits to human health and the environment over existing insecticides. Azinphos-methyl and phosmet, two organophosphate insecticides, are widely used in pome fruits (such as apples and pears), stone fruits (such as cherries and peaches), and tree nuts (such as walnuts and pecans). The mammalian acute oral toxicity of spinetoram is more than 1,000 times lower than that of azinphos-methyl and 44 times lower than that of phosmet. The low toxicity of spinetoram reduces the risk of exposures throughout the supply chain: in manufacturing, transportation, and application and to the public.

Spinetoram has a lower environmental impact than do many current insecticides because both its use rate and its toxicity to non-target species are low. Spinetoram is effective at much lower rates than many competing insecticides. It is effective at use rates that are 10–34 times lower than azinphos-methyl and phosmet. Spinetoram is also less persistent in the environment compared with other traditional insecticides. In the United States alone, Dow AgroSciences expects spinetoram to eliminate about 1.8 million pounds of organophosphate insecticides applied to pome fruit, stone fruit, and tree nuts during its first five years of use. In 2007, EPA granted pesticide registrations to the spinetoram products Radiant™ and Delegate™, and Dow AgroSciences began commercial sales

2007 Winners

Academic Award

Professor Michael J. Krische

University of Texas at Austin

Hydrogen-Mediated Carbon–Carbon Bond Formation

Innovation and Benefits

A fundamental aspect of chemistry involves creating chemical bonds between carbon atoms. Chemical processes commonly used to make such bonds usually also generate significant amounts of waste. Professor Krische developed a broad new class of chemical reactions that make bonds between carbon atoms using hydrogen and metal catalysts. This new class of reactions can be used to convert simple chemicals into complex substances, such as pharmaceuticals, pesticides, and other important chemicals, with minimal waste.

Reductions mediated by hydrogen, termed “hydrogenations”, rank among the most widely used catalytic methods employed industrially. They are generally used to form carbon–hydrogen (C–H) bonds. Professor Michael J. Krische and his coworkers at the University of Texas at Austin have developed a new class of hydrogenation reactions that form carbon–carbon (C–C) bonds. In these metal-catalyzed reactions, two or more organic molecules combine with hydrogen gas to create a single, more complex product. Because all atoms present in the starting building-block molecules appear in the final product, Professor Krische’s reactions do not generate any byproducts or wastes. Hence, Professor Krische’s C–C bond-forming hydrogenations eliminate pollution at its source.

Prior to Professor Krische’s work, hydrogen-mediated C–C bond formations were limited almost exclusively to the use of carbon monoxide in reactions such as alkene hydroformylation (1938) and the Fischer-Tropsch reaction (1923). These prototypical hydrogen-mediated C–C bond formations are practiced industrially on an enormous scale. Yet, despite the importance of these reactions, no one had engaged in

systematic research to develop related C–C bond-forming hydrogenations. Only a small fraction of hydrogenation's potential as a method of C–C coupling had been realized, and the field lay fallow for nearly 70 years.

Professor Krische's hydrogen-mediated couplings circumvent the use of preformed organometallic reagents, such as Grignard and Gilman reagents, in carbonyl and imine addition reactions. Such organometallic reagents are highly reactive, typically moisture-sensitive, and sometimes pyrophoric, meaning that they combust when exposed to air. Professor Krische's coupling reactions take advantage of catalysts that avoid the hazards of traditional organometallic reagents. Further, using chiral hydrogenation catalysts, Professor Krische's couplings generate C–C bonds in a highly enantioselective fashion.

Catalytic hydrogenation has been known for over a century and has stood the test of time due its efficiency, atom economy, and cost-effectiveness. By exploiting hydrogenation as a method of C–C bond formation, Professor Krische has added a broad, new dimension to one of chemistry's most fundamental catalytic processes. The C–C bond-forming hydrogenations developed by Professor Krische allow chemists to create complex organic molecules in a highly selective fashion, eliminating both hazardous starting materials and hazardous waste. Commercial application of this technology may eliminate vast quantities of hazardous chemicals. The resulting increases in plant and worker safety may enable industry to perform chemical transformations that were too dangerous using traditional reagents.

Small Business Award

NovaSterilis Inc.

Environmentally Benign Medical Sterilization Using Supercritical Carbon Dioxide

Innovation and Benefits

Sterilizing biological tissue for transplant is critical to safety and success in medical treatment. Common existing sterilization techniques use ethylene oxide or gamma radiation, which are toxic or have safety problems. NovaSterilis invented a technology that uses carbon dioxide and a form of peroxide to sterilize a wide variety of delicate biological materials such as graft tissue, vaccines, and biopolymers. Their Nova 2200™ sterilizer requires neither hazardous ethylene oxide nor gamma radiation.

None of the common methods for medical sterilization is well-suited to sterilizing delicate biological materials. The sterility of these materials is critical. Distribution of contaminated donor tissues by tissue banks has resulted in serious infections and illnesses in transplant patients. The two most widely used sterilants (ethylene oxide and gamma radiation) also raise toxicity and safety concerns. Ethylene oxide is a mutagenic, carcinogenic, volatile, flammable, reactive gas. Residues of ethylene oxide remain in the sterilized material, increasing the risk of toxic side effects. Gamma radiation is highly penetrating and is lethal to all cells. Neither ethylene oxide nor gamma radiation can sterilize packaged biological products without eroding their physical integrity.

NovaSterilis, a privately held biotechnology company in Ithaca, NY, has successfully developed and commercialized a highly effective and environmentally benign technique for sterilizing delicate biological materials using supercritical carbon dioxide (CO₂). NovaSterilis licensed a patent for bacterial inactivation in biodegradable polymers that was issued to Professor Robert S. Langer and his team at the Massachusetts Institute of Technology. NovaSterilis then enhanced, expanded, and optimized the technology to kill bacterial endospores. Their

supercritical CO₂ technology uses low temperature and cycles of moderate pressure along with a peroxide (peracetic acid) and small amounts of water. Their Nova 2200™ sterilizer consistently achieves rapid (less than one hour) and total inactivation of a wide range of microbes, including bacterial endospores. The mechanism of bacterial inactivation is not well-understood, but does not appear to involve bacterial cell lysis or wholesale degradation of bacterial proteins.

The new technology is compatible with sensitive biological materials and is effective for a wide range of important biomedical materials including: (a) musculoskeletal allograft tissue (e.g., human bone, tendons, dermis, and heart valves) for transplantation; (b) biodegradable polymers and related materials used in medical devices, instruments, and drugs; (c) drug delivery systems; and (d) whole-cell vaccines that retain high antigenicity. Besides being a green chemical technology, supercritical CO₂ sterilization achieves “terminal” sterilization, that is, sterilization of the final packaged product. Terminal sterilization provides greater assurance of sterility than traditional methods of aseptic processing. Sterilization of double-bagged tissue allows tissue banks to ship terminally sterilized musculoskeletal tissues in packages that can be opened in operating rooms by surgical teams immediately prior to use. NovaSterilis’s patented technology addresses the market need in tissue banks as well as other needs in the biomedical, biologics, medical device, pharmaceutical, and vaccine industries. By the end of 2006, NovaSterilis had sold several units to tissue banks.

Greener Synthetic Pathways Award

Professor Kaichang Li, Oregon State University; Columbia Forest Products; Hercules Incorporated

Development and Commercial Application of Environmentally Friendly Adhesives for Wood Composites

Innovation and Benefits

Adhesives used in manufacturing plywood and other wood composites often contain formaldehyde, which is toxic. Professor Kaichang Li of Oregon State University, Columbia Forest Products, and Hercules Incorporated developed an alternate adhesive made from soy flour. Their environmentally friendly adhesive is stronger than and cost-competitive with conventional adhesives. During 2006, Columbia used the new, soy-based adhesive to replace more than 47 million pounds of conventional formaldehyde-based adhesives.

Since the 1940s, the wood composites industry has been using synthetic adhesive resins to bind wood pieces into composites, such as plywood, particleboard, and fiberboard. The industry has been the predominate user of formaldehyde-based adhesives such as phenol-formaldehyde and urea-formaldehyde (UF) resins. Formaldehyde is a probable human carcinogen. The manufacture and use of wood composite panels bonded with formaldehyde-based resins release formaldehyde into the air, creating hazards for both workers and consumers.

Inspired by the superior properties of the protein that mussels use to adhere to rocks, Professor Li and his group at Oregon State University invented environmentally friendly wood adhesives based on abundant, renewable soy flour. Professor Li modified some of the amino acids in soy protein to resemble those of mussels' adhesive protein. Hercules Incorporated provided a critical curing agent and the expertise to apply it to commercial production of plywood.

Oregon State University, Columbia Forest Products (CFP), and Hercules have jointly commercialized soy-based adhesives to produce cost-competitive plywood and particleboard for interior uses. The soy-based adhesives do not contain formaldehyde or use formaldehyde as a raw material. They are environmentally friendly, cost-competitive with the UF resin in plywood, and superior to the UF resin in strength and water resistance. All CFP plywood plants now use soy-based adhesives, replacing more than 47 million pounds of the toxic UF resin in 2006 and reducing the emission of hazardous air pollutants (HAPs) from each CFP plant by 50 to 90 percent. This new CFP plywood is sold under the PureBond™ name. During 2007, CFP will replace UF at its particleboard plant; the company is also seeking arrangements with other manufacturers to further the adoption of this technology.

With this technology, those who make and use furniture, kitchen cabinetry, and other wood composite materials have a high-performing formaldehyde-free alternative. As a result, indoor air quality in homes and offices could improve significantly. This technology represents the first cost-competitive, environmentally friendly adhesive that can replace the toxic UF resin. The technology can greatly enhance the global competitiveness of U.S. wood composite companies. In addition, by creating a new market for soy flour, currently in over-supply, this technology provides economic benefits for soybean farmers.

Greener Reaction Conditions Award

Headwaters Technology Innovation

Direct Synthesis of Hydrogen Peroxide by Selective Nanocatalyst Technology

Innovation and Benefits

Hydrogen peroxide is an environmentally friendly alternative to chlorine and chlorine-containing bleaches and oxidants. It is expensive, however, and its current manufacturing process involves the use of hazardous chemicals. Headwaters Technology Innovation (HTI) developed an advanced metal catalyst that makes hydrogen peroxide directly from hydrogen and oxygen, eliminates the use of hazardous chemicals, and produces water as the only byproduct. HTI has demonstrated their new technology and is partnering with Degussa AG to build plants to produce hydrogen peroxide.

Hydrogen peroxide (H_2O_2) is a clean, versatile, environmentally friendly oxidant that can substitute for environmentally harmful chlorinated oxidants in many manufacturing operations. However, the existing manufacturing process for H_2O_2 is complex, expensive, and energy-intensive. This process requires an anthraquinone working solution containing several toxic chemicals. The solution is reduced by hydrogen in the presence of a catalyst, forming anthrahydroquinone, which then reacts with oxygen to release H_2O_2 . The H_2O_2 is removed from the solution with an energy-intensive stripping column and then concentrated by vacuum distillation. The bulk of the working solution is recycled, but the process generates a waste stream of undesirable quinone-derived byproducts that requires environmentally acceptable disposal.

Headwaters Technology Innovation (HTI) has produced a robust catalyst technology that enables the synthesis of H_2O_2 directly from hydrogen and oxygen. This breakthrough technology, called NxCat™, is a palladium-platinum catalyst that eliminates all the hazardous reaction conditions and chemicals of the existing process, along with its undesir-

able byproducts. It produces H_2O_2 more efficiently, cutting both energy use and costs. It uses innocuous, renewable feedstocks and generates no toxic waste.

NxCat™ catalysts work because of their precisely controlled surface morphology. HTI has engineered a set of molecular templates and substrates that maintain control of the catalyst's crystal structure, particle size, composition, dispersion, and stability. This catalyst has a uniform 4-nanometer feature size that safely enables a high rate of production with a hydrogen gas concentration below 4 percent in air (i.e., below the flammability limit of hydrogen). It also maximizes the selectivity for H_2O_2 up to 100 percent.

The NxCat™ technology enables a simple, commercially viable H_2O_2 manufacturing process. In partnership with Degussa AG (a major H_2O_2 manufacturer), HTI successfully demonstrated the NxCat™ technology and, in 2006, completed construction of a demonstration plant. This demonstration plant will allow the partners to collect the data necessary to design a full-scale plant and begin commercial production in 2009. The NxCat™ process has the potential to cut the cost of H_2O_2 significantly, generating a more competitively priced supply of H_2O_2 and increasing its market acceptance as an industrial oxidant. Except for its historically higher price, H_2O_2 is an excellent substitute for the more frequently used—and far more deleterious—chlorinated oxidants. The NxCat™ technology has the benefit of producing an effective, environmentally preferable oxidant (H_2O_2) without the waste or high cost associated with the traditional process.

Designing Greener Chemicals Award

Cargill, Incorporated

BiOH™ Polyols

Innovation and Benefits

Foam cushioning used in furniture or bedding is made from polyurethane, a man-made material. One of the two chemical building blocks used to make polyurethane is a “polyol.” Polyols are conventionally manufactured from petroleum products. Cargill’s BiOH™ polyols are manufactured from renewable, biological sources such as vegetable oils. Foams made with BiOH™ polyols are comparable to foams made from conventional polyols. As a result, each million pounds of BiOH™ polyols saves nearly 700,000 pounds of crude oil. In addition, Cargill’s process reduces total energy use by 23 percent and carbon dioxide emissions by 36 percent.

Polyols are key ingredients in flexible polyurethane foams, which are used in furniture and bedding. Historically, polyurethane has been made from petrochemical polyols. The idea of replacing these polyols with biobased polyols is not new, but the poor performance, color, quality, consistency, and odor of previous biobased polyols restricted them to limited markets. Previous biobased polyols also suffer from poor chemical reactivity, resulting in foam with inferior properties.

Cargill has successfully developed biobased polyols for several polyurethane applications, including flexible foams, which are the most technically challenging. Cargill makes BiOH™ polyols by converting the carbon–carbon double bonds in unsaturated vegetable oils to epoxide derivatives and then further converting these derivatives to polyols using mild temperature and ambient pressure. BiOH™ polyols provide excellent reactivity and high levels of incorporation leading to high-performing polyurethane foams. These foams set a new standard for consistent quality with low odor and color. Foams containing BiOH™ polyols retain their white color longer without ultraviolet stabilizers. They also are superior to foams containing only petroleum-based

polyols in standard tests. In large slabstock foams, such as those used in furniture and bedding, BiOH 5000 polyol provides a wide processing window, improved comfort factor, and reduced variations in density and load-bearing capacity. In molded foams such as automotive seating and headrests, BiOH 2100 polyol can enhance load-bearing or hardness properties relative to conventional polyols.

Use of BiOH™ polyols reduces the environmental footprint relative to today's conventional polyols for polyurethane production. BiOH™ polyols "harvest" carbon that plants remove from the air during photosynthesis. All of the carbon in BiOH™ polyols is recently fixed. In conventional polyols, the carbon is petroleum-based. Replacing petroleum-based polyols with BiOH™ polyols cuts total energy use by 23 percent including a 61 percent reduction in nonrenewable energy use, leading to a 36 percent reduction in carbon dioxide emissions. For each million pounds of BiOH™ polyol used in place of petroleum-based polyols, about 700,000 pounds (2,200 barrels) of crude oil are saved, thereby reducing the dependence on petroleum. BiOH™ polyols diversify the industry's supply options and help mitigate the effects of uncertainty and volatility of petroleum supply and pricing. Cargill is the first company to commercialize biobased polyols on a large scale in the flexible foam market. Formulators can now use biobased polyols in flexible foam without compromising product performance. That the top North American polyol users choose BiOH™ polyols is validation of Cargill's accomplishment.

2006 Winners

Academic Award

Professor Galen J. Suppes

University of Missouri-Columbia

Biobased Propylene Glycol and Monomers from Natural Glycerin

Innovation and Benefits

Professor Suppes developed an inexpensive method to convert waste glycerin, a byproduct of biodiesel fuel production, into propylene glycol, which can replace ethylene glycol in automotive antifreeze. This high-value use of the glycerin byproduct can keep production costs down and help biodiesel become a cost-effective, viable alternative fuel, thereby reducing emissions and conserving fossil fuels.

Glycerin is a coproduct of biodiesel production. The U.S. biodiesel industry is expected to introduce one billion pounds of additional glycerin into a market that is currently only 600 million pounds. The economics of biodiesel depend heavily on using its glycerin coproduct. A high-value use for glycerin could reduce the cost of biodiesel by as much as 40¢ per gallon. There is simply not enough demand for glycerin, however, to make use of all the waste glycerin expected.

One solution is to convert the glycerin to propylene glycol. Approximately 2.4 billion pounds of propylene glycol are currently made each year, almost exclusively from petroleum-based propylene oxide. Propylene glycol is a less toxic alternative to ethylene glycol in anti-freeze, but is currently more expensive and, as a result, has a very small market share. Professor Galen J. Suppes has developed a catalytic process that efficiently converts crude glycerin to propylene glycol.

Professor Suppes's system couples a new copper-chromite catalyst with a reactive distillation. This system has a number of advantages over previous systems that perform this conversion. The new process uses a lower temperature and lower pressure than do previous systems (428 °F versus 500 °F and <145 psi versus >2,170 psi), converts

glycerin to propylene glycol more efficiently, and produces less byproduct than do similar catalysts. Propylene glycol made from glycerin by Professor Suppes's method is also significantly cheaper than propylene glycol made from petroleum.

Another solution is to convert glycerin to acetol (i.e., 1-hydroxy-2-propanone or hydroxyacetone), a well-known intermediate and monomer used to make polyols. When made from petroleum, acetol costs approximately \$5 per pound, prohibiting its wide use. Professor Suppes's technology can be used to make acetol from glycerin at a cost of approximately 50¢ per pound, opening up even more potential applications and markets for products made from glycerin.

Professor Suppes initiated this project in June 2003. The first commercial facility, with a capacity of 50 million pounds per year, is under construction and is expected to be in operation by October 2006.

Small Business Award

Arkon Consultants

NuPro Technologies, Inc.

Environmentally Safe Solvents and Reclamation in the Flexographic Printing Industry

Innovation and Benefits

Flexographic printing is used in a wide array of print jobs such as food wrappers and boxes, but the process uses millions of gallons of solvents each year. Arkon and NuPro developed a safer chemical processing system that reduces the amounts of solvents needed for printing. The new system eliminates hazardous solvents, reduces explosion potential and emissions during solvent recycling, and increases worker safety in the flexographic printing industry.

Flexographic printing is used on everything from food wrappers to secondary containers such as cereal boxes to shipping cartons. The photopolymerizable material on a flexographic printing plate cross-links when exposed to light and captures an image. After exposure, flexographic printing plates are immersed in a solvent to remove the unpolymerized material. The developing, or washout, solvent is typically a mixture of chloro, saturated cyclic, or acyclic hydrocarbons. Xylene is the most common solvent. Most traditional washout solvents are hazardous air pollutants (HAPs) subject to stringent reporting requirements; they also raise worker safety issues and create problems with recycling and disposal. North America alone uses 2 million gallons of washout solvents each year with a market value of \$20 million. Many small printing plants use these solvents.

Together, Arkon Consultants and NuPro Technologies have developed a safer chemical processing system, including washout solvents and reclamation/recycling machinery for the flexographic printing industry. NuPro/Arkon have developed several new classes of washout solvents with methyl esters, terpene derivatives, and highly substituted cyclic hydrocarbons. The advantages include higher flash points and lower

toxicity, which reduce explosion potential, worker exposure, and regulatory reporting. The methyl esters and terpene derivatives are biodegradable and can be manufactured from renewable sources. All of their solvents are designed to be recycled in their Cold Reclaim System™. In contrast to traditional vacuum distillation, this combination of filtration and centrifugation lowers exposures, decreases maintenance, and reduces waste. The waste is a solid, nonhazardous polymeric material.

In the U.S. market, NuPro/Arkon are currently selling washout solvents that are terpene ether- and ester-based or made with low-hazard cyclics. They are marketing their methyl ester-based solvent in China and Japan. Their first filtration-based Cold Recovery System™ is currently in use in Menasha, WI and is being marketed to larger U.S. users. Their centrifugation reclamation system for smaller users is in the final stages of development.

Use of these solvents and systems benefits both human health and the environment by lowering exposure to hazardous materials, reducing explosion potential, reducing emissions, and, in the case of the terpene and methyl ester-based solvents, using renewable resources. These solvents and the reclamation equipment represent major innovations in the safety of handling, exposure, and recovery. The reduced explosion potential, reduced emissions, decreased worker exposure, and reduced transport and maintenance costs translate into decreased cost and improved safety in all aspects of flexographic printing processes.

Greener Synthetic Pathways Award

Merck & Co., Inc.

Novel Green Synthesis for β -Amino Acids Produces the Active Ingredient in Januvia™

Innovation and Benefits

Merck discovered a highly innovative and efficient catalytic synthesis for sitagliptin, which is the active ingredient in Januvia™, the company's new treatment for type 2 diabetes. This revolutionary synthesis creates 220 pounds less waste for each pound of sitagliptin manufactured and increases the overall yield by nearly 50 percent. Over the lifetime of Januvia™, Merck expects to eliminate the formation of at least 330 million pounds of waste, including nearly 110 million pounds of aqueous waste.

Januvia™ is a new treatment for type 2 diabetes; Merck filed for regulatory approval in December 2005. Sitagliptin, a chiral β -amino acid derivative, is the active ingredient in Januvia™. Merck used a first-generation synthesis of sitagliptin to prepare over 200 pounds for clinical trials. With modifications, this synthesis could have been a viable manufacturing process, but it required eight steps including a number of aqueous work-ups. It also required several high-molecular-weight reagents that were not incorporated into the final molecule and, therefore, ended up as waste.

While developing a highly efficient second-generation synthesis for sitagliptin, Merck researchers discovered a completely unprecedented transformation: the asymmetric catalytic hydrogenation of unprotected enamines. In collaboration with Solvias, a company with expertise in this area, Merck scientists discovered that hydrogenation of unprotected enamines using rhodium salts of a ferrocenyl-based ligand as the catalyst gives β -amino acid derivatives of high optical purity and yield. This new method provides a general synthesis of β -amino acids, a class of molecules well-known for interesting biological properties. Merck scientists and engineers applied this new method in a completely novel way: using it in the final synthetic step to maximize the

yield in terms of the valuable chiral catalyst. The dehydro precursor to sitagliptin used in the asymmetric hydrogenation is prepared in an essentially one-pot procedure. Following the hydrogenation, Merck recovers and recycles over 95 percent of the valuable rhodium. The reactive amino group of sitagliptin is only revealed in the final step; as a result, there is no need for protecting groups. The new synthesis has only three steps and increases the overall yield by nearly 50 percent.

This strategy is broadly applicable to other pharmaceutical syntheses; Merck has used it to make several exploratory drug candidates. Implementing the new route on a manufacturing scale has reduced the amount of waste by over 80 percent and completely eliminated aqueous waste streams. This second-generation synthesis will create 220 pounds less waste for each pound of sitagliptin manufactured. Over the lifetime of the drug, Merck expects to eliminate the formation of 330 million pounds or more of waste, including nearly 110 million pounds of aqueous waste. Because Merck's new synthesis has reduced the amount of raw materials, processing time, energy, and waste, it is a more cost-effective option than the first-generation synthesis. The technology discovered, developed, and implemented by Merck for the manufacture of Januvia™ is an excellent example of scientific innovation resulting in benefits to the environment.

Greener Reaction Conditions Award

Codexis, Inc.

Directed Evolution of Three Biocatalysts to Produce the Key Chiral Building Block for Atorvastatin, the Active Ingredient in Lipitor[®]

Innovation and Benefits

Codexis developed cutting-edge genetic methods to create “designer enzymes”. Codexis applied its methods to produce enzymes that greatly improve the manufacture of the key building block for Lipitor[®], one of the world’s best-selling drugs. The new enzymatic process reduces waste, uses less solvent, and requires less processing equipment – marked improvements over processes used in the past. The process also increases yield and improves worker safety.

Atorvastatin calcium is the active ingredient of Lipitor[®], a drug that lowers cholesterol by blocking its synthesis in the liver. Lipitor[®] is the first drug in the world with annual sales exceeding \$10 billion. The key chiral building block in the synthesis of atorvastatin is ethyl (*R*)-4-cyano-3-hydroxybutyrate, known as hydroxynitrile (HN). Annual demand for HN is estimated to be about 440,000 pounds. Traditional commercial processes for HN require a resolution step with 50 percent maximum yield or syntheses from chiral pool precursors; they also require hydrogen bromide to generate a bromohydrin for cyanation. All previous commercial HN processes ultimately substitute cyanide for halide under heated alkaline conditions, forming extensive byproducts. They require a difficult high-vacuum fractional distillation to purify the final product, which decreases the yield even further.

Codexis designed a green HN process around the exquisite selectivity of enzymes and their ability to catalyze reactions under mild, neutral conditions to yield high-quality products. Codexis developed three specific enzymes using state-of-the-art, recombinant-based, directed evolution technologies to provide the activity, selectivity, and stability required for a practical and economic process. The bioengineered enzymes are so active and stable that Codexis can recover high-quality

product by extracting the reaction mixture. In the first step, two of the enzymes catalyze the enantioselective reduction of a prochiral chloroketone (ethyl 4-chloroacetoacetate) by glucose to form an enantiopure chlorohydrin. In the second step, a third enzyme catalyzes the novel biocatalytic cyanation of the chlorohydrin to the cyanohydrin under neutral conditions (aqueous, pH ~7, 77–104 °F, atmospheric pressure). On a biocatalyst basis, the three enzymes have improved the volumetric productivity of the reduction reaction by approximately 100-fold and that of the cyanation reaction by approximately 4,000-fold.

The process involves fewer unit operations than earlier processes, most notably obviating the fractional distillation of the product. The process provides environmental and human health benefits by increasing yield, reducing the formation of byproducts, reducing the generation of waste, avoiding hydrogen gas, reducing the need for solvents, reducing the use of purification equipment, and increasing worker safety. The Codexis process is operated by Lonza to manufacture HN for Pfizer's production of atorvastatin calcium.

Designing Greener Chemicals Award

S.C. Johnson & Son, Inc.

Greenlist™ Process to Reformulate Consumer Products

Innovation and Benefits

SC Johnson developed Greenlist™, a system that rates the environmental and health effects of the ingredients in its products. SC Johnson is now using Greenlist™ to reformulate many of its products. For example, SC Johnson eliminated the use of nearly 4 million pounds of polyvinylidene chloride (PVDC) annually after its “Greenlist” review of Saran Wrap® revealed opportunities for changes.

SC Johnson (SCJ) formulates and manufactures consumer products including a wide variety of products for home cleaning, air care, personal care, insect control, and home storage. For more than a century, SCJ has been guided by the belief that, because it is a family business, it must consider the next generation when it makes current product decisions, not merely the next fiscal quarter. The most recent initiative in SCJ’s long history of commitment to environmentally preferable products is its Greenlist™ process, a system that rates the environmental footprint of the ingredients in its products. Through Greenlist™, SCJ chemists and product formulators around the globe have instant access to environmental ratings of potential product ingredients.

Starting in 2001, SCJ developed Greenlist™ according to the rigorous standards of scientific best practices. Greenlist™ uses four to seven specific criteria to rate ingredients within 17 functional categories. SCJ enlisted the help of suppliers, university scientists, government agencies, and nongovernmental organizations (NGOs) to ensure that the rating criteria were meaningful, objective, and valid. These criteria include vapor pressure, octanol/water partition coefficient, biodegradability, aquatic toxicity, human toxicity, European Union Classification, source/supply, and others, as appropriate. The Greenlist™ process assigns an environmental classification (EC) score to each ingredient by

averaging its scores for the criteria in its category. EC scores range from Best (3) to Restricted Use Material (0). SCJ lowers the EC score for chemicals with other significant concerns including PBT (persistence, bioaccumulation, and toxicity), endocrine disruption, carcinogenicity, and reproductive toxicity. Today, Greenlist™ provides ratings for more than 90 percent of the raw materials SCJ uses, including solvents, surfactants, inorganic acids and bases, chelants, propellants, preservatives, insecticides, fragrances, waxes, resins, nonwoven fabrics, and packaging. Company scientists have also developed criteria for dyes, colorants, and thickeners and are working on additional categories as well.

During fiscal 2000-2001, the baseline year, SCJ's EC average was 1.12. Their goal was to reach an average EC of 1.40 during fiscal 2007-2008. The company reached this goal three years early, with an average EC of 1.41 covering almost 1.4 billion pounds of raw materials.

In recent years, SCJ has used Greenlist™ to reformulate multiple products to make them safer and more environmentally responsible. In one example, SCJ used the Greenlist™ process to replace polyvinylidene chloride (PVDC) with polyethylene in Saran Wrap®. In another example, SCJ applied Greenlist™ to remove a particular volatile organic compound (VOC) from Windex®. They developed a novel new formula containing amphoteric and anionic surfactants, a solvent system with fewer than 4 percent VOCs, and a polymer for superior wetting. Their formula cleans 30 percent better and eliminates over 1.8 million pounds of VOCs per year.

2005 Winners

Academic Award

Professor Robin D. Rogers

The University of Alabama

A Platform Strategy Using Ionic Liquids to Dissolve and Process Cellulose for Advanced New Materials

Innovation and Benefits

Professor Rogers developed methods that allow cellulose from wood, cloth, or even paper to be chemically modified to make new biorenewable or biocompatible materials. His methods also allow cellulose to be mixed with other substances, such as dyes, or simply to be processed directly from solution into a formed shape. Together, these methods can potentially save resources, time, and energy.

Major chemical companies are currently making tremendous strides towards using renewable resources in biorefineries. In a typical biorefinery, the complexity of natural polymers, such as cellulose, is first broken down into simple building blocks (e.g., ethanol, lactic acid), then built up into complex polymers. If one could use the biocomplexity of natural polymers to form new materials directly, however, one could eliminate many destructive and constructive synthetic steps. Professor Robin D. Rogers and his group have successfully demonstrated a platform strategy to efficiently exploit the biocomplexity afforded by one of Nature's renewable polymers, cellulose, potentially reducing society's dependence on nonrenewable petroleum-based feedstocks for synthetic polymers. No one had exploited the full potential of cellulose previously, due in part to the shift towards petroleum-based polymers since the 1940s, difficulty in modifying the cellulose polymer properties, and the limited number of common solvents for cellulose.

Professor Rogers's technology combines two major principles of green chemistry: developing environmentally preferable solvents and using biorenewable feedstocks to form advanced materials. Professor

Rogers has found that cellulose from virtually any source (fibrous, amorphous, pulp, cotton, bacterial, filter paper, etc.) can be dissolved readily and rapidly, without derivatization, in a low-melting ionic liquid (IL), 1-butyl-3-methylimidazolium chloride ([C4mim]Cl), by gentle heating (especially with microwaves). IL-dissolved cellulose can easily be reconstituted in water in controlled architectures (fibers, membranes, beads, flocs, etc.) using conventional extrusion spinning or forming techniques. By incorporating functional additives into the solution before reconstitution, Professor Rogers can prepare blended or composite materials. The incorporated functional additives can be either dissolved (e.g., dyes, complexants, other polymers) or dispersed (e.g., nanoparticles, clays, enzymes) in the IL before or after dissolution of the cellulose. With this simple, noncovalent approach, Professor Rogers can readily prepare encapsulated cellulose composites of tunable architecture, functionality, and rheology. The IL can be recycled by a novel salting-out step or by common cation exchange, both of which save energy compared to recycling by distillation. Professor Rogers's current work is aimed at improved, more efficient, and economical syntheses of [C4mim]Cl, studies of the IL toxicology, engineering process development, and commercialization.

Professor Rogers and his group are currently doing market research and business planning leading to the commercialization of targeted materials, either through joint development agreements with existing chemical companies or through the creation of small businesses. Green chemistry principles will guide the development work and product selection. For example, targeting polypropylene- and polyethylene-derived thermoplastic materials for the automotive industry could result in materials with lower cost, greater flexibility, lower weight, lower abrasion, lower toxicity, and improved biodegradability, as well as significant reductions in the use of petroleum-derived plastics.

Professor Rogers's work allows the novel use of ILs to dissolve and reconstitute cellulose and similar polymers. Using green chemistry principles to guide development and commercialization, he envisions that his platform strategy can lead to a variety of commercially viable advanced materials that will obviate or reduce the use of synthetic polymers.

Small Business Award

Metabolix, Inc.

Producing Nature's Plastics Using Biotechnology

Innovation and Benefits

Metabolix used new biotechnology methods to develop microorganisms that produce polyhydroxyalkanoates (PHAs) directly. PHAs are natural plastics with a range of environmental benefits, including reduced reliance on fossil carbon, reduced solid waste, and reduced greenhouse gas emissions. PHAs biodegrade to harmless products in the environment, reducing the burden of plastic waste on landfills and the environment. Metabolix hopes to develop plants that produce PHAs as well.

Metabolix is commercializing polyhydroxyalkanoates (PHAs), a broadly useful family of natural, environmentally friendly, high-performing, biobased plastics. PHAs are based on a biocatalytic process that uses renewable feedstocks, such as cornstarch, cane sugar, cellulose hydrolysate, and vegetable oils. PHAs can provide a sustainable alternative to petrochemical plastics in a wide variety of applications.

Metabolix uses biotechnology to introduce entire enzyme-catalyzed reaction pathways into microbes, which then produce PHAs, in effect creating living biocatalysts. The performance of these engineered microbes has been fully validated in commercial equipment, demonstrating reliable production of a wide range of PHA copolymers at high yield and reproducibility. A highly efficient commercial process to recover PHAs has also been developed and demonstrated. The routine expression of exogenous, chromosomally integrated genes coding for the enzymes used in a non-native metabolic pathway is a tour de force in the application of biotechnology. These accomplishments have led Metabolix to form an alliance with Archer Daniels Midland Company, announced in November 2004, to produce PHAs commercially, starting with a 100-million-pound-per-year plant to be sited in the U.S. Midwest.

These new natural PHA plastics are highly versatile, have a broad range of physical properties, and are practical alternatives to synthetic petrochemical plastics. PHAs range from rigid to highly elastic, have very good barrier properties, and are resistant to hot water and greases. Metabolix has developed PHA formulations suitable for processing on existing equipment and demonstrated them in key end-use applications such as injection molding, thermoforming, blown film, and extrusion melt casting including film, sheet, and paper coating.

Metabolix's PHA natural plastics will bring a range of environmental benefits, including reduced reliance on fossil carbon and reduced greenhouse gas emissions. PHAs are now made from renewable raw materials, such as sugar and vegetable oils. In the future, they will be produced directly in plants. In addition, PHAs will reduce the burden of plastic waste on solid waste systems, municipal waste treatment systems, and marine and wetland ecosystems: they will biodegrade to harmless products in a wide variety of both aerobic and anaerobic environments, including soil, river and ocean water, septic systems, anaerobic digesters, and compost.

Metabolix's PHA technology is the first commercialization of plastics based on renewable resources that employs living biocatalysts in microbial fermentation to convert renewable raw materials all the way to the finished copolymer product. PHAs are also the first family of plastics that combine broadly useful properties with biodegradability in a wide range of environments, including marine and wetlands ecosystems. Replacement of petrochemical plastics with PHAs will also have significant economic benefits. Producing 50 billion pounds of PHA natural plastics to replace about half of the petrochemical plastics currently used in the United States would reduce oil imports by over 200–230 million barrels per year, improving the U.S. trade balance by \$6–9 billion per year, assuming oil at \$30–40 per barrel.

Greener Synthetic Pathways Award

Archer Daniels Midland Company

Novozymes

Novalipid™: Low *Trans* Fats and Oils Produced by Enzymatic Interesterification of Vegetable Oils Using Lipozyme®

Innovation and Benefits

Archer Daniels Midland Company and Novozymes developed a way to make edible fats and oils that contain no *trans* fatty acids. The improved “interesterification” process they developed uses less resources. Potential savings include hundreds of millions of pounds of soybean and other vegetable oils, processing chemicals, and water resources each year.

Two major challenges facing the food and ingredient industry are providing health-conscious products to the public and developing environmentally responsible production technology. Archer Daniels Midland Company (ADM) and Novozymes are commercializing enzymatic interesterification, a technology that not only has a tremendous positive impact on public health by reducing *trans* fatty acids in American diet, but also offers great environmental benefits by eliminating the waste streams generated by the chemical interesterification process.

Triglycerides consist of one glycerol plus three fatty acids. Triglycerides that contain mostly unsaturated fatty acids are liquid at room temperature. Manufacturers partially hydrogenate these fatty acids to make them solids at room temperature. *Trans* fatty acids form during the hydrogenation process; they are found at high concentrations in a wide variety of processed foods. Unfortunately, consumption of *trans* fatty acids is also a strong risk factor for heart disease. To reduce *trans* fats in the American diet as much as possible, the FDA is requiring labeling of *trans* fats on all nutritional fact panels by January 1, 2006. In response, the U.S. food and ingredient industry has been investigating methods to reduce *trans* fats in food.

Of the available strategies, interesterification is the most effective way to decrease the *trans* fat content in foods without sacrificing the functionality of partially hydrogenated vegetable oils. During interesterification, triglycerides containing saturated fatty acids exchange one or two of their fatty acids with triglycerides containing unsaturated fatty acids, resulting in triglycerides that do not contain any *trans* fatty acids. Enzymatic interesterification processes have many benefits over chemical methods, but the high cost of the enzymatic process and poor enzyme stability had prevented its adoption in the bulk fat industry.

Extensive research and development work by both Novozymes and ADM has led to the commercialization of an enzymatic interesterification process. Novozymes developed a cost-effective immobilized enzyme, and ADM developed a process to stabilize the immobilized enzyme enough for successful commercial production. The interesterified oil provides food companies with broad options for zero and reduced *trans* fat food products. Since the first commercial production in 2002, ADM has produced more than 15 million pounds of interesterified oils. ADM is currently expanding the enzyme process at two of its U.S. production facilities.

Enzymatic interesterification positively affects both environmental and human health. Environmental benefits include eliminating the use of several harsh chemicals, eliminating byproducts and waste streams (solid and water), and improving the use of edible oil resources. As one example, margarines and shortenings currently consume 10 billion pounds of hydrogenated soybean oil each year. Compared to partial hydrogenation, the ADM/Novozymes process has the potential to save 400 million pounds of soybean oil and eliminate 20 million pounds of sodium methoxide, 116 million pounds of soaps, 50 million pounds of bleaching clay, and 60 million gallons of water each year. The enzymatic process also contributes to improved public health by replacing partially hydrogenated oils with interesterified oils that contain no *trans* fatty acids and have increased polyunsaturated fatty acids.

Greener Synthetic Pathways Award

Merck & Co., Inc.

A Redesigned, Efficient Synthesis of Aprepitant, the Active Ingredient in Emend®: A New Therapy for Chemotherapy-Induced Emesis

Innovation and Benefits

Emend® is a drug that combats the nausea and vomiting often resulting from chemotherapy treatment. Merck now makes Emend® using a new process that requires much less energy, raw materials, and water than the original process. With its new method, Merck eliminates approximately 41,000 gallons of waste per 1,000 pounds of the drug that it produces.

Emend® is a new therapy for chemotherapy-induced nausea and vomiting, the most common side effects associated with the chemotherapeutic treatment of cancer. Emend® has been clinically shown to reduce nausea and vomiting when used during and shortly after chemotherapy. Aprepitant is the active pharmaceutical ingredient in Emend®.

Aprepitant, which has two heterocyclic rings and three stereogenic centers, is a challenging synthetic target. Merck's first-generation commercial synthesis required six synthetic steps and was based on the discovery synthesis. The raw material and environmental costs of this route, however, along with operational safety issues compelled Merck to discover, develop, and implement a completely new route to aprepitant.

Merck's new route to aprepitant demonstrates several important green chemistry principles. This innovative and convergent synthesis assembles the complex target in three highly atom-economical steps using four fragments of comparable size and complexity. The first-generation synthesis required stoichiometric amounts of an expensive, complex chiral acid as a reagent to set the absolute stereochemistry of aprepitant. In contrast, the new synthesis incorporates a chiral alcohol as a feedstock; this alcohol is itself synthesized in a catalytic asymmet-

ric reaction. Merck uses the stereochemistry of this alcohol feedstock in a practical crystallization-induced asymmetric transformation to set the remaining stereogenic centers of the molecule during two subsequent transformations. The new process nearly doubles the yield of the first-generation synthesis. Much of the chemistry developed for the new route is novel and has wider applications. In particular, the use of a stereogenic center that is an integral part of the final target molecule to set new stereocenters with high selectivity is applicable to the large-scale synthesis of other chiral molecules, especially drug substances.

Implementing the new route has drastically improved the environmental impact of aprepitant production. Merck's new route eliminates all of the operational hazards associated with the first-generation synthesis, including those of sodium cyanide, dimethyl titanocene, and gaseous ammonia. The shorter synthesis and milder reaction conditions have also reduced the energy requirements significantly. Most important, the new synthesis requires only 20 percent of the raw materials and water used by the original one. By adopting this new route, Merck has eliminated approximately 41,000 gallons of waste per 1,000 pounds of aprepitant that it produces.

The alternative synthetic pathway for the synthesis of aprepitant as discovered and implemented by Merck is an excellent example of minimizing environmental impact while greatly reducing production costs by employing the principles of green chemistry. Merck implemented the new synthesis during its first year of production of Emend®; as a result, Merck will realize the benefits of this route for virtually the entire lifetime of this product. The choice to implement the new route at the outset of production has led to a huge reduction in the cost to produce aprepitant, demonstrating quite clearly that green chemistry solutions can be aligned with cost-effective ones.

Greener Reaction Conditions Award

BASF Corporation

A UV-Curable, One-Component, Low-VOC Refinish Primer:
Driving Eco-Efficiency Improvements

Innovation and Benefits

BASF developed a new automobile paint primer that contains less than half the amount of volatile organic compounds (VOCs) used in conventional primers. The new primer is also free of diisocyanates, a major source of occupational asthma. Use in repair facilities has shown that only one-third as much of this primer is needed compared to conventional primer and that waste is reduced from 20 percent to nearly zero.

The market for automotive refinish coatings in North America exceeds \$2 billion for both collision repairs and commercial vehicle applications. Over 50,000 body shops in North America use these products. For more than a decade, automotive refinishers and coating manufacturers have dealt with increasing regulation of emissions of volatile organic compounds (VOCs). At first, coating manufacturers were able to meet VOC maximums with high-performance products such as two-component reactive urethanes, which require solvents as carriers for their high-molecular-weight resins. As thresholds for VOCs became lower, however, manufacturers had to reformulate their reactive coatings, and the resulting reformulations were slow to set a film. Waterborne coatings are also available, but their utility has been limited by the time it takes the water to evaporate. Continuing market pressures demanded faster film setting without compromising either quality or emissions.

Through intense research and development, BASF has invented a new urethane acrylate oligomer primer system. The resin cross-links with monomer (added to reduce viscosity) into a film when the acrylate double bonds are broken by radical propagation. The oligomers and monomers react into the film's cross-linked structure, improving adhesion, water resistance, solvent resistance, hardness, flexibility, and

cure speed. The primer cures in minutes by visible or near-ultraviolet (UV) light from inexpensive UV-A lamps or even sunlight. BASF's UV-cured primer eliminates the need for bake ovens that cure the current primers, greatly reducing energy consumption. BASF's primer performs better than the current conventional urethane technologies: it cures ten times faster, requires fewer preparation steps, has a lower application rate, is more durable, controls corrosion better, and has an unlimited shelf life. BASF is currently offering its UV-cured primers in its R-M® line as Flash Fill™ VP126 and in its Glasurit® line as 151-70.

BASF's primer contains only 1.7 pounds of VOCs per gallon, in contrast to 3.5–4.8 pounds of VOCs per gallon of conventional primers, a reduction of over 50 percent. The primer meets even the stringent requirements of South Coast California, whereas its superior properties ensure its acceptance throughout the U.S. market. The one-component nature of the product reduces hazardous waste and cleaning of equipment, which typically requires solvents. Applications in repair facilities over the past year have shown that only one-third as much primer is needed and that waste is reduced from 20 percent to nearly zero. The BASF acrylate-based technology requires less complex, less costly personal protective equipment (PPE) than the traditional isocyanate-based coatings; this, in turn, increases the probability that small body shops will purchase and use the PPE, increasing worker safety.

This eco-efficient product is the first step in an automobile refinishing coating system for which BASF plans to include the globally accepted waterborne basecoat from BASF (sold under the Glasurit® brand as line 90). In the near future, this system can be finished with the application of a one-component, UV-A-curable clearcoat. The system will deliver quality, energy efficiency, economy, and speed for the small businessperson operating a local body shop, while respecting the health and safety of the workers in this establishment and the environment in which these products are manufactured and used. To fully support these claims, BASF has conducted an eco-efficiency study with an independent evaluation.

Designing Greener Chemicals Award

Archer Daniels Midland Company

Archer RC™: A Nonvolatile, Reactive Coalescent for the Reduction of VOCs in Latex Paints

Innovation and Benefits

Latex paints require coalescents to help the paint particles flow together and cover surfaces well. Archer Daniels Midland developed Archer RC™, a new biobased coalescent to replace traditional coalescents that are volatile organic compounds (VOCs). This new coalescent has other performance advantages as well, such as lower odor, increased scrub resistance, and better opacity.

Since the 1980s, waterborne latex coatings have found increasingly broad acceptance in architectural and industrial applications. Traditional latex coatings are based on small-particle emulsions of a synthetic resin, such as acrylate- and styrene-based polymers. They require substantial quantities of a coalescent to facilitate the formation of a coating film as water evaporates after the coating is applied. The coalescent softens (plasticizes) the latex particles, allowing them to flow together to form a continuous film with optimal performance properties. After film formation, traditional coalescents slowly diffuse out of the film into the atmosphere. The glass transition temperature of the latex polymer increases as the coalescent molecules evaporate and the film hardens. Alcohol esters and ether alcohols, such as ethylene glycol monobutyl ether (EGBE) and Texanol® (2,2,4-trimethyl-1,3-pentanediol monoisobutyrate), are commonly used as coalescents. They are also volatile organic compounds (VOCs). Both environmental concerns and economics continue to drive the trend to reduce the VOCs in coating formulations. Inventing new latex polymers that do not require a coalescent is another option, but these polymers often produce soft films and are expensive to synthesize, test, and commercialize. Without a coalescent, the latex coating may crack and may not adhere to the substrate surface when dry at ambient temperatures.

Archer RC™ provides the same function as traditional coalescing agents but eliminates the unwanted VOC emissions. Instead of evaporating into the air, the unsaturated fatty acid component of Archer RC™ oxidizes and even cross-links into the coating. Archer RC™ is produced by interesterifying vegetable oil fatty acid esters with propylene glycol to make the propylene glycol monoesters of the fatty acids. Corn and sunflower oils are preferred feedstocks for Archer RC™ because they have a high level of unsaturated fatty acids and tend to resist the yellowing associated with linolenic acid, found at higher levels in soybean and linseed oils. Because Archer RC™ remains in the coating after film formation, it adds to the overall solids of a latex paint, providing an economic advantage over volatile coalescents.

The largest commercial category for latex paint, the architectural market, was 618 million gallons in the United States in 2001. Typically, coalescing solvents constitute 2–3 percent of the finished paint by volume; this corresponds to an estimated 120 million pounds of coalescing solvents in the United States and perhaps three times that amount globally. Currently, nearly all of these solvents are lost into the atmosphere each year.

Archer Daniels Midland Company has developed and tested a number of paint formulations using Archer RC™ in place of conventional coalescing solvents. In these tests, Archer RC™ performed as well as commercial coalescents such as Texanol®. Archer RC™ often had other advantages as well, such as lower odor, increased scrub resistance, and better opacity. Paint companies and other raw material suppliers have demonstrated success formulating paints with Archer RC™ and their existing commercial polymers. Archer RC™ has been in commercial use since March 2004.

2004 Winners

Academic Award

*Professors Charles A. Eckert and Charles L. Liotta
Georgia Institute of Technology*

Benign Tunable Solvents Coupling Reaction and Separation Processes

Innovation and Benefits

Professors Eckert and Liotta found ways to replace conventional organic solvents with benign solvents, such as supercritical CO₂ or water “tuned” by carefully selecting both temperature and pressure. These methods combine reactions and separations, improving efficiency and reducing waste in a variety of industrial applications.

For any chemical process, there must be both a reaction and a separation. Generally, the same solvent is used for both but is optimized only for the reaction. The separation typically involves 60–80 percent of the cost, however, and almost always has a large environmental impact. Conventional reactions and separations are often designed separately, but Professors Charles A. Eckert and Charles L. Liotta have combined them with a series of novel, benign, tunable solvents to create a paradigm for sustainable development: benign solvents and improved performance.

Supercritical CO₂, nearcritical water, and CO₂-expanded liquids are tunable benign solvents that offer exceptional opportunities as replacement solvents. They generally exhibit better solvent properties than gases and better transport properties than liquids. They offer substantial property changes with small variations in thermodynamic conditions, such as temperature, pressure, and composition. They also provide wide-ranging environmental advantages, from human health to pollution prevention and waste minimization. Professors Eckert, Liotta, and their team have combined reactions with separations in a synergistic manner to use benign solvents, minimize waste, and improve performance.

These researchers have used supercritical CO₂ to tune reaction equilibria and rates, improve selectivities, and eliminate waste. They were the first to use supercritical CO₂ with phase transfer catalysts to separate products cleanly and economically. Their method allows them to recycle their catalysts effectively. They have demonstrated the feasibility of a variety of phase transfer catalysts on reactions of importance in the chemical and pharmaceutical industries, including chiral syntheses. They have carried out a wide variety of synthetic reactions in nearcritical water, replacing conventional organic solvents. This includes acid- and base-catalysis using the enhanced dissociation of nearcritical water, negating the need for any added acid or base and eliminating subsequent neutralization and salt disposal. They have used CO₂ to expand organic fluids to make it easier to recycle homogeneous catalysts, including phase transfer catalysts, chiral catalysts, and enzymes. Finally, they have used tunable benign solvents to design syntheses that minimize waste by recycling and demonstrate commercial feasibility by process economics.

The team of Eckert and Liotta has combined state-of-the-art chemistry with engineering know-how, generating support from industrial sponsors to facilitate technology transfer. They have worked with a wide variety of government and industrial partners to identify the environmental and commercial opportunities available with these novel solvents; their interactions have facilitated the technology transfer necessary to implement their advances.

Small Business Award

Jeneil Biosurfactant Company

Rhamnolipid Biosurfactant: A Natural, Low-Toxicity Alternative to Synthetic Surfactants

Innovation and Benefits

Billions of pounds of surfactants are used each year to lubricate, clean, or reduce undesired foaming in industrial applications. Jeneil Biosurfactant Company developed biobased surfactants that are less toxic and more biodegradable than conventional surfactants. Jeneil makes its biosurfactants using a simple fermentation.

Surfactants are chemicals that reduce the surface tension of water. Surfactants are widely used in soaps, laundry detergents, dishwashing liquids, and many personal care products, such as shampoos. Other important uses are in lubricants, emulsion polymerization, textile processing, mining flocculates, petroleum recovery, and wastewater treatment. Most currently used surfactants are derived from petroleum feedstocks. The total worldwide chemical surfactant consumption in the year 2000 has been estimated to be approximately 36 billion pounds. Many of these chemical surfactants pose significant environmental risks because they form harmful compounds from incomplete biodegradation in water or soil.

Jeneil Biosurfactant Company has successfully produced a series of rhamnolipid biosurfactant products, making them commercially available and economical for the first time. These biosurfactant products provide good emulsification, wetting, detergency, and foaming properties, along with very low toxicity. They are readily biodegradable and leave no harmful or persistent degradation products. Their superior qualities make them suitable for many diverse applications.

Rhamnolipid biosurfactant is a naturally occurring extracellular glycolipid that is found in the soil and on plants. Jeneil produces this biosurfactant commercially in controlled, aerobic fermentations using particular

strains of the soil bacterium, *Pseudomonas aeruginosa*. The biosurfactant is recovered from the fermentation broth after sterilization and centrifugation, then purified to various levels to fit intended applications.

Rhamnolipid biosurfactants are a much less toxic and more environmentally friendly alternative to traditional synthetic or petroleum-derived surfactants. Rhamnolipid biosurfactants are also “greener” throughout their life cycle. Biosurfactant production uses feedstocks that are innocuous and renewable compared to those used for synthetic or petroleum-derived surfactants. In addition, their production requires less resources, employs processes that are less complex and less capital- and energy-intensive, and does not require the use and disposal of hazardous substances.

Some current uses of rhamnolipid biosurfactant are in consumer cleaning products, in solutions to clean contact lenses, and in an agricultural fungicide as the active ingredient. These biosurfactants are also extremely effective in precluding harmful environmental impacts and remediating environmental pollution. For example, rhamnolipid biosurfactants can facilitate removal of hydrocarbons or heavy metals from soil, clean crude oil tanks, and remediate sludge; often they can facilitate recovery of a significant amount of the hydrocarbons. In many applications, these biosurfactants can replace less environmentally friendly synthetic or petroleum-derived surfactants. Further, these biosurfactants have excellent synergistic activity with many synthetic surfactants and, when formulated together in a cosurfactant system, can allow a substantial reduction in the synthetic surfactant component.

Although rhamnolipid biosurfactants have been the subject of considerable research, they had previously been produced only on a small scale in laboratories. Jeneil Biosurfactant Company, in conjunction with its associated company, Jeneil Biotech, Inc., has commercialized the rhamnolipid technology by developing efficient bacterial strains, as well as cost-effective processes and equipment for commercial-scale production. Jeneil’s facility in Saukville, WI produces the surfactants.

Greener Synthetic Pathways Award

Bristol-Myers Squibb Company

Development of a Green Synthesis for Taxol® Manufacture via Plant Cell Fermentation and Extraction

Innovation and Benefits

Bristol-Myers Squibb manufactures paclitaxel, the active ingredient in the anticancer drug, Taxol®, using plant cell fermentation (PCF) technology. PCF replaces the conventional process that extracts a paclitaxel building block from leaves and twigs of the European yew. During the first five years of commercialization, PCF technology will eliminate an estimated 71,000 pounds of hazardous chemicals and materials, eliminate 10 solvents and 6 drying steps, and save a significant amount of energy.

Paclitaxel, the active ingredient in the anticancer drug Taxol®, was first isolated and identified from the bark of the Pacific yew tree, *Taxus brevifolia*, in the late 1960s by Wall and Wani under the auspices of the National Cancer Institute (NCI). The utility of paclitaxel to treat ovarian cancer was demonstrated in clinical trials in the 1980s. The continuity of supply was not guaranteed, however, because yew bark contains only about 0.0004 percent paclitaxel. In addition, isolating paclitaxel required stripping the bark from the yew trees, killing them in the process. Yews take 200 years to mature and are part of a sensitive ecosystem.

The complexity of the paclitaxel molecule makes commercial production by chemical synthesis from simple compounds impractical. Published syntheses involve about 40 steps with an overall yield of approximately 2 percent. In 1991, NCI signed a Collaborative Research and Development Agreement with Bristol-Myers Squibb (BMS) in which BMS agreed to ensure supply of paclitaxel from yew bark while it developed a semisynthetic route (semisynthesis) to paclitaxel from the naturally occurring compound 10-deacetylbaccatin III (10-DAB).

10-DAB contains most of the structural complexity (8 chiral centers) of the paclitaxel molecule. It is present in the leaves and twigs of the European yew, *Taxus baccata*, at approximately 0.1 percent by dry weight and can be isolated without harm to the trees. *Taxus baccata* is cultivated throughout Europe, providing a renewable supply that does not adversely impact any sensitive ecosystem. The semisynthetic process is complex, however, requiring 11 chemical transformations and 7 isolations. The semisynthetic process also presents environmental concerns, requiring 13 solvents along with 13 organic reagents and other materials.

BMS developed a more sustainable process using the latest plant cell fermentation (PCF) technology. In the cell fermentation stage of the process, calluses of a specific taxus cell line are propagated in a wholly aqueous medium in large fermentation tanks under controlled conditions at ambient temperature and pressure. The feedstock for the cell growth consists of renewable nutrients: sugars, amino acids, vitamins, and trace elements. BMS extracts paclitaxel directly from plant cell cultures, then purifies it by chromatography and isolates it by crystallization. By replacing leaves and twigs with plant cell cultures, BMS improves the sustainability of the paclitaxel supply, allows year-round harvest, and eliminates solid biomass waste. Compared to the semisynthesis from 10-DAB, the PCF process has no chemical transformations, thereby eliminating six intermediates. During its first five years, the PCF process will eliminate an estimated 71,000 pounds of hazardous chemicals and other materials. In addition, the PCF process eliminates 10 solvents and 6 drying steps, saving a considerable amount of energy. BMS is now manufacturing paclitaxel using only plant cell cultures.

Greener Reaction Conditions Award

Buckman Laboratories International, Inc.

Optimize[®]: A New Enzyme Technology to Improve Paper Recycling

Innovation and Benefits

Paper mills traditionally use hazardous solvents, such as mineral spirits, to remove sticky contaminants (stickies) from machinery. Optimize[®] technology uses a novel enzyme to remove stickies from paper products prior to recycling, increasing the percentage of paper that can be recycled. Each paper mill that switches to Optimize[®] can reduce its hazardous solvent use by 200 gallons daily, reduce its chemical use by approximately 600,000 pounds yearly, increase its production by more than 6 percent, and save up to \$1 million per year.

Recycling paper products is an important part of maintaining our environment. Although produced from renewable resources, paper is a major contributor to landfilled waste. Paper can be recycled numerous times, and much progress has been made: about one-half of the paper and paperboard currently used in the United States is collected and reused. Some papers, however, contain adhesives, coatings, plastics, and other materials that form sticky contaminants, creating serious problems during the paper recycling process. These contaminants, called “stickies” by the paper industry, can produce spots and holes in paper goods made from recycled materials, ruining their appearance and lowering their quality.

Stickies also waste significant manufacturing resources when production must stop to clean the equipment. One source estimates the cost to the industry from production downtime alone to be more than \$500 million annually. Further, this cleaning is traditionally done with chemical solvents, typically mineral spirits, which can have health and safety problems, are obtained from nonrenewable, petroleum resources, and are not readily recycled. These solvents are volatile organic compounds (VOCs) that contribute to air pollution. As a result, some paper grades cannot be recycled into reusable products.

Optimize[®] technology from Buckman Laboratories is a completely new way to control the problems associated with stickies. It uses a novel enzyme to eliminate common problems in the manufacture of paper from recycled papers. A major component of the sticky contaminants in paper is poly(vinyl acetate) and similar materials. Optimize[®] contains an esterase enzyme that catalyzes the hydrolysis of this type of polymer to poly(vinyl alcohol), which is not sticky and is water-soluble. A bacterial species produces large amounts of the Optimize[®] enzyme by fermentation. As a protein, the enzyme is completely biodegradable, much less toxic than alternatives, and much safer. Only renewable resources are required to manufacture Optimize[®].

Optimize[®] has been commercially available since May 2002. In that short time, more than 40 paper mills have converted to Optimize[®] for manufacturing paper goods from recycled papers. In one U.S. mill, conversion to Optimize[®] reduced solvent use by 200 gallons per day and chemical use by about 600,000 pounds per year. Production increased by more than 6 percent, which amounted to a \$1 million benefit per year for this mill alone.

This new enzyme technology has improved production of a broad range of paper products, including tissue, paper toweling, corrugated cartons, and many other materials. It improves the quality and efficiency of papermaking, dramatically reducing downtime to clean equipment. As a result, more paper is being recycled and grades of paper that were not recyclable earlier are now being recycled. Paper mills adopting Optimize[®] have been able to greatly reduce the use of hazardous solvents.

In summary, Optimize[®] makes it possible to recycle more grades of paper, allows more efficient processing of recycled papers, and produces higher-quality paper goods from recycled materials. The Optimize[®] technology comes from renewable resources, is safe to use, and is itself completely recyclable.

Designing Greener Chemicals Award

Engelhard Corporation (now BASF Corporation)

Engelhard Rightfit™ Organic Pigments: Environmental Impact, Performance, and Value

Innovation and Benefits

Rightfit™ azo pigments contain calcium, strontium, or barium; they replace conventional heavy-metal-based pigments containing lead, hexavalent chromium, or cadmium. Because of their low potential toxicity and very low migration, most of the Rightfit™ azo pigments have received U.S. Food and Drug Administration (FDA) and Canadian Health Protection Branch (HPB) approval for indirect food contact applications. By 2004, Engelhard expects to have replaced all 6.5 million pounds of its heavy-metal-based pigments with Rightfit™ pigments.

Historically, pigments based on lead, chromium(VI), and cadmium have served the red, orange, and yellow color market. When the U.S. EPA began regulating heavy metals, however, color formulators typically turned to high-performance organic pigments to replace heavy-metal-based pigments. Although high-performance pigments meet performance requirements, they do so at the expense of the following: (1) their higher cost often acts as a deterrent to reformulation; (2) their production uses large volumes of organic solvents; (3) some require large quantities of polyphosphoric acid, resulting in phosphates in the effluent; and (4) some are based on dichlorobenzidine or polychlorinated phenyls.

Engelhard has developed a wide range of environmentally friendly Rightfit™ azo pigments that contain calcium, strontium, or sometimes barium instead of heavy metals. True to their name, the Rightfit™ pigments have the right environmental impact, right color space, right performance characteristics, and right cost-to-performance value. Since 1995, when Engelhard produced 6.5 million pounds of pigments containing heavy metals, it has been transitioning to Rightfit™ azo pigments. In 2002, Engelhard produced only 1.2 million pounds of

heavy-metal pigments; they expect to phase them out completely in 2004.

Rightfit™ pigments eliminate the risk to human health and the environment from exposure to heavy metals such as cadmium, chromium(VI), and lead used in the manufacture of cadmium and chrome yellow pigments. They are expected to have very low potential toxicity based on toxicity studies, physical properties, and structural similarities to many widely used food colorants. Because they have low potential toxicity and very low migration, most of the Rightfit™ pigments have been approved both by the U.S. Food and Drug Administration (FDA) and the Canadian Health Protection Branch (HPB) for indirect food contact applications. In addition, these pigments are manufactured in aqueous medium, eliminating exposure to the polychlorinated intermediates and organic solvents associated with the manufacture of traditional high-performance pigments.

Rightfit™ pigments have additional benefits, such as good dispersibility, improved dimensional stability, improved heat stability, and improved color strength. Their higher color strength achieves the same color values using less pigment. Rightfit™ pigments also cover a wide color range from purple to green-shade yellow color. Being closely related chemically, these pigments are mutually compatible, so two or more can combine to achieve any desired intermediate color shade.

Rightfit™ pigments meet the essential performance characteristics at significantly lower cost than high-performance organic pigments. Thus, formulators get the right performance properties at the right cost, resulting in a steadily increasing market for these pigments. Rightfit™ pigments provide environmentally friendly, value-added color to packaging used in the food, beverage, petroleum product, detergent, and other household durable goods markets.

2003 Winners

Academic Award

Professor Richard A. Gross

Polytechnic University

New Options for Mild and Selective Polymerizations Using Lipases

Innovation and Benefits

Professor Gross developed a highly selective, more efficient way to make polyesters using enzymes. This technique requires less energy and toxic substances than conventional methods that typically use heavy metal catalysts and hazardous solvents. This innovation also makes it possible to manufacture new types of polyesters.

Isolated lipases, harvested from living organisms, have been used as catalysts for polymer synthesis *in vitro*. Professor Richard A. Gross's developments on lipase-catalyzed polymer synthesis have relied on the ability of enzymes to reduce the activation energy of polymerizations and, thus, to decrease process energy consumption. Further, the regioselectivity of lipases has been used to polymerize polyols directly. Alternative synthetic pathways for such polymerizations require protection-deprotection chemical steps. The mild reaction conditions allow polymerization of chemically and thermally sensitive molecules. Current alternative chemical routes require coupling agents (e.g., carbodiimides) that would be consumed in stoichiometric quantities relative to the reactants. Fundamental studies of these polymerizations have uncovered remarkable capabilities of lipases for polymerization chemistry. Selected examples include: (1) lipases catalyze transesterification reactions between high-molecular-weight chains in melt conditions; (2) lipases will use non-natural nucleophiles such as carbohydrates and monohydroxyl polybutadiene (M_n 19,000) in place of water; (3) the catalysis of ring-opening polymerization occurs in a controlled manner without termination reactions and with predictable molecular weights; and (4) the selectivity of lipase-catalyzed step-condensation polymerizations leads to nonstatistical molecular weight distributions (polydispersities well below 2.0). These accomplishments are elaborated on the next page.

A series of polyol-containing polyesters was synthesized via a one-pot lipase-catalyzed condensation polymerization. By using various mixtures of polyols (e.g., glycerol, sorbitol) with other diacid and diol building blocks, the polyols are partially or completely solubilized, resulting in highly reactive condensation polymerizations. By this method, organic solvents and activated acids (e.g., divinyl esters) are not needed. The polymerization reactions give high-molecular-weight products (M_W up to 200,000) with narrow polydispersities (as low as 1.3). Further, the condensation reactions with glycerol and sorbitol building blocks proceed with high regioselectivity. Although the polyols used have three or more hydroxyl groups, only two of these hydroxyl groups are highly reactive in the polymerization. Thus, instead of obtaining highly cross-linked products, the regioselectivity provided by the lipase leads to lightly branched polymers where the degree of branching varies with the reaction time and monomer stoichiometry. By using lipase as the catalyst, highly versatile polymerizations result that can simultaneously polymerize lactones, hydroxyacids, cyclic carbonates, cyclic anhydrides, amino alcohols, and hydroxythiols. The method developed offers simplicity, mild reaction conditions, and the ability to incorporate carbohydrates, such as sugars, into polyesters without protection-deprotection steps.

Professor Gross's laboratory discovered that certain lipases catalyze transesterification reactions between high-molecular-weight chains that contain intrachain esters or have functional end-groups. Thus, lipases, such as Lipase B from *Candida antarctica*, catalyze intrachain exchange reactions between polymer chains as well as transesterification reactions between a monomer and a polymer. For polymers that have melting points below 100 °C, the reactions can be conducted in bulk. Transacylation reactions occur because the lipase has the ability to accommodate large-molecular-weight substrates and to catalyze the breaking of ester bonds within chains. Immobilized *Candida antarctica* Lipase B (Novozyme-435) catalyzed transesterification reactions between aliphatic polyesters that had M_n values in excess of 40,000 grams per mole. In addition to catalyzing metal-free transesterifications at remarkably low temperatures, lipases endow transesterification reactions with remarkable selectivity. This feature allows the preparation of block copolymers that have selected block lengths.

Small Business Award

AgraQuest, Inc.

Serenade®: An Effective, Environmentally Friendly Biofungicide

Innovation and Benefits

Serenade® is a new biofungicide for fruits and vegetables based on a naturally occurring strain of bacteria. Serenade® is nontoxic to beneficial and other nontarget organisms, does not generate any hazardous chemical residues, and is safe for workers and groundwater. It is well-suited for use in integrated pest management (IPM) programs and is listed with the Organic Materials Review Institute (OMRI) for use in organic agriculture.

Serenade® Biofungicide is based on a naturally occurring strain of *Bacillus subtilis* QST-713, discovered in a California orchard by AgraQuest scientists. Serenade® has been registered for sale as a microbial pesticide in the United States since July 2000. It is also registered for use in Chile, Mexico, Costa Rica, and New Zealand. Registration is pending in the Philippines, Europe, Japan, and several other countries. The product is formulated as a wettable powder, wettable granule, and liquid aqueous suspension. Serenade® has been tested on 30 crops in 20 countries and is registered for use in the United States on blueberries, cherries, cucurbits, grape vines, greenhouse vegetables, green beans, hops, leafy vegetables, mint, peanuts, peppers, pome fruit, potatoes, tomatoes, and walnuts. It is also registered for home and garden use. AgraQuest has been issued four U.S. patents; several international patents are pending on the QST-713 strain, associated antifungal lipopeptides, formulations, and combinations with other pesticides.

Serenade® works through a complex mode of action that is manifested both by the physiology of the bacteria and through the action of secondary metabolites produced by the bacteria. Serenade® prevents plant diseases first by covering the leaf surface and physically preventing attachment and penetration of the pathogens. In addition, Serenade® produces three groups of lipopeptides (iturins, agrastatins/

plipastatins, and surfactins) that act in concert to destroy germ tubes and mycelium. The iturins and plipastatins have been reported to have antifungal properties. Strain QST-713 is the first strain reported to produce iturins, plipastatins, and surfactins, as well as two new compounds with a novel cyclic peptide moiety, the agrastatins. The surfactins have no activity on their own, but low levels (25 ppm or less) in combination with the iturins or the agrastatin/plipastatin group cause significant inhibition of spores and germ tubes. In addition, the agrastatins and iturins have synergistic activities towards inhibition of plant pathogen spores.

The Serenade® formulation is available as a wettable powder, wettable granule, and aqueous suspension that is applied just like any other foliar fungicide. It can be applied alone or tank mixed; it can also be alternated with traditional chemical pesticides. Serenade® is not toxic to beneficial and nontarget organisms, such as trout, quail, lady beetles, lacewings, parasitic wasps, earthworms, and honey bees. Serenade® is exempt from tolerance because there are no synthetic chemical residues and it is safe to workers and ground water.

Serenade®'s wettable granule formulation is listed with the Organic Materials Review Institute (OMRI) for use in organic agriculture and will continue to be listed under the National Organic Standards, which were enacted in the United States in October 2002.

Serenade®'s novel, complex mode of action, environmental friendliness, and broad spectrum control make it well-suited for use in integrated pest management (IPM) programs that utilize many tools, such as cultural practices, classical biological control, and other fungicides. Serenade® can be applied right up until harvest, providing needed pre- and post-harvest protection when there is weather conducive to disease development around harvest time.

Greener Synthetic Pathways Award

Süd-Chemie Inc.

A Wastewater-Free Process for Synthesis of Solid Oxide Catalysts

Innovation and Benefits

Süd-Chemie's new process to synthesize solid oxide catalysts used in producing hydrogen and clean fuel has virtually zero wastewater discharge, zero nitrate discharge, and no or little NO_x emissions. Each 10 million pounds of oxide catalyst produced by the new pathway eliminates approximately 760 million pounds of wastewater discharges, 29 million pounds of nitrate discharges, and 7.6 million pounds of NO_x emissions. The process also saves water and energy.

Some major achievements in pollution reduction have been made recently through advancement of catalytic technologies. One such effort is in the area of hydrogen and clean fuel production. However, the synthesis of catalysts for such reactions is often accompanied by the discharge of large amounts of wastewater and other pollutants, such as NO_x , SO_x , and halogens.

As a result of their commitment to continuously develop and invest in new and improved catalyst synthesis technologies, Süd-Chemie successfully developed and demonstrated a new synthetic pathway that is able to achieve virtually zero wastewater discharge, zero nitrate discharge, and no or little NO_x emissions. Meantime, it substantially reduces the consumption of water and energy. For example, it is estimated that about 760 million pounds of wastewater discharges, about 29 million pounds of nitrate discharges, and about 7.6 million pounds of NO_x emissions can be eliminated for every 10 million pounds of oxide catalyst produced.

The new synthetic pathway is based on very simple chemistry. Instead of acid-base precipitation typically using metal nitrate as raw material, the new process starts with a clean metal that is readily and economically available in commercial quantities. The synthesis proceeds by

reaction of the metal with a mild organic acid in the presence of an oxidation agent. The function of the acid is to activate the metal and extract electrons to form the oxide precursor. With assistance of the oxidation agent (typically air), a porous solid oxide is synthesized in one step at ambient temperature without any wastewater discharge. The other active ingredients of the catalyst can be incorporated using the concept of wet-agglomeration. In contrast, the precipitation process requires intensive washing and filtration to remove nitrate and the other salts. Further, the new process substantially reduces the consumption of water and energy for production of solid oxide catalysts over conventional methods. The emission in the entire process is only pure water vapor and a small amount of CO₂ that is generated during spray-drying and afterburning of hydrogen.

This wastewater-free process for making solid oxide catalysts has been demonstrated, and more than 300 kilograms of the metal oxide catalysts have been produced. Patent protection is being sought for the development. The catalysts made by the green process give superior performance in the synthesis of clean fuels and chemicals. The market for such solid oxide catalysts is estimated to be approximately \$100 million. Süd-Chemie is the first in the industry to use the green process for making a catalyst for the synthesis of “green” fuels and chemicals.

Greener Reaction Conditions Award

DuPont

Microbial Production of 1,3-Propanediol

Innovation and Benefits

DuPont and Genencor International jointly developed a genetically engineered microorganism to manufacture the key building block for DuPont's Sorona® polyester. The process uses renewable cornstarch instead of petroleum to make environmentally friendly, cost-competitive textiles.

DuPont is integrating biology in the manufacture of its newest polymer platform, DuPont Sorona® polymer. Combining metabolic engineering with polymer science, researchers are introducing a microbial process in a business that, historically, has relied solely on traditional chemistry and petrochemical feedstocks. This achievement, comprising biocatalytic production of 1,3-propanediol from renewable resources, offers economic as well as environmental advantages. The key to the novel biological process is an engineered microorganism that incorporates several enzyme reactions, obtained from naturally occurring bacteria and yeast, into an industrial host cell line. For the first time, a highly engineered microorganism will be used to convert a renewable resource into a chemical at high volume.

The catalytic efficiency of the engineered microorganism allows replacement of a petroleum feedstock, reducing the amount of energy needed in manufacturing steps and improving process safety. The microbial process is environmentally green, less expensive, and more productive than the chemical operations it replaces. 1,3-Propanediol, a key ingredient in the Sorona® polymers, provides advantageous attributes for apparel, upholstery, resins, and nonwoven applications.

Scientists and engineers from DuPont and Genencor International, Inc. redesigned a living microbe to produce 1,3-propanediol. Inserting

biosynthetic pathways from several microorganisms into an industrial host cell line allows the direct conversion of glucose to 1,3-propanediol, a route not previously available in a single microorganism. Genes from a yeast strain with the ability to convert glucose, derived from cornstarch, to glycerol were inserted into the host. Genes from a bacterium with the ability to transform glycerol to 1,3-propanediol were also incorporated. Additionally, the reactions present naturally in the host were altered to optimize product formation. The modifications maximize the ability of the organism to convert glucose to 1,3-propanediol while minimizing its ability to produce biomass and unwanted byproducts. Coalescing enzyme reactions from multiple organisms expands the range of materials that can be economically produced by biological means.

For more than 50 years, scientists have recognized the performance benefits of polyesters produced with 1,3-propanediol; however, the high cost of manufacturing the ingredient using petroleum feedstock and traditional chemistry kept it from the marketplace. The biological process using glucose as starting material will enable cost-effective manufacture of Sorona[®] polymer, which will offer consumer fabrics with softness, stretch and recovery, easy care, stain resistance, and colorfastness. A unique kink in the structure of the polymer containing 1,3-propanediol allows recovery at a high rate when it is stretched. As a result, Sorona[®] improves fit and comfort because the fabric quickly recovers its original shape when stretched, for example, in knees or elbows. The resilience of Sorona[®] also adds beneficial features to automotive upholstery and home textiles. In resin applications, Sorona[®]'s barrier characteristics protect moisture, taste, and odor.

Biology offers chemical manufacturers attractive options for the production of chemicals while adhering to the principles of green chemistry. This microbial production of a key polymer ingredient from renewable sources is one example. By integrating biology with chemistry, physics, and engineering, DuPont develops new solutions that enhance the environment and improve upon existing materials.

Designing Greener Chemicals Award

Shaw Industries, Inc.

EcoWorx™ Carpet Tile: A Cradle-to-Cradle Product

Innovation and Benefits

Conventional backings for carpet tiles contain bitumen, polyvinyl chloride (PVC), or polyurethane. EcoWorx™ carpet tiles have a novel backing that uses less toxic materials and has superior adhesion and dimensional stability. Because EcoWorx™ carpet tiles can be readily separated into carpet fiber and backing, each component can be easily recycled.

Historically, carpet tile backings have been manufactured using bitumen, polyvinyl chloride (PVC), or polyurethane (PU). While these backing systems have performed satisfactorily, there are several inherently negative attributes due to their feedstocks or their ability to be recycled. Although PVC has, to date, held the largest market share of carpet tile backing systems, it was Shaw's intent to design around PVC due to the health and environmental concerns around vinyl chloride monomer, chlorine-based products, plasticized PVC-containing phthalate esters, and toxic byproducts of combustion of PVC, such as dioxin and hydrochloric acid. While some claims are accepted by the Agency for Toxic Substances and Disease Registry (ATSDR) and the U.S. EPA, those resulting from publicly debated consumer perceptions provide ample justification for finding a PVC alternative.

Due to the thermoset cross-linking of polyurethanes, they are extremely difficult to recycle and are typically downcycled or landfilled at the end of their useful life. Bitumen provides some advantages in recycling, but the modified bitumen backings offered in Europe have failed to gain market acceptance in the United States and are unlikely to do so.

Shaw selected a combination of polyolefin resins from Dow Chemical as the base polymer of choice for EcoWorx™ due to the low toxicity of its feedstocks, superior adhesion properties, dimensional stability, and

its ability to be recycled. The EcoWorx™ compound also had to be designed to be compatible with nylon carpet fiber. Although EcoWorx™ may be recovered from any fiber type, nylon-6 provides a significant advantage. Polyolefins are compatible with known nylon-6 depolymerization methods. PVC interferes with those processes. Nylon-6 chemistry is well-known and not addressed in first-generation production.

From its inception, EcoWorx™ met all of the design criteria necessary to satisfy the needs of the marketplace from a performance, health, and environmental standpoint. Research indicated that separation of the fiber and backing through elutriation, grinding, and air separation proved to be the best way to recover the face and backing components, but an infrastructure for returning postconsumer EcoWorx™ to the elutriation process was necessary. Research also indicated that the postconsumer carpet tile had a positive economic value at the end of its useful life. The cost of collection, transportation, elutriation, and return to the respective nylon and EcoWorx™ manufacturing processes is less than the cost of using virgin raw materials.

With introduction in 1999 and an anticipated lifetime of ten to fifteen years on the floor, significant quantities of EcoWorx™ will not flow back to Shaw until 2006 to 2007. An expandable elutriation unit is now operating at Shaw, typically dealing with industrial EcoWorx™ waste. Recovered EcoWorx™ is flowing back to the backing extrusion unit. Caprolactam recovered from the elutriated nylon-6 is flowing back into nylon compounding. EcoWorx™ will soon displace all PVC at Shaw.

2002 Winners

Academic Award

Professor Eric J. Beckman

University of Pittsburgh

Design of Non-Fluorous, Highly CO₂-Soluble Materials

Innovation and Benefits

Carbon dioxide (CO₂) is a nontoxic chemical that can be used as a solvent in many industrial processes. Professor Beckman developed new detergents that allow a broad range of substances to dissolve in CO₂. Any process that can now use CO₂ may reduce or eliminate the use of hazardous solvents.

Carbon dioxide (CO₂), an environmentally benign and nonflammable solvent, has been investigated extensively in both academic and industrial settings. Solubility studies performed during the 1980s had suggested that CO₂'s solvent power was similar to that of *n*-alkanes, leading to hopes that the chemical industry could use CO₂ as a "drop-in" replacement for a wide variety of organic solvents. It was learned that these solubility studies inflated the solvent power value by as much as 20 percent due to the strong quadrupole moment of CO₂ and that CO₂ is actually a rather feeble solvent compared to alkanes. As the 1980s drew to a close, a number of research groups began to explore the design of CO₂-philic materials, that is, compounds that dissolve in CO₂ at significantly lower pressures than do their alkyl analogs. These new CO₂-philes, primarily fluoropolymers, opened up a host of new applications for CO₂ including heterogeneous polymerization, protein extraction, and homogeneous catalysis.

Although fluorinated amphiphiles allow new applications for CO₂, their cost (approximately \$1 per gram) reduces the economic viability of CO₂ processes, particularly given that the use of CO₂ requires high-pressure equipment. Furthermore, data have recently shown that fluoroalkyl materials persist in the environment, leading to the withdrawal of certain consumer products from the market. The drawbacks inherent

to the use of fluorinated precursors, therefore, have inhibited the commercialization of many new applications for CO₂, and the full promise of CO₂-based technologies has yet to be realized. To address this need, Professor Eric J. Beckman and his group at the University of Pittsburgh have developed materials that work well, exhibiting miscibility pressures in CO₂ that are comparable or lower than fluorinated analogs and yet contain no fluorine.

Drawing from recent studies of the thermodynamics of CO₂ mixtures, Professor Beckman hypothesized that CO₂-philic materials should contain three primary features: (1) a relatively low glass transition temperature; (2) a relatively low cohesive energy density; and (3) a number of Lewis base groups. Low glass transition temperature correlates to high free volume and high molecular flexibility, which imparts a high entropy of mixing with CO₂ (or any solvent). A low cohesive energy density is primarily a result of weak solute-solute interactions, a necessary feature given that CO₂ is a rather feeble solvent. Finally, because CO₂ is a Lewis acid, the presence of Lewis base groups should create sites for specific favorable interactions with CO₂.

Professor Beckman's simple heuristic model was demonstrated on three sets of materials: functional silicones; poly(ether-carbonates); and acetate-functional polyethers. Poly(ether-carbonates) were found to exhibit lower miscibility pressures in CO₂ than perfluoropolyethers, yet are biodegradable and 100 times less expensive to prepare. Other families of non-fluorous CO₂-philes will inevitably be discovered using this model, further broadening the applicability of CO₂ as a greener process solvent.

Small Business Award

SC Fluids, Inc.

SCORR—Supercritical CO₂ Resist Remover

Innovation and Benefits

SCORR (Supercritical CO₂ Resist Remover) technology cleans residues from semiconductor wafers during their manufacture. SCORR improves on conventional techniques: it minimizes hazardous solvents and waste, is safer for workers, costs less, and uses less water and energy. SCORR also eliminates rinsing with ultrapure water and subsequent drying.

The semiconductor industry is the most successful growth industry in history, with sales totaling over \$170 billion in the year 2000. The fabrication of integrated circuits (ICs) relies heavily on photolithography to define the shape and pattern of individual components. Current manufacturing practices use hazardous chemicals and enormous amounts of purified water during this intermediate step, which may be repeated up to 30 times for a single wafer. It is estimated that a typical chip-fabrication plant generates 4 million gallons of wastewater and consumes thousands of gallons of corrosive chemicals and hazardous solvents each day.

SC Fluids, in partnership with Los Alamos National Laboratory, has developed a new process, SCORR, that removes photoresist and post-ash, -etch, and -CMP (particulate) residue from semiconductor wafers. The SCORR technology outperforms conventional photoresist removal techniques in the areas of waste minimization, water use, energy consumption, worker safety, feature size compatibility, material compatibility, and cost. The key to the effectiveness of SCORR is the use of supercritical CO₂ in place of hazardous solvents and corrosive chemicals. Neat CO₂ is also utilized for the rinse step, thereby eliminating the need for a deionized water rinse and an isopropyl alcohol drying step. In the closed-loop SCORR process, CO₂ returns to a gaseous phase upon depressurization, leaving the silicon wafer dry and free of residue.

SCORR is cost-effective for five principal reasons. It minimizes the use of hazardous solvents, thereby minimizing costs required for disposal and discharge permits. It thoroughly strips photoresists from the wafer surface in less than half the time required for wet-stripping and far outperforms plasma, resulting in increased throughput. It eliminates rinsing and drying steps during the fabrication process, thereby simplifying and streamlining the manufacturing process. It eliminates the need for ultrapure deionized water, thus reducing time, energy, and cost. Supercritical CO₂ costs less than traditional solvents and is recyclable.

SCORR will meet future, as well as current technology demands. To continue its astounding growth, the semiconductor industry must develop ICs that are smaller, faster, and cheaper. Due to their high viscosity, traditional wet chemistries cannot clean small feature sizes. Vapor cleaning technologies are available, but viable methods for particle removal in the gas phase have not yet been developed. Using SCORR, the smallest features present no barriers because supercritical fluids have zero surface tension and a “gaslike” viscosity and, therefore, can clean features less than 100 nm. The low viscosity of supercritical fluids also allows particles less than 100 nm to be removed. The end result is a technically enabling “green” process that has been accepted by leading semiconductor manufacturers and equipment and material suppliers.

SCORR technology is being driven by industry in pursuit of its own accelerated technical and manufacturing goals. SCORR was initially developed through a technical request from Hewlett Packard (now Agilent). A joint Cooperative Research and Development Agreement between Los Alamos National Laboratory and SC Fluids has led to the development of commercial units (SC Fluids’s Arroyo™ System). Other industry leaders, such as IBM, ATMI, and Shipley, are participating in the development of this innovative technology.

Greener Synthetic Pathways Award

Pfizer, Inc.

Green Chemistry in the Redesign of the Sertraline Process

Innovation and Benefits

Pfizer dramatically improved its manufacturing process for sertraline, the active ingredient in its popular drug, Zoloft®. The new process doubles overall product yield, reduces raw material use by 20–60 percent, eliminates the use or generation of approximately 1.8 million pounds of hazardous materials, reduces energy and water use, and increases worker safety.

Sertraline is the active ingredient in the important pharmaceutical, Zoloft®. Zoloft® is the most prescribed agent of its kind and is used to treat an illness (depression) that each year strikes 20 million adults in the United States, and that costs society \$43.7 billion (1990 dollars). As of February 2000, more than 115 million Zoloft® prescriptions had been written in the United States.

Applying the principles of green chemistry, Pfizer has dramatically improved the commercial manufacturing process of sertraline. After meticulously investigating each of the chemical steps, Pfizer implemented a substantive green chemistry technology for a complex commercial process requiring extremely pure product. As a result, Pfizer significantly improved both worker and environmental safety. The new commercial process (referred to as the “combined” process) offers substantial pollution prevention benefits including improved safety and material handling, reduced energy and water use, and doubled overall product yield.

Specifically, a three-step sequence in the original manufacturing process was streamlined to a single step in the new sertraline process. The new process consists of imine formation of monomethylamine with a tetralone, followed by reduction of the imine function and in situ resolution of the diastereomeric salts of mandelic acid to provide chirally pure sertraline in much higher yield and with greater selectivity.

A more selective palladium catalyst was implemented in the reduction step, which reduced the formation of impurities and the need for reprocessing. Raw material use was cut by 60 percent, 45 percent, and 20 percent for monomethylamine, tetralone, and mandelic acid, respectively.

Pfizer also optimized its process using the more benign solvent ethanol for the combined process. This change eliminated the need to use, distill, and recover four solvents (methylene chloride, tetrahydrofuran, toluene, and hexane) from the original synthesis. Pfizer's innovative use of solubility differences to drive the equilibrium toward imine formation in the first reaction of the combined steps eliminated approximately 310,000 pounds per year of the problematic reagent titanium tetrachloride. This process change eliminates 220,000 pounds of 50 percent sodium hydroxide, 330,000 pounds of 35 percent hydrochloric acid waste, and 970,000 pounds of solid titanium dioxide waste per year.

By eliminating waste, reducing solvents, and maximizing the yield of key intermediates, Pfizer has demonstrated significant green chemistry innovation in the manufacture of an important pharmaceutical agent.

Greener Reaction Conditions Award

Cargill Dow LLC (now NatureWorks LLC)

NatureWorks™ PLA Process

Innovation and Benefits

The NatureWorks™ process makes biobased, compostable, and recyclable polylactic acid (PLA) polymers using 20–50 percent less fossil fuel resources than comparable petroleum-based polymers. The synthesis of PLA polymers eliminates organic solvents and other hazardous materials, completely recycles product and byproduct streams, and efficiently uses catalysts to reduce energy consumption and improve yield.

NatureWorks™ polylactic acid (PLA) is the first family of polymers derived entirely from annually renewable resources that can compete head-to-head with traditional fibers and plastic packaging materials on a cost and performance basis. For fiber consumers, this will mean a new option for apparel and carpeting applications: a material that bridges the gap in performance between conventional synthetic fibers and natural fibers such as silk, wool, and cotton. Clothing made with NatureWorks™ fibers features a unique combination of desirable attributes such as superior hand, touch, and drape, wrinkle resistance, excellent moisture management, and resilience. In packaging applications, consumers will have the opportunity to use a material that is natural, compostable, and recyclable without experiencing any tradeoffs in product performance.

The NatureWorks™ PLA process offers significant environmental benefits in addition to the outstanding performance attributes of the polymer. NatureWorks™ PLA products are made in a revolutionary new process developed by Cargill Dow LLC that incorporates all 12 green chemistry principles. The process consists of three separate and distinct steps that lead to the production of lactic acid, lactide, and PLA high polymer. Each of the process steps is free of organic solvent: water is used in the fermentation while molten lactide and polymer serve as the reaction media in monomer and polymer production. Each step not

only has exceptionally high yields (over 95 percent) but also utilizes internal recycle streams to eliminate waste. Small (ppm) amounts of catalyst are used in both the lactide synthesis and polymerization to further enhance efficiency and reduce energy consumption. Additionally, the lactic acid is derived from annually renewable resources, PLA requires 20–50 percent less fossil resources than comparable petroleum-based plastics, and PLA is fully biodegradable or readily hydrolyzed into lactic acid for recycling back into the process.

While the technology to create PLA in the laboratory has been known for many years, previous attempts at large-scale production were targeted solely at niche biodegradable applications and were not commercially viable. Only now has Cargill Dow been able to perfect the NatureWorks™ process and enhance the physical properties of PLA resins to compete successfully with commodity petroleum-based plastics. Cargill Dow is currently producing approximately 8.8 million pounds of PLA per year to meet immediate market development needs. Production in the first world-scale 310-million-pound-per-year plant began November 1, 2001.

The NatureWorks™ process embodies the well-known principles of green chemistry by preventing pollution at the source through the use of a natural fermentation process to produce lactic acid, substituting annually renewable materials for petroleum-based feedstock, eliminating the use of solvents and other hazardous materials, completely recycling product and byproduct streams, and efficiently using catalysts to reduce energy consumption and improve yield. In addition, NatureWorks™ PLA products can be either recycled or composted after use.

Designing Greener Chemicals Award

Chemical Specialties, Inc. (now Viance)

ACQ Preserve®: The Environmentally Advanced Wood Preservative

Innovation and Benefits

ACQ Preserve® is an environmentally advanced wood preservative designed to replace chromated copper arsenate (CCA) wood preservatives, which have been phased out because of their toxicity. ACQ Preserve® will eliminate the use of 40 million pounds of arsenic and 64 million pounds of hexavalent chromium each year. It also avoids the potential risks associated with producing, transporting, using, and disposing of CCA wood preservatives and CCA-treated wood.

The pressure-treated wood industry is a \$4 billion industry, producing approximately 7 billion board feet of preserved wood per year. More than 95 percent of the pressure-treated wood used in the United States is currently preserved with chromated copper arsenate (CCA). Approximately 150 million pounds of CCA wood preservatives were used in the production of pressure-treated wood in 2001, enough wood to build 435,000 homes. About 40 million pounds of arsenic and 64 million pounds of chromium(VI) were used to manufacture these CCA wood preservatives.

Over the past few years, scientists, environmentalists, and regulators have raised concerns regarding the risks posed by the arsenic that is either dislodged or leached from CCA-treated wood. A principal concern is the risk to children from contact with CCA-treated wood in playground equipment, picnic tables, and decks. This concern has led to increased demand for and use of alternatives to CCA.

Chemical Specialties, Inc. (CSI) developed its alkaline copper quaternary (ACQ) wood preservative as an environmentally advanced formula designed to replace the CCA industry standard. ACQ formulations combine a bivalent copper complex and a quaternary ammonium compound in a 2:1 ratio. The copper complex may be dissolved in

either ethanolamine or ammonia. Carbon dioxide (CO₂) is added to the formulation to improve stability and to aid in solubilization of the copper.

Replacing CCA with ACQ is one of the most dramatic pollution prevention advancements in recent history. Because more than 90 percent of the 44 million pounds of arsenic used in the United States each year is used to make CCA, replacing CCA with ACQ will virtually eliminate the use of arsenic in the United States. In addition, ACQ Preserve® will eliminate the use of 64 million pounds of chromium(VI). Further, ACQ avoids the potential risks associated with the production, transportation, use, and disposal of the arsenic and chromium(VI) contained in CCA wood preservatives and CCA-treated wood. In fact, ACQ does not generate any RCRA (i.e., Resource Conservation and Recovery Act) hazardous waste from production and treating facilities. The disposal issues associated with CCA-treated wood and ash residues associated with the burning of treated wood will also be avoided.

In 1996, CSI commercialized ACQ Preserve® in the United States. More than one million active pounds of ACQ wood preservatives were sold in the United States in 2001 for use by 13 wood treaters to produce over 100 million board feet of ACQ-preserved wood. In 2002, CSI plans to spend approximately \$20 million to increase its production capacity for ACQ to over 50 million active pounds. By investing in ACQ technology, CSI has positioned itself and the wood preservation industry to transition away from arsenic-based wood preservatives to a new generation of preservative systems.

2001 Winners

Academic Award

Professor Chao-Jun Li

Tulane University

Quasi-Nature Catalysis: Developing Transition Metal Catalysis in Air and Water

Innovation and Benefits

Professor Li developed a novel method to carry out a variety of important chemical reactions that had previously required both an oxygen-free atmosphere and hazardous organic solvents. His reactions use metal catalysts and run in open containers of water. His method is inherently safer, requires fewer process steps, operates at lower temperatures, and generates less waste.

The use of transition metals for catalyzing reactions is of growing importance in modern organic chemistry. These catalyses are widely used in the synthesis of pharmaceuticals, fine chemicals, petrochemicals, agricultural chemicals, polymers, and plastics. Of particular importance is the formation of C–C, C–O, C–N, and C–H bonds. Traditionally, the use of an inert gas atmosphere and the exclusion of moisture have been essential in both organometallic chemistry and transition-metal catalysis. The catalytic actions of transition metals in ambient atmosphere have played key roles in various enzymatic reactions including biocatalysis, biodegradation, photosynthesis, nitrogen fixation, and digestions, as well as the evolution of bioorganisms. Unlike traditionally used transition-metal catalysts, these “natural” catalytic reactions occur under aqueous conditions in an air atmosphere.

The research of Professor Chao-Jun Li has focused on the development of numerous transition-metal-catalyzed reactions both in air and water. Specifically, Professor Li has developed a novel [3+2] cycloaddition reaction to generate 5-membered carbocycles in water; a synthesis of β -hydroxyl esters in water; a chemoselective alkylation and pinacol

coupling reaction mediated by manganese in water; and a novel alkylation of 1,3-dicarbonyl-type compounds in water. His work has enabled rhodium-catalyzed carbonyl addition and rhodium-catalyzed conjugate addition reactions to be carried out in air and water for the first time. A highly efficient, zinc-mediated Ullman-type coupling reaction catalyzed by palladium in water has also been designed. This reaction is conducted at room temperature under an atmosphere of air. In addition, a number of Barbier-Grignard-type reactions in water have been developed; these novel synthetic methodologies are applicable to the synthesis of a variety of useful chemicals and compounds. Some of these reactions demonstrate unprecedented chemoselectivity that eliminates byproduct formation and product separation. Application of these new methodologies to natural product synthesis, including polyhydroxylated natural products, medium-sized rings, and macrocyclic compounds, yields shorter reaction sequences.

Transition-metal-catalyzed reactions in water and air offer many advantages. Water is readily available and inexpensive; it is not flammable, explosive, or toxic. Consequently, aqueous-based production processes are inherently safer with regard to accident potential. Using water as a reaction solvent can save synthetic steps by avoiding protection and deprotection processes that affect overall synthetic efficiency and contribute to solvent emission. Product isolation may be facilitated by simple phase separation rather than energy-intensive and organic-emitting processes involving distillation of organic solvent. The temperature of reactions performed in aqueous media is also easier to control since water has such a high heat capacity. The open-air feature offers convenience in operations of chemical synthesis involving small-scale combinatorial synthesis, large-scale manufacturing, and catalyst recycling. As such, Professor Li's work in developing transition-metal-mediated and -catalyzed reactions in air and water offers an attractive alternative to the inert atmosphere and organic solvents traditionally used in synthesis.

Small Business Award

EDEN Bioscience Corporation

Messenger®: A Green Chemistry Revolution in Plant Production and Food Safety

Innovation and Benefits

EDEN Bioscience Corporation discovered and commercialized harpins, a new class of nontoxic, naturally occurring, biodegradable proteins, as an alternative to traditional pesticides. Harpins activate a plant's defense and growth mechanisms, thereby increasing crop yield and quality, and minimizing crop losses. EDEN manufactures Messenger®, its commercially available, harpin-containing, EPA-approved product, using a water-based fermentation system.

In today's competitive agricultural environment, growers must maximize crop productivity by enhancing yield and minimizing crop losses. The Food and Agriculture Organization of the United Nations estimates that annual losses to growers from pests reach \$300 billion worldwide. In addition to basic agronomic practices, growers generally have two alternatives to limit these economic losses and increase yields: (1) use traditional chemical pesticides; or (2) grow crops that are genetically engineered for pest resistance. Each of these approaches has come under increasing criticism from a variety of sources worldwide including environmental groups, government regulators, consumers, and labor advocacy groups. Harpin technology, developed by EDEN Bioscience Corporation, provides growers with a highly effective alternative approach to crop production that addresses these concerns.

EDEN's harpin technology is based on a new class of nontoxic, naturally occurring proteins called harpins, which were first discovered by Dr. Zhongmin Wei, EDEN's Vice President of Research, and his colleagues during his tenure at Cornell University. Harpin proteins trigger a plant's natural defense systems to protect against disease and pests and simultaneously activate certain plant growth systems without altering the plant's DNA. When applied to crops, harpins increase

plant biomass, photosynthesis, nutrient uptake, and root development, and, ultimately, lead to greater crop yield and quality.

Unlike most agricultural chemicals, harpin-based products are produced in a water-based fermentation system that uses no harsh solvents or reagents, requires only modest energy inputs, and generates no hazardous chemical wastes. Fermentation byproducts are fully biodegradable and safely disposable. In addition, EDEN uses low-risk ingredients to formulate the harpin protein-based end product. Approximately 70 percent of the dried finished product consists of an innocuous, food-grade substance that is used as a carrier for harpin protein.

The result of this technology is a U.S. EPA-approved product called Messenger[®] that has been demonstrated on more than 40 crops to effectively stimulate plants to defend themselves against a broad spectrum of viral, fungal, and bacterial diseases, including some for which there currently is no effective treatment. In addition, Messenger[®] has been shown through an extensive safety evaluation to have virtually no adverse effect on any of the organisms tested, including mammals, birds, honey bees, plants, fish, aquatic invertebrates, and algae. Only 0.004–0.14 pounds of harpin protein per acre per season is necessary to protect crops and enhance yields. As with most proteins, harpin is a fragile molecule that is degraded rapidly by UV and natural microorganisms and has no potential to bioaccumulate or to contaminate surface or groundwater resources.

Deployment of harpin technology conserves resources and protects the environment by reducing total agricultural inputs and partially replacing many higher-risk products. Using environmentally benign harpin protein technology, growers for the first time in the history of modern agriculture will be able to harness the innate defense and growth systems of crops to substantially enhance yields, improve crop quality, and reduce reliance on conventional agricultural chemicals.

Greener Synthetic Pathways Award

Bayer Corporation

Bayer AG

Baypure™ CX (Sodium Iminodisuccinate): An Environmentally Friendly and Readily Biodegradable Chelating Agent

Innovation and Benefits

Chelating agents are ingredients in a variety of products, such as detergents, fertilizers, and household and industrial cleaners. Most traditional chelating agents do not break down readily in the environment. Bayer Corporation and Bayer AG developed a waste-free, environmentally friendly manufacturing process for a new, biodegradable, nontoxic chelating agent. This new process eliminates the use of formaldehyde and hydrogen cyanide.

Chelating agents are used in a variety of applications, including detergents, agricultural nutrients, and household and industrial cleaners. Most traditional chelating agents, however, are poorly biodegradable. Some are actually quite persistent and do not adsorb at the surface of soils in the environment or at activated sludge in wastewater treatment plants. Because of this poor biodegradability combined with high water solubility, traditional chelators are readily released into the environment and have been detected in the surface waters of rivers and lakes and in make-up water processed for drinking water.

As part of its commitment to Responsible Care®, Bayer Corporation manufactures a readily biodegradable and environmentally friendly chelating agent, D,L-aspartic-N-(1,2-dicarboxyethyl) tetrasodium salt, also known as sodium iminodisuccinate. This agent is characterized by excellent chelation capabilities, especially for iron(III), copper(II), and calcium, and is both readily biodegradable and benign from a toxicological and ecotoxicological standpoint. Sodium iminodisuccinate is also an innovation in the design of chemicals that favorably impact the environment. This accomplishment was realized not by “simple”

modification of molecular structures of currently used chelating agents, but instead by the development of a wholly new molecule. Sodium iminodisuccinate is produced by a 100 percent waste-free and environmentally friendly manufacturing process. Bayer AG was the first to establish an environmentally friendly, patented manufacturing process to provide this innovative chelant commercially.

Sodium iminodisuccinate belongs to the aminocarboxylate class of chelating agents. Nearly all aminocarboxylates in use today are acetic acid derivatives produced from amines, formaldehyde, sodium hydroxide, and hydrogen cyanide. The industrial use of thousands of tons of hydrogen cyanide is an extreme toxicity hazard. In contrast, Bayer's sodium iminodisuccinate is produced from maleic anhydride (a raw material also produced by Bayer), water, sodium hydroxide, and ammonia. The only solvent used in the production process is water, and the only side product formed, ammonia dissolved in water, is recycled back into sodium iminodisuccinate production or used in other Bayer processes.

Because sodium iminodisuccinate is a readily biodegradable, nontoxic, and nonpolluting alternative to other chelating agents, it can be used in a variety of applications that employ chelating agents. For example, it can be used as a builder and bleach stabilizer in laundry and dishwashing detergents to extend and improve the cleaning properties of the eight billion pounds of these products that are used annually. Specifically, sodium iminodisuccinate chelates calcium to soften water and improve the cleaning function of the surfactant. In photographic film processing, sodium iminodisuccinate complexes metal ions and helps to eliminate precipitation onto the film surface. In agriculture, chelated metal ions help to prevent, correct, and minimize crop mineral deficiencies. Using sodium iminodisuccinate as the chelating agent in agricultural applications eliminates the problem of environmental persistence common with other synthetic chelating agents. In summary, Bayer's sodium iminodisuccinate chelating agent offers the dual benefits of producing a biodegradable, environmentally friendly chelating agent that is also manufactured in a waste-free process.

Greener Reaction Conditions Award

Novozymes North America, Inc.

BioPreparation™ of Cotton Textiles: A Cost-Effective, Environmentally Compatible Preparation Process

Innovation and Benefits

Novozymes North America developed BioPreparation™, a technology to separate natural waxes, oils, and contaminants from cotton before it is made into fabric. This technology uses enzymes instead of corrosive chemicals and could save 7–12 billion gallons of water each year.

In textiles, the source of one of the most negative impacts on the environment originates from traditional processes used to prepare cotton fiber, yarn, and fabric. Fabric preparation consists of a series of various treatments and rinsing steps critical to obtaining good results in subsequent textile finishing processes. These water-intensive, wet processing steps generate large volumes of wastes, particularly from alkaline scouring and continuous/batch dyeing. These wastes include large amounts of salts, acids, and alkali. In view of the 40 billion pounds of cotton fiber that are prepared annually on a global scale, it becomes clear that the preparation process is a major source of environmentally harsh chemical contribution to the environment.

Cotton wax, a natural component in the outer layer of cotton fibers, is a major obstacle in processing textiles; it must be removed to prepare the textile for dyeing and finishing. Conventional chemical preparation processes involve treatment of the cotton substrate with hot solutions of sodium hydroxide, chelating agents, and surface active agents, often followed by a neutralization step with acetic acid. The scouring process is designed to break down or release natural waxes, oils, and contaminants and emulsify or suspend these impurities in the scouring bath. Typically, scouring wastes contribute high biological oxygen demand (BOD) loads during cotton textile preparation (as much as 50 percent).

Novozymes's BioPreparation™ technology is an alternative to sodium hydroxide that offers many advantages for textile wet processing, including reduced biological and chemical oxygen demand (BOD/ COD) and decreased water use. BioPreparation™ is an enzymatic process for treating cotton textiles that meets the performance characteristics of alkaline scour systems while reducing chemical and effluent load. Pectate lyase is the main scouring agent that degrades pectin to release the entangled waxes and other components from the cotton surface. The enzyme is also compatible with other enzymatic preparations (amylases, cellulases) used to improve the performance properties of cotton fabrics.

The practical implications that BioPreparation™ technology has on the textile industry are realized in terms of conservation of chemicals, water, energy, and time. Based on field trials, textile mills may save as much as 30–50 percent in water costs by replacing caustic scours or by combining the usually separate scouring and dyeing steps into one. This water savings results because BioPreparation™ uses fewer rinsing steps than required during a traditional caustic scour. Significant time savings were also demonstrated by combining treatment steps. A recent statistical survey determined that 162 knitting mills typically use 24 billion gallons per year of water in processing goods from scouring to finishing; the BioPreparation™ approach would save from 7–12 billion gallons per year of water. In addition, field trials established that BOD and COD loads are decreased by 25 and 40 percent, respectively, when compared to conventional sodium hydroxide treatments. Furthermore, these conservation measures translate directly into cost savings of 30 percent or more. As such, this patented process provides an economical and environmentally friendly alternative to alkaline scour systems currently used in the textile industry.

Designing Greener Chemicals Award

PPG Industries

Yttrium as a Lead Substitute in Cationic Electrodeposition Coatings

Innovation and Benefits

PPG Industries developed a novel metal primer that uses yttrium instead of lead to resist corrosion in automobiles. The metal yttrium is far less toxic to human health and the environment than is lead and is more effective in preventing corrosion. PPG's primer should eliminate one million pounds of lead from automobile manufacture over the next few years. In addition, this primer does not require chromium- or nickel-based pretreatments, potentially eliminating the use of 25,000 pounds of chromium and 50,000 pounds of nickel each year.

PPG Industries introduced the first cationic electrodeposition primer to the automotive industry in 1976. During the succeeding years, this coating technology became very widely used in the industry such that today essentially all automobiles are given a primer coat using the chemistry and processing methods developed by PPG. The major benefits of this technology are corrosion resistance, high transfer efficiency (low waste), reliable automated application, and very low organic emissions. Unfortunately, the high corrosion resistance property of electrocoat has always been dependent on the presence of small amounts of lead salts or lead pigments in the product. As regulatory pressure on lead increased and consumer demand for improved corrosion resistance grew, lead was regularly exempted from regulation in electrocoat because there were no cost-effective substitutes. This is especially important in moderately priced cars and trucks where the high cost of using 100 percent zinc-coated (galvanized) steel could not be tolerated. Lead is very effective for protecting cold-rolled steel, which is still a common material of construction in automobiles.

For more than 20 years, PPG and other paint companies have sought a substitute for lead in this application. This search led to PPG's discovery that yttrium can replace lead in cationic electrocoat without any sacri-

fice in corrosion performance. Yttrium is a common element in the environment, being widely distributed in low concentrations throughout the earth's crust and more plentiful in the earth's crust than lead and silver. Although yttrium is much less studied than lead, the available data on yttrium indicate orders of magnitude lower hazard. As a dust hazard, yttrium is 100 times safer than lead at typical levels of use.

Numerous other benefits are realized when yttrium is used in electrocoat applications. Yttrium is twice as effective as lead on a weight basis, allowing the formulation of commercial coatings that contain half the yttrium by weight relative to lead in comparably performing lead-containing products. In addition, it has been found that as yttrium is deposited in an electrocoat film, it deposits as the hydroxide. The hydroxide is converted to yttrium oxide during normal baking of the electrocoat. The oxide is extraordinarily nontoxic by ingestion as indicated by the LD₅₀ of over 10 grams per kilogram in rats, which is in stark contrast to lead. The ubiquitous nature of yttrium in the environment and the insoluble ceramic-like nature of the oxide combine to make it an unlikely cause of future environmental or health problems.

An environmental side benefit of yttrium is its performance over low-nickel and chrome-free metal pretreatments. In automotive production, a metal pretreatment is always applied to the body prior to electrocoat, which is designed to assist in adhesion and corrosion performance. This process generates significant quantities of chromium- and nickel-containing waste and, like lead, is also a concern to recyclers of the finished vehicle. By using yttrium in the electrocoat step, chrome can be completely eliminated using standard chrome-free rinses and low-nickel or possibly nickel-free pretreatments, both of which are commercially available today. This should be possible without concern of compromising long-term vehicle corrosion performance. For PPG pretreatment customers, this should result in the elimination of up to 25,000 pounds of chrome and 50,000 pounds of nickel annually from PPG products. As PPG customers implement yttrium over the next several years, approximately one million pounds of lead (as lead metal) will be removed from the electrocoat applications of PPG automotive customers.

2000 Winners

Academic Award

Professor Chi-Huey Wong

The Scripps Research Institute

Enzymes in Large-Scale Organic Synthesis

Innovation and Benefits

Professor Wong developed methods to replace traditional reactions requiring toxic metals and hazardous solvents. His methods use enzymes, environmentally acceptable solvents, and mild reaction conditions. His methods also enable novel reactions that were otherwise impossible or impractical on an industrial scale. Professor Wong's methods hold promise for applications in a wide variety of chemical industries.

Organic synthesis has been one of the most successful of scientific disciplines and has contributed significantly to the development of the pharmaceutical and chemical industries. New synthetic reagents, catalysts, and processes have made possible the synthesis of molecules with varying degrees of complexity. The types of problems at which nonbiological organic synthesis has excelled, ranging from stoichiometric reactions to catalysis with acids, bases, and metals, will continue to be very important. New synthetic and catalytic methods are, however, necessary to deal with the new classes of compounds that are becoming the key targets of molecular research and development.

Compounds with polyfunctional groups such as carbohydrates and related structures pose particular challenges to nonbiological synthetic methods but are natural targets for biological methods. In addition, biological methods are necessary to deal with increasing environmental concerns. Transition metals, heavy elements, and toxic organic solvents are often used in nonbiological processes. When these materials are used with great care and efficiency, they may still be environmentally acceptable, but their handling and disposal pose problems. The ability to use recombinant and engineered enzymes to carry out environmentally acceptable synthetic transformations that are otherwise impossible

or impractical offers one of the best opportunities now available to chemistry and the pharmaceutical industry.

Professor Chi-Huey Wong at the Scripps Research Institute has pioneered work on the development of effective enzymes and the design of novel substrates and processes for large-scale organic synthesis. The methods and strategies that Professor Wong has developed have made possible synthetic transformations that are otherwise impossible or impractical, especially in areas vitally important in biology and medicine, and have pointed the way toward new green methodologies for use in large-scale chemistry. A recent study by the Institute for Scientific Information ranked Professor Wong in the top 15 of the most-cited chemists in the world for the period 1994 to 1996. According to this study, he is also the most-cited chemist worldwide working in the area of enzymes.

Some of the strategies and methods developed by Professor Wong are breakthrough achievements that laid the framework for much of the current use of enzymes as catalysts in large-scale organic synthesis. The techniques and reagents developed in this body of pioneering work are used widely today for research and development. The scope of contributions ranges from relatively simple enzymatic processes (e.g., chiral resolutions and stereoselective syntheses) to complex, multistep enzymatic reactions (e.g., oligosaccharide synthesis). For example, the irreversible enzymatic transesterification reaction using enol esters in environmentally acceptable organic solvents invented by Professor Wong represents the most widely used method for enantioselective transformation of alcohols in pharmaceutical development. The multi-enzyme system based on genetically engineered glycosyltransferases coupled with in situ regeneration of sugar nucleotides developed by Professor Wong has revolutionized the field of carbohydrate chemistry and enabled the large-scale synthesis of complex oligosaccharides for clinical evaluation. All of these new enzymatic reactions are carried out in environmentally acceptable solvents, under mild reaction conditions, at ambient temperature, and with minimum protection of functional groups. The work of Professor Wong represents a new field of green chemistry suitable for large-scale synthesis that is impossible or impractical to achieve by nonenzymatic means.

Small Business Award

RevTech, Inc.

Envirogluv™: A Technology for Decorating Glass and Ceramicware with Radiation-Curable, Environmentally Compliant Inks

Innovation and Benefits

RevTech developed the Envirogluv™ process to print top-quality labels directly on glass, replacing paper labels, decals, or applied ceramic labeling. Envirogluv™ inks do not contain heavy metals, contain little to no volatile organic compounds (VOCs), and are biodegradable. This technology saves energy by replacing high-temperature ovens with ultraviolet light, saves raw materials, wastes no ink, and produces decorated glass that is completely recyclable.

Billions of products are sold in glass containers in the United States every year. Most, if not all, of these glass containers are labeled in some fashion. Typically, decorative indicia are applied to glass using paper labels, decals, or a process known as applied ceramic labeling (ACL). ACL involves first printing the glass with an ink composition that contains various heavy metals such as lead, cadmium, and chromium, then bonding the ink to the glass by baking in an oven known as a lehr at temperatures of 1,000 °F or more for several hours.

All of these processes have disadvantages. Paper labels are inexpensive but can be easily removed if the container is exposed to water or abrasion. In addition, paper labels do not provide the aesthetics desired by decorators who want rich, expensive-looking containers. Decals are expensive and difficult to apply at the high line speeds that are required in the decoration of most commercial containers. More important, decals are made from materials that are not biodegradable, which causes serious problems in the recycling of glass containers that are decorated by this method. The use and disposal of the heavy metals required in ACL presents serious environmental concerns. Moreover, the high-temperature lehr ovens required in ACL decorating utilize substantial amounts of energy and raise safety issues with

respect to workers and plant facilities that use this equipment. The inks used in ACL decorating also tend to contain high levels of volatile organic compounds (VOCs) that can lead to undesirable emissions.

Clearly, there has been a need in the glass decorating industry for a decorated glass container that is aesthetically pleasing, durable, and obtained in a cost-effective, environmentally friendly, and energy-efficient manner. Envirogluv™ technology fills that need. Envirogluv™ is a glass decorating technology that directly silk-screens radiation-curable inks onto glass, then cures the ink almost instantly by exposure to UV light. The result is a crisp, clean label that is environmentally sound, with a unit cost that is about half that of traditional labeling.

Envirogluv™ technology offers many human health and environmental benefits. The ink compositions used in the Envirogluv™ process do not contain any heavy metals and contain little to no VOCs. All Envirogluv™ pigments are biodegradable. The Envirogluv™ inks are cured directly on the glass by exposure to UV radiation, eliminating the high-temperature baking in a lehr oven that is associated with the ACL process. This provides additional safety and environmental benefits, such as reduced energy consumption and reduced chance of worker injury. In addition, the process uses less raw materials and does not generate any waste ink. Furthermore, Envirogluv™ decorated glass containers eliminate the need for extra packaging and are completely recyclable. Applications suitable for the Envirogluv™ process include tableware, cosmetics containers, and plate glass.

Greener Synthetic Pathways Award

Roche Colorado Corporation

An Efficient Process for the Production of Cytovene[®], a Potent Antiviral Agent

Innovation and Benefits

Roche Colorado developed an environmentally friendly way to synthesize Cytovene[®], a potent antiviral drug. Their process eliminates nearly 2.5 million pounds of hazardous liquid waste and over 55,000 pounds of hazardous solid waste each year. This process also increases the overall yield more than 25 percent and doubles the production throughput.

The design, development, and implementation of environmentally friendly processes for the large-scale production of pharmaceutical products is one of the most technically challenging aspects of business operations in the pharmaceutical industry. Roche Colorado Corporation (RCC), in establishing management and operational systems for the continuous improvement of environmental quality in its business activities, has, in essence, adopted the Presidential Green Chemistry Challenge Program's basic principles of green chemistry: the development of environmentally friendly processes for the manufacture of pharmaceutical products. In particular, RCC has successfully applied these principles to the manufacture of ganciclovir, the active ingredient in Cytovene[®], a potent antiviral agent. Cytovene[®] is used in the treatment of cytomegalovirus (CMV) retinitis infections in immunocompromised patients, including patients with AIDS, and also used for the prevention of CMV disease in transplant recipients at risk for CMV.

In the early 1990s, Roche Colorado Corporation developed the first commercially viable process for the production of Cytovene[®]. By 1993, chemists at RCC's Boulder Technology Center designed a new and expedient process for the production of Cytovene[®], which at the time had an estimated commercial demand of approximately 110,000 pounds per year. Leveraging the basic principles of green chemistry and molecular conservation into the design process, signifi-

cant improvements were demonstrated in the second-generation Guanine Triester (GTE) Process. Compared to the first-generation commercial manufacturing process, the GTE Process reduced the number of chemical reagents and intermediates from 22 to 11, eliminated the (only) two hazardous solid waste streams, eliminated 11 different chemicals from the hazardous liquid waste streams, and efficiently recycled and reused four of the five ingredients not incorporated into the final product. Inherent within the process improvements demonstrated was the complete elimination of the need for operating and monitoring three different potentially hazardous chemical reactions. Overall, the GTE Process provided an expedient method for the production of Cytovene[®], demonstrating a procedure that provided an overall yield increase of more than 25 percent and a production throughput increase of 100 percent.

In summary, the new GTE Process for the commercial production of Cytovene[®] clearly demonstrates the successful implementation of the general principles of green chemistry: the development of environmentally friendly syntheses, including the development of alternative syntheses utilizing nonhazardous and nontoxic feedstocks, reagents, and solvents; elimination of waste at the source (liquid waste: 2.5 million pounds per year and solid waste: 56,000 pounds per year); and elimination of the production of toxic wastes and byproducts. The process establishes new and innovative technology for a general and efficient method for the preparation of Cytovene[®] and other potent antiviral agents. It is registered with the U.S. Food and Drug Administration (FDA) as the current manufacturing process for the world's supply of Cytovene[®].

Greener Reaction Conditions Awards

Bayer Corporation

Bayer AG

Two-Component Waterborne Polyurethane Coatings

Innovation and Benefits

Bayer developed a series of high-performance, water-based, two-component polyurethane coatings that eliminate most or all of the organic solvents used in conventional polyurethane coatings. Bayer's water-based polyurethane coatings reduce volatile organic compound (VOC) and hazardous air pollutant (HAP) emissions by 50–90 percent.

Two-component (2K) waterborne polyurethane coatings are an outstanding example of the use of alternative reaction conditions for green chemistry. This technology is achieved by replacing most or all of the volatile organic compounds (VOCs) and hazardous air pollutants (HAPs) used in conventional 2K solventborne polyurethane coatings with water as the carrier, without significant reduction in performance of the resulting coatings. This may seem an obvious substitution, but, due to the particular chemistry of the reactive components of polyurethane, it is not that straightforward.

Two-component solventborne polyurethane coatings have long been considered in many application areas to be the benchmark for high-performance coatings systems. The attributes that make these systems so attractive are fast cure under ambient or bake conditions, high-gloss and mirror-like finishes, hardness or flexibility as desired, chemical and solvent resistance, and excellent weathering. The traditional carrier, however, has been organic solvent that, upon cure, is freed to the atmosphere as VOC and HAP material. High-solids systems and aqueous polyurethane dispersions ameliorate this problem but do not go far enough.

An obvious solution to the deficiencies of 2K solventborne polyurethanes and aqueous polyurethane dispersions is a reactive 2K polyure-

thane system with water as the carrier. In order to bring 2K waterborne polyurethane coatings to the U.S. market, new waterborne and water-reducible resins had to be developed. To overcome some application difficulties, new mixing/spraying equipment was also developed. For the technology to be commercially viable, an undesired reaction of a polyisocyanate cross-linker with water had to be addressed, as well as problems with the chemical and film appearance resulting from this side reaction. The work done on the 2K waterborne polyurethanes over the past several years has resulted in a technology that will provide several health and environmental benefits. VOCs will be reduced by 50–90 percent and HAPs by 50–99 percent. The amount of chemical byproducts evolved from films in interior applications will also be reduced, and rugged interior coatings with no solvent smell will now be available.

Today, 2K waterborne polyurethane is being applied on industrial lines where good properties and fast cure rates are required for such varied products as metal containers and shelving, sporting equipment, metal- and fiberglass-reinforced utility poles, agricultural equipment, and paper products. In flooring coatings applications where the market-driving force is elimination of solvent odor, 2K waterborne polyurethane floor coatings provide a quick dry, high abrasion resistance, and lack of solvent smell (<0.1 pound organic solvent per gallon). In wood applications, 2K waterborne polyurethane coatings meet the high-performance wood finishes requirements for kitchen cabinet, office, and laboratory furniture manufacturers while releasing minimal organic solvents in the workplace or to the atmosphere. In the United States, the greatest market acceptance of 2K waterborne polyurethane is in the area of special-effect coatings in automotive applications. These coatings provide the soft, luxurious look and feel of leather to hard plastic interior automobile surfaces, such as instrument panels and air bag covers. Finally, in military applications, 2K waterborne polyurethane coatings are being selected because they meet the demanding military performance criteria that include flat coatings with camouflage requirements, corrosion protection, chemical and chemical agent protection, flexibility, and exterior durability, along with VOC reductions of approximately 50 percent.

Designing Greener Chemicals Award

Dow AgroSciences LLC

Sentricon™ Termite Colony Elimination System, A New Paradigm for Termite Control

Innovation and Benefits

Dow's Sentricon™ System eliminates termite colonies with highly specific bait applied only where termites are active; it replaces widespread applications of pesticide in the soil around houses and other structures. The U.S. EPA has registered Sentricon™ as a reduced-risk pesticide. Dow's system reduces the use of hazardous materials and reduces potential impacts on human health and the environment. By late 1999, Sentricon™ was used for over 300,000 structures in the United States.

The annual cost of termite treatments to the U.S. consumer is about \$1.5 billion, and each year as many as 1.5 million homeowners will experience a termite problem and seek a control option. From the 1940s until 1995, the nearly universal treatment approach for subterranean termite control involved the placement of large volumes of insecticide dilutions into the soil surrounding a structure to create a chemical barrier through which termites could not penetrate. Problems with this approach include difficulty in establishing an uninterrupted barrier in the vast array of soil and structural conditions, use of large volumes of insecticide dilution, and potential hazards associated with accidental misapplications, spills, off-target applications, and worker exposure. These inherent problems associated with the use of chemical barrier approaches for subterranean termite control created a need for a better method. The search for a baiting alternative was the focus of a research program established by Dr. Nan-Yao Su of the University of Florida who, in the 1980s, had identified the characteristics needed for a successful termite bait toxicant.

The unique properties of hexaflumuron made it an excellent choice for use in controlling subterranean termite colonies. The Sentricon™ Termite Colony Elimination System, developed by Dow AgroSciences in

collaboration with Dr. Su, was launched commercially in 1995 after receiving U.S. EPA registration as a reduced-risk pesticide. Sentricon™ represents truly novel technology employing an Integrated Pest Management approach using monitoring and targeted delivery of a highly specific bait. Because it eliminates termite colonies threatening structures using a targeted approach, Sentricon™ delivers unmatched technical performance, environmental compatibility, and reduced human risk. The properties of hexaflumuron as a termite control agent are attractive from an environmental and human risk perspective, but more important, the potential for adverse effects is dramatically reduced because it is present only in very small quantities in stations with termite activity. The comparisons to barrier methods show significant reduction in the use of hazardous materials and substantial reduction in potential impacts on human health and the environment.

The discovery of hexaflumuron's activity with its unique fit and applicability for use as a termite bait was a key milestone for the structural pest control industry and Dow AgroSciences. The development and commercial launch of Sentricon™ changed the paradigm for protecting structures from damage caused by subterranean termites. The development of novel research methodologies, new delivery systems, and the establishment of an approach that integrates monitoring and baiting typify the innovation that has been a hallmark of the project. More than 300,000 structures across the United States are now being safeguarded through application of this revolutionary technology, and adoption is growing rapidly.

1999 Winners

Academic Award

Professor Terry Collins

Carnegie Mellon University

TAML™ Oxidant Activators: General Activation of Hydrogen Peroxide for Green Oxidation Technologies

Innovation and Benefits

Professor Collins developed a series of activator chemicals that work with hydrogen peroxide to replace chlorine bleaches. His TAML™ activators have many potential uses that include preparing wood pulp for paper-making and removing stains from laundry. This novel, environmentally benign technology eliminates chlorinated byproducts from wastewater streams and saves both energy and water.

In nature, selectivity is achieved through complex mechanisms using a limited set of elements available in the environment. In the laboratory, chemists prefer a simpler design that utilizes the full range of the periodic table. The problem of persistent pollutants in the environment can be minimized by employing reagents and processes that mimic those found in nature. By developing a series of activators effective with the natural oxidant, hydrogen peroxide, Professor Terry Collins has devised an environmentally-benign oxidation technique with widespread applications. TAML™ activators (tetraamido-macrocyclic ligand activators) are iron-based and contain no toxic functional groups. These activators offer significant technology breakthroughs in the pulp and paper industry and the laundry field.

The key to quality papermaking is the selective removal of lignin from the white fibrous polysaccharides, cellulose, and hemicellulose. Wood pulp delignification has traditionally relied on chlorine-based processes that produce chlorinated pollutants. Professor Collins has demonstrated that TAML™ activators effectively catalyze hydrogen peroxide in the selective delignification of wood pulp. This is the first low-temperature peroxide oxidation technique for treating wood pulp,

which translates to energy savings for the industry. Environmental compliance costs may be expected to decrease with this new approach because chlorinated organics are not generated in this totally chlorine-free process.

TAML™ activators may also be applied to the laundry field, where most bleaches are based on peroxide. When bound to fabric, most commercial dyes are unaffected by the TAML™-activated peroxide. However, random dye molecules that “escape” the fabric during laundering are intercepted and destroyed by the activated peroxide before they have a chance to transfer to other articles of clothing. This technology prevents dye-transfer accidents while offering improved stain-removal capabilities. Washing machines that require less water will be practical when the possibility of dye-transfer is eliminated.

An active area of investigation is the use of TAML™ peroxide activators for water disinfection. Ideally, the activators would first kill pathogens in the water sample, then destroy themselves in the presence of a small excess of peroxide. This protocol could have global applications, from developing nations to individual households.

The versatility of the TAML™ activators in catalyzing peroxide has been demonstrated in the pulp and paper and laundry industries. Environmental benefits include decreased energy requirements, elimination of chlorinated organics from the waste stream, and decreased water use. The development of new activators and new technologies will provide environmental advantages in future applications.

Small Business Award

Biofine, Inc. (now BioMetics, Inc.)

Conversion of Low-Cost Biomass Wastes to Levulinic Acid and Derivatives

Innovation and Benefits

Biofine developed a process to convert the waste cellulose in paper mill sludge, municipal solid waste, unrecyclable waste paper, waste wood, and agricultural residues into levulinic acid (LA). LA can be used as a building block for many other useful chemicals. LA made from waste cellulose reduces the use of fossil fuels and reduces the overall cost of LA from \$4–6 per pound to as little as \$0.32 per pound.

Replacing petroleum-based feedstocks with renewable ones is a crucial step toward achieving sustainability. When considering alternatives to traditional feedstocks, attention often focuses on plant-based materials. Renewable biomass conserves our dwindling supplies of fossil fuels and contributes no net CO₂ to the atmosphere. Biofine has developed a high-temperature, dilute-acid hydrolysis process that converts cellulosic biomass to levulinic acid (LA) and derivatives. Cellulose is initially converted to soluble sugars, which are then transformed to levulinic acid. Byproducts in the process include furfural, formic acid, and condensed tar, all of which have commercial value as commodities or fuel. Feedstocks used include paper mill sludge, municipal solid waste, unrecyclable waste paper, waste wood, and agricultural residues.

Levulinic acid serves as a building block in the synthesis of useful chemical products. Markets already exist for tetrahydrofuran, succinic acid, and diphenolic acid, all of which are levulinic acid derivatives. The use of diphenolic acid (DPA) as a monomer for polycarbonates and epoxy resins is currently under investigation. An industry/government consortium has conducted research on two additional derivatives with commercial value: methyltetrahydrofuran (MTHF), a fuel additive, and δ -amino levulinic acid (DALA), a pesticide.

The conversion of levulinic acid to MTHF is accomplished at elevated temperature and pressure using a catalytic hydrogenation process. MTHF is a fuel additive that is miscible with gasoline and hydrophobic, allowing it to be blended at the refinery rather than later in the distribution process. Using MTHF as a fuel additive increases the oxygenate level in gasoline without adversely affecting engine performance. MTHF also boasts a high octane rating (87) and a lower vapor pressure, thereby reducing fuel evaporation and improving air quality.

DALA can be obtained from levulinic acid in high yield using a three-step process. DALA is a broad-spectrum pesticide that is nontoxic and biodegradable. Its activity is triggered by light, selectively killing weeds while leaving most major crops unaffected. DALA also shows potential as an insecticide.

Diphenolic acid is synthesized by reacting levulinic acid with phenol. DPA has the potential to displace bisphenol-A, a possible endocrine disruptor, in polymer applications. Brominated DPA shows promise as an environmentally-acceptable marine coating, while dibrominated DPA may find use as a fire retardant.

Currently, levulinic acid has a worldwide market of about one million pounds per year at a price of \$4–6 per pound. Large-scale commercialization of the Biofine process could produce levulinic acid for as little as \$0.32 per pound, spurring increased demand for LA and its derivatives. Using the Biofine process, waste biomass can be transformed into valuable chemical products. The ability to produce levulinic acid economically from waste biomass and renewable feedstocks is the key to increased commercialization of LA and its derivatives.

Greener Synthetic Pathways Award

Lilly Research Laboratories

Practical Application of a Biocatalyst in Pharmaceutical Manufacturing

Innovation and Benefits

Lilly Research Laboratories developed a novel, low-waste process for drug synthesis. One key aspect uses yeast to replace a chemical reaction.

Applying its process, Lilly eliminates approximately 41 gallons of solvent and 3 pounds of chromium waste for every pound of a drug candidate that it manufactures. Lilly's process also improves worker safety and increases product yield from 16 to 55 percent.

The synthesis of a pharmaceutical agent is frequently accompanied by the generation of a large amount of waste. This should not be surprising, as numerous steps are commonly necessary, each of which may require feedstocks, reagents, solvents, and separation agents. Lilly Research Laboratories has redesigned its synthesis of an anticonvulsant drug candidate, LY300164. This pharmaceutical agent is being developed for the treatment of epilepsy and neurodegenerative disorders.

The synthesis used to support clinical development of the drug candidate proved to be an economically viable process, although several steps proved problematic. A large amount of chromium waste was generated, an additional activation step was required, and the overall process required a large volume of solvent. Significant environmental improvements were realized upon implementing the new synthetic strategy. Roughly 9,000 gallons of solvent and 660 pounds of chromium waste were eliminated for every 220 pounds of LY300164 produced. Only three of the six intermediates generated were isolated, limiting worker exposure and decreasing processing costs. The synthetic scheme proved more efficient as well, with percent yield climbing from 16 to 55 percent.

The new synthesis begins with the biocatalytic reduction of a ketone to an optically pure alcohol. The yeast *Zygosaccharomyces rouxii* demonstrated good reductase activity but was sensitive to high product concentrations. To circumvent this problem, a novel three-phase reaction design was employed. The starting ketone was charged to an aqueous slurry containing a polymeric resin, buffer, and glucose, with most of the ketone adsorbed on the surface of the resin. The yeast reacted with the equilibrium concentration of ketone remaining in the aqueous phase. The resulting product was adsorbed onto the surface of the resin, simplifying product recovery. All of the organic reaction components were removed from the aqueous waste stream, permitting the use of conventional wastewater treatments.

A second key step in the synthesis was selective oxidation to eliminate the unproductive redox cycle present in the original route. The reaction was carried out using dimethylsulfoxide, sodium hydroxide, and compressed air, eliminating the use of chromium oxide, a possible carcinogen, and preventing the generation of chromium waste. The new protocol was developed by combining innovations from chemistry, microbiology, and engineering. Minimizing the number of changes to the oxidation state improved the efficiency of the process while reducing the amount of waste generated. The alternative synthesis presents a novel strategy for producing 5H-2,3-benzodiazepines. The approach is general and has been applied to the production of other anticonvulsant drug candidates. The technology is low-cost and easily implemented; it should have broad applications within the manufacturing sector.

Greener Reaction Conditions Award

Nalco Chemical Company

The Development and Commercialization of ULTIMER®: The First of a New Family of Water-Soluble Polymer Dispersions

Innovation and Benefits

The Nalco Chemical Company developed a novel way to synthesize the polymers used to treat water in a variety of industrial and municipal operations. Nalco now manufactures these polymers in water, replacing the traditional water-in-oil mixtures and preventing the release of organic solvents and other chemicals into the environment.

High-molecular-weight polyacrylamides are commonly used as process aids and water treatment agents in various industrial and municipal operations. Annually, at least 200 million pounds of water-soluble, acrylamide-based polymers are used to condition and purify water. These water-soluble polymers assist in removing suspended solids and contaminants and effecting separations. Traditionally, these polymers are produced as water-in-oil emulsions. Emulsions are prepared by combining the monomer, water, and a hydrocarbon oil-surfactant mixture in approximately equal parts. Although the oil and surfactant are required for processing, they do not contribute to the performance of the polymer. Consequently, approximately 90 million pounds of oil and surfactant are released to the environment each year. Nalco has developed a new technology that permits production of the polymers as stable colloids in water, eliminating the introduction of oil and surfactants into the environment.

The Nalco process uses a homogeneous dispersion polymerization technique. The water-soluble monomers are dissolved in an aqueous salt solution of ammonium sulfate then polymerized using a water-soluble, free-radical initiator. A low-molecular-weight dispersant polymer is added to prevent aggregation of the growing polymer chains. For end-use applications, the dispersion is simply added to water, thereby diluting the salt and allowing the polymer to dissolve into a clear,

homogeneous, polymer solution. This technology has been successfully demonstrated with cationic copolymers of acrylamide, anionic copolymers of acrylamide, and non-ionic polymers.

Development of water-based dispersion polymers provides three important environmental benefits. First, the new process eliminates the use of hydrocarbon solvents and surfactants required in the manufacture of emulsion polymers. Dispersion polymers produce no VOCs and exhibit lower biological oxygen demand (BOD) and chemical oxygen demand (COD) than do emulsion polymers. Second, the salt used, ammonium sulfate, is a waste byproduct from another industrial process, the production of caprolactam. Caprolactam is the precursor in the manufacture of nylon; 2.5–4.5 million pounds of ammonium sulfate are produced for every million pounds of caprolactam, providing a ready supply of feedstock. Finally, dispersion polymers eliminate the need for costly equipment and inverter surfactants needed for mixing emulsion polymers. This technological advantage will make wastewater treatment more affordable for small- and medium-sized operations.

Nalco's dispersion polymers contain the same active polymer component as traditional emulsion polymers without employing oil and surfactant carrier systems. The polymers are produced as stable colloids in water, retaining ease and safety of handling while eliminating the release of oil and surfactants into the environment. By adopting this new technology, Nalco has conserved over one million pounds of hydrocarbon solvent and surfactants since 1997 on two polymers alone. In 1998, the water-based dispersions used 3.2 million pounds of ammonium sulfate, a byproduct from caprolactam synthesis that would otherwise be treated as waste. Additional environmental benefits will be realized as the dispersion polymerization process is extended to the manufacture of other polymers.

Designing Greener Chemicals Award

Dow AgroSciences LLC

Spinosad: A New Natural Product for Insect Control

Innovation and Benefits

Dow developed spinosad, a highly selective, environmentally friendly insecticide made by a soil microorganism. It controls many chewing insect pests in cotton, trees, fruits, vegetables, turf, and ornamentals. Unlike traditional pesticides, it does not persist in the environment; it also has low toxicity to mammals and birds.

Controlling insect pests is essential to maintaining high agricultural productivity and minimizing monetary losses. Synthetic organic pesticides, from a relatively small number of chemical classes, play a leading role in pest control. The development of new and improved pesticides is necessitated by increased pest resistance to existing products, along with stricter environmental and toxicological regulations. To meet this need, Dow AgroSciences has designed spinosad, a highly selective, environmentally friendly insecticide.

High-volume testing of fermentation isolates in agricultural screens produced numerous leads, including the extracts of a Caribbean soil sample found to be active on mosquito larvae. The microorganism, *Saccharopolyspora spinosa*, was isolated from the soil sample, and the insecticidal activity of the spinosyns was identified. Spinosyns are unique macrocyclic lactones, containing a tetracyclic core to which two sugars are attached. Most of the insecticidal activity is due to a mixture of spinosyns A and D, commonly referred to as spinosad. Products such as Tracer® Naturalyte® Insect Control and Precise® contain spinosad as the active ingredient.

Insects exposed to spinosad exhibit classical symptoms of neurotoxicity: lack of coordination, prostration, tremors, and other involuntary muscle contractions leading to paralysis and death. Although the mode of action of spinosad is not fully understood, it appears to affect

nicotinic and γ -aminobutyric acid receptor function through a novel mechanism.

Spinosad presents a favorable environmental profile. It does not leach, bioaccumulate, volatilize, or persist in the environment. Spinosad will degrade photochemically when exposed to light after application. Because spinosad strongly adsorbs to most soils, it does not leach through soil to groundwater. Spinosad demonstrates low mammalian and avian toxicity. No long-term health problems were noted in mammals, and a low potential for acute toxicity exists due to low oral, dermal, and inhalation toxicity. This is advantageous, because low mammalian toxicity imparts reduced risk to those who handle, mix, and apply the product. Although spinosad is moderately toxic to fish, this toxicity represents a reduced risk to fish when compared with many synthetic insecticides currently in use.

Spinosad has proven effective in controlling many chewing insect pests in cotton, trees, fruits, vegetables, turf, and ornamentals. High selectivity is also observed: 70–90 percent of beneficial insects and predatory wasps are left unharmed. Spinosad features a novel molecular structure and mode of action that provide the excellent crop protection associated with synthetic products coupled with the low human and environmental risk found in biological products. The selectivity and low toxicity of spinosad make it a promising tool for integrated pest management.

1998 Winners

Academic Award

Professor Barry M. Trost

Stanford University

The Development of the Concept of Atom Economy

Innovation and Benefits

Professor Trost developed the concept of atom economy: chemical reactions that do not waste atoms. Professor Trost's concept of atom economy includes reducing the use of nonrenewable resources, minimizing the amount of waste, and reducing the number of steps used to synthesize chemicals. Atom economy is one of the fundamental cornerstones of green chemistry. This concept is widely used by those who are working to improve the efficiency of chemical reactions.

The general area of chemical synthesis covers virtually all segments of the chemical industry—oil refining, bulk or commodity chemicals, and fine chemicals, including agrochemicals, flavors, fragrances, pharmaceuticals, etc. Economics generally dictates the feasibility of processes that are “practical”. A criterion that traditionally has not been explicitly recognized relates to the total quantity of raw materials required for the process compared to the quantity of product produced or, simply put, “how much of what you put into your pot ends up in your product.” In considering the question of what constitutes synthetic efficiency, Professor Barry M. Trost has explicitly enunciated a new set of criteria by which chemical processes should be evaluated. They fall under two categories—selectivity and atom economy.

Selectivity and atom economy evolve from two basic considerations. First, the vast majority of the synthetic organic chemicals in production derive from nonrenewable resources. It is self-evident that such resources should be used as sparingly as possible. Second, all waste streams should be minimized. This requires employment of reactions that produce minimal byproducts, either through the intrinsic stoichi-

ometry of a reaction or as a result of minimizing competing undesirable reactions (i.e., making reactions more selective).

The issues of selectivity can be categorized under four headings—chemoselectivity (differentiation among various functional groups in a molecule), regioselectivity (locational), diastereoselectivity (relative stereochemistry), and enantioselectivity (absolute stereochemistry). The chemical community at large has readily accepted these considerations. In too many cases, however, efforts to achieve the goal of selectivity led to reactions requiring multiple components in stoichiometric quantities that are not incorporated into the product, thus creating significant amounts of waste. How much of the reactants end up in the product (i.e., atom economy) traditionally has been ignored. When Professor Trost's first paper on atom economy appeared in the literature, the idea generally was not adopted by either academia or industry. Many in industry, however, were practicing this concept without explicitly enunciating it. Others in industry did not consider the concept because it did not appear to have any economic consequence. Today, all of the chemical industry explicitly acknowledges the importance of atom economy.

Achieving the objectives of selectivity and atom economy encompasses the entire spectrum of chemical activities—from basic research to commercial processes. In enunciating these principles, Professor Trost has set a challenge for those involved in basic research to create new chemical processes that meet the objectives. Professor Trost's efforts to meet this challenge involve the rational invention of new chemical reactions that are either simple additions or, at most, produce low-molecular-weight innocuous byproducts. A major application of these reactions is in the synthesis of fine chemicals and pharmaceuticals, which, in general, utilize very atom-uneconomical reactions. Professor Trost's research involves catalysis, largely focused on transition metal catalysis but also main group catalysis. The major purpose of his research is to increase the toolbox of available reactions to serve these industries for problems they encounter in the future. However, even today, there are applications for which such methodology may offer more efficient syntheses.

Academic Award

Dr. Karen M. Draths and Professor John W. Frost

Michigan State University

Use of Microbes as Environmentally Benign Synthetic Catalysts

Innovation and Benefits

Adipic acid, a building block for nylon, and catechol, a building block for pharmaceuticals and pesticides, are two chemicals of major industrial importance. Using environmentally benign, genetically engineered microbes, Dr. Draths and Professor Frost synthesized adipic acid and catechol from sugars. These two chemicals are traditionally made from benzene, a petroleum product; they can now be made with less risk to human health and the environment.

Fundamental change in chemical synthesis can be achieved by elaboration of new, environmentally benign routes to existing chemicals. Alternatively, fundamental change can follow from characterization and environmentally benign synthesis of chemicals that can replace those chemicals currently manufactured by environmentally problematic routes. Examples of these design principles are illustrated by the syntheses of adipic acid and catechol developed by Dr. Karen M. Draths and Professor John W. Frost. The Draths-Frost syntheses of adipic acid and catechol use biocatalysis and renewable feedstocks to create alternative synthetic routes to chemicals of major industrial importance. These syntheses rely on the use of genetically manipulated microbes as synthetic catalysts. Nontoxic glucose is employed as a starting material, which, in turn, is derived from renewable carbohydrate feedstocks, such as starch, hemicellulose, and cellulose. In addition, water is the primary reaction solvent, and the generation of toxic intermediates and environment-damaging byproducts is avoided.

In excess of 4.2 billion pounds of adipic acid are produced annually and used in the manufacture of nylon 6,6. Most commercial syntheses of adipic acid use benzene, derived from the benzene-toluene-xylene (BTX) fraction of petroleum refining, as the starting material. In addition, the last step in the current manufacture of adipic acid em-

loys a nitric acid oxidation resulting in the formation of nitrous oxide as a byproduct. Due to the massive scale on which it is industrially synthesized, adipic acid manufacture has been estimated to account for some 10 percent of the annual increase in atmospheric nitrous oxide levels. The Draths-Frost synthesis of adipic acid begins with the conversion of glucose into *cis,cis*-muconic acid using a single, genetically engineered microbe expressing a biosynthetic pathway that does not exist in nature. This novel biosynthetic pathway was assembled by isolating and amplifying the expression of genes from different microbes including *Klebsiella pneumoniae*, *Acinetobacter calcoaceticus*, and *Escherichia coli*. The *cis,cis*-muconic acid, which accumulates extracellularly, is hydrogenated to afford adipic acid.

Yet another example of the Draths-Frost strategy for synthesizing industrial chemicals using biocatalysis and renewable feedstocks is their synthesis of catechol. Approximately 46 million pounds of catechol are produced globally each year. Catechol is an important chemical building block used to synthesize flavors (e.g., vanillin, eugenol, isoeugenol), pharmaceuticals (e.g., L-DOPA, adrenaline, papaverine), agrochemicals (e.g., carbofuran, propoxur), and polymerization inhibitors and antioxidants (e.g., 4-*t*-butylcatechol, veratrol). Although some catechol is distilled from coal tar, petroleum-derived benzene is the starting material for most catechol production. The Draths-Frost synthesis of catechol uses a single, genetically engineered microbe to catalyze the conversion of glucose into catechol, which accumulates extracellularly. As mentioned previously, plant-derived starch, hemicellulose, and cellulose can serve as the renewable feedstocks from which the glucose starting material is derived.

In contrast to the traditional syntheses of adipic acid and catechol, the Draths-Frost syntheses are based on renewable feedstocks, carbohydrate starting materials, and microbial biocatalysis. As the world moves to national limits on carbon dioxide (CO₂) emissions, each molecule of a chemical made from a carbohydrate may well be counted as a credit due to the CO₂ that is fixed by plants to form the carbohydrate. Biocatalysis using intact microbes also allows the Draths-Frost syntheses to use water as a reaction solvent, near-ambient pressures, and temperatures that typically do not exceed human body temperature.

Small Business Award

PYROCOOL Technologies, Inc.

Technology for the Third Millennium: The Development and Commercial Introduction of an Environmentally Responsible Fire Extinguishment and Cooling Agent

Innovation and Benefits

PYROCOOL Technologies developed PYROCOOL F.E.F., a fire extinguishing foam that is nontoxic and highly biodegradable. PYROCOOL F.E.F. replaces ozone-depleting gases and aqueous foams that release toxic and persistent chemicals to the environment during use. PYROCOOL F.E.F. is effective at approximately one-tenth the concentration of conventional fire extinguishing chemicals.

Advances in chemical technology have greatly benefited firefighting in this century. From the limitation of having only local water supplies at their disposal, firefighters have been presented over the years with a wide variety of chemical agents, as additives or alternatives to water, to assist them. These advances in chemical extinguishment agents, however, have themselves created, in actual use, potential long-term environmental and health problems that tend to outweigh their firefighting benefits. PYROCOOL Technologies, Inc. developed PYROCOOL F.E.F. (Fire Extinguishing Foam) as an alternative formulation of highly biodegradable surfactants designed for use in very small quantities as a universal fire extinguishment and cooling agent.

Halon gases, hailed as a tremendous advance when introduced, have since proven to be particularly destructive to the ozone layer, having an ozone depletion potential (ODP) value of 10–16 times that of common refrigerants. Aqueous film-forming foams (AFFFs) developed by the U.S. Navy in the 1960s to combat pooled-surface, volatile, hydrocarbon fires release both toxic hydrofluoric acid and fluorocarbons when used. The fluorosurfactant compounds that make these agents so effective against certain types of fires render them resistant

to microbial degradation, often leading to contamination of ground-water supplies and failure of wastewater treatment systems.

In 1993, PYROCOOL Technologies initiated a project to create a fire extinguishment and cooling agent that would be effective in extinguishing fires and that would greatly reduce the potential long-term environmental and health problems associated with traditional products. To achieve this objective, PYROCOOL Technologies first determined that the product (when finally developed) would contain no glycol ethers or fluorosurfactants. In addition, it decided that the ultimate formulation must be an effective fire extinguishment and cooling agent at very low mixing ratios. PYROCOOL F.E.F. is a formulation of highly biodegradable nonionic surfactants, anionic surfactants, and amphoteric surfactants with a mixing ratio (with water) of 0.4 percent. In initial fire tests at the world's largest fire-testing facility in the Netherlands, PYROCOOL F.E.F. was demonstrated to be effective against a broad range of combustibles.

Since its development in 1993, PYROCOOL F.E.F. has been employed successfully against numerous fires both in America and abroad. PYROCOOL F.E.F. carries the distinction of extinguishing the last large oil tanker fire at sea (a fire estimated by Lloyd's of London to require 10 days to extinguish) on board the *Nassia* tanker in the Bosphorous Straits in just 12.5 minutes, saving 80 percent of the ship's cargo and preventing 160 million pounds of crude oil from spilling into the sea.

As demonstrated by the PYROCOOL F.E.F. technology, selective employment of rapidly biodegradable substances dramatically enhances the effectiveness of simple water, while eliminating the environmental and toxic impact of other traditional fire extinguishment agents. Because PYROCOOL F.E.F. is mixed with water at only 0.4 percent, an 87–93 percent reduction in product use is realized compared to conventional extinguishment agents typically used at 3–6 percent. Fire affects all elements of industry and society, and no one is immune from its dangers. PYROCOOL F.E.F. provides an innovative, highly effective, and green alternative for firefighters.

Greener Synthetic Pathways Award

Flexsys America L.P.

Elimination of Chlorine in the Synthesis of 4-Aminodiphenylamine:
A New Process That Utilizes Nucleophilic Aromatic Substitution
for Hydrogen

Innovation and Benefits

Flexsys developed a new method to eliminate waste from a critically important reaction used to manufacture a wide range of chemical products. They are using this method to manufacture 4-ADPA, a key, high-volume building block for a rubber preservative. Converting just 30 percent of the world's production capacity of this key building block to the Flexsys process would reduce chemical waste by 74 million pounds per year and wastewater by 1.4 billion pounds per year.

The development of new environmentally favorable routes for the production of chemical intermediates and products is an area of considerable interest to the chemical processing industry. Recently, the use of chlorine in large-scale chemical syntheses has come under intense scrutiny. Solutia, Inc. (formerly Monsanto Chemical Company), one of the world's largest producers of chlorinated aromatics, has funded research over the years to explore alternative synthetic reactions for manufacturing processes that do not require the use of chlorine. It was clear that replacing chlorine in a process would require the discovery of new atom-efficient chemical reactions. Ultimately, it was Monsanto's goal to incorporate fundamentally new chemical reactions into innovative processes that would focus on the elimination of waste at the source. In view of these emerging requirements, Monsanto's Rubber Chemicals Division (now Flexsys), in collaboration with Monsanto Corporate Research, began to explore new routes to a variety of aromatic amines that would not rely on the use of halogenated intermediates or reagents. Of particular interest was the identification of novel synthetic strategies to 4-aminodiphenylamine (4-ADPA), a key intermediate in the Rubber Chemicals family of antidegradants. The total world volume of antidegradants based on 4-ADPA and related materials is approximately

300 million pounds per year, of which Flexsys is the world's largest producer. (Flexsys is a joint venture of the rubber chemicals operations of Monsanto and Akzo Nobel.)

Flexsys's current process to 4-ADPA is based on the chlorination of benzene. Since none of the chlorine used in the process ultimately resides in the final product, the pounds of waste generated in the process per pound of product produced from the process are highly unfavorable. A significant portion of the waste is in the form of an aqueous stream that contains high levels of inorganic salts contaminated with organics that are difficult and expensive to treat. Furthermore, the process also requires the storage and handling of large quantities of chlorine gas. Flexsys found a solution to this problem in a class of reactions known as nucleophilic aromatic substitution of hydrogen (NASH). Through a series of experiments designed to probe the mechanism of NASH reactions, Flexsys realized a breakthrough in understanding this chemistry that has led to the development of a new process to 4-ADPA that utilizes the base-promoted, direct coupling of aniline and nitrobenzene.

The environmental benefits of this process are significant and include a dramatic reduction in waste generated. In comparison to the process traditionally used to synthesize 4-ADPA, the Flexsys process generates 74 percent less organic waste, 99 percent less inorganic waste, and 97 percent less wastewater. In global terms, if just 30 percent of the world's capacity to produce 4-ADPA and related materials were converted to the Flexsys process, 74 million pounds less chemical waste would be generated per year and 1.4 billion pounds less wastewater would be generated per year. The discovery of the new route to 4-ADPA and the elucidation of the mechanism of the reaction between aniline and nitrobenzene have been recognized throughout the scientific community as a breakthrough in the area of nucleophilic aromatic substitution chemistry.

This new process for the production of 4-ADPA has achieved the goal for which all green chemistry endeavors strive: the elimination of waste at the source via the discovery of new chemical reactions that can be implemented into innovative and environmentally safe chemical processes.

Greener Reaction Conditions Award

Argonne National Laboratory

Novel Membrane-Based Process for Producing Lactate Esters—
Nontoxic Replacements for Halogenated and Toxic Solvents

Innovation and Benefits

Argonne developed a novel process to synthesize organic solvents from sugars. These solvents can replace a wide variety of more hazardous solvents, such as methylene chloride. Argonne's process requires little energy, is highly efficient, eliminates large volumes of salt waste, and reduces pollution and emissions. These solvents can potentially replace 7.6 billion pounds of toxic solvents used annually by industry, commerce, and households.

Argonne National Laboratory (ANL) has developed a process based on selective membranes that permits low-cost synthesis of high-purity ethyl lactate and other lactate esters from carbohydrate feedstock. The process requires little energy input, is highly efficient and selective, and eliminates the large volumes of salt waste produced by conventional processes. ANL's novel process uses pervaporation membranes and catalysts. In the process, ammonium lactate is thermally and catalytically cracked to produce the acid, which, with the addition of alcohol, is converted to the ester. The selective membranes pass the ammonia and water with high efficiency while retaining the alcohol, acid, and ester. The ammonia is recovered and reused in the fermentation to make ammonium lactate, eliminating the formation of waste salt. The innovation overcomes major technical hurdles that had made current production processes for lactate esters technically and economically noncompetitive. The innovation will enable the replacement of toxic solvents widely used by industry and consumers, expand the use of renewable carbohydrate feedstocks, and reduce pollution and emissions.

Ethyl lactate has a good temperature performance range (boiling point: 309 °F, melting point: 104 °F), is compatible with both aqueous

and organic systems, is easily biodegradable, and has been approved for food by the U.S. Food and Drug Administration (FDA). Lactate esters (primarily ethyl lactate) can replace most halogenated solvents (including ozone-depleting chlorofluorocarbons (CFCs), carcinogenic methylene chloride, toxic ethylene glycol ethers, perchloroethylene, and chloroform) on a 1:1 basis. At 1998 prices (\$1.60–2.00 per pound), the market for ethyl lactate is about 20 million pounds per year for a wide variety of specialty applications. The novel and efficient ANL membrane process will reduce the selling price of ethyl lactate to \$0.85–1.00 per pound and enable ethyl lactate to compete directly with the petroleum-derived toxic solvents currently in use. The favorable economics of the ANL membrane process, therefore, can lead to the widespread substitution of petroleum-derived toxic solvents by ethyl lactate in electronics manufacturing, paints and coatings, textiles, cleaners and degreasers, adhesives, printing, de-inking, and many other industrial, commercial, and household applications. More than 80 percent of the applications requiring the use of more than 7.6 billion pounds of solvents in the United States each year are suitable for reformulation with environmentally friendly lactate esters.

The ANL process has been patented for producing esters from all fermentation-derived organic acids and their salts. Organic acids and their esters, at the purity achieved by this process, offer great potential as intermediates for synthesizing polymers, biodegradable plastics, oxygenated chemicals (e.g., propylene glycol and acrylic acid), and specialty products. By improving purity and lowering costs, the ANL process promises to make fermentation-derived organic acids an economically viable alternative to many chemicals and products derived from petroleum feedstocks.

A U.S. patent on this technology has been allowed, and international patents have been filed. NTEC, Inc. has licensed the technology for lactate esters and provided the resources for a pilot-scale demonstration of the integrated process at ANL. The pilot-scale demonstration has produced a high-purity ethyl lactate product that meets or exceeds all the process performance objectives. A 10-million-pound-per-year demonstration plant is being planned for early 1999, followed by a 100-million-pound-per-year, full-scale plant.

Designing Greener Chemicals Award

Rohm and Haas Company

Invention and Commercialization of a New Chemical Family of Insecticides Exemplified by CONFIRM™ Selective Caterpillar Control Agent and the Related Selective Insect Control Agents MACH 2™ and INTREPID™

Innovation and Benefits

Rohm and Haas developed CONFIRM™, a novel insecticide for controlling caterpillar pests in turf and a variety of crops. CONFIRM™ is less toxic than other insecticides to a wide range of nontarget organisms, poses no significant hazard to farm workers or the food chain, and does not present a significant spill hazard. U.S. EPA has classified CONFIRM™ as a reduced-risk pesticide.

The value of crops destroyed worldwide by insects exceeds tens of billions of dollars. Over the past fifty years, only a handful of classes of insecticides have been discovered to combat this destruction. Rohm and Haas Company has discovered a new class of chemistry, the diacylhydrazines, that offers farmers, consumers, and society a safer, effective technology for insect control in turf and a variety of agronomic crops. One member of this family, CONFIRM™, is a breakthrough in caterpillar control. It is chemically, biologically, and mechanistically novel. It effectively and selectively controls important caterpillar pests in agriculture without posing significant risk to the applicator, the consumer, or the ecosystem. It will replace many older, less effective, more hazardous insecticides and has been classified by the U.S. EPA as a reduced-risk pesticide.

CONFIRM™ controls target insects through an entirely new mode of action that is inherently safer than current insecticides. The product acts by strongly mimicking a natural substance found within the insect's body called 20-hydroxy ecdysone, which is the natural "trigger" that induces molting and regulates development in insects. Because of this "ecdysonoid" mode of action, CONFIRM™ powerfully

disrupts the molting process in target insects, causing them to stop feeding shortly after exposure and to die soon thereafter.

Since 20-hydroxy ecdysone neither occurs nor has any biological function in most nonarthropods, CONFIRM™ is inherently safer than other insecticides to a wide range of nontarget organisms such as mammals, birds, earthworms, plants, and various aquatic organisms. CONFIRM™ is also remarkably safe to a wide range of key beneficial, predatory, and parasitic insects such as honeybees, lady beetles, parasitic wasps, predatory bugs, beetles, flies, and lacewings, as well as other predatory arthropods such as spiders and predatory mites. Because of this unusual level of safety, the use of these products will not create an outbreak of target or secondary pests due to destruction of key natural predators or parasites in the local ecosystem. This should reduce the need for repeat applications of additional insecticides and reduce the overall chemical load on both the target crop and the local environment.

CONFIRM™ has low toxicity to mammals by ingestion, inhalation, and topical application and has been shown to be completely non-oncogenic, nonmutagenic, and without adverse reproductive effects. Because of its high apparent safety and relatively low use rates, CONFIRM™ poses no significant hazard to the applicator or the food chain and does not present a significant spill hazard. CONFIRM™ has proven to be an outstanding tool for control of caterpillar pests in many integrated pest management (IPM) and resistance management situations. All of these attributes make CONFIRM™ among the safest, most selective, and most useful insect control agents ever discovered.

1997 Winners

Academic Award

Professor Joseph M. DeSimone

*University of North Carolina at Chapel Hill (UNC)
and North Carolina State University (NCSU)*

Design and Application of Surfactants for Carbon Dioxide

Innovation and Benefits

Professor DeSimone developed new detergents that allow carbon dioxide (CO₂), a nontoxic gas, to be used as a solvent in many industrial applications. Using CO₂ as a solvent allows manufacturers to replace traditional, often hazardous chemical solvents and processes, conserve energy, and reduce worker exposure to hazardous substances.

It has been a dilemma of modern industrial technology that the solvents required to dissolve the environment's worst contaminants themselves have a contaminating effect. Now, new technologies for the design and application of surfactants for carbon dioxide (CO₂), developed at UNC, promise to resolve this dilemma.

Over 30 billion pounds of organic and halogenated solvents are used worldwide each year as solvents, processing aids, cleaning agents, and dispersants. Solvent-intensive industries are considering alternatives that can reduce or eliminate the negative impact that solvent emissions can have in the workplace and in the environment. CO₂ in a solution state has long been recognized as an ideal solvent, extractant, and separation aid. CO₂ solutions are nontoxic, nonflammable, energy-efficient, cost-effective, waste-minimizing, reusable, and safe to work with. Historically, the prime factor inhibiting the use of this solvent replacement has been the low solubility of most materials in CO₂, in both its liquid and supercritical states. With the discovery of CO₂ surfactant systems, Professor Joseph M. DeSimone and his students have dramatically advanced the solubility performance characteristics of CO₂ systems for several industries.

The design of broadly applicable surfactants for CO₂ relies on the identification of “CO₂-philic” materials from which to build amphiphiles. Although CO₂ in both its liquid and supercritical states dissolves many small molecules readily, it is a very poor solvent for many substances at easily accessible conditions (T < 212 °F and P < 4,350 psi). As an offshoot of Professor DeSimone’s research program on polymer synthesis in CO₂, he and his researchers exploited the high solubility of a select few CO₂-philic polymeric segments to develop nonionic surfactants capable of dispersing high-solids polymer latexes in both liquid and supercritical CO₂ phases. The design criteria they developed for surfactants, which were capable of stabilizing heterogeneous polymerizations in CO₂, have been expanded to include CO₂-insoluble compounds in general.

This development lays the foundation by which surfactant-modified CO₂ can be used to replace conventional (halogenated) organic solvent systems currently used in manufacturing and service industries such as precision cleaning, medical device fabrication, and garment care, as well as in the chemical manufacturing and coating industries.

Small Business Award

Legacy Systems, Inc.

Coldstrip™, A Revolutionary Organic Removal and Wet Cleaning Technology

Innovation and Benefits

During manufacture, silicon-based semiconductors and flat-panel displays require cleaning to remove manufacturing residues, usually with corrosive acid solutions. Legacy Systems developed the Coldstrip™ process, which uses only water and oxygen to clean silicon semiconductors. Coldstrip™ has the potential to cut the use of corrosive solutions by hundreds of thousands of gallons and also save millions of gallons of water each year.

For over 30 years, the removal of photoresists with Piranha solutions (sulfuric acid, hydrogen peroxide, or ashers) has been the standard in the semiconductor, flat panel display, and micromachining industries. Use of Piranha solutions has been associated with atmospheric, ground, and water pollution. Legacy Systems, Inc. (LSI) has developed a revolutionary wet processing technology, Coldstrip™, which removes photoresist and organic contaminants for the semiconductor, flat panel display, and micromachining industries.

LSI's Coldstrip™ process is a chilled-ozone process that uses only oxygen and water as raw materials. The active product is ozone, which safely decomposes to oxygen in the presence of photoresist. Carbon dioxide, carbon monoxide, oxygen, and water are formed. There are no high temperatures, no hydrogen peroxide, and no nitric acid, all of which cause environmental issues.

The equipment required for the chilled-ozone process consists of a gas diffuser, an ozone generator, a recirculating pump, a water chiller, and a process vessel. The water solution remains clear and colorless throughout the entire process sequence. There are no particles or resist flakes shed from the wafer into the water; therefore, there are no requirements for particle filtration.

Using oxygen and water as raw materials replacing the Piranha solutions significantly benefits the environment. One benefit is the elimination of over 8,400 gallons of Piranha solutions used per year per silicon wet station and over 25,200 gallons used per year per flat panel display station. Additionally, the overall water consumption is reduced by over 3,355,800 gallons per year per silicon wafer wet station and over 5,033,700 gallons per year per flat panel display station. The corresponding water consumption in LSI's process is 4,200 gallons per year and there is no Piranha use.

In 1995, the U.S. Patent Office granted LSI Patent 5,464,480 covering this technology. The system has the lowest environmental impact of any wet-resist-strip process, eliminating the need for thousands of gallons of Piranha chemicals and millions of gallons of water a year.

Greener Synthetic Pathways Award

BHC Company (now BASF Corporation)

BHC Company Ibuprofen Process

Innovation and Benefits

BHC Company developed an efficient method to make ibuprofen, a commonly used painkiller, using only three steps instead of six. BHC recovers and recycles the waste byproduct from the manufacturing process and has virtually eliminated large volumes of aqueous salt wastes. BASF Corporation, one of the BHC partners, uses this process in one of the largest ibuprofen production plants in the world.

BHC Company has developed a new synthetic process to manufacture ibuprofen, a well-known nonsteroidal anti-inflammatory painkiller marketed under brand names such as Advil™ and Motrin™. Commercialized since 1992 in BHC's 7.7-million-pound-per-year facility in Bishop, TX, the new process has been cited as an industry model of environmental excellence in chemical processing technology. For its innovation, BHC was the recipient of the Kirkpatrick Achievement Award for "outstanding advances in chemical engineering technology" in 1993.

The new technology involves only three catalytic steps with approximately 80 percent atom utilization (virtually 99 percent including the recovered byproduct acetic acid) and replaces technology with six stoichiometric steps and less than 40 percent atom utilization. The use of anhydrous hydrogen fluoride as both catalyst and solvent offers important advantages in reaction selectivity and waste reduction. As such, this chemistry is a model of source reduction, the method of waste minimization that tops U.S. EPA's waste management hierarchy. Virtually all starting materials are either converted to product or reclaimed byproduct or are completely recovered and recycled in the process. The generation of waste is practically eliminated.

The BHC ibuprofen process is an innovative, efficient technology that has revolutionized bulk pharmaceutical manufacturing. The process provides an elegant solution to a prevalent problem encountered in bulk pharmaceutical synthesis (i.e., how to avoid the large quantities of solvents and wastes associated with the traditional stoichiometric use of auxiliary chemicals for chemical conversions). Large volumes of aqueous wastes (salts) normally associated with such manufacturing are virtually eliminated. The anhydrous hydrogen fluoride catalyst/solvent is recovered and recycled with greater than 99.9 percent efficiency. No other solvent is needed in the process, simplifying product recovery and minimizing fugitive emissions. The nearly complete atom utilization of this streamlined process truly makes it a waste-minimizing, environmentally friendly technology.

Greener Reaction Conditions Award

Imation

DryView™ Imaging Systems

Innovation and Benefits

Imation's DryView™ Imaging Systems use a new type of photographic film for medical imaging that uses heat instead of hazardous developer chemicals. During 1996, Imation delivered more than 1,500 DryView™ Imaging Systems worldwide. These units alone eliminate the annual disposal of over half a million gallons of developer chemicals and 54.5 million gallons of contaminated water and reduce workers' exposure to chemicals.

Photothermography is an imaging technology whereby a latent image, created by exposing a sensitized emulsion to appropriate light energy, is processed by the application of thermal energy. Photothermographic films are easily imaged by laser diode imaging systems, with the resultant exposed film processed by passing it over a heat roll. A heat roll operating at 250 °F in contact with the film will produce diagnostic-quality images in approximately 15 seconds. Based on photothermography technology, Imation's DryView™ Imaging Systems use no wet chemistry, create no effluent, and require no additional postprocess steps such as drying.

In contrast, silver halide photographic films are processed by being bathed in a chemical developer, soaked in a fix solution, washed with clean water, and finally dried. The developer and fix solutions contain toxic chemicals such as hydroquinone, silver, and acetic acid. In the wash cycle, these chemicals, along with silver compounds, are flushed from the film and become part of the waste stream. The resulting effluent amounts to billions of gallons of liquid waste each year.

Significant developments in photothermographic image quality have been achieved that allow it to compete successfully with silver halide technology. During 1996, Imation placed more than 1,500 DryView™

medical laser imagers, which represent 6 percent of the world's installed base. These units alone have eliminated the annual disposal of 192,000 gallons of developer, 330,000 gallons of fixer, and 54.5 million gallons of contaminated water into the waste stream. As future systems are placed, the reductions will be even more dramatic.

DryView™ technology is applicable to all industries that process panchromatic film products. The largest of these industries are medical radiography, printing, industrial radiography, and military reconnaissance. DryView™ is valued by these industries because it supports pollution prevention through source reduction.

Designing Greener Chemicals Award

Albright & Wilson Americas (now Rhodia)

THPS Biocides: A New Class of Antimicrobial Chemistry

Innovation and Benefits

Albright & Wilson discovered the antimicrobial properties of THPS and developed it into a safer biocide that can be used to control the growth of bacteria and algae in industrial water systems. THPS, or tetrakis(hydroxymethyl)phosphonium sulfate, offers many advantages over other, traditional biocides because, for example, it is significantly less toxic to nontarget organisms, is effective at much lower concentrations, and is more biodegradable than other biocides.

Conventional biocides used to control the growth of bacteria, algae, and fungi in industrial cooling systems, oil fields, and process applications are highly toxic to humans and aquatic life and often persist in the environment, leading to long-term damage. To address this problem, a new and relatively benign class of biocides, tetrakis(hydroxymethyl)phosphonium sulfate (THPS), has been discovered by Albright & Wilson Americas. THPS biocides represent a completely new class of antimicrobial chemistry that combines superior antimicrobial activity with a relatively benign toxicology profile. THPS's benefits include low toxicity, low recommended treatment level, rapid breakdown in the environment, and no bioaccumulation. When substituted for more toxic biocides, THPS biocides provide reduced risks to both human health and the environment.

THPS is so effective as a biocide that, in most cases, the recommended treatment level is below that which would be toxic to fish. In addition, THPS rapidly breaks down in the environment through hydrolysis, oxidation, photodegradation, and biodegradation. In many cases, it has already substantially broken down before the treated water enters the environment. The degradation products have been shown to possess a relatively benign toxicology profile. Furthermore,

THPS does not bioaccumulate and, therefore, offers a much-reduced risk to higher life forms.

THPS biocides are aqueous solutions and do not contain volatile organic compounds (VOCs). Because THPS is halogen-free, it does not contribute to the formation of dioxin or absorbable organic halides (AOX). Because of its low overall toxicity and easier handling compared to alternative products, THPS provides an opportunity to reduce the risk of health and safety incidents.

THPS has been applied to a range of industrial water systems for the successful control of microorganisms. The U.S. industrial water treatment market for nonoxidizing biocides alone is 42 million pounds per year and growing at 6–8 percent annually. There are over 500,000 individual user sites in this industry category. Because of its excellent environmental profile, THPS has already been approved for use in environmentally sensitive areas around the world and is being used as a replacement for higher risk alternatives.

1996 Winners

Academic Award

Professor Mark Holtzapple

Texas A&M University

Conversion of Waste Biomass to Animal Feed, Chemicals, and Fuels

Innovation and Benefits

Professor Holtzapple developed a family of technologies that convert waste biomass, such as sewage sludge and agricultural wastes, into animal feed products, industrial chemicals, or fuels, depending on the technology used. Because these technologies convert waste biomass into useful products, other types of basic resources, such as petroleum, can be conserved. Also, the technologies can reduce the amount of biomass waste going to landfills or incinerators.

A family of technologies has been developed by Professor Mark Holtzapple at Texas A&M University that converts waste biomass into animal feed, industrial chemicals, and fuels. Waste biomass includes such resources as municipal solid waste, sewage sludge, manure, and agricultural residues. Waste biomass is treated with lime to improve digestibility. Lime-treated agricultural residues (e.g., straw, stover, and bagasse) may be used as ruminant animal feeds. Alternatively, the lime-treated biomass can be fed into a large anaerobic fermentor in which rumen microorganisms convert the biomass into volatile fatty acid (VFA) salts, such as calcium acetate, propionate, and butyrate. The VFA salts are concentrated and may be converted into chemicals or fuels via three routes. In one route, the VFA salts are acidified, releasing acetic, propionic, and butyric acids. In a second route, the VFA salts are thermally converted to ketones, such as acetone, methyl ethyl ketone, and diethyl ketone. In a third route, the ketones are hydrogenated to their corresponding alcohols such as isopropanol, isobutanol, and isopentanol.

The technologies above offer many benefits for human health and the environment. Lime-treated animal feed can replace feed corn, which is

approximately 88 percent of corn production. Growing corn exacerbates soil erosion and requires intensive inputs of fertilizers, herbicides, and pesticides, all of which contaminate ground water.

Chemicals (e.g., organic acids and ketones) may be produced economically from waste biomass. Typically, waste biomass is landfilled or incinerated, which incurs a disposal cost and contributes to land or air pollution. Through the production of chemicals from biomass, non-renewable resources, such as petroleum and natural gas, are conserved for later generations. Because 50 percent of U.S. petroleum consumption is now imported, displacing foreign oil will help reduce the U.S. trade deficit.

Fuels (e.g., alcohols) produced from waste biomass have the benefits cited above (i.e., reduced environmental impact from waste disposal and reduced trade deficit). In addition, oxygenated fuels derived from biomass are cleaner-burning and do not add net carbon dioxide to the environment, thereby reducing factors that contribute to global warming.

Small Business Award

Donlar Corporation (now NanoChem Solutions, Inc.)

Production and Use of Thermal Polyaspartic Acid

Innovation and Benefits

Donlar developed TPA, a nontoxic, environmentally safe, biodegradable polymer for use in agriculture, water treatment, and other industries.

Donlar manufactures TPA using a highly efficient process that eliminates use of organic solvents, cuts waste, and uses less energy. TPA has been used successfully in a variety of applications, such as improving fertilizer uptake in plants, and improving the efficiency of oil and gas production.

Millions of pounds of anionic polymers are used each year in many industrial applications. Polyacrylic acid (PAC) is one important class of such polymers, but the disposal of PAC is problematic because it is not biodegradable. An economically viable, effective, and biodegradable alternative to PAC is thermal polyaspartate (TPA).

Donlar Corporation invented two highly efficient processes to manufacture TPA for which patents have either been granted or allowed. The first process involves a dry and solid polymerization converting aspartic acid to polysuccinimide. No organic solvents are involved during the conversion and the only byproduct is water. The process is extremely efficient—a yield of more than 97 percent of polysuccinimide is routinely achieved. The second step in this process, the base hydrolysis of polysuccinimide to polyaspartate, is also extremely efficient and waste-free.

The second TPA production process involves using a catalyst during the polymerization, which allows a lower heating temperature to be used. The resulting product has improvements in performance characteristics, lower color, and biodegradability. The catalyst can be recovered from the process, thus minimizing waste.

Independent toxicity studies of commercially produced TPA have been conducted using mammalian and environmental models. Results indicate that TPA is nontoxic and environmentally safe. TPA biodegradability has also been tested by an independent lab using established Organization for Economic Cooperation and Development (OECD) methodology. Results indicate that TPA meets OECD guidelines for Intrinsic Biodegradability. PAC cannot be classified as biodegradable when tested under these same conditions.

Many end-uses of TPA have been discovered, such as in agriculture to improve fertilizer or nutrient management. TPA increases the efficiency of plant nutrient uptake, thereby increasing crop yields while protecting the ecology of agricultural lands. TPA can also be used for water treatment, as well as in the detergent, oil, and gas industries.

Greener Synthetic Pathways Award

Monsanto Company

Catalytic Dehydrogenation of Diethanolamine

Innovation and Benefits

DSIDA is a key building block for the herbicide RoundUp®. Monsanto's novel synthesis of DSIDA eliminates most of the manufacturing hazards associated with the previous synthesis; it uses no ammonia, cyanide, or formaldehyde. This synthesis is safer to operate, has a higher overall yield, and has fewer process steps.

Disodium iminodiacetate (DSIDA) is a key intermediate in the production of Monsanto's Roundup® herbicide, an environmentally friendly, nonselective herbicide. Traditionally, Monsanto and others have manufactured DSIDA using the Strecker process requiring ammonia, formaldehyde, hydrochloric acid, and hydrogen cyanide. Hydrogen cyanide is acutely toxic and requires special handling to minimize risk to workers, the community, and the environment. Furthermore, the chemistry involves the exothermic generation of potentially unstable intermediates, and special care must be taken to preclude the possibility of a runaway reaction. The overall process also generates up to 1 pound of waste for every 7 pounds of product, and this waste must be treated prior to safe disposal.

Monsanto has developed and implemented an alternative DSIDA process that relies on the copper-catalyzed dehydrogenation of diethanolamine. The raw materials have low volatility and are less toxic. Process operation is inherently safer, because the dehydrogenation reaction is endothermic and, therefore, does not present the danger of a runaway reaction. Moreover, this zero-waste route to DSIDA produces a product stream that, after filtration of the catalyst, is of such high quality that no purification or waste cut is necessary for subsequent use in the manufacture of Roundup®. The new technology represents a major breakthrough in the production of DSIDA, because

it avoids the use of cyanide and formaldehyde, is safer to operate, produces higher overall yield, and has fewer process steps.

The metal-catalyzed conversion of amino-alcohols to amino acid salts has been known since 1945. Commercial application, however, was not known until Monsanto developed a series of proprietary catalysts that made the chemistry commercially feasible. Monsanto's patented improvements on metallic copper catalysts afford an active, easily recoverable, highly selective, and physically durable catalyst that has proven itself in large-scale use.

This catalysis technology also can be used in the production of other amino acids, such as glycine. Moreover, it is a general method for conversion of primary alcohols to carboxylic acid salts; it is potentially applicable to the preparation of many other agricultural, commodity, specialty, and pharmaceutical chemicals.

Greener Reaction Conditions Award

The Dow Chemical Company

100 Percent Carbon Dioxide as a Blowing Agent for the Polystyrene Foam Sheet Packaging Market

Innovation and Benefits

Dow developed a process for manufacturing polystyrene foam sheets that uses carbon dioxide (CO₂) as a blowing agent, eliminating 3.5 million pounds per year of traditional blowing agents. Traditional blowing agents deplete the ozone layer or contribute to ground-level smog. In addition, Dow will obtain CO₂ only from existing commercial and natural sources that generate it as a byproduct, so this process will not contribute to global CO₂ levels.

In recent years the chlorofluorocarbon (CFC) blowing agents used to manufacture polystyrene foam sheet have been associated with environmental concerns such as ozone depletion, global warming, and ground-level smog. Due to these environmental concerns, The Dow Chemical Company has developed a novel process for the use of 100 percent carbon dioxide (CO₂). Polystyrene foam sheet is a useful packaging material offering a high stiffness-to-weight ratio, good thermal insulation value, moisture resistance, and recyclability. This combination of desirable properties has resulted in the growth of the polystyrene foam sheet market in the United States to over 700 million pounds in 1995. Current applications for polystyrene foam include thermoformed meat, poultry, and produce trays; fast food containers; egg cartons; and serviceware.

The use of 100 percent CO₂ offers optimal environmental performance because CO₂ does not deplete the ozone layer, does not contribute to ground-level smog, and will not contribute to global warming because CO₂ will be used from existing byproduct commercial and natural sources. The use of CO₂ byproduct from existing commercial and natural sources, such as ammonia plants and natural gas wells, will ensure that no net increase in global CO₂ results from the use of this

technology. CO₂ is also nonflammable, providing increased worker safety. It is cost-effective and readily available in food-grade quality. CO₂ also is used in such common applications as soft drink carbonation and food chilling and freezing.

The Dow 100 percent CO₂ technology eliminates the use of 3.5 million pounds per year of hard CFC-12 and soft HCFC-22. This technology has been scaled from pilot-line to full-scale commercial facilities. Dow has made the technology available through a commercial license covering both patented and know-how technology. The U.S. Patent Office granted Dow two patents for this technology (5,250,577 and 5,266,605).

Designing Greener Chemicals Award

Rohm and Haas Company

Designing an Environmentally Safe Marine Antifoulant

Innovation and Benefits

Rohm and Haas developed Sea-Nine™, a novel antifoulant to control the growth of plants and animals on the hulls of ships. In 1995, fouling cost the shipping industry approximately \$3 billion a year in increased fuel consumption. Sea-Nine™ replaces environmentally persistent and toxic tin-containing antifoulants.

Fouling, the unwanted growth of plants and animals on a ship's surface, costs the shipping industry approximately \$3 billion a year, largely due to increased fuel consumption to overcome hydrodynamic drag. Increased fuel consumption contributes to pollution, global warming, and acid rain.

The main compounds used worldwide to control fouling are the organotin antifoulants, such as tributyltin oxide (TBTO). While effective, they persist in the environment and cause toxic effects, including acute toxicity, bioaccumulation, decreased reproductive viability, and increased shell thickness in shellfish. These harmful effects led to a U.S. EPA special review and to the Organotin Antifoulant Paint Control Act of 1988. This act mandated restrictions on the use of tin in the United States, and charged the U.S. EPA and the U.S. Navy with conducting research on alternatives to organotins.

Rohm and Haas Company searched for an environmentally safe alternative to organotin compounds. Compounds from the 3-isothiazolone class were chosen as likely candidates and over 140 were screened for antifouling activity. The 4,5-dichloro-2-*n*-octyl-4-isothiazolin-3-one (Sea-Nine™ antifoulant) was chosen as the candidate for commercial development.

Extensive environmental testing compared Sea-Nine™ antifoulant to TBTO, the current industry standard. Sea-Nine™ antifoulant degraded extremely rapidly with a half-life of one day in seawater and one hour in sediment. Tin had bioaccumulation factors as high as 10,000-fold, whereas Sea-Nine™ antifoulant's bioaccumulation was essentially zero. Both TBTO and Sea-Nine™ were acutely toxic to marine organisms, but TBTO had widespread chronic toxicity, whereas Sea-Nine™ antifoulant showed no chronic toxicity. Thus, the maximum allowable environmental concentration (MAEC) for Sea-Nine™ antifoulant was 0.63 parts per billion (ppb) whereas the MAEC for TBTO was 0.002 ppb.

Hundreds of ships have been painted with coatings containing Sea-Nine™ worldwide. Rohm and Haas Company obtained U.S. EPA registration for the use of Sea-Nine™ antifoulant, the first new antifoulant registration in over a decade.

Program Information

Additional information on the Presidential Green Chemistry Challenge program is available from:

- The Green Chemistry Program Web site at <http://www.epa.gov/greenchemistry>
- The Industrial Chemistry Branch of EPA by e-mail at greenchemistry@epa.gov or by telephone at 202-564-8740 and
- EPA's Pollution Prevention Information Clearinghouse by e-mail at ppic@epa.gov or by telephone at 202-566-0799.

Disclaimer

Note: The summaries provided in this document were obtained from the entries received for the 1996–2008 Presidential Green Chemistry Challenge Awards. They were edited for space, stylistic consistency, and clarity, but they were neither written nor officially endorsed by the U.S. EPA. These summaries represent only a fraction of the information that was provided in the entries received and, as such, are intended to highlight the nominated projects, not describe them fully. These summaries were not used in the judging process; judging was conducted on all information contained in the entries.