

# TABLE OF CONTENTS

<i>Preface</i> . . . . .	xxvii	
GEORGE WYPYCH		
<b>1</b>	<b>INTRODUCTION . . . . .</b>	<b>1</b>
CHRISTIAN REICHARDT		
<b>2</b>	<b>FUNDAMENTAL PRINCIPLES GOVERNING SOLVENTS USE . . . . .</b>	<b>7</b>
2.1	Solvent effects on chemical systems . . . . .	7
ESTANISLAO SILLA, ARTURO ARNAU, IÑAKI TUÑÓN		
2.1.1	Historical outline . . . . .	7
2.1.2	Classification of solute-solvent interactions . . . . .	10
2.1.2.1	Electrostatic . . . . .	11
2.1.2.2	Polarization . . . . .	12
2.1.2.3	Dispersion . . . . .	13
2.1.2.4	Repulsion . . . . .	14
2.1.2.5	Specific interactions . . . . .	15
2.1.2.6	Hydrophobic interactions . . . . .	16
2.1.3	Modelling of solvent effects . . . . .	17
2.1.3.1	Computer simulations . . . . .	18
2.1.3.2	Continuum models . . . . .	20
2.1.3.3	Cavity surfaces . . . . .	21
2.1.3.4	Supermolecule models . . . . .	22
2.1.3.5	Application example: glycine in solution . . . . .	23
2.1.4	Thermodynamic and kinetic characteristics of chemical reactions in solution . . . . .	27
2.1.4.1	Solvent effects on chemical equilibria . . . . .	27
2.1.4.2	Solvent effects on the rate of chemical reactions . . . . .	28
2.1.4.3	Example of application: addition of azide anion to tetrafuranosides . . . . .	30
2.1.5	Solvent catalytic effects . . . . .	32
2.2	Molecular design of solvents . . . . .	36
KOICHIRO NAKANISHI		
2.2.1	Molecular design and molecular ensemble design . . . . .	36
2.2.2	From prediction to design . . . . .	37
2.2.3	Improvement in prediction method . . . . .	38
2.2.4	Role of molecular simulation . . . . .	39
2.2.5	Model system and paradigm for design . . . . .	40
2.3	Appendix. Predictive equation for the diffusion coefficient in dilute solution . . . . .	41
Basic physical and chemical properties of solvents . . . . .		42
GEORGE WYPYCH		
2.3.1	Molecular weight and molar volume . . . . .	43
2.3.2	Boiling and freezing points . . . . .	44
2.3.3	Specific gravity . . . . .	46
2.3.4	Refractive index . . . . .	47
2.3.5	Vapor density and pressure . . . . .	48
2.3.6	Solvent volatility . . . . .	49
2.3.7	Flash point . . . . .	50
2.3.8	Flammability limits . . . . .	51
2.3.9	Sources of ignition and autoignition temperature . . . . .	52
2.3.10	Heat of combustion (calorific value) . . . . .	54
2.3.11	Heat of fusion . . . . .	54
2.3.12	Electric conductivity . . . . .	54
2.3.13	Dielectric constant (relative permittivity) . . . . .	54
2.3.14	Occupational exposure indicators . . . . .	56
2.3.15	Odor threshold . . . . .	56

2.3.16	Toxicity indicators . . . . .	57
2.3.17	Ozone-depletion and creation potential . . . . .	58
2.3.18	Oxygen demand . . . . .	58
2.3.19	Solubility . . . . .	58
2.3.20	Other typical solvent properties and indicators . . . . .	60
<b>3</b>	<b>PRODUCTION METHODS, PROPERTIES, AND MAIN APPLICATIONS . . . . .</b>	<b>65</b>
3.1	Definitions and solvent classification . . . . .	65
	GEORGE WYPYCH	
3.2	Overview of methods of solvent manufacture . . . . .	69
	GEORGE WYPYCH	
3.3	Solvent properties . . . . .	74
	GEORGE WYPYCH	
3.3.1	Hydrocarbons . . . . .	75
3.3.1.1	Aliphatic hydrocarbons . . . . .	75
3.3.1.2	Aromatic hydrocarbons . . . . .	76
3.3.2	Halogenated hydrocarbons . . . . .	78
3.3.3	Nitrogen-containing compounds (nitrates, nitriles) . . . . .	79
3.3.4	Organic sulfur compounds . . . . .	80
3.3.5	Monohydric alcohols . . . . .	81
3.3.6	Polyhydric alcohols . . . . .	83
3.3.7	Phenols . . . . .	84
3.3.8	Aldehydes . . . . .	85
3.3.9	Ethers . . . . .	86
3.3.10	Glycol ethers . . . . .	87
3.3.11	Ketones . . . . .	88
3.3.11	Acids . . . . .	90
3.3.12	Amines . . . . .	91
3.3.13	Esters . . . . .	92
3.3.14	Comparative analysis of all solvents . . . . .	94
3.4	Terpenes . . . . .	96
	TILMAN HAHN, KONRAD BOTZENHART, FRITZ SCHWEINSBERG	
3.4.1	Definitions and nomenclature . . . . .	96
3.4.2	Occurrence . . . . .	96
3.4.3	General . . . . .	96
3.4.4	Toxicology . . . . .	97
3.4.5	Threshold limit values . . . . .	97
<b>4</b>	<b>GENERAL PRINCIPLES GOVERNING DISSOLUTION OF MATERIALS IN SOLVENTS . . . . .</b>	<b>101</b>
4.1	Simple solvent characteristics . . . . .	101
	VALERY YU. SENICHEV, VASILY V. TERESHATOV	
4.1.1	Solvent power . . . . .	101
4.1.2	One-dimensional solubility parameter approach . . . . .	103
4.1.3	Multi-dimensional approaches . . . . .	110
4.1.4	Hansen's solubility . . . . .	112
4.1.5	Three-dimensional dualistic model . . . . .	116
4.1.6	Solubility criterion . . . . .	119
4.1.7	Solvent system design . . . . .	120
4.2	Effect of system variables on solubility . . . . .	124
	VALERY YU. SENICHEV, VASILY V. TERESHATOV	
4.2.1	General considerations . . . . .	124
4.2.2	Chemical structure . . . . .	126
4.2.3	Flexibility of a polymer chain . . . . .	127
4.2.4	Crosslinking . . . . .	128
4.2.5	Temperature and pressure . . . . .	128
4.2.6	Methods of calculation of solubility based on thermodynamic principles . . . . .	130

4.3	Polar solvation dynamics: Theory and simulations . . . . .	132
	ABRAHAM NITZAN	
4.3.1	Introduction . . . . .	132
4.3.2	Continuum dielectric theory of solvation dynamics . . . . .	133
4.3.3	Linear response theory of solvation dynamics . . . . .	136
4.3.4	Numerical simulations of solvation in simple polar solvents: The simulation model . . . . .	138
4.3.5	Numerical simulations of solvation in simple polar solvents: Results and discussion . . . . .	140
4.3.6	Solvation in complex solvents . . . . .	144
4.3.7	Conclusions . . . . .	145
4.4	Methods for the measurement of solvent activity of polymer solutions . . . . .	146
	CHRISTIAN WOHLFARTH	
4.4.1	Introduction . . . . .	146
4.4.2	Necessary thermodynamic equations . . . . .	149
4.4.3	Experimental methods, equipment and data reduction . . . . .	154
4.4.3.1	Vapor-liquid equilibrium (VLE) measurements . . . . .	154
4.4.3.1.1	Experimental equipment and procedures for VLE-measurements . . . . .	155
4.4.3.1.2	Primary data reduction . . . . .	170
4.4.3.1.3	Comparison of experimental VLE-methods . . . . .	175
4.4.3.2	Other measurement methods . . . . .	178
4.4.3.2.1	Membrane osmometry . . . . .	178
4.4.3.2.2	Light scattering . . . . .	181
4.4.3.2.3	X-ray scattering . . . . .	184
4.4.3.2.4	Neutron scattering . . . . .	185
4.4.3.2.5	Ultracentrifuge . . . . .	186
4.4.3.2.6	Cryoscopy (freezing point depression of the solvent) . . . . .	188
4.4.3.2.7	Liquid-liquid equilibrium (LLE) . . . . .	189
4.4.3.2.8	Swelling equilibrium . . . . .	193
4.4.4	Thermodynamic models for the calculation of solvent activities of polymer solutions . . . . .	195
4.4.4.1	Models for residual chemical potential and activity coefficient in the liquid phase . . . . .	196
4.4.4.2	Fugacity coefficients from equations of state . . . . .	207
4.4.4.3	Comparison and conclusions . . . . .	214
	Appendix 4.4A . . . . .	223
<b>5</b>	<b>SOLUBILITY OF SELECTED SYSTEMS AND INFLUENCE OF SOLUTES . . . . .</b>	<b>243</b>
5.1	Experimental methods of evaluation and calculation of solubility parameters of polymers and solvents. Solubility parameters data . . . . .	243
	VALERY YU. SENICHEV, VASILY V. TERESHATOV	
5.1.1	Experimental evaluation of solubility parameters of liquids . . . . .	243
5.1.1.1	Direct methods of evaluation of the evaporation enthalpy . . . . .	243
5.1.1.2	Indirect methods of evaluation of evaporation enthalpy . . . . .	244
5.1.1.3	Static and quasi-static methods of evaluation of pair pressure . . . . .	245
5.1.1.4	Kinetic methods . . . . .	245
5.1.2	Methods of experimental evaluation and calculation of solubility parameters of polymers . . . . .	246
5.2	Prediction of solubility parameter . . . . .	253
	NOBUYUKI TANAKA	
5.2.1	Solubility parameter of polymers . . . . .	253
5.2.2	Glass transition in polymers . . . . .	254
5.2.2.1	Glass transition enthalpy . . . . .	254
5.2.2.2	$C_p$ jump at the glass transition . . . . .	256
5.2.3	Prediction from thermal transition enthalpies . . . . .	258
5.3	Methods of calculation of solubility parameters of solvents and polymers . . . . .	261
	VALERY YU. SENICHEV, VASILY V. TERESHATOV	

5.4	Mixed solvents, a way to change the polymer solubility . . . . .	267
	LIGIA GARGALLO AND DEODATO RADIC	
5.4.1	Introduction . . . . .	267
5.4.2	Solubility-cosolvency phenomenon . . . . .	268
5.4.3	New cosolvents effects. Solubility behavior . . . . .	273
5.4.4	Thermodynamical description of ternary systems. Association equilibria theory of preferential adsorption . . . . .	274
5.4.5	Polymer structure of the polymer dependence of preferential adsorption.	
	Polymer molecular weight and tacticity dependence of preferential adsorption.	277
5.5	The phenomenological theory of solvent effects in mixed solvent systems . . . . .	281
	KENNETH A. CONNORS	
5.5.1	Introduction . . . . .	281
5.5.2	Theory . . . . .	281
5.5.2.1	Principle . . . . .	281
5.5.2.2	The intersolute effect: solute-solute interactions . . . . .	282
5.5.2.3	The solvation effect: solute-solvent interaction . . . . .	283
5.5.2.4	The general medium effect: solvent-solvent interactions . . . . .	284
5.5.2.5	The total solvent effect . . . . .	285
5.5.3	Applications . . . . .	285
5.5.3.1	Solubility . . . . .	285
5.5.3.2	Surface tension . . . . .	288
5.5.3.3	Electronic absorption spectra . . . . .	290
5.5.3.4	Complex formation . . . . .	291
5.5.3.5	Chemical kinetics . . . . .	295
5.5.3.6	Liquid chromatography . . . . .	298
5.5.4	Interpretations . . . . .	298
5.5.4.1	Ambiguities and anomalies . . . . .	298
5.5.4.2	A modified derivation . . . . .	299
5.5.4.3	Interpretation of parameter estimates . . . . .	300
5.5.4.4	Confounding effects . . . . .	301
	Solute-solute interactions . . . . .	301
	Coupling of general medium and solvation effects . . . . .	301
	The cavity surface area . . . . .	301
	The role of interfacial tension . . . . .	302
<b>6</b>	<b>SWELLING . . . . .</b>	<b>305</b>
6.1	Modern views on kinetics of swelling of crosslinked elastomers in solvents . . . . .	305
	E. YA. DENISYUK, V. V. TERESHATOV	
6.1.1	Introduction . . . . .	305
6.1.2	Formulation of swelling for a plane elastomer layer . . . . .	306
6.1.3	Diffusion kinetics of plane layer swelling . . . . .	310
6.1.4	Experimental study of elastomer swelling kinetics . . . . .	314
6.1.5	Conclusions . . . . .	317
6.2	Equilibrium swelling in binary solvents . . . . .	318
	VASILY V. TERESHATOV, VALERY YU. SENICHENKO	
6.3	Swelling data on crosslinked polymers in solvents . . . . .	327
	VASILY V. TERESHATOV, VALERY YU. SENICHENKO	
6.4	Influence of structure on equilibrium swelling . . . . .	331
	VASILY V. TERESHATOV, VALERY YU. SENICHENKO	
<b>7</b>	<b>SOLVENT TRANSPORT PHENOMENA . . . . .</b>	<b>339</b>
7.1	Introduction to diffusion, swelling, and drying . . . . .	339
	GEORGE WYPYCH	
7.1.1	Diffusion . . . . .	339
7.1.2	Swelling . . . . .	344
7.1.3	Drying . . . . .	348
7.2	Bubbles dynamics and boiling of polymeric solutions . . . . .	356
	SEMYON LEVITSKY, ZINOVY SHULMAN	
7.2.1	Rheology of polymeric solutions and bubble dynamics . . . . .	356

7.2.1.1	Rheological characterization of solutions of polymers . . . . .	356
7.2.1.2	Dynamic interaction of bubbles with polymeric liquid . . . . .	363
7.2.2	Thermal growth of bubbles in superheated solutions of polymers . . . . .	372
7.2.3	Boiling of macromolecular liquids . . . . .	377
7.3	Drying of coated film . . . . .	386
	SEUNG SU KIM AND JAE CHUN HYUN	
7.3.1	Introduction . . . . .	386
7.3.2	Theory for the drying . . . . .	388
7.3.2.1	Simultaneous heat and mass transfer . . . . .	388
7.3.2.2	Liquid-vapor equilibrium . . . . .	389
7.3.2.3	Heat and mass transfer coefficient . . . . .	390
7.3.2.4	Prediction of drying rate of coating . . . . .	392
7.3.2.5	Drying regimes: constant drying rate period (CDRP) and falling drying rate period (FDRP) . . . . .	394
7.3.3	Measurement of the drying rate of coated film . . . . .	396
7.3.3.1	Thermo-gravimetric analysis . . . . .	396
7.3.3.2	Rapid scanning FT-IR spectrometer analysis . . . . .	399
7.3.3.3	High-airflow drying experiment using flame ionization detector (FID) total hydrocarbon analyzer . . . . .	401
7.3.3.4	Measurement of drying rate in the production scale dryer . . . . .	404
7.3.4	Miscellaneous . . . . .	407
7.3.4.1	Drying of coated film with phase separation . . . . .	407
7.3.4.2	Drying defects . . . . .	409
7.3.4.2.1	Internal stress induced defects . . . . .	409
7.3.4.2.2	Surface tension driven defects . . . . .	412
7.3.4.2.3	Defects caused by air motion and others . . . . .	414
7.3.4.3	Control of lower explosive level (LEL) in a multiple zone dryer . . . . .	414
<b>8</b>	<b>INTERACTIONS IN SOLVENTS AND SOLUTIONS . . . . .</b>	<b>419</b>
	JACOPO TOMASI, BENEDETTA MENNUCCI, CHIARA CAPPELLI	
8.1	Solvents and solutions as assemblies of interacting molecules . . . . .	419
8.2	Basic simplifications of the quantum model . . . . .	420
8.3	Cluster expansion . . . . .	424
8.4	Two-body interaction energy: the dimer . . . . .	424
8.4.1	Decomposition of the interaction energy of a dimer: variational approach . . . . .	426
	The electrostatic term . . . . .	426
	The induction term . . . . .	428
	The exchange term . . . . .	428
	The charge transfer term . . . . .	429
	The dispersion term . . . . .	430
	The decomposition of the interaction energy through a variational approach: a summary . . . . .	432
8.4.2	Basis set superposition error and counterpoise corrections . . . . .	433
8.4.3	Perturbation theory approach . . . . .	436
8.4.4	Modeling of the separate components of $\Delta E$ . . . . .	441
	The electrostatic term . . . . .	441
	The induction term . . . . .	445
	The dispersion term . . . . .	446
	The exchange (or repulsion) term . . . . .	447
	The other terms . . . . .	448
	A conclusive view . . . . .	448
8.4.5	The relaxation of the rigid monomer constraint . . . . .	449
8.5	Three- and many-body interactions . . . . .	451
	Screening many-body effects . . . . .	453
	Effective interaction potentials . . . . .	454
8.6	The variety of interaction potentials . . . . .	456
8.7	Theoretical and computing modeling of pure liquids and solutions . . . . .	461
8.7.1	Physical models . . . . .	461

8.7.1.1	Integral equation methods . . . . .	465
8.7.1.2	Perturbation theories . . . . .	467
8.7.2	Computer simulations . . . . .	468
8.7.2.1	Car-Parrinello direct QM simulation . . . . .	470
8.7.2.2	Semi-classical simulations . . . . .	472
	Molecular dynamics . . . . .	472
	Monte Carlo . . . . .	473
	QM/MM . . . . .	478
8.7.3	Continuum models . . . . .	479
8.7.3.1	QM-BE methods: the effective Hamiltonian . . . . .	482
8.8	Practical applications of modeling . . . . .	487
	Dielectric constant . . . . .	487
	Thermodynamical properties . . . . .	490
	Compressibilities . . . . .	490
	Relaxation times and diffusion coefficients . . . . .	491
	Shear viscosity . . . . .	492
8.9	Liquid surfaces . . . . .	492
8.9.1	The basic types of liquid surfaces . . . . .	493
8.9.2	Systems with a large surface/bulk ratio . . . . .	495
8.9.3	Studies on interfaces using interaction potentials . . . . .	497
<b>9</b>	<b>MIXED SOLVENTS . . . . .</b>	<b>505</b>
	Y. Y. FIALKOV, V. L. CHUMAK	
9.1	Introduction . . . . .	505
9.2	Chemical interaction between components in mixed solvents . . . . .	505
9.2.1	Processes of homomolecular association . . . . .	505
9.2.2	Conformic and tautomeric equilibrium. Reactions of isomerization . . . . .	506
9.2.3	Heteromolecular association . . . . .	507
9.2.4	Heteromolecular associate ionization . . . . .	507
9.2.5	Electrolytic dissociation (ionic association) . . . . .	508
9.2.6	Reactions of composition . . . . .	508
9.2.7	Exchange interaction . . . . .	509
9.2.8	Amphotерism of mixed solvent components . . . . .	509
9.2.8.1	Amphotерism of hydrogen acids . . . . .	509
9.2.8.2	Amphotерism of L-acids . . . . .	509
9.2.8.3	Amphotерism in systems H-acid-L-acid . . . . .	510
9.2.8.4	Amphotерism in binary solutions amine-amine . . . . .	510
9.3	Physical properties of mixed solvents . . . . .	511
9.3.1	The methods of expression of mixed solvent compositions . . . . .	511
9.3.1.1	Permittivity . . . . .	513
9.3.1.2	Viscosity . . . . .	515
9.3.1.3	Density, molar volume . . . . .	516
9.3.1.4	Electrical conductivity . . . . .	516
9.3.2	Physical characteristics of the mixed solvents with chemical interaction between components . . . . .	517
9.3.2.1	Permittivity . . . . .	518
9.3.2.2	Viscosity . . . . .	519
9.3.2.3	Density, molar volume . . . . .	521
9.3.2.4	Conductivity . . . . .	522
9.3.3	Chemical properties of mixed solvents . . . . .	524
9.3.3.1	Autoprotolysis constants . . . . .	524
9.3.3.2	Solvating ability . . . . .	526
9.3.3.3	Donor-acceptor properties . . . . .	527
9.4	Mixed solvent influence on the chemical equilibrium . . . . .	527
9.4.1	General considerations . . . . .	527
9.4.2	Mixed solvent effect on the position of equilibrium of homomolecular association process . . . . .	529
9.4.3	Mixed solvent influence on the conformer equilibrium . . . . .	530

9.4.4	Solvent effect on the process of heteromolecular association . . . . .	532
9.4.4.1	Selective solvation. Resolution . . . . .	538
9.4.5	Mixed solvent effect on the ion association process . . . . .	546
9.4.6	Solvent effect on exchange interaction processes . . . . .	552
	Systems with non-associated reagents . . . . .	552
	Systems with one associated participant of equilibrium . . . . .	553
	Systems with two associated participants of equilibrium . . . . .	553
9.4.7	Mixed solvent effect on processes of complex formation . . . . .	556
9.5	The mixed solvent effect on the chemical equilibrium thermodynamics . . . . .	557
<b>10</b>	<b>ACID-BASE INTERACTIONS . . . . .</b>	<b>565</b>
10.1	General concept of acid-base interactions . . . . .	565
	<b>GEORGE WYPYCH</b>	
10.2	Effect of polymer/solvent acid-base interactions: relevance to the aggregation of PMMA . . . . .	570
	S. BISTAC, M. BROGLY	
10.2.1	Recent concepts in acid-base interactions . . . . .	570
10.2.1.1	The nature of acid-base molecular interactions . . . . .	571
10.2.1.1.1	The original Lewis definitions . . . . .	571
10.2.1.1.2	Molecular Orbital (MO) approach to acid-base reactions . . . . .	571
10.2.1.1.3	The case of hydrogen bonding . . . . .	573
10.2.1.2	Quantitative determination of acid-base interaction strength . . . . .	574
10.2.1.2.1	Perturbation theory . . . . .	574
10.2.1.2.2	Hard-Soft Acid-Base (HSAB) principle . . . . .	574
10.2.1.2.3	Density functional theory . . . . .	575
10.2.1.2.4	Effect of ionicity and covalency: Drago's concept . . . . .	576
10.2.1.2.5	Effect of amphotericity of acid-base interaction: Gutmann's numbers . . . . .	577
10.2.1.2.6	Spectroscopic measurements: Fowkes' approach . . . . .	578
10.2.2	Effect of polymer/solvent interactions on aggregation of stereoregular PMMA . . . . .	578
10.2.2.1	Aggregation of stereoregular PMMA . . . . .	578
10.2.2.2	Relation between the complexing power of solvents and their acid-base properties . . . . .	579
10.2.3	Influence of the nature of the solvent on the $\alpha$ and $\beta$ -relaxations of conventional PMMA . . . . .	581
10.2.3.1	Introduction . . . . .	581
10.2.3.2	Dielectric spectroscopy results . . . . .	581
10.2.4	Concluding remarks . . . . .	582
10.3	Solvent effects based on pure solvent scales . . . . .	583
	<b>JAVIER CATALÁN</b>	
10.3.1	Introduction . . . . .	583
10.3.1	The solvent effect and its dissection into general and specific contributions . . . . .	584
10.3.2	Characterization of a molecular environment with the aid of the probe/homomorph model . . . . .	585
10.3.3	Single-parameter solvent scales: the Y, G, $E_T(30)$ , $P_y$ , Z, $\chi_R$ , $\Phi$ , and S' scales . . . . .	587
10.3.3.1	The solvent ionizing power scale or Y scale . . . . .	587
10.3.3.2	The G values of Allerhand and Schleyer . . . . .	588
10.3.3.3	The $E_T(30)$ scale of Dimroth and Reichardt . . . . .	588
10.3.3.4	The $P_y$ scale of Dong and Winnick . . . . .	589
10.3.3.5	The Z scale of Kosower . . . . .	589
10.3.3.6	The $\chi_R$ scale of Brooker . . . . .	590
10.3.3.7	The $\Phi$ scale of Dubois and Bienvenüe . . . . .	590
10.3.3.8	The S' scale of Drago . . . . .	591
10.3.4	Solvent polarity: the SPP scale . . . . .	591
10.3.5	Solvent basicity: the SB scale . . . . .	600
10.3.6	Solvent acidity: the SA scale . . . . .	601
10.3.7	Applications of the pure SPP, SA and SB scales . . . . .	605
10.3.7.1	Other reported solvents scales . . . . .	605
10.3.7.2	Treatment of the solvent effect in: . . . . .	608

10.3.7.2.1	Spectroscopy . . . . .	608
10.3.7.2.2	Kinetics . . . . .	611
10.3.7.2.3	Electrochemistry . . . . .	612
10.3.7.2.4	Thermodynamics . . . . .	612
10.3.7.3	Mixtures of solvents. Understanding the preferential solvation model . . . . .	612
10.4	Acid-base equilibria in ionic solvents (ionic melts) . . . . .	616
	VICTOR CHERGINETS	
10.4.1	Acid-base definitions used for the description of donor-acceptor interactions in ionic media . . . . .	617
10.4.1.1	The Lewis definition . . . . .	617
10.4.1.2	The Lux-Flood definition. . . . .	618
10.4.2	The features of ionic melts as media for acid-base interactions . . . . .	618
10.4.2.1	Oxygen-less media . . . . .	619
10.4.2.2	Oxygen-containing melts. . . . .	619
10.4.2.3	The effect of the ionic solvent composition on acid-base equilibria . . . . .	620
10.4.3	Methods for estimations of acidities of solutions based on ionic melts . . . . .	623
10.4.4	On studies of the homogeneous acid-base reactions in ionic melts . . . . .	625
10.4.4.1	Nitrate melts . . . . .	625
10.4.4.2	Sulphate melts . . . . .	627
10.4.4.3	Silicate melts . . . . .	628
10.4.4.4	The equimolar mixture KCl-NaCl . . . . .	629
10.4.4.5	Other alkaline halide melts . . . . .	631
10.4.5	Reactions of melts with gaseous acids and bases . . . . .	632
10.4.5.1	High-temperature hydrolysis of molten halides . . . . .	632
10.4.5.2	The processes of removal of oxide admixtures from melts . . . . .	633
<b>11</b>	<b>ELECTRONIC AND ELECTRICAL EFFECTS OF SOLVENTS . . . . .</b>	<b>639</b>
11.1	Theoretical treatment of solvent effects on electronic and vibrational spectra of compounds in condensed media. . . . .	639
	MATI KARELSON	
11.1.1	Introduction . . . . .	639
11.1.2	Theoretical treatment of solvent cavity effects on electronic-vibrational spectra of molecules . . . . .	647
11.1.3	Theoretical treatment of solvent electrostatic polarization on electronic-vibrational spectra of molecules . . . . .	649
11.1.4	Theoretical treatment of solvent dispersion effects on electronic-vibrational spectra of molecules . . . . .	671
11.1.5	Supermolecule approach to the intermolecular interactions in condensed media . . . . .	674
11.2	Dielectric solvent effects on the intensity of light absorption and the radiative rate constant . . . . .	680
	TAI-ICHI SHIBUYA	
11.2.1	The Chako formula or the Lorentz-Lorenz correction . . . . .	680
11.2.2	The generalized local-field factor for the ellipsoidal cavity . . . . .	680
11.2.3	Dielectric solvent effect on the radiative rate constant . . . . .	682
<b>12</b>	<b>OTHER PROPERTIES OF SOLVENTS, SOLUTIONS, AND PRODUCTS OBTAINED FROM SOLUTIONS . . . . .</b>	<b>683</b>
12.1	Rheological properties, aggregation, permeability, molecular structure, crystallinity, and other properties affected by solvents . . . . .	683
	GEORGE WYPYCH	
12.1.1	Rheological properties . . . . .	683
12.1.2	Aggregation . . . . .	689
12.1.3	Permeability . . . . .	693
12.1.4	Molecular structure and crystallinity . . . . .	697
12.1.5	Other properties affected by solvents . . . . .	700
12.2	Chain conformations of polysaccharides in different solvents. . . . .	706
	RANIERI URBANI AND ATILIO CESÁRO	
12.2.1	Introduction . . . . .	706
12.2.2	Structure and conformation of polysaccharides in solution . . . . .	707

12.2.2.1	Chemical structure . . . . .	707
12.2.2.2	Solution chain conformation . . . . .	707
12.2.3	Experimental evidence of solvent effect on oligosaccharide conformational equilibria . . . . .	711
12.2.4	Theoretical evaluation of solvent effect on conformational equilibria of sugars	715
12.2.4.1	Classical molecular mechanics methods . . . . .	715
12.2.4.2	Molecular dynamic methods . . . . .	720
12.2.5	Solvent effect on chain dimensions and conformations of polysaccharides . .	722
12.2.6	Solvent effect on charged polysaccharides and the polyelectrolyte model . .	726
12.2.6.1	Experimental behavior of polysaccharides polyelectrolytes . . . . .	726
12.2.6.2	The Haug and Smidsrød parameter: description of the salt effect on the chain dimension. . . . .	727
12.2.6.3	The statistical thermodynamic counterion-condensation theory of Manning .	729
12.2.6.4	Conformational calculations of charged polysaccharides . . . . .	731
12.2.7	Conclusions . . . . .	733
<b>13</b>	<b>EFFECT OF SOLVENT ON CHEMICAL REACTIONS AND REACTIVITY . . . . .</b>	<b>737</b>
13.1	Solvent effects on chemical reactivity . . . . .	737
	ROLAND SCHMID	
13.1.1	Introduction . . . . .	737
13.1.2	The dielectric approach . . . . .	737
13.1.3	The chemical approach . . . . .	738
13.1.4	Dielectric vs. chemical approach . . . . .	742
13.1.5	Conceptual problems with empirical solvent parameters . . . . .	744
13.1.6	The physical approach . . . . .	746
13.1.7	Some highlights of recent investigations . . . . .	753
	The like dissolves like rule . . . . .	
	Water's anomalies . . . . .	
	The hydrophobic effect . . . . .	
	The structure of liquids . . . . .	
	Solvent reorganization energy in ET . . . . .	
	The solution ionic radius . . . . .	
13.1.8	The future of the phenomenological approach . . . . .	772
13.2	Solvent effects on free radical polymerization . . . . .	777
	MICHELLE L. COOTE AND THOMAS P. DAVIS	
13.2.1	Introduction . . . . .	777
13.2.2	Homopolymerization . . . . .	777
13.2.2.1	Initiation . . . . .	777
13.2.2.2	Propagation . . . . .	778
13.2.2.3	Transfer . . . . .	779
13.2.2.4	Termination . . . . .	779
13.2.3	Copolymerization . . . . .	779
13.2.3.1	Polarity effect . . . . .	780
13.2.3.1.1	Basic mechanism . . . . .	780
13.2.3.1.2	Copolymerization model . . . . .	781
13.2.3.1.3	Evidence for polarity effects in propagation reactions . . . . .	781
13.2.3.2	Radical-solvent complexes . . . . .	782
13.2.3.2.1	Basic mechanism . . . . .	782
13.2.3.2.2	Copolymerization model . . . . .	782
13.2.3.2.3	Experimental evidence . . . . .	783
13.2.3.3	Monomer-solvent complexes . . . . .	785
13.2.3.3.1	Introduction . . . . .	785
13.2.3.3.2	Monomer-monomer complex participation model . . . . .	785
13.2.3.3.3	Monomer-monomer complex dissociation model . . . . .	790
13.2.3.3.4	Specific solvent effects . . . . .	791
13.2.3.4	Bootstrap model . . . . .	791
13.2.3.4.1	Basic mechanism . . . . .	791

13.2.3.4.2	Copolymerization model . . . . .	791
13.2.3.4.3	Experimental evidence . . . . .	793
13.2.4	Concluding remarks . . . . .	795
13.3	Effects of organic solvents on phase-transfer catalysis . . . . .	798
	MAW-LING WANG	
13.3.1	Two-phase phase-transfer catalytic reactions . . . . .	801
13.3.1.1	Theoretical analysis of the polarity of the organic solvents and the reactions . . . . .	801
13.3.1.2	Effect of organic solvent on the reaction in various reaction systems . . . . .	805
13.3.1.3	Effects of the organic solvents on the reactions in other catalysts . . . . .	811
13.3.1.4	Effect of the volume of organic solvent and water on the reactions in various reaction systems . . . . .	822
13.3.1.5	Effects of organic solvents on other phase-transfer catalytic reactions . . . . .	825
13.3.1.6	Other effects on the phase-transfer catalytic reactions . . . . .	828
13.3.2	Three-phase reactions (triphase catalysis) . . . . .	830
13.3.2.1	The interaction between solid polymer (hydrophilicity) and the organic solvents . . . . .	830
13.3.2.2	Effect of solvents on the reaction in triphase catalysis . . . . .	833
13.3.2.3	Effect of volume of organic solvent and water on the reactions in triphase catalysis . . . . .	836
13.4	Effect of polymerization solvent on the chemical structure and curing of aromatic poly(amideimide). . . . .	841
	NORIO TSUBOKAWA	
13.4.1	Introduction . . . . .	841
13.4.2	Effect of solvent on the chemical structure of PAI . . . . .	842
13.4.2.1	Imide and amide bond content of PAI . . . . .	842
13.4.2.2	Intrinsic viscosity and carboxyl group content . . . . .	844
13.4.3	Effect of solvent on the curing of PAI by heat treatment . . . . .	844
13.4.3.1	Chemical structure of PAI after heat treatment . . . . .	844
13.4.3.2	Curing PAI by post-heating . . . . .	845
13.4.4	Conclusions . . . . .	846
<b>14</b>	<b>SOLVENT USE IN VARIOUS INDUSTRIES</b> . . . . .	<b>847</b>
14.1	Adhesives and sealants . . . . .	847
	GEORGE WYPYCH	
14.2	Aerospace . . . . .	852
	GEORGE WYPYCH	
14.3	Asphalt compounding . . . . .	855
	GEORGE WYPYCH	
14.4	Biotechnology . . . . .	856
14.4.1	Organic solvents in microbial production processes . . . . .	856
	MICHIAKI MATSUMOTO, SONJA ISKEN, JAN A. M. DE BONT	
14.4.1.1	Introduction . . . . .	856
14.4.1.2	Toxicity of organic solvents . . . . .	859
14.4.1.3	Solvent-tolerant bacteria . . . . .	862
14.4.1.4	Biotransformation using solvent-tolerant microorganisms . . . . .	863
14.4.2	Solvent-resistant microorganisms . . . . .	865
	TILMAN HAHN, KONRAD BOTZENHART	
14.4.2.1	Introduction . . . . .	865
14.4.2.2	Toxicity of solvents for microorganisms . . . . .	865
14.4.2.2.1	Spectrum of microorganisms and solvents . . . . .	865
14.4.2.2.2	Mechanisms of solvent toxicity for microorganisms . . . . .	866
14.4.2.3	Adaption of microorganisms to solvents - solvent-resistant microorganisms . . . . .	867
14.4.2.3.1	Spectrum of solvent-resistant microorganisms . . . . .	867
14.4.2.3.2	Adaption mechanisms of microorganisms to solvents . . . . .	868
14.4.2.4	Solvents and microorganisms in the environment and industry - examples . . . . .	869
14.4.2.4.1	Examples . . . . .	869
14.4.3	Choice of solvent for enzymatic reaction in organic solvent . . . . .	872
	TSUNEO YAMANE	

14.4.3.1	Introduction . . . . .	872
14.4.3.2	Classification of organic solvents . . . . .	872
14.4.3.3	Influence of solvent parameters on nature of enzymatic reactions in organic media. . . . .	873
14.4.3.4	Properties of enzymes affected by organic solvents . . . . .	875
14.4.3.5	Concluding remarks . . . . .	879
14.5	Coil coating. . . . .	880
	GEORGE WYPYCH	
14.6	Cosmetics and personal care products . . . . .	881
	GEORGE WYPYCH	
14.7	Dry cleaning - treatment of textiles in solvents . . . . .	883
	KASPAR D. HASENCLEVER	
14.7.1	Dry cleaning . . . . .	883
14.7.1.1	History of dry cleaning . . . . .	883
14.7.1.2	Basis of dry cleaning . . . . .	884
14.7.1.3	Behavior of textiles in solvents and water . . . . .	885
14.7.1.4	Removal of soiling in dry cleaning . . . . .	886
14.7.1.5	Activity of detergents in dry cleaning . . . . .	887
14.7.1.6	Dry cleaning processes . . . . .	888
14.7.1.7	Recycling of solvents in dry cleaning . . . . .	890
14.7.2	Spotting. . . . .	891
14.7.2.1	Spotting in dry cleaning . . . . .	891
14.7.2.2	Spotting agents . . . . .	891
14.7.2.3	Spotting procedure . . . . .	892
14.7.3	Textile finishing . . . . .	893
14.7.3.1	Waterproofing . . . . .	893
14.7.3.2	Milling . . . . .	893
14.7.3.3	Antistatic finishing . . . . .	893
14.8	Electronic industry - CFC-free alternatives for cleaning in electronic industry.	894
	MARTIN HANEK, NORBERT LÖW, ANDREAS MÜHLBAUER	
14.8.1	Cleaning requirements in the electronic industry . . . . .	894
14.8.2	Available alternatives. . . . .	896
14.8.2.1	Water based systems; advantages and disadvantages . . . . .	897
14.8.2.1.1	Cleaning with DI - water . . . . .	897
14.8.2.1.2	Cleaning with alkaline water-based media . . . . .	898
14.8.2.1.3	Aqueous-based cleaning agents containing water soluble organic components .	898
14.8.2.1.4	Water-based cleaning agents based on MPC® Technology (MPC = Micro Phase Cleaning) . . . . .	899
14.8.2.1.5	Advantages and disadvantages of aqueous cleaning media . . . . .	899
14.8.2.2	Semi-aqueous cleaners based on halogen-free solvents, advantages and disadvantages. . . . .	900
14.8.2.2.1	Water insoluble cleaning fluids . . . . .	901
14.8.2.2.2	Water-soluble, water-based cleaning agents . . . . .	901
14.8.2.2.3	Comparison of the advantages (+) and disadvantages (-) of semi-aqueous cleaning fluids . . . . .	901
14.8.2.3	Other solvent based cleaning systems . . . . .	902
14.8.3	Cleaning of tools and auxiliaries . . . . .	904
14.8.3.1	Cleaning substrates and contamination. . . . .	904
14.8.3.2	Compatibility of stencil and cleaning agent . . . . .	905
14.8.3.3	Different cleaning media . . . . .	906
14.8.3.4	Comparison of manual cleaning vs. automated cleaning. . . . .	908
14.8.3.5	Cleaning equipment for stencil cleaning applications . . . . .	909
14.8.3.6	Stencil cleaning in screen printing machines. . . . .	911
14.8.3.7	Summary . . . . .	911
14.8.4	Cleaning agents and process technology available for cleaning PCB . . . . .	911
14.8.4.1	Flux remove and aqueous process . . . . .	911
14.8.4.1.1	The limits of a no-clean process . . . . .	911

14.8.4.1.2	Different cleaning media and cleaning processes . . . . .	912
14.8.4.1.3	Semi-aqueous cleaning . . . . .	913
14.8.4.1.4	Aqueous cleaning in spray in air cleaning equipment . . . . .	913
14.8.4.2	Flux removal from printed circuit boards - water-free cleaning processes . . . . .	914
14.8.4.2.1	Water-free cleaning processes using HFE (hydrofluoroethers) in combination with a cosolvent . . . . .	915
14.8.4.2.2	Water-free cleaning processes in closed, one-chamber vapor defluxing systems . . . . .	916
14.8.5	Criteria for assessment and evaluation of cleaning results . . . . .	917
14.8.6	Cost comparison of different cleaning processes . . . . .	919
14.9	Fabricated metal products . . . . .	920
	GEORGE WYPYCH	
14.10	Food industry - solvents for extracting vegetable oils . . . . .	923
	PHILLIP J. WAKELYN, PETER J. WAN	
14.10.1	Introduction . . . . .	923
14.10.2	Regulatory concerns . . . . .	924
14.10.2.1	Workplace regulations . . . . .	925
14.10.2.1.1	Air Contaminants Standard (29 CFR 1910.1000) . . . . .	925
14.10.2.1.2	Hazard Communication Standard (HCS) (29 CFR 1910.1200) . . . . .	926
14.10.2.1.3	Process Safety Management (PSM) Standard (29 CFR 1910.119) . . . . .	927
14.10.2.2	Environmental regulations . . . . .	927
14.10.2.2.1	Clean Air Act (CAA; 42 U.S. Code 7401 et seq.) . . . . .	929
14.10.2.2.2	Clean Water Act (CWA; 33 U.S. Code 1251 et seq.) . . . . .	932
14.10.2.2.3	Resource Conservation and Recovery Act (RCRA; 42 U.S. Code 6901 et seq.) . . . . .	932
14.10.2.2.4	Emergency Planning and Community Right-to-Know Act (EPCRA; 42 U.S. Code 11001 et seq.) . . . . .	933
14.10.2.2.5	Toxic Substances Control Act (TSCA; 15 U.S. Code 2601 et seq.) . . . . .	933
14.10.2.3	Food safety . . . . .	934
14.10.3	The solvent extraction process . . . . .	935
14.10.3.1	Preparation for extraction . . . . .	936
14.10.3.2	Oil extraction . . . . .	938
14.10.3.3	Processing crude oil . . . . .	938
14.10.4	Review of solvents studied for extraction efficiency . . . . .	940
14.10.4.1	Hydrocarbon solvents . . . . .	941
14.10.4.1.1	Nomenclature, structure, composition and properties of hydrocarbons . . . . .	942
14.10.4.1.2	Performance of selected hydrocarbon solvents . . . . .	942
14.10.5	Future trends . . . . .	946
14.11	Ground transportation . . . . .	950
	GEORGE WYPYCH	
14.12	Inorganic chemical industry . . . . .	950
	GEORGE WYPYCH	
14.13	Iron and steel industry . . . . .	951
	GEORGE WYPYCH	
14.14	Lumber and wood products - Wood preservation treatment: significance of solvents . . . . .	953
	TILMAN HAHN, KONRAD BOTZENHART, FRITZ SCHWEINSBERG, GERHARD VOLLAND	
14.14.1	General aspects . . . . .	953
14.14.2	Role of solvents . . . . .	954
14.14.2.1	Occurrence . . . . .	954
14.14.2.2	Technical and environmental aspects . . . . .	955
14.15	Medical applications . . . . .	955
	GEORGE WYPYCH	
14.16	Metal casting . . . . .	957
	GEORGE WYPYCH	
14.17	Motor vehicle assembly . . . . .	958
	GEORGE WYPYCH	
14.18	Organic chemical industry . . . . .	962
	GEORGE WYPYCH	

14.19	Paints and coatings . . . . .	963
14.19.1	Architectural surface coatings and solvents . . . . .	963
	TILMAN HAHN, KONRAD BOTZENHART, FRITZ SCHWEINSBERG, GERHARD VOLAND	
14.19.1.1	General aspects . . . . .	963
14.19.1.2	Technical aspects and properties of coating materials . . . . .	963
14.19.2	Recent advances in coalescing solvents for waterborne coatings . . . . .	969
	DAVID RANDALL	
14.19.2.1	Introduction . . . . .	969
14.19.2.2	Water based coatings . . . . .	970
14.19.2.3	Emulsion polymers . . . . .	970
14.19.2.4	Role of a coalescing solvent . . . . .	971
14.19.2.5	Properties of coalescing agents . . . . .	972
14.19.2.5.1	Hydrolytic stability . . . . .	972
14.19.2.5.2	Water solubility . . . . .	972
14.19.2.5.3	Freezing point . . . . .	972
14.19.2.5.4	Evaporation rate . . . . .	972
14.19.2.5.5	Odor . . . . .	972
14.19.2.5.6	Color . . . . .	973
14.19.2.5.7	Coalescing efficiency . . . . .	973
14.19.2.5.8	Incorporation . . . . .	973
14.19.2.5.9	Improvement of physical properties . . . . .	973
14.19.2.5.10	Biodegradability . . . . .	973
14.19.2.5.11	Safety . . . . .	973
14.19.2.6	Comparison of coalescing solvents . . . . .	973
14.19.2.7	Recent advances in diester coalescing solvents . . . . .	974
14.19.2.8	Appendix - Classification of coalescing solvents . . . . .	975
14.20	Petroleum refining industry . . . . .	975
	GEORGE WYPYCH	
14.21	Pharmaceutical industry . . . . .	977
14.21.1	Use of solvents in the manufacture of drug substances (DS) and drug products (DP) . . . . .	977
	MICHEL BAUER, CHRISTINE BARTHÉLÉMY	
14.21.1.1	Introduction . . . . .	977
14.21.1.2	Where are solvents used in the manufacture of pharmaceutical drugs? . . . . .	979
14.21.1.2.1	Intermediates of synthesis, DS and excipients . . . . .	979
14.21.1.2.2	Drug products . . . . .	984
14.21.1.3	Impacts of the nature of solvents and their quality on the physicochemical characteristics of raw materials and DP . . . . .	985
14.21.1.3.1	Raw materials (intermediates, DS, excipients) . . . . .	985
14.21.1.3.2	Drug product . . . . .	988
14.21.1.3.3	Conclusions . . . . .	989
14.21.1.4	Setting specifications for solvents . . . . .	990
14.21.1.4.1	Solvents used for the raw material manufacture . . . . .	990
14.21.1.4.2	Solvents used for the DP manufacture . . . . .	991
14.21.1.5	Quality of solvents and analysis . . . . .	991
14.21.1.5.1	Quality of solvents used in spectroscopy . . . . .	991
14.21.1.5.2	Quality of solvents used in chromatography . . . . .	993
14.21.1.5.3	Quality of solvents used in titrimetry . . . . .	996
14.21.1.6	Conclusions . . . . .	996
14.21.2	Predicting cosolvency for pharmaceutical and environmental applications . . . . .	997
	AN LI	
14.21.2.1	Introduction . . . . .	997
14.21.2.2	Applications of cosolvency in pharmaceutical sciences and industry . . . . .	998
14.21.2.3	Applications of cosolvency in environmental sciences and engineering . . . . .	1000
14.21.2.4	Experimental observations . . . . .	1001
14.21.2.5	Predicting cosolvency in homogeneous liquid systems . . . . .	1003
14.21.2.6	Predicting cosolvency in non-ideal liquid mixtures . . . . .	1007

14.21.2.7	Summary . . . . .	1013
14.22	Polymers and man-made fibers. . . . .	1016
	GEORGE WYPYCH	
14.23	Printing industry . . . . .	1020
	GEORGE WYPYCH	
14.24	Pulp and paper . . . . .	1023
	GEORGE WYPYCH	
14.25	Rubber and plastics. . . . .	1025
	GEORGE WYPYCH	
14.26	Use of solvents in the shipbuilding and ship repair industry. . . . .	1026
	MOHAMED SERAGELDIN, DAVE REEVES	
14.26.1	Introduction. . . . .	1026
14.26.2	Shipbuilding and ship repair operations . . . . .	1026
14.26.3	Coating operations . . . . .	1026
14.26.4	Cleaning operations using organic solvents . . . . .	1027
14.26.4.1	Surface preparation and initial corrosion protection . . . . .	1027
14.26.4.2	Cleaning operations after coatings are applied. . . . .	1028
14.26.4.3	Maintenance cleaning of equipment items and components . . . . .	1031
14.26.5	Marine coatings. . . . .	1031
14.26.6	Thinning of marine coatings . . . . .	1032
14.26.7	Solvent emissions . . . . .	1033
14.26.8	Solvent waste. . . . .	1035
14.26.9	Reducing solvent usage, emissions, and waste. . . . .	1036
14.26.10	Regulations and guidelines for cleaning solvents . . . . .	1037
14.27	Stone, clay, glass, and concrete . . . . .	1039
	GEORGE WYPYCH	
14.28	Textile industry. . . . .	1041
	GEORGE WYPYCH	
14.29	Transportation equipment cleaning. . . . .	1042
	GEORGE WYPYCH	
14.30	Water transportation . . . . .	1042
	GEORGE WYPYCH	
14.31	Wood furniture . . . . .	1043
	GEORGE WYPYCH	
14.32	Summary . . . . .	1045
<b>15</b>	<b>METHODS OF SOLVENT DETECTION AND TESTING. . . . .</b>	<b>1053</b>
15.1	Standard methods of solvent analysis . . . . .	1053
	GEORGE WYPYCH	
15.1.1	Alkalinity and acidity. . . . .	1053
15.1.2	Autoignition temperature. . . . .	1054
15.1.3	Biodegradation potential . . . . .	1054
15.1.4	Boiling point . . . . .	1055
15.1.5	Bromine index . . . . .	1055
15.1.6	Calorific value . . . . .	1056
15.1.7	Cleaning solvents. . . . .	1056
15.1.8	Color . . . . .	1056
15.1.9	Corrosion (effect of solvents) . . . . .	1057
15.1.10	Density . . . . .	1057
15.1.11	Dilution ratio . . . . .	1057
15.1.12	Dissolving and extraction . . . . .	1058
15.1.13	Electric properties . . . . .	1058
15.1.14	Environmental stress crazing. . . . .	1059
15.1.15	Evaporation rate . . . . .	1059
15.1.16	Flammability limits. . . . .	1059
15.1.17	Flash point . . . . .	1060
15.1.18	Freezing point . . . . .	1061
15.1.19	Free halogens in halogenated solvents . . . . .	1061

15.1.20	Gas chromatography . . . . .	1061
15.1.21	Labeling . . . . .	1062
15.1.22	Odor . . . . .	1062
15.1.23	Paints standards related to solvents . . . . .	1063
15.1.24	pH. . . . .	1063
15.1.25	Purity . . . . .	1063
15.1.26	Refractive index . . . . .	1066
15.1.27	Residual solvents . . . . .	1066
15.1.28	Solubility . . . . .	1066
15.1.29	Solvent partitioning in soils . . . . .	1066
15.1.30	Solvent extraction . . . . .	1067
15.1.31	Specifications. . . . .	1067
15.1.32	Sustained burning . . . . .	1067
15.1.33	Vapor pressure . . . . .	1068
15.1.34	Viscosity . . . . .	1068
15.1.35	Volatile organic compound content, VOC . . . . .	1069
15.2	Special methods of solvent analysis . . . . .	1078
15.2.1	Use of breath monitoring to assess exposures to volatile organic solvents . . . . .	1078
MYRTO PETREAS		
15.2.1.1	Principles of breath monitoring . . . . .	1078
15.2.1.2	Types of samples used for biological monitoring . . . . .	1080
15.2.1.3	Fundamentals of respiratory physiology . . . . .	1080
15.2.1.3.1	Ventilation . . . . .	1081
15.2.1.3.2	Partition coefficients . . . . .	1081
15.2.1.3.3	Gas exchange . . . . .	1082
15.2.1.4	Types of exhaled air samples. . . . .	1083
15.2.1.5	Breath sampling methodology . . . . .	1084
15.2.1.6	When is breath monitoring appropriate? . . . . .	1087
15.2.1.7	Examples of breath monitoring. . . . .	1088
15.2.2	A simple test to determine toxicity using bacteria . . . . .	1095
JAMES L. BOTSFORD		
15.2.2.1	Introduction. . . . .	1095
15.2.2.2	Toxicity defined . . . . .	1095
15.2.2.3	An alternative. . . . .	1097
15.2.2.4	Chemicals tested . . . . .	1099
15.2.2.5	Comparisons with other tests. . . . .	1103
15.2.2.6	Toxic herbicides . . . . .	1107
15.2.2.7	Toxicity of divalent cations . . . . .	1108
15.2.2.8	Toxicity of organics in the presence of EDTA. . . . .	1108
15.2.2.9	Mechanism for reduction of the dye . . . . .	1110
15.2.2.10	Summary . . . . .	1111
15.2.3	Description of an innovative GC method to assess the influence of crystal texture and drying conditions on residual solvent content in pharmaceutical products. . . . .	1113
CHRISTINE BARTHÉLÉMY, MICHEL BAUER		
15.2.3.1	Description of the RS determination method . . . . .	1113
15.2.3.2	Application: Influence of crystal texture and drying conditions on RS content . . . . .	1114
15.2.3.2.1	First example: monocrystalline particles of paracetamol . . . . .	1116
15.2.3.2.2	Second example: polycrystalline particles of meprobamate and ibuprofen . . . . .	1119
15.2.3.2.3	Third example: polycrystalline particles of paracetamol. . . . .	1122
<b>16</b>	<b>RESIDUAL SOLVENTS IN PRODUCTS . . . . .</b>	<b>1125</b>
16.1	Residual solvents in various products . . . . .	1125
GEORGE WYPYCH		
16.2	Residual solvents in pharmaceutical substances . . . . .	1129
MICHEL BAUER, CHRISTINE BARTHÉLÉMY		
16.2.1	Introduction. . . . .	1129
16.2.2	Why should we look for RS?. . . . .	1129

16.2.2.1	Modifying the acceptability of the drug product . . . . .	1129
16.2.2.2	Modifying the physico-chemical properties of drug substances (DS) and drug products (DP) . . . . .	1130
16.2.2.3	Implications of possible drug/container interactions . . . . .	1131
16.2.2.4	As a tool for forensic applications . . . . .	1131
16.2.2.5	As a source of toxicity . . . . .	1131
16.2.2.5.1	General points . . . . .	1131
16.2.2.5.2	Brief overview of the toxicology of solvents. . . . .	1132
16.2.3	How to identify and control RS in pharmaceutical substances? . . . . .	1133
16.2.3.1	Loss of weight . . . . .	1133
16.2.3.2	Miscellaneous methods. . . . .	1133
16.2.3.3	Gas chromatography (GC) . . . . .	1134
16.2.3.3.1	General points . . . . .	1134
16.2.3.3.2	Review of methods . . . . .	1135
16.2.3.3.3	Official GC methods for RS determination . . . . .	1139
16.2.4	How to set specifications? Examination of the ICH guidelines for residual solvents . . . . .	1140
16.2.4.1	Introduction. . . . .	1143
16.2.4.2	Classification of residual solvents by risk assessment . . . . .	1143
16.2.4.3	Definition of PDE. Method for establishing exposure limits . . . . .	1143
16.2.4.4	Limits for residual solvents. . . . .	1143
16.2.4.5	Analytical procedures . . . . .	1145
16.2.4.6	Conclusions regarding the ICH guideline . . . . .	1145
16.2.5	Conclusions. . . . .	1146
<b>17</b>	<b>ENVIRONMENTAL IMPACT OF SOLVENTS. . . . .</b>	<b>1149</b>
17.1	The environmental fate and movement of organic solvents in water, soil, and air . . . . .	1149
	WILLIAM R. ROY	
17.1.1	Introduction. . . . .	1149
17.1.2	Water . . . . .	1150
17.1.2.1	Solubility . . . . .	1150
17.1.2.2	Volatilization . . . . .	1150
17.1.2.3	Degradation. . . . .	1151
17.1.2.4	Adsorption . . . . .	1151
17.1.3	Soil . . . . .	1151
17.1.3.1	Volatilization . . . . .	1151
17.1.3.2	Adsorption . . . . .	1152
17.1.3.3	Degradation. . . . .	1153
17.1.4	Air . . . . .	1153
17.1.4.1	Degradation. . . . .	1153
17.1.4.2	Atmospheric residence time . . . . .	1154
17.1.5	The 31 solvents in water . . . . .	1154
17.1.5.1	Solubility . . . . .	1154
17.1.5.2	Volatilization from water . . . . .	1155
17.1.5.3	Degradation in water . . . . .	1155
17.1.6	Soil . . . . .	1157
17.1.6.1	Volatilization . . . . .	1157
17.1.6.2	Adsorption . . . . .	1159
17.1.6.3	Degradation. . . . .	1160
17.1.7	Air . . . . .	1161
17.2	Fate-based management of organic solvent-containing wastes . . . . .	1162
	WILLIAM R. ROY	
17.2.1	Introduction. . . . .	1162
17.2.1.1	The waste disposal site . . . . .	1163
17.2.1.2	The advection-dispersion model and the required input . . . . .	1164
17.2.1.3	Maximum permissible concentrations . . . . .	1164
17.2.1.4	Distribution of organic compounds in leachate . . . . .	1164

17.2.2	Movement of solvents in groundwater . . . . .	1166
17.2.3	Mass limitations . . . . .	1167
17.3	Environmental fate and ecotoxicological effects of glycol ethers . . . . .	1169
	JAMES DEVILLERS, AURÉLIE CHEZEAU, ANDRÉ CICOLELLA, ERIC THYBAUD	
17.3.1	Introduction . . . . .	1169
17.3.2	Occurrence . . . . .	1170
17.3.3	Environmental behavior . . . . .	1171
17.3.4	Ecotoxicity . . . . .	1175
17.3.4.1	Survival and growth . . . . .	1175
17.3.4.2	Reproduction and development . . . . .	1185
17.3.5	Conclusion . . . . .	1187
17.4	Organic solvent impacts on tropospheric air pollution. . . . .	1188
	MICHELLE BERGIN, ARMISTEAD RUSSELL	
17.4.1	Sources and impacts of volatile solvents . . . . .	1188
17.4.2	Modes and scales of impact . . . . .	1189
17.4.2.1	Direct exposure . . . . .	1189
17.4.2.2	Formation of secondary compounds . . . . .	1190
17.4.2.3	Spatial scales of secondary effects . . . . .	1190
17.4.2.3.1	Global impacts . . . . .	1190
17.4.2.3.2	Stratospheric ozone depletion . . . . .	1191
17.4.2.3.3	Global climate forcing . . . . .	1191
17.4.2.4	Urban and regional scales . . . . .	1192
17.4.3	Tropospheric ozone. . . . .	1192
17.4.3.1	Effects . . . . .	1192
17.4.3.2	Tropospheric photochemistry and ozone formation . . . . .	1193
17.4.3.3	Assessing solvent impacts on ozone and VOC reactivity . . . . .	1195
17.4.3.3.1	Quantification of solvent emissions on ozone formation . . . . .	1196
17.4.4	Regulatory approaches to ozone control and solvents . . . . .	1198
17.4.5	Summary . . . . .	1299
<b>18</b>	<b>CONCENTRATION OF SOLVENTS IN VARIOUS INDUSTRIAL ENVIRONMENTS . . . . .</b>	<b>1201</b>
18.1	Measurement and estimation of solvents emission and odor. . . . .	1201
	MARGOT SCHEITHAUER	
18.1.1	Definition “solvent” and “volatile organic compounds” (VOC) . . . . .	1201
18.1.2	Review of sources of solvent emissions . . . . .	1203
18.1.2.1	Causes for emissions . . . . .	1203
18.1.2.2	Emissions of VOCs from varnishes and paints . . . . .	1203
18.1.2.3	VOC emissions from emulsion paints . . . . .	1205
18.1.3	Measuring of VOC-content in paints and varnishes . . . . .	1205
18.1.3.1	Definition of low-emissive coating materials . . . . .	1205
18.1.3.2	Determination of the VOC content according to ASTM D 3960-1 . . . . .	1205
18.1.3.3	Determination of the VOC content according to ISO/DIS 11 890/1 and 2 . . . . .	1206
18.1.3.3.1	VOC content > 15% . . . . .	1206
18.1.3.3.2	VOC content > 0.1 and < 15 %. . . . .	1208
18.1.3.4	Determination of VOC-content in water-thinnable emulsion paints (in-can VOC) . . . . .	1208
18.1.4	Measurement of solvent emissions in industrial plants . . . . .	1209
18.1.4.1	Plant requirements . . . . .	1209
18.1.4.2	The determination of the total carbon content in mg C/Nm <sup>3</sup> . . . . .	1214
18.1.4.2.1	Flame ionization detector (FID) . . . . .	1214
18.1.4.2.2	Silica gel approach . . . . .	1214
18.1.4.3	Qualitative and quantitative assessment of individual components in the exhaust-gas . . . . .	1215
18.1.4.3.1	Indicator tubes . . . . .	1215
18.1.4.3.2	Quantitative solvent determination in exhaust gas of plants by means of gas-chromatography . . . . .	1215
18.1.5	“Odor” definition . . . . .	1219

18.1.6	Measurement of odor in materials and industrial plants . . . . .	1222
18.1.6.1	Introduction . . . . .	1222
18.1.6.2	Odor determination by means of the “electronic nose” . . . . .	1222
18.1.6.3	Odor determination by means of the olfactometer . . . . .	1223
18.1.6.4	Example for odor determination for selected materials: Determination of odorant concentration in varnished furniture surfaces . . . . .	1223
18.1.6.5	Example of odor determination in industrial plants: Odor measurement in an industrial varnishing plant. . . . .	1225
18.2	Prediction of organic solvents emission during technological processes . . . . .	1227
	KRZYSZTOF M. BENCZEK, JOANNA KURPIEWSKA	
18.2.1	Introduction . . . . .	1227
18.2.2	Methods of degreasing . . . . .	1227
18.2.3	Solvents. . . . .	1228
18.2.4	Identification of the emitted compounds . . . . .	1228
18.2.5	Emission of organic solvents during technological processes . . . . .	1228
18.2.6	Verification of the method . . . . .	1230
18.2.7	Relationships between emission and technological parameters . . . . .	1231
18.2.7.1	Laboratory test stand . . . . .	1231
18.2.7.2	The influence of temperature on emission . . . . .	1231
18.2.7.3	The influence of air velocity on emission . . . . .	1232
18.2.7.4	The relationship between the mass of solvent on wet parts and emissions . . . . .	1232
18.2.8	Emission of solvents . . . . .	1232
18.2.9	Verification in industrial conditions . . . . .	1232
18.3	Indoor air pollution by solvents contained in paints and varnishes . . . . .	1234
	TILMAN HAHN, KONRAD BOTZENHART, FRITZ SCHWEINSBERG, GERHARD VOLLAND	
18.3.1	Composition - solvents in paints and varnishes. Theoretical aspects . . . . .	1234
18.3.2	Occurrence of solvents in paints and varnishes . . . . .	1235
18.3.2.1	Solvents in products . . . . .	1235
18.3.2.2	Paints and varnishes . . . . .	1237
18.3.3	Emission of solvents . . . . .	1240
18.3.3.1	Emission . . . . .	1240
18.3.3.2	Immission. . . . .	1242
18.3.4	Effects on health of solvents from paints and varnishes . . . . .	1243
18.3.4.1	Exposure . . . . .	1243
18.3.4.2	Health effects . . . . .	1243
18.3.4.2.1	Toxic responses of skin and mucose membranes . . . . .	1243
18.3.4.2.2	Neurological disorders . . . . .	1244
18.3.4.2.3	Carcinogenic effects . . . . .	1245
18.3.4.2.4	Respiratory effects . . . . .	1246
18.3.4.2.5	Toxic responses of blood. . . . .	1247
18.3.4.2.6	Toxic responses of the reproductive system . . . . .	1247
18.3.4.2.7	Toxic responses of other organ systems . . . . .	1247
18.3.5	Methods for the examination of solvents in paints and varnishes . . . . .	1248
18.3.5.1	Environmental monitoring . . . . .	1248
18.3.5.1.1	Solvents in products . . . . .	1248
18.3.5.1.2	Emission of solvents . . . . .	1248
18.3.5.2	Biological monitoring of solvents in human body fluids . . . . .	1248
18.3.5.2.1	Solvents and metabolites in human body fluids and tissues . . . . .	1248
18.3.5.2.2	Biomarkers . . . . .	1248
18.4	Solvent uses with exposure risks . . . . .	1251
	PENTTI KALLIKOSKI, KAI SAVOLINEN	
18.4.1	Introduction. . . . .	1251
18.4.2	Exposure assessment . . . . .	1252
18.4.3	Production of paints and printing inks . . . . .	1255
18.4.4	Painting. . . . .	1256
18.4.5	Printing . . . . .	1257
18.4.6	Degreasing, press cleaning and paint removal . . . . .	1258

18.4.7	Dry cleaning . . . . .	1260
18.4.8	Reinforced plastics industry . . . . .	1261
18.4.9	Gluing . . . . .	1262
18.4.10	Other . . . . .	1262
18.4.11	Summary . . . . .	1263
<b>19</b>	<b>REGULATIONS . . . . .</b>	<b>1267</b>
	CARLOS M. NUÑEZ	
19.1	Introduction . . . . .	1267
19.2	Air laws and regulations . . . . .	1282
19.2.1	Clean Air Act Amendments of 1990 . . . . .	1282
19.2.1.1	Background . . . . .	1282
19.2.1.2	Title I - Provisions for Attainment and Maintenance of National Ambient Air Quality Standards . . . . .	1284
19.2.1.3	Title III - Hazardous Air Pollutants . . . . .	1288
19.2.1.4	Title V - Permits . . . . .	1292
19.2.1.5	Title VI - Stratospheric Ozone Protection . . . . .	1292
19.3	Water laws and regulations . . . . .	1293
19.3.1	Clean Water Act . . . . .	1293
19.3.1.1	Background . . . . .	1293
19.3.1.2	Effluent Limitations . . . . .	1293
19.3.1.3	Permit Program . . . . .	1294
19.3.2	Safe Drinking Water Act . . . . .	1294
19.3.2.1	Background . . . . .	1294
19.3.2.2	National Primary Drinking Water Regulations . . . . .	1295
19.4	Land laws & regulations . . . . .	1295
19.4.1	Resource Conservation and Recovery Act (RCRA) . . . . .	1295
19.4.1.1	Background . . . . .	1295
19.4.1.2	RCRA, Subtitle C - Hazardous Waste . . . . .	1296
19.5	Multimedia laws and regulations . . . . .	1297
19.5.1	Pollution Prevention Act of 1990 . . . . .	1297
19.5.1.1	Background . . . . .	1297
19.5.1.2	Source Reduction Provisions . . . . .	1298
19.5.2	Toxic Substances Control Act . . . . .	1300
19.5.2.1	Background . . . . .	1300
19.5.2.2	Controlling toxic substances . . . . .	1300
19.6	Occupational laws and regulations . . . . .	1301
19.6.1	Occupational Safety and Health Act . . . . .	1301
19.6.1.1	Background . . . . .	1301
19.6.1.2	Air contaminants exposure limits . . . . .	1301
19.6.1.3	Hazard Communication Standard . . . . .	1302
19.7	International perspective . . . . .	1302
19.7.1	Canada . . . . .	1303
19.7.2	European Union . . . . .	1303
19.8	Tools and resources for solvents . . . . .	1304
19.9	Summary . . . . .	1306
19.10	Regulations in Europe . . . . .	1311
	TILMAN HAHN, KONRAD BOTZENHART, FRITZ SCHWEINSBERG	
19.10.1	EEC regulations . . . . .	1311
19.10.2	German regulations . . . . .	1312
<b>20</b>	<b>TOXIC EFFECTS OF SOLVENT EXPOSURE . . . . .</b>	<b>1315</b>
20.1	Toxicokinetics, toxicodynamics, and toxicology . . . . .	1315
	TILMAN HAHN, KONRAD BOTZENHART, FRITZ SCHWEINSBERG	
20.1.1	Toxicokinetics and toxicodynamics . . . . .	1315
20.1.1.1	Exposure . . . . .	1315
20.1.1.2	Uptake . . . . .	1315
20.1.1.2.1	Inhalation . . . . .	1316
20.1.1.2.2	Dermal uptake . . . . .	1316

20.1.1.2	Metabolism, distribution, excretion . . . . .	1317
20.1.1.3	Modeling of toxicokinetics and modifying factors. . . . .	1317
20.1.2	Toxicology . . . . .	1318
20.1.2.1	General effects . . . . .	1318
20.1.2.2	Specific non-immunological effects . . . . .	1318
20.1.2.3	Immunological effects . . . . .	1319
20.1.2.4	Toxic effects of solvents on other organisms . . . . .	1320
20.1.2.5	Carcinogenicity . . . . .	1320
20.1.2.6	Risk assessment . . . . .	1323
20.1.3	Conclusions. . . . .	1323
20.2	Cognitive and psychosocial outcome of chronic occupational solvent neurotoxicity . . . . .	1326
JENNI A. OGDEN		
20.2.1	Introduction. . . . .	1326
20.2.2	Acute symptoms of solvent neurotoxicity . . . . .	1327
20.2.3	Categorization of OSN . . . . .	1327
20.2.4	Assessment of OSN . . . . .	1328
20.2.5	Do the symptoms of Type 2 OSN resolve? . . . . .	1330
20.2.6	Individual differences in susceptibility to OSN . . . . .	1331
20.2.7	Psychosocial consequences of OSN, and rehabilitation . . . . .	1331
20.3	Pregnancy outcome following maternal organic solvent exposure . . . . .	1333
KRISTEN I. McMARTIN, GIDEON KOREN		
20.3.1	Introduction. . . . .	1333
20.3.2	Animal studies . . . . .	1334
20.3.3	Pregnancy outcome following maternal organic solvent exposure: a meta-analysis of epidemiologic studies . . . . .	1338
20.3.4	Pregnancy outcome following gestational exposure to organic solvents: a prospective controlled study . . . . .	1345
20.3.5	A proactive approach for the evaluation of fetal safety in chemical industries . . . . .	1347
20.3.6	Overall conclusion . . . . .	1353
20.4	Industrial solvents and kidney disease . . . . .	1355
NACHMAN BRAUTBAR		
20.4.1	Introduction. . . . .	1355
20.4.2	Experimental animal studies . . . . .	1356
20.4.3	Case reports. . . . .	1356
20.4.4	Case control studies . . . . .	1357
20.4.5	Epidemiological assessment . . . . .	1360
20.4.6	Mechanism . . . . .	1361
20.5	Lymphohematopoietic study of workers exposed to benzene including multiple myeloma, lymphoma and chronic lymphatic leukemia. . . . .	1363
NACHMAN BRAUTBAR		
20.5.1	Introduction. . . . .	1363
20.5.2	Routes of exposure . . . . .	1363
20.5.3	Hematopoietic effects of benzene . . . . .	1365
20.5.4	Carcinogenic effects of benzene . . . . .	1365
20.5.5	Risk assessment estimates . . . . .	1367
20.5.6	Levels of exposure . . . . .	1367
20.5.7	Cell types: hematolymphoproliferative effects of benzene . . . . .	1369
20.5.8	Epidemiological studies . . . . .	1369
20.5.9	Solvents and benzene. . . . .	1370
20.5.10	Genetic fingerprint theory . . . . .	1372
20.6	Chromosomal aberrations and sister chromatid exchanges. . . . .	1375
NACHMAN BRAUTBAR		
20.7	Hepatotoxicity . . . . .	1379
NACHMAN BRAUTBAR		

20.7.1	Introduction . . . . .	1379
20.7.2	Individual variability and hepatotoxicity of solvents . . . . .	1384
20.7.3	Non-halogenated solvents . . . . .	1385
20.7.4	Solvent mixtures . . . . .	1386
20.7.5	Trichloroethylene . . . . .	1387
20.7.6	Tetrachloroethylene . . . . .	1388
20.7.7	Toluene . . . . .	1388
20.7.8	Dichloromethane . . . . .	1389
20.7.9	Stoddard solvent . . . . .	1389
20.7.10	1,1,1-Trichloroethane . . . . .	1389
20.7.11	Summary . . . . .	1390
20.8	Solvents and the liver . . . . .	1393
	DAVID K. BONALITO, C. ANDREW BRODKIN, WILLIAM O. ROBERTSON	
20.8.1	Normal anatomic and physiologic function of the liver . . . . .	1393
20.8.1.1	Factors influencing solvent hepatotoxicity . . . . .	1394
20.8.1.2	Microscopic, biochemical and clinical findings associated with liver injury due to solvents . . . . .	1394
20.8.2	Hepatotoxicity associated with specific solvents . . . . .	1395
20.8.2.1	Haloalkanes and haloalkenes . . . . .	1396
20.8.2.2	Carbon tetrachloride . . . . .	1396
20.8.2.3	Chloroform . . . . .	1397
20.8.2.4	Dichloromethane . . . . .	1398
20.8.2.5	Trichloroethanes . . . . .	1398
20.8.2.6	1,1,2,2-Tetrachloroethane . . . . .	1398
20.8.2.7	Tetrachloroethylene and trichloroethylene . . . . .	1399
20.8.2.8	Other halogenated hydrocarbons . . . . .	1399
20.8.2.9	Styrene and aromatic hydrocarbons . . . . .	1399
20.8.2.10	N-substituted amides . . . . .	1400
20.8.2.11	Nitroparaffins . . . . .	1400
20.8.2.12	Other solvents and mixed solvents . . . . .	1401
20.9	Toxicity of environmental solvent exposure for brain, lung and heart . . . . .	1404
	KAYE H. KILBURN	
<b>21</b>	<b>SUBSTITUTION OF SOLVENTS BY SAFER PRODUCTS AND PROCESSES . . . . .</b>	<b>1419</b>
21.1	Supercritical solvents . . . . .	1419
	AYDIN K. SUNOL, SERMIN G. SUNOL	
21.1.1	Introduction . . . . .	1419
21.1.1.1	A promising path to green chemistry . . . . .	1422
21.1.1.2	Unique and tunable physico-chemical properties . . . . .	1422
21.1.1.3	Sustainable applications in many different areas . . . . .	1422
21.1.2	Fundamentals . . . . .	1423
21.1.2.1	Phase behavior with supercritical solvents . . . . .	1423
21.1.2.1.1	Experimental methods . . . . .	1426
21.1.2.1.2	Computational aspects . . . . .	1428
21.1.2.1.3	Modeling . . . . .	1429
21.1.2.2	Transport properties of supercritical solvents . . . . .	1431
21.1.2.2.1	Viscosity . . . . .	1431
21.1.2.2.2	Diffusivity . . . . .	1432
21.1.2.2.3	Thermal conductivity . . . . .	1433
21.1.2.2.4	Surface tension . . . . .	1435
21.1.2.3	Entrainier (co-solvent effects) of supercritical solvents . . . . .	1435
21.1.2.4	Reaction rate implication in supercritical solvents . . . . .	1436
21.1.2.5	Sorption behavior of supercritical solvents . . . . .	1437
21.1.2.6	Swelling with supercritical solvents . . . . .	1437
21.1.2.7	Surfactants and micro-emulsions . . . . .	1438
21.1.3	Separation with supercritical solvents . . . . .	1438
21.1.3.1	Leaching - generic application . . . . .	1441

21.1.3.2 Extraction - generic applications . . . . .	1442
21.1.3.3 Crystallization - generic applications . . . . .	1443
21.1.3.4 Sorption - generic applications . . . . .	1443
21.1.4 Reactions in supercritical solvents . . . . .	1444
21.1.4.1 Homogenous reactions in supercritical solvents - examples . . . . .	1445
21.1.4.1.1 Homogeneous reactions catalyzed by organometallic compounds . . . . .	1446
21.1.4.1.2 Homogeneous reactions of supercritical water. . . . .	1447
21.1.4.1.3 Homogeneous non-catalytic reactions in supercritical solvents . . . . .	1448
21.1.4.2 Heterogeneous reactions in supercritical solvents - examples . . . . .	1448
21.1.4.2.1 Heterogeneous catalytic reactions in supercritical solvents . . . . .	1449
21.1.4.2.2 Heterogeneous non-catalytic reactions in supercritical solvents . . . . .	1450
21.1.4.3 Biochemical reactions - examples . . . . .	1451
21.1.4.4 Polymerization reactions - examples . . . . .	1451
21.1.4.5 Materials processing with supercritical solvents . . . . .	1452
21.1.4.6 Particle synthesis - generic application. . . . .	1453
21.1.4.7 Encapsulation - generic application . . . . .	1454
21.1.4.8 Spraying and coating - generic application. . . . .	1454
21.1.4.9 Extrusion - generic application. . . . .	1454
21.1.4.10 Perfusion (impregnation) - generic application . . . . .	1454
21.1.4.11 Parts cleaning - generic application . . . . .	1455
21.1.4.12 Drying - generic application . . . . .	1455
21.2 Ionic liquids . . . . .	1459
D.W. ROONEY, K.R. SEDDON	
21.2.1 Introduction. . . . .	1459
21.2.2 Fundamental principles of the formation of room temperature ionic liquids . . . . .	1461
21.2.2.1 Development of ionic liquids. . . . .	1461
21.2.2.2 Binary ionic liquid systems. . . . .	1465
21.2.3 Catalysis in ionic liquids . . . . .	1466
21.2.3.1 Reactions involving first generation chloroaluminate(III) ionic liquids . . . . .	1467
21.2.3.2 Reactions in neutral or second generation ionic liquids. . . . .	1469
21.2.4 Electrochemical applications . . . . .	1472
21.2.4.1 Electrosynthesis . . . . .	1473
21.2.5 Physical characterization . . . . .	1473
21.2.5.1 Viscosity . . . . .	1473
21.2.5.2 Density . . . . .	1478
21.2.6 Summary . . . . .	1480
21.3 Oxide solubilities in ionic melts . . . . .	1484
VICTOR CHERGINETS	
21.3.1 Methods used for solubility estimations in ionic melts . . . . .	1484
21.3.1.1 Isothermal saturation method. . . . .	1485
21.3.1.2 Potentiometric titration method . . . . .	1486
21.3.2 Oxygen-containing melts. . . . .	1487
21.3.3 Halide melts . . . . .	1487
21.3.3.1 The eutectic mixture KCl-LiCl (0.41:0.59) . . . . .	1487
21.3.3.2 Molten KCl-NaCl (0.50:0.50) . . . . .	1488
21.3.3.3 Other chloride-based melts . . . . .	1491
21.3.3.4 Other alkaline halides . . . . .	1493
21.3.4 On the possibility to predict oxide solubilities on the base of the existing data . . . . .	1494
21.3.4.1 The estimation of effect of anion. . . . .	1494
21.3.4.2 The estimation of effect of melt acidity . . . . .	1494
21.3.4.3 The estimation of effect of temperature . . . . .	1495
21.3.5 Conclusions. . . . .	1495
21.4 Alternative cleaning technologies/drycleaning installations . . . . .	1497
KASPAR D. HASENCLEVER	
21.4.1 Drycleaning with liquid carbon dioxide (LCD) . . . . .	1497
21.4.1.1 Basics. . . . .	1497
21.4.1.2 State of the art . . . . .	1498

21.4.1.3	Process technology . . . . .	1498
21.4.1.4	Risks . . . . .	1499
21.4.1.5	Competition . . . . .	1500
21.4.2	Wet cleaning . . . . .	1501
21.4.2.1	Kreussler textile cleaning system. . . . .	1501
21.4.2.2	Possibilities . . . . .	1503
21.4.2.3	Limitations . . . . .	1504
21.4.2.4	Adapting to working practices . . . . .	1504
21.4.3	Future. . . . .	1505
<b>22</b>	<b>SOLVENT RECYCLING, REMOVAL, AND DEGRADATION.</b> . . . . .	<b>1507</b>
22.1	Absorptive solvent recovery . . . . .	1507
KLAUS-DIRK HENNING		
22.1.1	Introduction. . . . .	1507
22.1.2	Basic principles. . . . .	1509
22.1.2.1	Fundamentals of adsorption . . . . .	1509
22.1.2.2	Adsorption capacity . . . . .	1510
22.1.2.3	Dynamic adsorption in adsorber beds . . . . .	1511
22.1.2.4	Regeneration of the loaded adsorbents. . . . .	1512
22.1.3	Commercially available adsorbents . . . . .	1513
22.1.3.1	Activated carbon . . . . .	1513
22.1.3.2	Molecular sieve zeolites . . . . .	1514
22.1.3.3	Polymeric adsorbents. . . . .	1515
22.1.4	Absorptive solvent recovery systems. . . . .	1515
22.1.4.1	Basic arrangement of absorptive solvent recovery with steam desorption. . . . .	1515
22.1.4.2	Designing solvent recovery systems . . . . .	1518
22.1.4.2.1	Design basis . . . . .	1518
22.1.4.2.2	Adsorber types . . . . .	1519
22.1.4.2.3	Regeneration . . . . .	1521
22.1.4.2.4	Safety requirements . . . . .	1522
22.1.4.3	Special process conditions . . . . .	1523
22.1.4.3.1	Selection of the adsorbent . . . . .	1523
22.1.4.3.2	Air velocity and pressure drop . . . . .	1526
22.1.4.3.3	Effects of solvent-concentration, adsorption temperature and pressure . . . . .	1526
22.1.4.3.4	Influence of humidity . . . . .	1528
22.1.4.3.5	Interactions between solvents and activated carbon . . . . .	1529
22.1.4.3.6	Activated carbon service life . . . . .	1531
22.1.5	Examples from different industries. . . . .	1531
22.1.5.1	Rotogravure printing shops. . . . .	1531
22.1.5.2	Packaging printing industry . . . . .	1532
22.1.5.2.1	Fixed bed adsorption with circulating hot gas desorption . . . . .	1533
22.1.5.2.2	Solvent recovery with adsorption wheels . . . . .	1535
22.1.5.3	Viscose industry . . . . .	1535
22.1.5.4	Refrigerator recycling . . . . .	1539
22.1.5.5	Petrochemical industry and tank farms. . . . .	1539
22.1.5.6	Chemical industry . . . . .	1541
22.2	Solvent recovery . . . . .	1543
ISAO KIMURA		
22.2.1	Activated carbon in fluidized bed adsorption method . . . . .	1543
22.2.2	Application of molecular sieves . . . . .	1544
22.2.3	Continuous process for air cleaning using macroporous particles as adsorption agents . . . . .	1546
22.2.4	Solvent recovery from hazardous wastes. . . . .	1548
22.2.5	Halogenated solvent recovery . . . . .	1549
22.2.5.1	Coating process. . . . .	1549
22.2.5.2	Tableting process of pharmaceutical products . . . . .	1552
22.2.6	Energy recovery from waste solvent . . . . .	1553
22.3	Solvent treatment in a paints and coating plant . . . . .	1555

	DENIS KARGOL	
22.4	Application of solar photocatalytic oxidation to VOC-containing airstreams . . . . .	1559
	K. A. MAGRINI, A. S. WATT, L. C. BOYD, E. J. WOLFRUM, S. A. LARSON, C. ROTH	
	G. C. GLATZMAIER	
22.4.1	Solvent degradation by photocatalytic oxidation. . . . .	1559
22.4.2	PCO pilot scale systems . . . . .	1560
22.4.2.1	Air stripper application. . . . .	1560
22.4.2.2	Paint booth application . . . . .	1562
22.4.3	Field test results . . . . .	1564
22.4.3.1	Air stripper application . . . . .	1564
22.4.3.2	Paint booth application . . . . .	1566
22.4.4	Comparison with other treatment systems . . . . .	1568
<b>23</b>	<b>CONTAMINATION CLEANUP: NATURAL ATTENUATION AND ADVANCED REMEDIATION TECHNOLOGIES . . . . .</b>	<b>1571</b>
23.1	Natural attenuation of chlorinated solvents in ground water. . . . .	1571
	HANADI S. RIFAI, CHARLES J. NEWELL, TODD H. WIEDEMEIER	
23.1.1	Introduction. . . . .	1571
23.1.2	Natural attenuation processes affecting chlorinated solvent plumes. . . . .	1572
23.1.2.1	Advection. . . . .	1572
23.1.2.2	Dispersion . . . . .	1573
23.1.2.3	Sorption. . . . .	1574
23.1.2.4	One-dimensional advection-dispersion equation with retardation . . . . .	1577
23.1.2.5	Dilution (recharge) . . . . .	1577
23.1.2.6	Volatilization . . . . .	1578
23.1.2.7	Hydrolysis and dehydrohalogenation . . . . .	1579
23.1.2.8	Reduction reactions. . . . .	1581
23.1.3	Biodegradation of chlorinated solvents . . . . .	1581
23.1.3.1	Halorespiration or reductive dechlorination using hydrogen. . . . .	1582
23.1.3.1.1	Stoichiometry of reductive dechlorination . . . . .	1585
23.1.3.1.2	Chlorinated solvents that are amenable to halorespiration . . . . .	1585
23.1.3.2	Oxidation of chlorinated solvents . . . . .	1586
23.1.3.2.1	Direct aerobic oxidation of chlorinated compounds . . . . .	1586
23.1.3.2.2	Aerobic cometabolism of chlorinated compounds . . . . .	1587
23.1.3.2.3	Anaerobic oxidation of chlorinated compounds . . . . .	1587
23.1.4	Biodegradation rates for chlorinated solvents . . . . .	1588
23.1.4.1	Michaelis-Menten rates. . . . .	1588
23.1.4.2	Zero-order rates. . . . .	1590
23.1.4.3	First-order rate constants . . . . .	1591
23.1.5	Geochemical evidence of natural bioremediation at chlorinated solvent sites . . . . .	1599
23.1.5.1	Assessing reductive dechlorination at field sites . . . . .	1599
23.1.5.2	Plume classification schemes. . . . .	1599
23.1.5.2.1	Type 1 . . . . .	1599
23.1.5.2.2	Type 2 . . . . .	1600
23.1.5.2.3	Type 3 . . . . .	1601
23.1.5.2.4	Mixed environments . . . . .	1601
23.1.6	Chlorinated solvent plumes - case studies of natural attenuation . . . . .	1602
23.1.6.1	Plume databases . . . . .	1602
23.1.6.2	Modeling chlorinated solvent plumes . . . . .	1605
23.1.6.2.1	BIOCHLOR natural attenuation model . . . . .	1605
23.1.6.3	RT3D numerical model . . . . .	1609
23.1.6.4	CS case study - The Plattsburgh Air Force Base . . . . .	1611
23.2	Remediation technologies and approaches for managing sites impacted by hydrocarbons . . . . .	1617
	BARRY J. SPARGO, JAMES G. MUELLER	
23.2.1	Introduction. . . . .	1617
23.2.1.1	Understanding HC and CHC in the environment . . . . .	1617
23.2.1.2	Sources of HC in the environment . . . . .	1617

23.2.1.3	Sources of CHC in the environment . . . . .	1618
23.2.2	In situ biotreatment . . . . .	1618
23.2.2.1	Microbial-enhanced natural attenuation/bioremediation . . . . .	1618
23.2.2.1.1	Case study - Cooper River Watershed, Charleston, SC, USA . . . . .	1620
23.2.2.2	Phytoremediation . . . . .	1622
23.2.2.2.1	Case study - phytoremediation for CHCs in groundwater at a chemical plant in Louisiana . . . . .	1622
23.2.3	In situ treatment technologies . . . . .	1623
23.2.3.1	Product recovery via GCW technology . . . . .	1623
23.2.3.1.1	Case study - GCW recovery of creosote, Cabot/Kopper's Superfund Site, Gainesville, FL . . . . .	1624
23.2.3.2	Surfactant enhanced product recovery . . . . .	1625
23.2.3.2.1	Case study - Surfactant-aided chlorinated HC DNAPL recovery, Hill Air Force Base, Ogden, Utah . . . . .	1625
23.2.3.3	Foam-enhanced product recovery . . . . .	1626
23.2.3.4	Thermal desorption - Six Phase Heating . . . . .	1626
23.2.3.4.1	Case study - Six-Phase Heating removal of CHC at a manufacturing facility near Chicago, IL . . . . .	1627
23.2.3.5	In situ steam enhanced extraction (Dynamic Underground Stripping) . . . . .	1628
23.2.3.6	In situ permeable reactive barriers (funnel and gate) . . . . .	1628
23.2.3.6.1	Case study - CHC remediation using an in situ permeable reactive barrier at Naval Air Station Moffett Field, CA . . . . .	1628
23.2.4	Conclusions . . . . .	1629
<b>24</b>	<b>PROTECTION . . . . .</b>	<b>1631</b>
	GEORGE WYPYCH	
24.1	Gloves . . . . .	1631
24.2	Suit materials . . . . .	1633
24.3	Respiratory protection . . . . .	1633
<b>25</b>	<b>NEW TRENDS BASED ON PATENT LITERATURE . . . . .</b>	<b>1637</b>
	GEORGE WYPYCH	
25.1	New solvents . . . . .	1637
25.2	Adhesives . . . . .	1638
25.3	Aerospace . . . . .	1640
25.4	Agriculture . . . . .	1640
25.5	Asphalt . . . . .	1640
25.6	Automotive applications . . . . .	1641
25.7	Coil coating . . . . .	1641
25.8	Composites and laminates . . . . .	1642
25.9	Cosmetics . . . . .	1643
25.10	Cleaning . . . . .	1644
25.11	Fibers . . . . .	1645
25.12	Furniture and wood coatings . . . . .	1646
25.13	Paper . . . . .	1647
25.14	Printing . . . . .	1647
25.15	Stone and concrete . . . . .	1648
25.16	Wax . . . . .	1648
25.17	Summary . . . . .	1649
	<b>ACKNOWLEDGMENTS . . . . .</b>	<b>1653</b>
	<b>INDEX . . . . .</b>	<b>1657</b>