

Med *Clean Propre Limpio*iterraneum



Regional Activity Centre
for Cleaner Production



Ministry of the Environment
Spain



Government of Catalonia
Ministry of the Environment

n. 38

Pollution prevention case studies

Modifying an established production process to generate less waste

Company background

Luxembourg Industries (Pamol) LTD (Arad, Israel) is a producer of diverse crop protection chemicals and chemical intermediates for the pharmaceutical and biotechnology industries.

Industrial sector Chemical industry.

Environmental considerations

During the purification stage of high-grade cacodylic acid, a removal of chloride salt is related with usage of isopropanol. The chloride salt is a waste. The chloride salt is saturated with both cacodylic acid and alcohol. This chloride salt cake is treated with water to recover the cacodylic acid and alcohol. The water is evaporated to recover the acid and the cacodylic acid. The treated chloride salt is then sent to a chemical waste site.

Background

The yield of the current process is approx. 50%. Although the cacodylic acid is recovered, there is a considerable work up and losses of alcohol. The additional water to treat the chloride salt has to be evaporated. Thus, there is an operational and energy added cost.

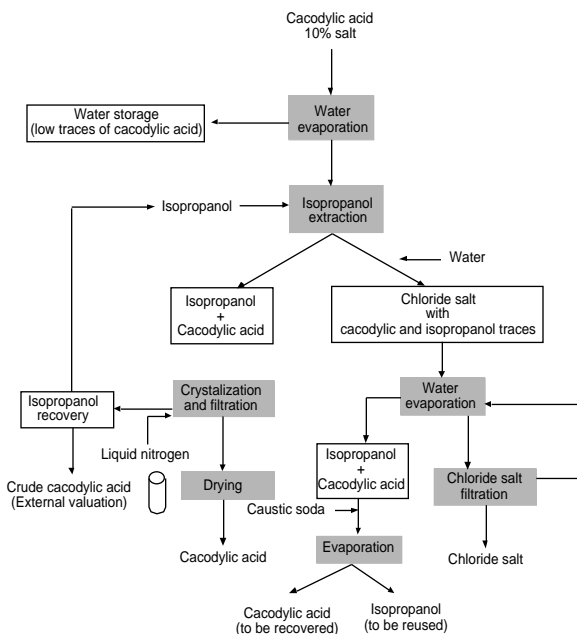
Summary of actions

A totally new approach to remove chlorides from the cacodylic acid aqueous solution feed has been implemented. Separation of chlorides is carried on by electrodialysis.

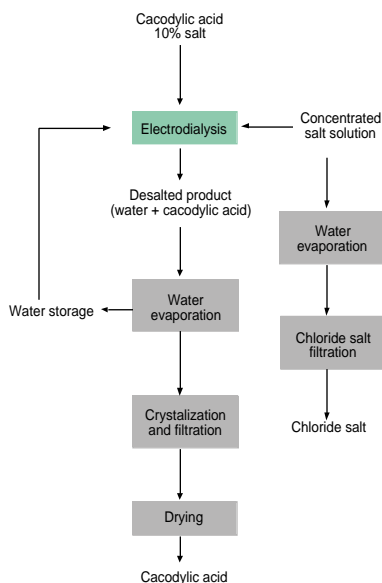
Removal of chlorides from the cacodylic acid aqueous solution feed eliminated the use of alcohol and the need to add water to the chloride salt is not required. Process (acid) yield is around 95-98%.

Diagrams

OLD PROCESS



NEW PROCESS



Balances

	OLD PROCESS (Ton/y)	NEW PROCESS (Ton/y)	SAVINGS (€/y)
Consumption of liquid nitrogen	7.2	0	3,636
Losses of cacodylic acid	0.5	0.05	6,464
Consumption of isopropanol	8.2	0	10,100
Operational costs (energy, salary, etc.)			30,300
Annual savings (€/year)			50,500
Total investment (€)			59,388
Pay-back period			14 months

Conclusions

A new technology, which is traditionally used for water desalination, was used successfully as waste reduction procedure. The most significant saving is the operational one due to rework required on the chloride salt, but not less important is safety increase by eliminating the use of alcohol. Most of the investment needed is related to extensive R&D work at the Ben Gurion University, Beer Sheva, Israel.

NOTE: This case study only seeks to illustrate a pollution prevention example and should not be taken as a general recommendation.

Case study presented by:
Ministry of the Environment
 POB 34033
 Kanfai Nesharim St.#5 (95464)
 Jerusalem (Israel)
 Tel. (+972) 2 655 37 70
 Fax (+972) 2 655 37 63



Regional Activity Centre
for Cleaner Production

Paris, 184
 08036 Barcelona (Spain)
 Tel. (+34) 93 415 11 12
 Fax (+34) 93 237 02 86
 e-mail: cleanpro@cema-sa.org
 http://www.cema-sa.org