

(12) STANDARD PATENT
(19) AUSTRALIAN PATENT OFFICE

(11) Application No. **AU 2019293885 B2**

(54) Title
Terephthalic acid esters formation

(51) International Patent Classification(s)
C07C 67/03 (2006.01) **C07C 69/82** (2006.01)
C07C 31/30 (2006.01) **C08J 11/24** (2006.01)

(21) Application No: **2019293885** (22) Date of Filing: **2019.06.24**

(87) WIPO No: **WO20/002999**

(30) Priority Data

(31) Number	(32) Date	(33) Country
62/689,597	2018.06.25	US

(43) Publication Date: **2020.01.02**

(44) Accepted Journal Date: **2024.08.29**

(71) Applicant(s)
9449710 Canada Inc.

(72) Inventor(s)
ESSADDAM, Fares;ESSADDAM, Adel

(74) Agent / Attorney
FB Rice Pty Ltd, L 33 477 Collins Street, Melbourne, VIC, 3000, AU

(56) Related Art
JP S 48-8745A
CN 104327254 A

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property

Organization

International Bureau

(43) International Publication Date

02 January 2020 (02.01.2020)



(10) International Publication Number

WO 2020/002999 A3

(51) International Patent Classification:

C07C 67/03 (2006.01) C08J 11/24 (2006.01)

C07C 31/30 (2006.01) C07C 69/82 (2006.01)

Published:

- with international search report (Art. 21(3))
- before the expiration of the time limit for amending the claims and to be republished in the event of receipt of amendments (Rule 48.2(h))

(21) International Application Number:

PCT/IB2019/000816

(22) International Filing Date:

24 June 2019 (24.06.2019)

(88) Date of publication of the international search report:

05 March 2020 (05.03.2020)

(25) Filing Language:

English

(26) Publication Language:

English

(30) Priority Data:

62/689,597 25 June 2018 (25.06.2018) US

(71) Applicant: 9449710 CANADA INC. [CA/CA]; 480 Fernand-poitras Street, Terrebonne, QC J6Y 1Y4 (CA).

(72) Inventors: ESSADDAM, Fares; 480 Fernand-poitras Street, Terrebonne, QC J6Y 1Y4 (CA). ESSADDAM, Adel; 480 Fernand-poitras Street, Terrebonne, QC J6Y 1Y4 (CA).

(81) Designated States (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM, AO, AT, AU, AZ, BA, BB, BG, BH, BN, BR, BW, BY, BZ, CA, CH, CL, CN, CO, CR, CU, CZ, DE, DJ, DK, DM, DO, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN, HR, HU, ID, IL, IN, IR, IS, JO, JP, KE, KG, KH, KN, KP, KR, KW, KZ, LA, LC, LK, LR, LS, LU, LY, MA, MD, ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PA, PE, PG, PH, PL, PT, QA, RO, RS, RU, RW, SA, SC, SD, SE, SG, SK, SL, SM, ST, SV, SY, TH, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

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

Declarations under Rule 4.17:

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

(54) Title: TEREPHTHALIC ACID ESTERS FORMATION

(57) Abstract: The present disclosure relates to the formation of a terephthalate by depolymerization of polyethylene terephthalate (PET) using a glycoxide catalyst. Preferably, the reaction is carried out in methanol, the glycoxide is monosodium glycoxide and the terephthalate product is dimethyl terephthalate (DMT). The monosodium glycoxide catalyst is preferably prepared as a suspension by reacting sodium hydroxide with monoethylene glycol, isolating the product, and then suspending it in a suspending solvent.



WO 2020/002999 A3

TEREPHTHALIC ACID ESTERS FORMATION

CROSS-REFERENCE

[0001] This application claims the benefit of U. S. Provisional Application Serial No. 62/689,597 filed June 25, 2018 which is hereby incorporated by reference in its entirety.

FIELD OF THE INVENTION

[0002] The present disclosure relates to the formation of ester derivatives from polyesters and more specifically to the formation of terephthalic acid esters from polyethylene terephthalate (PET). The present disclosure also relates to the formation of dimethyl terephthalate (DMT).

BACKGROUND OF THE INVENTION

[0003] The polyethylene terephthalate (PET) bottle resin market has been growing strongly as PET resins have replaced glass in carbonated soft drink, bottled water and food containers.

[0004] Dimethyl terephthalate (DMT) is primarily used in the manufacture of polyethylene terephthalate (PET) for fiber, film, container plastics, and specialty plastics applications.

[0005] The largest polyester sector is the fibers market where it is used to make clothes, home textiles such as sheets and curtains, carpets and rugs, and industrial products such as tire cord, seat belts, hoses and ropes. PET film is utilized in electrical applications such as dielectric metal foil capacitors and for food packaging.

[0006] The growth in polyester has not been converted into DMT demand. For most grades of polyester used in textiles and food and beverage containers, it is more economical to use purified terephthalic acid rather than DMT.

SUMMARY OF THE INVENTION

[0007] Disclosed herein is a process for the depolymerization of polyethylene terephthalate (PET) to form a terephthalate; the process comprising admixing polyethylene terephthalate (PET) with a mixture comprising a glycoxide.

[0008] In some embodiments of the process, the mixture further comprises a solvent.

[0009] In some embodiments of the process, the solvent is selected from methanol, ethanol, n-propanol, isopropanol, t-butanol, ethylene glycol, glycerol, cyclohexane-1,4-dimethanol, phenol, benzyl alcohol, and any combinations thereof. In some embodiments of the process, the solvent is methanol.

[0010] In some embodiments of the process, the solvent is added to the polyethylene terephthalate (PET) prior to the addition of the glycoxide.

[0011] In some embodiments of the process, the polyethylene terephthalate (PET) is mixed with the solvent prior to the addition of the glycoxide for about 15 mins to about 120 mins. In some embodiments of the process, the polyethylene terephthalate (PET) is mixed with the solvent prior to the addition of the glycoxide for about 60 min.

[0012] In some embodiments of the process, the polyethylene terephthalate (PET) is mixed with the solvent prior to the addition of the glycoxide at a temperature between about 50 °C to about 100 °C. In some embodiments of the process, the polyethylene terephthalate (PET) is mixed with the solvent prior to the addition of the glycoxide at a temperature of about 60 °C.

[0013] In some embodiments of the process, the terephthalate is dimethyl terephthalate (DMT).

[0014] In some embodiments of the process, the glycoxide is sodium glycoxide. In some embodiments of the process, the glycoxide is mono sodium glycoxide. In some embodiments of the process, sodium glycoxide is provided as a suspension.

[0015] In some embodiments of the process, the mono sodium glycoxide suspension is prepared by a process comprising:

- a) heating mono ethylene glycol;
- b) adding sodium hydroxide thereby forming mono sodium glycoxide;
- c) drying the mono sodium glycoxide;
- d) suspending the dried mono sodium glycoxide into a suspending solvent; and
- e) aging the suspension.

[0016] In some embodiments of the process, step (a) is performed at a temperature between about 70 °C to about 100 °C. In some embodiments of the process, step (a) is performed at a temperature of about 90 °C.

[0017] In some embodiments of the process, the ratio of mono sodium glycoxide to the suspending solvent is between about 0.05:1 to about 0.5: 1 (mol/mol).

[0018] In some embodiments of the process, the ratio of mono sodium glycoxide to the suspending solvent is about 0.2:1 (mol/mol).

[0019] In some embodiments of the process, the suspending solvent is methanol.

[0020] In some embodiments of the process, the suspension is aged for about 1-14 days. In some embodiments of the process, the suspension is aged for about 1-7 days. In some embodiments of the process, the suspension is aged for about 7 days.

[0021] In some embodiments of the process, the ratio of glycoxide to polyethylene terephthalate (PET) is between about 1:2 and about 1:20 (mol/mol).

[0022] In some embodiments of the process, the ratio of glycoxide to polyethylene terephthalate (PET) is between about 1:5 and about 1:20 (mol/mol).

[0023] In some embodiments of the process, the ratio of glycoxide to polyethylene terephthalate (PET) is between about 1:10 and about 1:20 (mol/mol).

[0024] In some embodiments of the process, the ratio of glycoxide to polyethylene terephthalate (PET) is between about 1:10 and about 1:15 (mol/mol).

[0025] In some embodiments of the process, the terephthalate is obtained in at least about 90 mol% yield. In some embodiments of the process, the terephthalate is obtained in at least about 95 mol% yield. In some embodiments of the process, the terephthalate is obtained in at least about 99 mol% yield.

[0026] In some embodiments of the process, the process further yields mono ethylene glycol. In some embodiments of the process, the mono ethylene glycol is obtained in at least about 80 mol% yield. In some embodiments of the process, the mono ethylene glycol is obtained in at least about 85 mol% yield.

[0027] Disclosed herein is a process for the depolymerization of polyethylene terephthalate (PET) to form a terephthalate; the process comprising:

- (i) admixing the polyethylene terephthalate (PET) with a first solvent to yield a first mixture;
 - (ii) adding a glycoxide to the first mixture;
 - (iii) adding a second solvent; and
 - (iv) admixing;
- thereby forming the terephthalate.

[0028] In some embodiments of the process, the terephthalate is dimethyl terephthalate (DMT).

[0029] In some embodiments of the process, the first solvent is selected from methanol, ethanol, n-propanol, isopropanol, t-butanol, ethylene glycol, glycerol, cyclohexane-1,4-dimethanol, phenol, benzyl alcohol, and any combinations thereof. In some embodiments of the process, the first solvent is methanol.

[0030] In some embodiments of the process, step (i) is performed for about 15 mins to about 120 mins. In some embodiments of the process, step (i) is performed for about 60 min.

[0031] In some embodiments of the process, step (i) is performed at a temperature between about 50 °C to about 100 °C. In some embodiments of the process, step (i) is performed at a temperature of about 60 °C.

[0032] In some embodiments of the process, a portion of the first solvent is removed prior to step (ii) to yield a second mixture.

[0033] In some embodiments of the process, the second mixture is heated at a temperature between about 70 °C to about 100 °C.

[0034] In some embodiments of the process, the second mixture is heated at a temperature of about 85 °C.

[0035] In some embodiments of the process, the glycoxide is sodium glycoxide. In some embodiments of the process, the glycoxide is mono sodium glycoxide. In some embodiments of the process, the mono sodium glycoxide is provided as a suspension in a suspending solvent.

[0036] In some embodiments of the process, the mono sodium glycoxide suspension is prepared by a process comprising:

- a) heating mono ethylene glycol;
- b) adding sodium hydroxide thereby forming mono sodium glycoxide;
- c) drying the mono sodium glycoxide;
- d) suspending the dried mono sodium glycoxide in a suspending solvent; and
- e) aging the suspension.

[0037] In some embodiments of the process, step (a) is performed at a temperature between about 70 °C to about 100 °C. In some embodiments of the process, step (a) is performed at a temperature of about 90 °C.

[0038] In some embodiments of the process, the ratio of mono sodium glycoxide to the suspending solvent is between about 0.05:1 to about 0.5: 1 (mol/mol).

[0039] In some embodiments of the process, the ratio of mono sodium glycoxide to the suspending solvent is about 0.2:1 (mol/mol).

[0040] In some embodiments of the process, the suspending solvent is methanol.

[0041] In some embodiments of the process, the suspension is aged for about 1-14 days. In some embodiments of the process, the suspension is aged for about 1-7 days. In some embodiments of the process, the suspension is aged for about 7 days.

[0042] In some embodiments of the process, the ratio of glycoxide to polyethylene terephthalate (PET) is between about 1:2 and about 1:20 (mol/mol). In some embodiments of the process, the ratio of glycoxide to polyethylene terephthalate (PET) is between about 1:5 and about 1:20 (mol/mol). In some embodiments of the process, the ratio of glycoxide to polyethylene terephthalate (PET) is between about 1:10 and about 1:20 (mol/mol). In some embodiments of the process, the ratio of glycoxide to polyethylene terephthalate (PET) is between about 1:10 and about 1:15 (mol/mol).

[0043] In some embodiments of the process, the second solvent is selected from methanol, ethanol, n-propanol, isopropanol, t-butanol, ethylene glycol, glycerol, cyclohexane-1,4-dimethanol, phenol, benzyl alcohol, and any combinations thereof. In some embodiments of the process, the second solvent is methanol.

[0044] In some embodiments of the process, step (iv) is performed for about 60 mins to about 600 mins. In some embodiments of the process, step (iv) is performed for about 360 min.

[0045] In some embodiments of the process, step (iv) is performed at a temperature between about 70 °C to about 100 °C. In some embodiments of the process, step (iv) is performed at a temperature of about 85 °C.

[0046] In some embodiments of the process, the process further comprises step (v) filtrating the terephthalate.

[0047] In some embodiments of the process, the terephthalate is obtained in at least about 90 mol% yield. In some embodiments of the process, the terephthalate is obtained in at least about 95 mol% yield. In some embodiments of the process, the terephthalate is obtained in at least about 99 mol% yield.

[0048] In some embodiments of the process, the process further yields mono ethylene glycol. In some embodiments of the process, the mono ethylene glycol is obtained in at least about 80 mol% yield. In some embodiments of the process, the mono ethylene glycol is obtained in at least about 85 mol% yield.

[0049] Also disclosed herein is process for preparing a mono sodium glycoxide suspension; the process comprising:

- a) heating mono ethylene glycol;
- b) adding sodium hydroxide thereby forming mono sodium glycoxide;
- c) drying the mono sodium glycoxide;
- d) suspending the dried mono sodium glycoxide into a suspending solvent; and
- e) aging the suspension.

[0050] In some embodiments of the process, step (a) is performed at a temperature between about 70 °C to about 100 °C. In some embodiments of the process, step (a) is performed at a temperature of about 90 °C.

[0051] In some embodiments of the process, the ratio of mono sodium glycoxide to the suspending solvent is between about 0.05:1 to about 0.5: 1 (mol/mol). In some embodiments of the process, the ratio of mono sodium glycoxide to the suspending solvent is about 0.2:1 (mol/mol).

[0052] In some embodiments of the process, the suspending solvent is methanol.

[0053] In some embodiments of the process, the suspension is aged for about 1-14 days. In some embodiments of the process, the suspension is aged for about 1-7 days. In some embodiments of the process, the suspension is aged for about 7 days.

DETAILED DESCRIPTION OF THE INVENTION

[0054] Dimethyl terephthalate (DMT) is used in the production of polyesters, including polyethylene terephthalate (PET), polytrimethylene terephthalate (PTT), and polybutylene terephthalate (PBT). Because DMT is volatile, it is an intermediate in some schemes for the recycling of PET, e.g. from plastic bottles. Hydrogenation of DMT affords the diol 1, 4-cyclohexanedimethanol, which is a useful monomer in the formation of polyester resins.

[0055] DMT has been produced in a number of ways. Conventionally and still of commercial value is the direct esterification of terephthalic acid. Alternatively, it is prepared by alternating oxidation and methyl-esterification steps from para-xylene via methyl para-toluate. The method for the production of DMT from para-xylene and methanol consists of four major steps: oxidation, esterification, distillation, and crystallization. A mixture of para-xylene and para-toluic ester is oxidized with air in the presence of a transition metal catalyst (Co/Mn). The acid mixture resulting from the oxidation is esterified with methanol to produce a mixture of esters. The crude ester mixture is distilled to remove all the heavy boilers and residue produced; the lighter esters are recycled to the oxidation section. The raw DMT is then crystallized to remove DMT isomers, residual acids, and aromatic aldehydes.

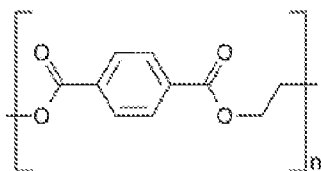
[0056] An Improvement in DMT production from PET recycling: due to the growing use of PET and PETG in the packaging and fiber (carpet and other textile) industries there is a need for an efficient, low energy, high yielding, and cost effective way to form DMT from PET or PETG.

POLYESTERS

[0057] Described herein is a process for the transformation of a polyester into an ester derivative; the process comprising admixing the polyester with a mixture comprising a glycoxide.

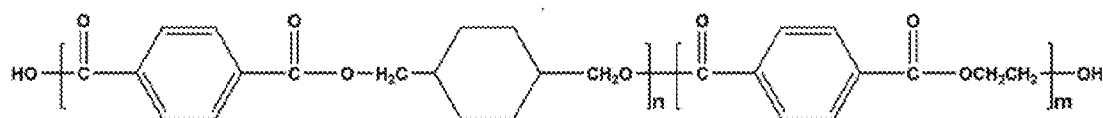
[0058] In some embodiments, the polyester is selected from polyethylene terephthalate (PET), poly(ethylene glycol-co-1,4-cyclohexanedimethanol terephthalate) (PETG), polyglycolide or polyglycolic acid (PGA), polylactic acid (PLA), polycaprolactone (PCL), polyhydroxybutyrate (PHB), polyethylene adipate (PEA), polybutylene succinate (PBS), poly(3-hydroxybutyrate-co-3-hydroxyvalerate) (PHBV), polybutylene terephthalate (PBT), polytrimethylene terephthalate (PTT), polyethylene naphthalate (PEN), Vectran[®], cutin, and any combinations thereof.

[0059] In some embodiments, the polyester is polyethylene terephthalate (PET):

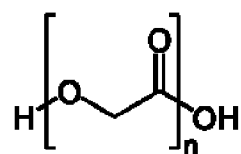


[0060] In some embodiments, the polyester is a terephthalic acid/ethylene glycol oligomer.

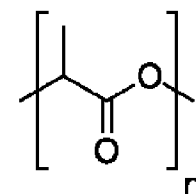
[0061] In some embodiments, the polyester is poly(ethylene glycol-co-1,4-cyclohexanedimethanol terephthalate) (PETG):



[0062] In some embodiments, the polyester is polyglycolide or polyglycolic acid (PGA),



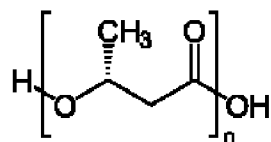
[0063] In some embodiments, the polyester is polylactic acid (PLA):



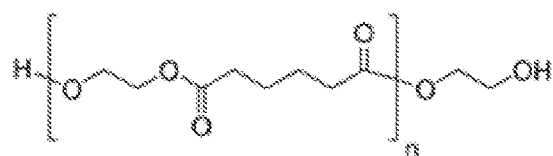
[0064] In some embodiments, the polyester is polycaprolactone (PCL):



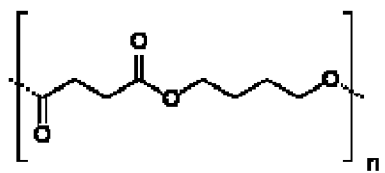
[0065] In some embodiments, the polyester is polyhydroxybutyrate (PHB):



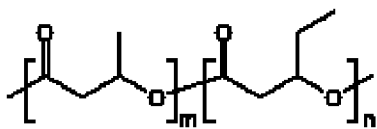
[0066] In some embodiments, the polyester is polyethylene adipate (PEA):



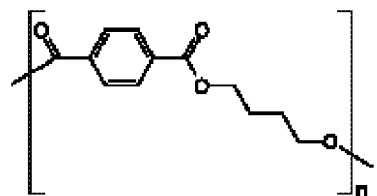
[0067] In some embodiments, the polyester is polybutylene succinate (PBS):



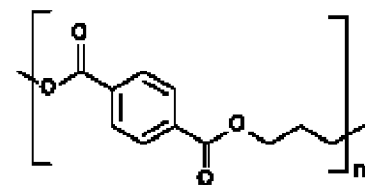
[0068] In some embodiments, the polyester is poly(3-hydroxybutyrate-co-3-hydroxyvalerate) (PHBV):



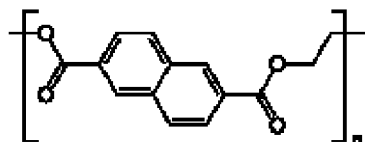
[0069] In some embodiments, the polyester is polybutylene terephthalate (PBT):



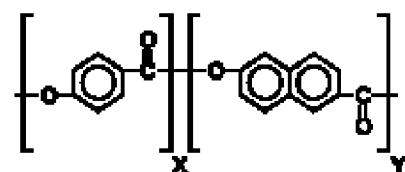
[0070] In some embodiments, the polyester is polytrimethylene terephthalate (PTT):



[0071] In some embodiments, the polyester is polyethylene naphthalate (PEN):



[0072] In some embodiments, the polyester is Vectran[®]:



[0073] In some embodiments, the polyester is cutin. Cutin is one of two waxy polymers that are the main components of the plant cuticle, which covers all aerial surfaces of plants. Cutin consists of omega hydroxy acids and their derivatives, which are interlinked via ester bonds, forming a polyester polymer. There are two major monomer families of cutin, the C16 and C18 families. The C16 family consists mainly of 16-hydroxy palmitic acid and 9,16- or 10,16-dihydroxypalmitic acid. The C18 family consists mainly of 18-hydroxy oleic acid, 9,10-epoxy-18-hydroxy stearic acid, and 9,10,18-trihydroxystearate. Tomato cutin consists of 16-hydroxy palmitic acid and 10,16-dihydroxypalmitic acid where the 10-isomer is largely dominant. The tomato cutin is a polyester biopolymer interesterified. The significant proportion of

secondary esters (esterification in the C-10 secondary hydroxyl) shows that the polyester structure is significantly branched.

ESTER DERIVATIVES

[0074] Described herein is a process for the transformation of a polyester into an ester derivative; the process comprising admixing the polyester with a mixture comprising a glycoxide.

[0075] In some embodiments, the polyester is polyglycolide or polyglycolic acid (PGA) and the ester derivative is a 2-hydroxyacetate derivative. In some embodiments, the ester derivative is methyl 2-hydroxyacetate.

[0076] In some embodiments, the polyester is polylactic acid (PLA) and the ester derivative is a 2-hydroxypropanoate derivative. In some embodiments, the ester derivative is methyl 2-hydroxypropanoate.

[0077] In some embodiments, the polyester is polycaprolactone (PCL) and the ester derivative is a 6-hydroxyhexanoate derivative. In some embodiments, the ester derivative is a methyl 6-hydroxyhexanoate.

[0078] In some embodiments, the polyester is polyhydroxybutyrate (PHB) and the ester derivative is a hydroxybutyrate derivative. In some embodiments, the ester derivative is methyl hydroxybutyrate.

[0079] In some embodiments, the polyester is polyethylene adipate (PEA) and the ester derivative is an adipate derivative. In some embodiments, the ester derivative is dimethyl adipate.

[0080] In some embodiments, the polyester is polybutylene succinate (PBS) and the ester derivative is a succinate derivative. In some embodiments, the ester derivative is dimethyl succinate.

[0081] In some embodiments, the polyester is poly(3-hydroxybutyrate-*co*-3-hydroxyvalerate) (PHBV) and the ester derivative is a hydroxybutyrate derivative, a hydroxyvalerate derivative, or a combination thereof. In some embodiments, the ester derivative is methyl hydroxybutyrate, methyl hydroxyvalerate, or a combination thereof.

[0082] In some embodiments, the polyester is polyethylene naphthalate (PEN) and the ester derivative is a naphthalate derivative. In some embodiments, the ester derivative is dimethyl naphthalate.

[0083] In some embodiments, the polyester is vectran and the ester derivative is a naphthoate derivative, a benzoate derivative, or a combination thereof. In some embodiments, the ester derivative is methyl hydroxynaphthoate or methyl hydroxybenzoate.

[0084] In some embodiments, the polyester is cutin and the ester derivative is a hydroxypalmitate or a dihydroxypalmitate derivative. In some embodiments, the ester derivative is methyl hydroxypalmitate or methyl dihydroxypalmitate.

[0085] In some embodiments, the polyester is polyethylene terephthalate (PET), poly(ethylene glycol-*co*-1,4-cyclohexanedimethanol terephthalate) (PETG), polytrimethylene terephthalate (PTT), or polybutylene terephthalate (PBT) and the ester derivative is a terephthalate. In some embodiments, the terephthalate is dimethyl terephthalate. In some embodiments, the terephthalate is diethyl terephthalate.

[0086] In some embodiments, the ester derivative contains less than about 10% impurity (w/w). In some embodiments, the ester derivative contains less than about 9% impurity (w/w). In some embodiments, the

ester derivative contains less than about 8% impurity (w/w). In some embodiments, the ester derivative contains less than about 7% impurity (w/w). In some embodiments, the ester derivative contains less than about 6% impurity (w/w). In some embodiments, the ester derivative contains less than about 5% impurity (w/w). In some embodiments, the ester derivative contains less than about 4% impurity (w/w). In some embodiments, the ester derivative contains less than about 3% impurity (w/w). In some embodiments, the ester derivative contains less than about 2% impurity (w/w). In some embodiments, the ester derivative contains less than about 1% impurity (w/w). In some embodiments, the ester derivative contains less than about 0.5% impurity (w/w). In some embodiments, the ester derivative contains less than about 0.4% impurity (w/w). In some embodiments, the ester derivative contains less than about 0.3% impurity (w/w). In some embodiments, the ester derivative contains less than about 0.2% impurity (w/w). In some embodiments, the ester derivative contains less than about 0.1% impurity (w/w).

[0087] In some embodiments, the ester derivative contains less than about 250 ppm of any metals, less than about 240 ppm of any metals, less than about 230 ppm of any metals, less than about 220 ppm of any metals, less than about 210 ppm of any metals, less than about 200 ppm of any metals, less than about 190 ppm of any metals, less than about 180 ppm of any metals, less than about 170 ppm of any metals, less than about 160 ppm of any metals, less than about 150 ppm of any metals, less than about 140 ppm of any metals, less than about 130 ppm of any metals, less than about 120 ppm of any metals, less than about 110 ppm of any metals, less than about 100 ppm of any metals, less than about 90 ppm of any metals, less than about 80 ppm of any metals, less than about 70 ppm of any metals, less than about 60 ppm of any metals, less than about 50 ppm of any metals, less than about 40 ppm of any metals, less than about 30 ppm of any metals, less than about 20 ppm of any metals, less than about 10 ppm of any metals, less than about 5 ppm of any metals, less than about 4 ppm of any metals, less than about 3 ppm of any metals, less than about 2 ppm of any metals, less than about 1 ppm of any metals, less than about 0.9 ppm of any metals, less than about 0.8 ppm of any metals, less than about 0.7 ppm of any metals, less than about 0.6 ppm of any metals, less than about 0.5 ppm of any metals, less than about 0.4 ppm of any metals, less than about 0.3 ppm of any metals, less than about 0.2 ppm of any metals, less than about 0.1 ppm of any metals, less than about 0.09 ppm of any metals, less than about 0.08 ppm of any metals, less than about 0.07 ppm of any metals, less than about 0.06 ppm of any metals, less than about 0.05 ppm of any metals, less than about 0.04 ppm of any metals, less than about 0.03 ppm of any metals, less than about 0.02 ppm of any metals, or less than about 0.01 ppm of any metals.

[0088] In some embodiments, the ester derivative contains less than about 10 ppm of glycoxide, less than about 5 ppm of glycoxide, less than about 4 ppm of glycoxide, less than about 3 ppm of glycoxide, less than about 2 ppm of glycoxide, less than about 1 ppm of glycoxide, less than about 0.9 ppm of glycoxide, less than about 0.8 ppm of glycoxide, less than about 0.7 ppm of glycoxide, less than about 0.6 ppm of glycoxide, less than about 0.5 ppm of glycoxide, less than about 0.4 ppm of glycoxide, less than about 0.3 ppm of glycoxide, less than about 0.2 ppm of glycoxide, less than about 0.1 ppm of glycoxide, less than about 0.09 ppm of glycoxide, less than about 0.08 ppm of glycoxide, less than about 0.07 ppm of glycoxide,

less than about 0.06 ppm of glycoxide, less than about 0.05 ppm of glycoxide, less than about 0.04 ppm of glycoxide, less than about 0.03 ppm of glycoxide, less than about 0.02 ppm of glycoxide, or less than about 0.01 ppm of glycoxide.

[0089] In some embodiments, the ester derivative is obtained in between about 80 and about 99 mol% yield. In some embodiments, the ester derivative is obtained in between about 85 and about 99 mol% yield. In some embodiments, the ester derivative is obtained in between about 90 and about 99 mol% yield. In some embodiments, the ester derivative is obtained in at least about 90 mol% yield. In some embodiments, the ester derivative is obtained in at least about 95 mol% yield. In some embodiments, the ester derivative is obtained in at least about 99 mol% yield.

[0090] In some embodiments, the terephthalate is obtained in between about 80 and about 99 mol% yield. In some embodiments, the terephthalate is obtained in between about 85 and about 99 mol% yield. In some embodiments, the terephthalate is obtained in between about 90 and about 99 mol% yield. In some embodiments, the terephthalate is obtained in at least about 80 mol% yield. In some embodiments, the terephthalate is obtained in at least about 85 mol% yield. In some embodiments, the terephthalate is obtained in at least about 90 mol% yield. In some embodiments, the terephthalate is obtained in at least about 95 mol% yield. In some embodiments, the terephthalate is obtained in at least about 99 mol% yield.

GLYCOL

[0091] Described herein is a process for the transformation of a polyester into an ester derivative and a glycol; the process comprising admixing the polyester with a mixture comprising a glycoxide. In some embodiments, the glycol is mono ethylene glycol (MEG) (or ethylene glycol). In some embodiments, the glycol is propylene glycol. In some embodiments, the glycol is butylene glycol.

[0092] In some embodiments, the glycol is obtained in between about 80 and about 99 mol% yield. In some embodiments, the glycol is obtained in between about 85 and about 99 mol% yield. In some embodiments, the glycol is obtained in between about 90 and about 99 mol% yield. In some embodiments, the glycol is obtained in at least about 80 mol% yield. In some embodiments, the glycol is obtained in at least about 85 mol% yield. In some embodiments, the glycol is obtained in at least about 90 mol% yield. In some embodiments, the glycol is obtained in at least about 95 mol% yield.

GLYCOXIDE

[0093] In some embodiments, the process described herein comprises an alkoxide which is derived from an alcohol with a boiling point higher than water. In some embodiments, the alcohol is mono ethylene glycol (MEG), glycerol, sorbitol, 1,3-propanediol, or cyclohexane-1,4-dimethanol. In some embodiments, the alcohol is mono ethylene glycol (MEG).

[0094] In some embodiments, the process described herein comprises an alkoxide which is cost efficient. In some embodiments, the process described herein comprises the use of an alkoxide in an amount that provides a cost savings compared to other catalysts such as sodium methoxide as a weight-weight ratio. In

some embodiments, the process described herein comprises the use of sodium glycoxide in an amount that provides a cost savings compared to other catalysts such as sodium methoxide as a weight-weight ratio. In some embodiments, the process described herein comprises an alkoxide that is able to undergo an exchange with methanol to results in sodium methoxide.

[0095] In some embodiments, the process described herein comprises a glycoxide. In some embodiments, the process described herein comprises a catalytic amount of a glycoxide. In some embodiments, the process described herein comprises a sub-stoichiometric amount of a glycoxide.

[0096] “Sub-stoichiometric amount”, as used herein, is used to indicate that the amount of material used is less than a stoichiometric amount. The term is used herein interchangeably with “catalytic amount.” In some embodiments, a sub-stoichiometric amount is less than or equal to about 95% of a stoichiometric amount. In some embodiments, a sub-stoichiometric amount is less than or equal to about 90% of a stoichiometric amount. In some embodiments, a sub-stoichiometric amount is less than or equal to about 85% of a stoichiometric amount. In some embodiments, a sub-stoichiometric amount is less than or equal to about 80% of a stoichiometric amount. In some embodiments, a sub-stoichiometric amount is less than or equal to about 75% of a stoichiometric amount. In some embodiments, a sub-stoichiometric amount is less than or equal to about 70% of a stoichiometric amount. In some embodiments, a sub-stoichiometric amount is less than or equal to about 65% of a stoichiometric amount. In some embodiments, a sub-stoichiometric amount is less than or equal to about 60% of a stoichiometric amount. In some embodiments, a sub-stoichiometric amount is less than or equal to about 55% of a stoichiometric amount. In some embodiments, a sub-stoichiometric amount is less than or equal to about 50% of a stoichiometric amount. In some embodiments, a sub-stoichiometric amount is less than or equal to about 45% of a stoichiometric amount. In some embodiments, a sub-stoichiometric amount is less than or equal to about 40% of a stoichiometric amount. In some embodiments, a sub-stoichiometric amount is less than or equal to about 35% of a stoichiometric amount. In some embodiments, a sub-stoichiometric amount is less than or equal to about 30% of a stoichiometric amount. In some embodiments, a sub-stoichiometric amount is less than or equal to about 25% of a stoichiometric amount. In some embodiments, a sub-stoichiometric amount is less than or equal to about 20% of a stoichiometric amount. In some embodiments, a sub-stoichiometric amount is less than or equal to about 15% of a stoichiometric amount. In some embodiments, a sub-stoichiometric amount is less than or equal to about 10% of a stoichiometric amount.

[0097] “Stoichiometric amount”, as used herein, is used to indicate that the amount of material used is equivalent to the number of ester linkages present in the polyester.

[0098] In some embodiments, the glycoxide, which comprises a glycoxide anion and a cation, is selected from an alkali metal glycoxide, an alkaline earth metal glycoxide, a metal glycoxide, an ammonium glycoxide, and any combinations thereof. In some embodiments, the cation is lithium, sodium, potassium, magnesium, calcium, strontium, barium, zinc, aluminum, or ammonium. In some embodiments, the glycoxide is sodium glycoxide. In some embodiments, the glycoxide is mono sodium glycoxide.

[0099] In some embodiments, the glycoxide is generated by addition of an alkali metal, an alkaline earth metal, or a metal to mono ethylene glycol (MEG). In some embodiments, the glycoxide is generated by addition of sodium hydroxyde to mono ethylene glycol (MEG).

[00100] In some embodiments, the glycoxide is provided as a suspension.

[00101] Disclosed herein is a process for preparing a mono sodium glycoxide suspension, the process comprising:

- a) heating mono ethylene glycol;
- b) adding sodium hydroxide thereby forming mono sodium glycoxide;
- c) drying the mono sodium glycoxide;
- d) suspending the dried mono sodium glycoxide into a suspending solvent; and
- e) aging the suspension.

[00102] In some embodiments, the suspending solvent is an alcohol. In some embodiments, the suspending solvent is methanol.

[00103] In some embodiments, step (a) is performed at a temperature between about 70 °C to about 100 °C. In some embodiments, step (a) is performed at a temperature between about 70 °C to about 90 °C. In some embodiments, step (a) is performed at a temperature between about 80 °C to about 100 °C. In some embodiments, step (a) is performed at a temperature of about 70 °C, about 75 °C, about 80 °C, about 85 °C, about 90 °C, about 95 °C, or about 100 °C. In some embodiments, step (a) is performed at a temperature of about 90 °C.

[00104] In some embodiments, the ratio of mono sodium glycoxide to the suspending solvent is between about 0.05:1 to about 0.5: 1 (mol/mol). In some embodiments, the ratio of mono sodium glycoxide to the suspending solvent is between about 0.1:1 to about 0.5: 1 (mol/mol). In some embodiments, the ratio of mono sodium glycoxide to the suspending solvent is between about 0.1:1 to about 0.3: 1 (mol/mol). In some embodiments, the ratio of mono sodium glycoxide to the suspending solvent is about 0.05:1 (mol/mol), about 0.06:1 (mol/mol), about 0.07:1 (mol/mol), about 0.08:1 (mol/mol), about 0.09:1 (mol/mol), about 0.1:1 (mol/mol), about 0.11:1 (mol/mol), about 0.12:1 (mol/mol), about 0.13:1 (mol/mol), about 0.14:1 (mol/mol), about 0.15:1 (mol/mol), about 0.16:1 (mol/mol), about 0.17:1 (mol/mol), about 0.18:1 (mol/mol), about 0.19:1 (mol/mol), about 0.2:1 (mol/mol), about 0.21:1 (mol/mol), about 0.22:1 (mol/mol), about 0.23:1 (mol/mol), about 0.24:1 (mol/mol), about 0.25:1 (mol/mol), about 0.26:1 (mol/mol), about 0.27:1 (mol/mol), about 0.28:1 (mol/mol), about 0.29:1 (mol/mol), about 0.30:1 (mol/mol), about 0.35:1 (mol/mol), about 0.40:1 (mol/mol), about 0.45:1 (mol/mol), or about 0.5:1 (mol/mol). In some embodiments, the ratio of mono sodium glycoxide to the suspending solvent is about 0.2:1 (mol/mol).

[00105] In some embodiments, the ratio of glycoxide to polyethylene terephthalate (PET) is between about 1:2 and about 1:20 (mol/mol). In some embodiments, the ratio of glycoxide to polyethylene terephthalate (PET) is between about 1:2 and about 1:10 (mol/mol). In some embodiments, the ratio of glycoxide to polyethylene terephthalate (PET) is between about 1:2 and about 1:6 (mol/mol). In some embodiments, the ratio of glycoxide to polyethylene terephthalate (PET) is between about 1:5 and about 1:20 (mol/mol). In

some embodiments, the ratio of glycoxide to polyethylene terephthalate (PET) is between about 1:10 and about 1:20 (mol/mol). In some embodiments, the ratio of glycoxide to polyethylene terephthalate (PET) is between about 1:10 and about 1:15 (mol/mol). In some embodiments, the ratio of glycoxide to polyethylene terephthalate (PET) is about 1:2 (mol/mol), about 1:3 (mol/mol), about 1:4 (mol/mol), about 1:5 (mol/mol), about 1:6 (mol/mol), about 1:7 (mol/mol), about 1:8 (mol/mol), about 1:9 (mol/mol), about 1:10 (mol/mol), about 1:11 (mol/mol), about 1:12 (mol/mol), about 1:13 (mol/mol), about 1:14 (mol/mol), about 1:15 (mol/mol), about 1:16 (mol/mol), about 1:17 (mol/mol), about 1:18 (mol/mol), about 1:19 (mol/mol), or about 1:2 (mol/mol).

[00106] In some embodiments, the mono sodium glycoxide is dried to remove water formed during the reaction. In some embodiments, the mono sodium glycoxide is dried at a temperature higher than the boiling point of water. In some embodiments, the mono sodium glycoxide is dried at a temperature between about 100 °C and about 150 °C. In some embodiments, the mono sodium glycoxide is dried at a temperature between about 110 °C and about 140 °C. In some embodiments, the mono sodium glycoxide is dried at a temperature between about 120 °C and about 130 °C. In some embodiments, the mono sodium glycoxide is dried at a temperature of about 100 °C, about 105 °C, about 110 °C, about 115 °C, about 120 °C, about 125 °C, about 130 °C, about 135 °C, about 140 °C, about 145 °C, or about 150 °C. In some embodiments, the mono sodium glycoxide is dried at about 130 °C.

[00107] In some embodiments, the suspension is aged for about 1 day to about 2 months. In some embodiments, the suspension is aged for about 1-14 days. In some embodiments, the suspension is aged for about 7-14 days. In some embodiments, the suspension is aged for about 5-8 days. In some embodiments, the suspension is aged for about 1-7 days. In some embodiments, the suspension is aged for about 1 day, about 2 days, about 3 days, about 4 days, about 5 days, about 6 days, about 7 days, about 8 days, about 9 days, about 10 days, about 11 days, about 12 days, about 13 days, or about 14 days. In some embodiments, the suspension is aged for about 7 days. In some embodiments, “aged” as used herein means stored at room temperature and ambient pressure. In some embodiments, the aging step allows for a fraction of the sodium glycoxide to convert to sodium methoxide. In some embodiments, the aged glycoxide suspension comprises up to about 85% of sodium methoxide. In some embodiments, the aged glycoxide suspension comprises up to about 85%, up to about 80%, up to about 75%, up to about 70%, up to about 65%, up to about 60%, up to about 55%, up to about 50%, up to about 45%, up to about 40%, up to about 45%, up to about 40%, up to about 35%, up to about 30%, up to about 25%, up to about 20%, up to about 15%, up to about 10%, or up to about 5% of sodium methoxide.

DEPOLYMERIZATION

[00108] Described herein is a process for the transformation of a polyester into an ester derivative; the process comprising admixing the polyester with a mixture comprising a glycoxide. Described herein is process for the depolymerization of polyethylene terephthalate (PET) to form a terephthalate; the process comprising admixing polyethylene terephthalate (PET) with a mixture comprising a glycoxide.

[00109] In some embodiments, the mixture further comprises a solvent.

[00110] In some embodiments, the solvent comprises a linear alcohol, branched alcohol, cyclic alcohol, or any combinations thereof. In some embodiments, the solvent is selected from methanol, ethanol, n-propanol, isopropanol, t-butanol, ethylene glycol, glycerol, cyclohexane-1,4-dimethanolphenol, benzyl alcohol, and any combinations thereof.

[00111] In some embodiments, the solvent is a linear C₁-C₄ alcohol. In some embodiments, the solvent is methanol, ethanol, propanol, butanol, or a combination thereof. In some embodiments, the solvent is methanol, ethanol, propanol, or a combination thereof. In some embodiments, the solvent is methanol. In some embodiments, the alcohol is ethanol. In some embodiments, the solvent is a branched C₃-C₄ alcohol. In some embodiments, the solvent is t-butanol, s-butanol, i-butanol, i-propanol, or any combinations thereof. In some embodiments, the solvent is a cyclic C₃-C₈ alcohol. In some embodiments, the solvent is cyclopropanol, cyclobutanol, cyclopentanol, cyclohexanol, cycloheptanol, cyclohexane-1,4-dimethanol, or any combinations thereof. In some embodiments, the solvent is cyclohexane-1,4-dimethanol.

[00112] In some embodiments, the solvent is a polyol. In some embodiments, the solvent is selected from ethylene glycol, glycerol, and any combinations thereof. In some embodiments, the solvent is selected from phenol, benzyl alcohol, and any combinations thereof.

[00113] In some embodiments, the solvent is added to the polyethylene terephthalate (PET) prior to the addition of the glycoxide. In some embodiments, the polyethylene terephthalate (PET) is mixed with the solvent prior to the addition of the glycoxide for about 15 mins to about 120 mins. In some embodiments, the polyethylene terephthalate (PET) is mixed with the solvent prior to the addition of the glycoxide for about 15 mins to about 90 mins. In some embodiments, the polyethylene terephthalate (PET) is mixed with the solvent prior to the addition of the glycoxide for about 30 mins to about 90 mins. In some embodiments, the polyethylene terephthalate (PET) is mixed with the solvent prior to the addition of the glycoxide for about 45 mins to about 90 mins. In some embodiments, the polyethylene terephthalate (PET) is mixed with the solvent prior to the addition of the glycoxide for about 15 mins, about 20 mins, about 25 mins, about 30 mins, about 35 mins, about 40 mins, about 45 mins, about 50 mins, about 55 mins, about 60 mins, about 65 mins, about 70 mins, about 75 mins, about 80 mins, about 85 mins, about 90 mins, about 95 mins, about 100 mins, about 105 mins, about 110 mins, about 115 mins, or about 120 mins. In some embodiments, the polyethylene terephthalate (PET) is mixed with the solvent prior to the addition of the glycoxide for about 60 min.

[00114] In some embodiments, the polyethylene terephthalate (PET) is mixed with the solvent prior to the addition of the glycoxide and heated to a temperature between about 50 °C to about 100 °C. In some embodiments, the polyethylene terephthalate (PET) is mixed with the solvent prior to the addition of the glycoxide and heated to a temperature between about 50 °C to about 90 °C. In some embodiments, the polyethylene terephthalate (PET) is mixed with the solvent prior to the addition of the glycoxide and heated to a temperature between about 50 °C to about 80 °C. In some embodiments, the polyethylene terephthalate (PET) is mixed with the solvent prior to the addition of the glycoxide and heated to a temperature between

about 50 °C to about 70 °C. In some embodiments, the polyethylene terephthalate (PET) is mixed with the solvent prior to the addition of the glycoxide and heated to a temperature of about 50 °C, about 55 °C, about 60 °C, about 65 °C, about 70 °C, about 75 °C, about 80 °C, about 85 °C, about 90 °C, about 95 °C, or about 100 °C. In some embodiments, the polyethylene terephthalate (PET) is mixed with the solvent prior to the addition of the glycoxide and heated to a temperature of about 60 °C.

[00115] Described herein is a process for the transformation of a polyester into an ester derivative; the process comprising:

- (i) admixing the polyethylene terephthalate (PET) with a first solvent to yield a first mixture;
 - (ii) adding a glycoxide to the first mixture;
 - (iii) adding a second solvent; and
 - (iv) admixing;
- thereby forming the ester derivative.

[00116] Also described herein is a process for the depolymerization of polyethylene terephthalate (PET) to form a terephthalate; the process comprising:

- (i) admixing the polyethylene terephthalate (PET) with a first solvent to yield a first mixture;
 - (ii) adding a glycoxide to the first mixture;
 - (iii) adding a second solvent; and
 - (iv) admixing;
- thereby forming the terephthalate.

[00117] In some embodiments, the first solvent comprises a linear alcohol, branched alcohol, cyclic alcohol, or any combinations thereof. In some embodiments, the first solvent is selected from methanol, ethanol, n-propanol, isopropanol, t-butanol, ethylene glycol, glycerol, cyclohexane-1,4-dimethanol, phenol, benzyl alcohol, and any combinations thereof.

[00118] In some embodiments, the first solvent is a linear C₁-C₄ alcohol. In some embodiments, the first solvent is methanol, ethanol, propanol, butanol, or a combination thereof. In some embodiments, the first solvent is methanol, ethanol, propanol, or a combination thereof. In some embodiments, the first solvent is methanol. In some embodiments, the alcohol is ethanol. In some embodiments, the first solvent is a branched C₃-C₄ alcohol. In some embodiments, the first solvent is t-butanol, s-butanol, i-butanol, i-propanol, or any combinations thereof. In some embodiments, the first solvent is a cyclic C₃-C₈ alcohol. In some embodiments, the first solvent is cyclopropanol, cyclobutanol, cyclopentanol, cyclohexanol, cycloheptanol, cyclohexane-1,4-dimethanol, or any combinations thereof. In some embodiments, the first solvent is cyclohexane-1,4-dimethanol.

[00119] In some embodiments, the first solvent is a polyol. In some embodiments, the first solvent is selected from ethylene glycol, glycerol, and any combinations thereof. In some embodiments, the first solvent is selected from phenol, benzyl alcohol, and any combinations thereof.

[00120] In some embodiments, step (i) is performed for about 15 mins to about 120 mins. In some embodiments, step (i) is performed for about 15 mins to about 90 mins. In some embodiments, step (i) is performed for about 30 mins to about 90 mins. In some embodiments, step (i) is performed for about 45 mins to about 90 mins. In some embodiments, step (i) is performed for about 15 mins, about 20 mins, about 25 mins, about 30 mins, about 35 mins, about 40 mins, about 45 mins, about 50 mins, about 55 mins, about 60 mins, about 65 mins, about 70 mins, about 75 mins, about 80 mins, about 85 mins, about 90 mins, about 95 mins, about 100 mins, about 105 mins, about 110 mins, about 115 mins, or about 120 mins. In some embodiments, step (i) is performed for about 60 mins.

[00121] In some embodiments, step (i) is performed at a temperature between about 50 °C to about 100 °C. In some embodiments, step (i) is performed at a temperature between about 50 °C to about 90 °C. In some embodiments, step (i) is performed at a temperature between about 50 °C to about 80 °C. In some embodiments, step (i) is performed at a temperature between about 50 °C to about 70 °C. In some embodiments, step (i) is performed at a temperature of about 50 °C, about 55 °C, about 60 °C, about 65 °C, about 70 °C, about 75 °C, about 80 °C, about 85 °C, about 90 °C, about 95 °C, or about 100 °C. In some embodiments, step (i) is performed at a temperature of about 60 °C.

[00122] In some embodiments, a portion of the first solvent is removed prior to step (ii) to yield a second mixture. In some embodiments, the removal of a portion of the first solvent allows for the removal of the water trapped in the polyethylene terephthalate (PET) feedstock. In some embodiments, between about 1 mol and about 5 mol of first solvent is removed per mol of PET. In some embodiments, between about 1 mol and about 3 mol of first solvent is removed per mol of PET. In some embodiments, between about 2 mol and about 4 mol of first solvent is removed per mol of PET. In some embodiments, about 1 mol, about 1.1 mol, about 1.2 mol, about 1.3 mol, about 1.4 mol, about 1.5 mol, about 1.6 mol, about 1.7 mol, about 1.8 mol, about 1.9 mol, about 2 mol, about 2.1 mol, about 2.2 mol, about 2.3 mol, about 2.4 mol, about 2.5 mol, about 2.6 mol, about 2.7 mol, about 2.8 mol, about 2.9 mol, about 3 mol, about 3.1 mol, about 3.2 mol, about 3.3 mol, about 3.4 mol, about 3.5 mol, about 3.6 mol, about 3.7 mol, about 3.8 mol, about 3.9 mol, about 4 mol, about 4.1 mol, about 4.2 mol, about 4.3 mol, about 4.4 mol, about 4.5 mol, about 4.6 mol, about 4.7 mol, about 4.8 mol, about 4.9 mol, or about 5 mol of first solvent is removed per mol of PET.

[00123] In some embodiments, the second mixture is heated at a temperature between about 70 °C to about 100 °C. In some embodiments, the second mixture is heated at a temperature between about 80 °C to about 100 °C. In some embodiments, the second mixture is heated at a temperature between about 70 °C to about 90 °C. In some embodiments, the second mixture is heated at a temperature of about 70 °C, about 75 °C, about 80 °C, about 85 °C, about 90 °C, about 95 °C, or about 100 °C. In some embodiments, the second mixture is heated at a temperature of about 85 °C.

[00124] In some embodiments, the second solvent comprises a linear alcohol, branched alcohol, cyclic alcohol, or any combinations thereof. In some embodiments, the second solvent is selected from methanol, ethanol, n-propanol, isopropanol, t-butanol, ethylene glycol, glycerol, cyclohexane-1,4-dimethanol, phenol, benzyl alcohol, and any combinations thereof.

[00125] In some embodiments, the second solvent is a linear C₁-C₄ alcohol. In some embodiments, the second solvent is methanol, ethanol, propanol, butanol, or a combination thereof. In some embodiments, the second solvent is methanol, ethanol, propanol, or a combination thereof. In some embodiments, the second solvent is methanol. In some embodiments, the alcohol is ethanol. In some embodiments, the second solvent is a branched C₃-C₄ alcohol. In some embodiments, the second solvent is t-butanol, s-butanol, i-butanol, i-propanol, or any combinations thereof. In some embodiments, the second solvent is a cyclic C₃-C₈ alcohol. In some embodiments, the second solvent is cyclopropanol, cyclobutanol, cyclopentanol, cyclohexanol, cycloheptanol, cyclohexane-1,4-dimethanol, or any combinations thereof. In some embodiments, the second solvent is cyclohexane-1,4-dimethanol. In some embodiments, the second solvent is a polyol. In some embodiments, the second solvent is selected from ethylene glycol, glycerol, and any combinations thereof. In some embodiments, the second solvent is selected from phenol, benzyl alcohol, and any combinations thereof.

[00126] In some embodiments, step (iv) is performed for about 60 mins to about 600 mins. In some embodiments, step (iv) is performed for about 120 mins to about 600 mins. In some embodiments, step (iv) is performed for about 180 mins to about 600 mins. In some embodiments, step (iv) is performed for about 60 mins to about 480 mins. In some embodiments, step (iv) is performed for about 180 mins to about 480 mins. In some embodiments, step (iv) is performed for about 60 mins, 90 mins, 120 mins, 180 mins, 240 mins, 300 mins, 360 mins, 420 mins, 480 mins, 540 mins, or 600 mins. In some embodiments, step (iv) is performed for about 360 min.

[00127] In some embodiments, step (iv) is performed at a temperature between about 70 °C to about 100 °C. In some embodiments, step (iv) is performed at a temperature between about 70 °C to about 90 °C. In some embodiments, step (iv) is performed at a temperature between about 80 °C to about 100 °C. In some embodiments, step (iv) is performed at a temperature of about 70 °C, about 75 °C, about 80 °C, about 85 °C, about 90 °C, about 95 °C, or about 100 °C. In some embodiments, step (iv) is performed at a temperature of about 85 °C.

[00128] In some embodiments, the process further comprises step (v) filtrating the terephthalate.

[00129] In some embodiments, the process further comprises step (vi) distilling the terephthalate.

Alternatively, in some embodiments, the process further comprises step (vi) subliming the terephthalate.

[00130] Also described herein is a process for the depolymerization of polyethylene terephthalate (PET) to form a terephthalate; the process comprising:

- (i) admixing the polyethylene terephthalate (PET) with a first solvent to yield a first mixture;
 - (ii) adding a glycoxide to the first mixture;
 - (iii) adding a second solvent;
 - (iv) admixing; and
 - (v) filtrating the terephthalate;
- thereby isolating the terephthalate.

[00131] Also described herein is a process for the depolymerization of polyethylene terephthalate (PET) to form a terephthalate; the process comprising:

- (i) admixing the polyethylene terephthalate (PET) with a first solvent to yield a first mixture;
 - (ii) adding a glycoxide to the first mixture;
 - (iii) adding a second solvent;
 - (iv) admixing;
 - (v) filtrating the terephthalate; and
 - (vi) distilling the terephthalate;
- thereby isolating pure terephthalate.

[00132] Also described herein is a process for the depolymerization of polyethylene terephthalate (PET) to form a terephthalate; the process comprising:

- (i) admixing the polyethylene terephthalate (PET) with a first solvent to yield a first mixture;
 - (ii) adding a glycoxide to the first mixture;
 - (iii) adding a second solvent;
 - (iv) admixing;
 - (v) filtrating the terephthalate; and
 - (vi) subliming the terephthalate;
- thereby isolating pure terephthalate.

[00133] Also described herein is a process for the depolymerization of polyethylene terephthalate (PET) to form a terephthalate; the process comprising:

- (i) admixing the polyethylene terephthalate (PET) with a first solvent to yield a first mixture;
 - (ii) removing a portion of the first solvent from the first mixture to yield a second mixture;
 - (iii) adding a glycoxide to the second mixture;
 - (iv) adding a second solvent; and
 - (v) admixing;
- thereby forming the terephthalate.

[00134] Also described herein is a process for the depolymerization of polyethylene terephthalate (PET) to form a terephthalate; the process comprising:

- (i) admixing the polyethylene terephthalate (PET) with a first solvent to yield a first mixture;
 - (ii) removing a portion of the second solvent from the first mixture to yield a second mixture;
 - (iii) adding a glycoxide to the second mixture;
 - (iv) adding a second solvent;
 - (v) admixing; and
 - (vi) filtrating the terephthalate;
- thereby isolating the terephthalate.

[00135] Also described herein is a process for the depolymerization of polyethylene terephthalate (PET) to form a terephthalate; the process comprising:

- (i) admixing the polyethylene terephthalate (PET) with a first solvent to yield a first mixture;
 - (ii) removing a portion of the second solvent from the first mixture to yield a second mixture;
 - (iii) adding a glycoxide to the second mixture;
 - (iv) adding a second solvent;
 - (v) admixing;
 - (vi) filtrating the terephthalate; and
 - (vii) distilling the terephthalate;
- thereby isolating pure terephthalate.

[00136] Also described herein is a process for the depolymerization of polyethylene terephthalate (PET) to form a terephthalate; the process comprising:

- (i) admixing the polyethylene terephthalate (PET) with a first solvent to yield a first mixture;
 - (ii) removing a portion of the second solvent from the first mixture to yield a second mixture;
 - (iii) adding a glycoxide to the second mixture;
 - (iv) adding a second solvent;
 - (v) admixing;
 - (vi) filtrating the terephthalate; and
 - (vii) subliming the terephthalate;
- thereby isolating pure terephthalate.

CERTAIN TERMINOLOGY

[00137] The section headings used herein are for organizational purposes only and are not to be construed as limiting the subject matter described.

[00138] Unless defined otherwise, all technical and scientific terms used herein have the same meaning as is commonly understood to which the claimed subject matter belongs. In the event that there are a plurality of definitions for terms herein, those in this section prevail.

[00139] It is to be understood that the general description and the detailed description are exemplary and explanatory only and are not restrictive of any subject matter claimed. In this application, the use of the singular includes the plural unless specifically stated otherwise. It must be noted that, as used in the specification and the appended claims, the singular forms “a,” “an” and “the” include plural referents unless the context clearly dictates otherwise. In this application, the use of “or” means “and/or” unless stated otherwise. Furthermore, use of the term “including” as well as other forms, such as “include”, “includes,” and “included,” is not limiting.

[00140] Unless the context requires otherwise, throughout the specification and claims which follow, the word “comprise” and variations thereof, such as, “comprises” and “comprising” are to be construed in an open, inclusive sense, that is, as “including, but not limited to.” Further, headings provided herein are for convenience only and do not interpret the scope or meaning of the claimed invention.

[00141] As used in this specification and the appended claims, the singular forms “a,” “an,” and “the” include plural referents unless the content clearly dictates otherwise. It should also be noted that the term “or” is generally employed in its sense including “and/or” unless the content clearly dictates otherwise.

[00142] As used herein, the term “about” or “approximately” means within 10%, preferably within 10%, and more preferably within 5% of a given value or range.

[00143] As used herein, ambient temperature is a colloquial expression for the typical or preferred indoor (climate-controlled) temperature to which people are generally accustomed. It represents the small range of temperatures at which the air feels neither hot nor cold, approximately 21 °C. In some embodiments, ambient temperature is 25±5 °C. In some embodiments, ambient temperature is 18 °C. In some embodiments, ambient temperature is 19 °C. In some embodiments, ambient temperature is 20 °C. In some embodiments, ambient temperature is 21 °C. In some embodiments, ambient temperature is 22 °C. In some embodiments, ambient temperature is 23 °C. In some embodiments, ambient temperature is 24 °C. In some embodiments, ambient temperature is 25 °C. In some embodiments, ambient temperature is 26 °C. In some embodiments, ambient temperature is 27 °C. In some embodiments, ambient temperature is 28 °C. In some embodiments, ambient temperature is 29 °C. In some embodiments, ambient temperature is 30 °C.

[00144] As used in this specification and the appended claims, depolymerization, refer to a way of breaking down a polymer to its starting material. It is essentially the opposite of polymerization. In some embodiments, the depolymerization is achieved by glycolysis, methanolysis or hydrolysis, categorized by the depolymerization reactant used, such as glycol, methanol or water, respectively.

[00145] As used herein, the term “mol” when referring to PET is the molar amount and is calculated using the molecular weight of the “PET” unit which is 192.17 g/mol.

[00146] Definition of standard chemistry terms may be found in reference works, including but not limited to, Carey and Sundberg “Advanced Organic Chemistry 4th Ed.” Vols. A (2000) and B (2001), Plenum Press, New York.

EXAMPLES

[00147] The following examples are intended to illustrate but not limit the disclosed embodiments.

Example 1: Mono Sodium Glycoxide Formation

Dissolution Step:

[00148] Mono ethylene glycol (MEG, 2447.7 g) was added to a 6 L glass reactor and heated to 90 °C while stirring at 230 RPM. Sodium hydroxide (NaOH, 1770.6 g, as micro granules) were slowly added (very exothermic). MEG/NaOH (mol/mol): 1 to 1.2:1. The temperature of the mixture after addition of sodium hydroxide was monitored and recorded). The mixture was stirred (280 RPM) while maintaining the temperature at 150 °C for about 10 minutes (to make sure that all the sodium hydroxide dissolves). The liquid obtained was spread on Pyrex® plates and placed in a vacuum oven (at 130 °C and -30 inches of Hg pressure) for 60 minutes. The vacuum oven chamber was purged with nitrogen and placed back under vacuum. The plates were dried for about 12 hours. Once the catalyst is dry it was removed from the vacuum oven, grinded, and placed again in the vacuum oven (at 130 °C and -30 inches of Hg pressure). The vacuum

oven chamber was purged with nitrogen and placed back under vacuum. The catalyst was dried for about 12 hours. Once the catalyst is dried it was removed from the vacuum oven and added to a Pyrex® bottle. Methanol was added (ratio catalyst/MeOH (mol/mol): 0.18: 1) and stirred for 30 minutes. The suspension was kept in a flammable cabinet for up to one week.

Example 2: Depolymerization of Polyethylene Terephthalate

Swelling and Rinse:

[00149] The polyethylene terephthalate feedstock (10Kg) was added to a jacketed with a scraped double motion agitation (hermetically closed) reactor. The reactor was purged with nitrogen for 3 minutes. Methanol (6 Kg) was added and the resulting mixture was heated at about 60 °C and stirred at 60 rpm for about 60 minutes. The pressure and temperature were recorded. A portion of the liquid (3.5 Kg) was drained.

Reaction:

[00150] The reactor's central agitation was started (155 RPM). The scraper was started (70 RPM). The heat was increased to about 85 °C. The glycoxide suspension (973.5 g, 31.5 weight% glycoxide) was added and the mixture was heated and stirred for 5 minutes. The pressure and temperature were recorded. Additional methanol (3.83 Kg) was added and the resulting mixture was reacted for about 360 minutes (after reaching temperature). The mixture was then cooled to 25 °C

Filtration:

[00151] The solid was filtered and washed with methanol (4.8 Kg). The filter cake (dimethyl terephthalate) was weighted.

Distillation:

[00152] *DMT recovery*: The cake containing the DMT and the unreacted material was melted at 150 °C. The mixture was then evaporated or distilled in a thin film or a distillation column or any evaporation or distillation system at 160 °C under 2 torr of vacuum or 180 °C under 50 torr of vacuum. The DMT was recovered as a solid or as a liquid if the receiving system is heated at 150 °C.

[00153] *MEG recovery*: The mother liquor containing the MEG and methanol was passed through an evaporation or distillation system such as a thin film, a distillation column, an evaporator, etc, to remove around 70% of the methanol (at 30 °C under full vacuum). The recovered slurry was then chilled at 3 to -6 °C and filtered. A liquid was recovered and the residual 30% of methanol was removed by evaporation or distillation. The MEG left was then distilled or evaporated at 100 °C under full vacuum.

[00154] DMT yields using various amounts of catalysts and different catalysts are shown in the table below. For all examples:

- The molar PET amount (calculated using the "PET" unit molecular weight of 192.17 g/mol) was 52 mol;
- The Molar amount of methanol was 218 mol;
- The temperature was 70 °C;
- The Reaction time was 480 mins.

Catalyst	Catalyst Amount (mol)	Pressure (psi) ¹	DMT Yield (%) ²
Mono sodium glycoxide	9.2	9	99
Sodium methoxide	9.2	13	99
Mono sodium glycoxide	5.5	8	99
Sodium methoxide	5.5	10	98
Mono sodium glycoxide	3.7	8	99
Sodium methoxide	3.7	11	96

¹ pressure generated in hermetically closed reactor.

² before DMT distillation.

[00155] MEG yields using different catalysts are shown in the table below:

Catalyst	Catalyst Amount (mol)	Pressure (psi)	Yield of conversion to MEG (%)	Amount of MEG generated (mol)	Amount of MEG in the mother liquor after filtration (mol)	Amount of MEG recovered by one distillation (mol)	MEG Yield (based on the amount found in the mother liquor)
Sodium glycoxide	5.2	8	99	51.5	46.7	38.7	83%
Sodium methoxide	5.2	10	98	51.0	46.0	32.1	70%

CLAIMS

1. A process for the depolymerization of polyethylene terephthalate (PET) to form a terephthalate; the process comprising admixing polyethylene terephthalate (PET) with a mixture comprising a glycoxide and a solvent comprising methanol.
2. The process of claim 1, wherein the solvent is added to the polyethylene terephthalate (PET) prior to the addition of the glycoxide.
3. The process of claim 2, wherein the polyethylene terephthalate (PET) is mixed with the solvent prior to the addition of the glycoxide for about 15 mins to about 120 mins.
4. The process of any one of claims 1-3, wherein the polyethylene terephthalate (PET) is mixed with the solvent prior to the addition of the glycoxide at a temperature from about 50 °C to about 100 °C.
5. The process of any one of claims 1-4, wherein the terephthalate is dimethyl terephthalate (DMT).
6. The process of any one of claims 1-5, wherein the glycoxide is sodium glycoxide or mono sodium glycoxide.
7. The process of claim 6, wherein the glycoxide is mono sodium glycoxide and the mono sodium glycoxide is provided as a suspension.
8. The process of claim 7, wherein the mono sodium glycoxide suspension is prepared by a process comprising:
 - a) heating mono ethylene glycol at a temperature from about 70 °C to about 100 °C;
 - b) adding sodium hydroxide thereby forming mono sodium glycoxide;
 - c) drying the mono sodium glycoxide;
 - d) suspending the dried mono sodium glycoxide into a suspending solvent; and
 - e) aging the suspension.
9. The process of claim 8, wherein a ratio of mono sodium glycoxide to the suspending solvent is from about 0.05:1 to about 0.5: 1 (mol/mol), optionally wherein the suspending solvent is methanol.
10. The process of claim 8 or 9, wherein the suspension is aged for about 1-14 days.
11. The process of any one of claims 1-10, wherein a ratio of glycoxide to ethylene terephthalate units of polyethylene terephthalate (PET) is from about 1:2 to about 1:20 (mol/mol).
12. The process of any one of claims 1-11, wherein the terephthalate is obtained in at least about 90 mol% yield, at least about 95 mol% yield, or at least about 99 mol% yield.
13. The process of any one of claims 1-12, wherein the process further yields mono ethylene glycol and the mono ethylene glycol is obtained in at least about 80 mol% yield.

14. A process for the depolymerization of polyethylene terephthalate (PET) to form a terephthalate; the process comprising:
 - (i) admixing the polyethylene terephthalate (PET) with a first solvent comprising methanol to yield a first mixture;
 - (ii) adding a glycoxide to the first mixture;
 - (iii) adding a second solvent; and
 - (iv) admixing;thereby forming the terephthalate.
15. The process of claim 14, wherein the terephthalate is dimethyl terephthalate (DMT).
16. The process of claim 14 or 15, wherein step (i) is performed for about 15 mins to about 120 mins, and/or step (i) is performed at a temperature from about 50 °C to about 100 °C.
17. The process of any one of claims 14-16, wherein a portion of the first solvent is removed prior to step (ii) to yield a second mixture, optionally wherein the second mixture is heated at a temperature from about 70 °C to about 100 °C.
18. The process of any one of claims 14-17, wherein the glycoxide is sodium glycoxide or mono sodium glycoxide.
19. The process of claim 18, wherein the glycoxide is mono sodium glycoxide and the mono sodium glycoxide is provided as a suspension in a suspending solvent.
20. The process of claim 19, wherein the mono sodium glycoxide suspension is prepared by a process comprising:
 - a) heating mono ethylene glycol at a temperature from about 70 °C to about 100 °C;
 - b) adding sodium hydroxide thereby forming mono sodium glycoxide;
 - c) drying the mono sodium glycoxide;
 - d) suspending the dried mono sodium glycoxide in a suspending solvent; and
 - e) aging the suspension.
21. The process of claim 20, wherein a ratio of mono sodium glycoxide to the suspending solvent is from about 0.05:1 to about 0.5: 1 (mol/mol), optionally wherein the suspending solvent is methanol.
22. The process of claim 20 or 21, wherein the suspension is aged for about 1-14 days.
23. The process of any one of claims 14-22, wherein a ratio of glycoxide to ethylene terephthalate units of polyethylene terephthalate (PET) is from about 1:2 to about 1:20 (mol/mol).

24. The process of any one of claims 14-23, wherein the second solvent is selected from methanol, ethanol, n-propanol, isopropanol, t-butanol, ethylene glycol, glycerol, cyclohexane-1,4-dimethanol, phenol, benzyl alcohol, and any combinations thereof.
25. The process of any one of claims 14-24, wherein the second solvent is methanol.
26. The process of any one of claims 14-25, wherein step (iv) is performed for about 60 mins to about 600 mins, and/or step (iv) is performed at a temperature from about 70 °C to about 100 °C.
27. The process of any one of claims 14-26, further comprising step (v) filtrating the terephthalate.
28. The process of any one of claims 14-27, wherein the terephthalate is obtained in at least about 90 mol% yield, at least about 95 mol% yield, or at least about 99 mol% yield.
29. The process of any one of claims 14-28, wherein the process further yields mono ethylene glycol and the mono ethylene glycol is obtained in at least about 80 mol% yield.
30. A terephthalate, wherein the terephthalate is formed by the process of any one of claims 1-29.