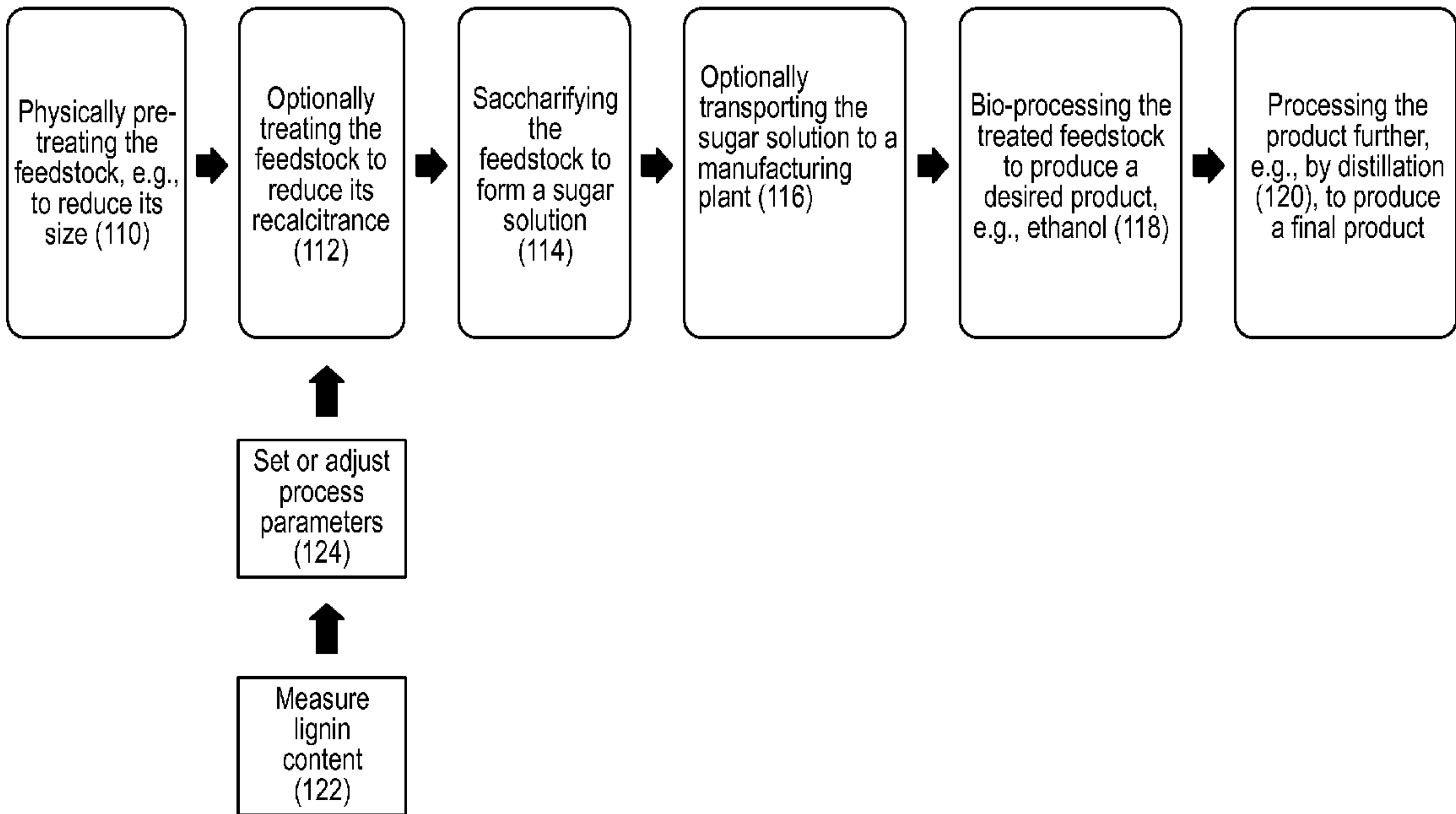




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(54) Titre : TRAITEMENT DE MATIERES PREMIERES DE PAPIER
(54) Title: PROCESSING PAPER FEEDSTOCKS



(57) **Abrégé/Abstract:**
Methods of processing paper feedstocks are provided, as well as intermediates and products made using such methods. Certain types of paper feedstocks, in particular highly pigmented papers, and/or highly loaded papers such as paper that has been color printed, e.g., magazines, and high basis weight coated papers, e.g., magazine stock, are utilized to produce useful intermediates and products, such as energy, fuels, foods or materials.

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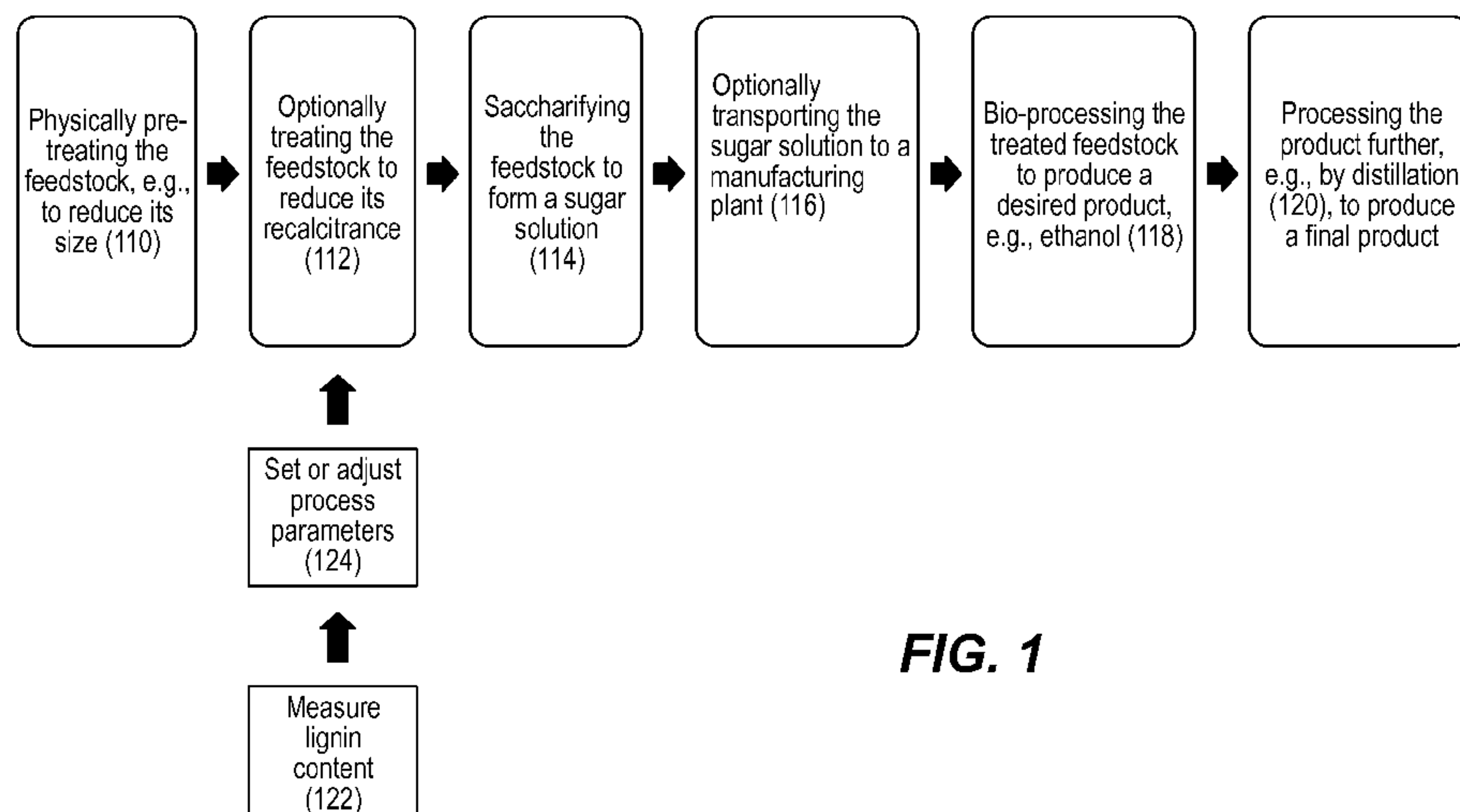
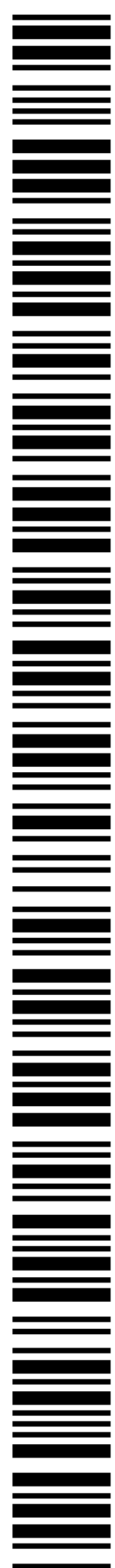


FIG. 1

(57) Abstract: Methods of processing paper feedstocks are provided, as well as intermediates and products made using such methods. Certain types of paper feedstocks, in particular highly pigmented papers, and/or highly loaded papers such as paper that has been color printed, e.g., magazines, and high basis weight coated papers, e.g., magazine stock, are utilized to produce useful intermediates and products, such as energy, fuels, foods or materials.



WO 2012/112488 A3

PROCESSING PAPER FEEDSTOCKS

RELATED APPLICATIONS

This application claims priority to U.S. Provisional Application Serial No. 61/442,710, filed February 14, 2011. The complete disclosure of this provisional application is hereby incorporated by reference herein.

BACKGROUND

5

Magazines, catalogs, and other paper products that contain high levels of coatings, pigments, and inks, are widely available as waste materials. While efforts are made to recycle this waste paper, generally by repulping it for use in recycled paper products, it would be advantageous if this waste paper could be economically utilized as a feedstock to make other types of products.

10

SUMMARY

Generally, this invention relates to methods of processing paper feedstocks, and to intermediates and products made therefrom. In particular, the invention relates generally to the processing of certain types of relatively heavy paper feedstocks, such as highly pigmented papers, and or loaded papers, such as paper that has been color printed (printed with colors other than or in addition to black), e.g., magazines, and other papers.

15

Many of the methods disclosed herein utilize microorganisms or products produced by microorganisms, e.g., enzymes, to bioprocess the feedstock, producing useful intermediates and products, e.g., energy, fuels, foods and other materials. For example, in some cases enzymes are used to saccharify the feedstocks, converting the feedstocks to sugars. The sugars may be used as an end product or intermediate, or processed further, e.g., by fermentation. For example xylose can be hydrogenated to xylitol and glucose can be hydrogenated to sorbitol.

20

In one aspect, the invention features methods for producing a sugar, e.g., in the form of a solution or suspension, that includes providing a paper feedstock, the paper feedstock including offset printing paper e.g., offset printed paper, colored paper and/or

25

coated paper e.g., polycoated paper and optionally mixing the feedstock with a fluid and/or saccharifying agent.

Some implementations include one or more of the following features. The paper feedstock may have a basis weight greater than 35 lb, e.g., from about 35 lb to 330 lb and/or the paper may have a high filler content, e.g., greater than about 10 wt.% e.g., greater than 20 wt.%. For example, the filler or any coating can be an inorganic material. The paper may also have a high grammage, e.g., greater than about 500 g/m². The paper may comprise a pigment or printing ink, e.g., at a level greater than about 0.025 wt.%. The paper can have an ash content greater than about 8 wt.%.

The method can further include adding a microorganism, for example a yeast and/or a bacteria (e.g., from the genus *Clostridium*), to the paper feedstock or saccharified paper and producing a product or intermediate.

The product can be a fuel, including, for example, alcohols (e.g., methanol, ethanol, propanol, isopropanol, erythritol, n-butanol, isobutanol, *sec*-butanol, *tert*-butanol, ethylene glycol, propylene glycol, 1,4-butane diol and/or glycerin), sugar alcohols (e.g., erythritol, glycol, glycerol, sorbitol threitol, arabitol, ribitol, mannitol, dulcitol, fucitol, iditol, isomalt, maltitol, lactitol, xylitol and other polyols), organic acids (e.g., formic acid, acetic acid, propionic acid, butyric acid, valeric acid, caproic acid, palmitic acid, stearic acid, oxalic acid, malonic acid, succinic acid, glutaric acid, oleic acid, linoleic acid, glycolic acid, lactic acid and/or γ -hydroxybutyric acid), hydrocarbons (methane, ethane, propane, isobutene, pentane, n-hexane, biodiesels and/or bio-gasolines), hydrogen and mixtures of these.

The method can further include adding a food-based nutrient source to the mixture, e.g., a nutrient source selected from the group consisting of grains, vegetables, residues of grains, residues of vegetables, and mixtures thereof, for example wheat, oats, barley, soybeans, peas, legumes, potatoes, corn, rice bran, corn meal, wheat bran, and mixtures thereof. In such cases, the mixture can further include an enzyme system selected to release nutrients from the food-based nutrient source, e.g., a system comprising a protease and an amylase.

The method can include detoxifying the sugar solution or suspension. The method can include further processing the sugar, for example, by separating xylose and or

glucose from the sugar. In some cases, the saccharification can be conducted at a pH of about 3.8 to 4.2. The mixture can further include a nitrogen source.

In some cases, the method further includes physically treating the paper feedstock, for example mechanically treating to reduce the bulk density of the paper feedstock and/or increase the BET surface area of the feedstock. Physically treating the paper feedstock can include irradiation, for example, with an electron beam. The method can include mixing the paper feedstock with a fluid. The method can include detoxifying the paper feedstock, sugar, and/or other products or intermediates. The paper feedstock may be in the form of magazines. The paper feedstock may also be a laminate of at least one layer of a polymer and paper and may further include at least one layer of a metal e.g., aluminum.

Although many embodiments include the use of relatively heavy paper feedstocks, e.g., containing fillers and/or coatings other papers can be used e.g., newsprint.

Unless otherwise defined, all technical and scientific terms used herein have the same meaning as commonly understood by one of ordinary skill in the art to which this invention belongs. Although methods and materials similar or equivalent to those described herein can be used in the practice or testing of the present invention, suitable methods and materials are described below. All publications, patent applications, patents, and other references mentioned herein are incorporated by reference in their entirety. In case of conflict, the present specification, including definitions, will control. In addition, the materials, methods, and examples are illustrative only and not intended to be limiting.

The invention as claimed relates to a method of producing a sugar comprising providing a paper with a filler content of greater than 10 wt.% and an ash content of at least 8 wt.% combining the paper with a saccharifying agent comprising an enzyme, in a tank, and using jet mixing to mix the tank contents during saccharification.

Other features and advantages of the invention will be apparent from the following detailed description, and from the claims.

DESCRIPTION OF DRAWINGS

FIG. 1 is a flow diagram illustrating conversion of a feedstock to ethanol via production of a glucose solution.

FIG. 2 is a schematic diagram of an ethanol manufacturing facility.

FIG. 3 is a diagram illustrating the enzymatic hydrolysis of cellulose to glucose.

DETAILED DESCRIPTION

Using the methods and nutrient packages described herein, paper feedstocks that include high levels of pigments, colors, fillers and/or coatings, and/or that have a high basis weight, and the saccharified derivatives of such feedstocks, can be bioprocessed, e.g., using fermentation, to produce useful intermediates and products such as those described herein. In some cases, the feedstock includes high levels pigments and/or fillers such as those feedstocks used in printing, e.g., magazines. Examples of such feedstocks are described herein. Feedstocks of this type are advantageous for a number of reasons, including their relatively low cost (if waste materials are used) and, in the case of high basis weight papers, their relatively high density, which contributes to ease of handling and processing.

CONVERTING CELLULOSIC AND LIGNOCELLULOSIC MATERIALS TO ALCOHOLS

Referring to FIG. 1, a process for manufacturing an alcohol, e.g., ethanol, or a butanol e.g., isobutanol, *sec*-butanol, tert-butanol or n-butanol, can include, for example, optionally mechanically treating the feedstock (step 110), before and/or after this treatment, optionally treating the feedstock with another physical treatment, for example irradiation, to further reduce its recalcitrance (step 112), saccharifying the feedstock to form a sugar solution (step 114), optionally transporting, e.g., by pipeline, railcar, truck or barge, the solution (or the feedstock, enzyme and water, if saccharification is performed en route) to a manufacturing plant (step 116), and then bio-processing the treated feedstock to produce a desired product (step 118), which is then processed further, e.g., by distillation (step 120). If desired, lignin content can be measured (step 122) and process parameters can be set or adjusted based on this measurement (step 124), as described in U.S. Application Serial No 12/704,519, filed on February 11, 2010, the complete disclosure of which is incorporated herein by reference.

Because paper feedstocks are generally low in, or entirely lack, nutrients to support bioprocesses, it is generally preferred that nutrients be added to the system, for example in the form of a food-based nutrient source or nutrient package, as disclosed in U.S. Application Serial No. 13/184,138, incorporated by reference herein in its entirety.

When utilized, the food-based nutrient source or nutrient package is present during bio-processing (step 118), e.g., fermentation, and may in some preferred implementations also be present during the saccharification step (step 114). In some implementations, the food-based nutrient source or nutrient package is added at the beginning of step 114,
5 along with an enzyme combination suitable for saccharification, fermentation, and release of nutrients from the food-based nutrient source.

Saccharification is conducted under a first set of process conditions (e.g., temperature and pH), and then when saccharification has proceeded to a desired extent the process conditions may be adjusted (e.g., by adjusting pH from 4 to 5) to allow
10 fermentation to proceed.

In some cases the feedstock includes materials that are not beneficial to the processing of the feedstock or decrease the quality of the intermediates and/or products. For example there may be materials that are toxic, and/or solid inorganic materials or insoluble organic materials. The toxic materials can be detrimental, for example, by
15 reducing the effectiveness of enzymes and/or microorganisms. Examples of toxic materials are pigments and inks described herein. Solid inorganic materials can be detrimental, for example, in increasing the total viscosity and density of solutions in various processes as well as forming slurries, sludge and settled material that may, for example, block openings, be difficult to remove, e.g., from the bottom of tanks, and/or
20 increase the wear on mixers. Examples of inorganic materials are fillers and coatings described herein. Insoluble organic materials can, for example, contaminate the final fuel products and/or cause foaming during mixing or other processing steps. Examples of insoluble organic materials are polymers used in polycoated paper described herein. It can therefore be advantageous to remove some of the insoluble solids and organic
25 materials and to detoxify the feedstock at any point during the processing as described herein. Surprisingly, it has been found that in some cases materials in the feedstock that would be expected to be detrimental, as discussed above, do not significantly adversely affect the process. For example, some yeasts that provide ethanol by fermentation of sugars derived from paper feedstocks appear to be very resilient to various pigments, inks
30 and fillers.

The manufacturing plant used in steps 118-120 (and in some cases all of the steps described above) can be, for example, an existing starch-based or sugar-based ethanol plant or one that has been retrofitted by removing or decommissioning the equipment upstream from the bio-processing system (which in a typical ethanol plant generally includes grain receiving equipment, a hammermill, a slurry mixer, cooking equipment and liquefaction equipment). In some cases, the feedstock received by the plant can be input directly into the fermentation equipment. A retrofitted plant is shown schematically in FIG. 2 and described below as well as, for example, in U.S. Serial No. 12/429,045, filed April 23, 2009, the complete disclosure of which is incorporated herein by reference.

FIG. 2 shows one particular system that utilizes the steps described above for treating a feedstock and then using the treated feedstock in a fermentation process to produce an alcohol. System 100 includes a module 102 in which a feedstock is initially mechanically treated (step 12, above), a module 104 in which the mechanically treated feedstock is structurally modified (step 14, above), e.g., by irradiation, and a module 106 in which the structurally modified feedstock is subjected to further mechanical treatment (step 16, above). As discussed above, the module 106 may be of the same type as the module 102, or a different type. In some implementations the structurally modified feedstock can be returned to module 102 for further mechanical treatment rather than being further mechanically treated in a separate module 106.

As described herein, many variations of system 100 can be utilized.

After these treatments, which may be repeated as many times as required to obtain desired feedstock properties, the treated feedstock is delivered to a fermentation system 108. Mixing may be performed during fermentation, in which case the mixing is preferably relatively gentle (low shear) so as to minimize damage to shear sensitive ingredients such as enzymes and other microorganisms. In some embodiments, jet mixing is used, as described in U.S. Serial No. 12/782,694, 13/293,977 and 13/293,985, the complete disclosures of which are incorporated herein by reference.

Referring again to FIG. 2, fermentation produces a crude ethanol mixture, which flows into a holding tank 110. Water or other solvent, and other non-ethanol components, are stripped from the crude ethanol mixture using a stripping column 112, and the ethanol is

then distilled using a distillation unit 114, e.g., a rectifier. Distillation may be by vacuum distillation. Finally, the ethanol can be dried using a molecular sieve 116 and/or denatured, if necessary, and output to a desired shipping method.

5 In some cases, the systems described herein, or components thereof, may be portable, so that the system can be transported (e.g., by rail, truck, or marine vessel) from one location to another. The method steps described herein can be performed at one or more locations, and in some cases one or more of the steps can be performed in transit. Such mobile processing is described in U.S. Serial No. 12/374,549 and International Application No. WO 2008/011598, the full disclosures of which are incorporated herein
10 by reference.

Any or all of the method steps described herein can be performed at ambient temperature. If desired, cooling and/or heating may be employed during certain steps. For example, the feedstock may be cooled during mechanical treatment to increase its brittleness. In some embodiments, cooling is employed before, during or after the initial
15 mechanical treatment and/or the subsequent mechanical treatment. Cooling may be performed as described in U.S. Serial No. 12/502,629, now U.S. Patent No. 7,900,857 the full disclosure of which is incorporated herein by reference. Moreover, the temperature in the fermentation system 108 may be controlled to enhance saccharification and/or fermentation.

20 The individual steps of the methods described above, as well as the materials used, will now be described in further detail.

PHYSICAL TREATMENT

Physical treatment processes can include one or more of any of those described herein, such as mechanical treatment, chemical treatment, irradiation, sonication,
25 oxidation, pyrolysis or steam explosion. Treatment methods can be used in combinations of two, three, four, or even all of these technologies (in any order). When more than one treatment method is used, the methods can be applied at the same time or at different times. Other processes that change a molecular structure of a feedstock may also be used, alone or in combination with the processes disclosed herein.

Mechanical Treatments

In some cases, methods can include mechanically treating the feedstock.

5 Mechanical treatments include, for example, cutting, milling, pressing, grinding, shearing and chopping. Milling may include, for example, ball milling, hammer milling, rotor/stator dry or wet milling, freezer milling, blade milling, knife milling, disk milling, roller milling or other types of milling. Other mechanical treatments include, e.g., stone grinding, cracking, mechanical ripping or tearing, pin grinding or air attrition milling.

10 Mechanical treatment can be advantageous for “opening up,” “stressing,” breaking and shattering cellulosic or other materials in the feedstock, making the cellulose of the materials more susceptible to chain scission and/or reduction of crystallinity. The open materials can also be more susceptible to oxidation when irradiated.

In some cases, the mechanical treatment may include an initial preparation of the feedstock as received, e.g., size reduction of materials, such as by cutting, grinding, 15 shearing, pulverizing or chopping. For example, in some cases, loose feedstock (e.g., Machine Offset Paper and/or Polycoated Paper) is prepared by shearing or shredding.

Alternatively, or in addition, the feedstock material can first be physically treated by one or more of the other physical treatment methods, e.g., chemical treatment, 20 radiation, sonication, oxidation, pyrolysis or steam explosion, and then mechanically treated. This sequence can be advantageous since materials treated by one or more of the other treatments, e.g., irradiation or pyrolysis, tend to be more brittle and, therefore, it may be easier to further change the molecular structure of the material by mechanical treatment.

25 In some embodiments, mechanical treatment includes shearing to expose fibers of the material. Shearing can be performed, for example, using a rotary knife cutter. Other methods of mechanically treating the feedstock include, for example, milling or grinding. Milling may be performed using, for example, a hammer mill, ball mill, colloid mill, conical or cone mill, disk mill, edge mill, Wiley mill or grist mill. Grinding may be 30 performed using, for example, a stone grinder, pin grinder, coffee grinder, or burr grinder. Grinding may be provided, for example, by a reciprocating pin or other element,

as is the case in a pin mill. Other mechanical treatment methods include mechanical ripping or tearing, other methods that apply pressure to the material, and air attrition milling. Suitable mechanical treatments further include any other technique that changes the molecular structure of the feedstock.

5 If desired, the mechanically treated material can be passed through a screen, e.g., having an average opening size of 1.59 mm or less (1/16 inch, 0.0625 inch). In some embodiments, shearing, or other mechanical treatment, and screening are performed concurrently. For example, a rotary knife cutter can be used to concurrently shear and screen the feedstock. The feedstock is sheared between stationary blades and rotating
10 blades to provide a sheared material that passes through a screen, and is captured in a bin.

 The paper feedstock can be mechanically treated in a dry state (e.g., having little or no free water on its surface), a hydrated state (e.g., having up to ten percent by weight absorbed water), or in a wet state, e.g., having between about 10 percent and about 75 percent by weight water. The fiber source can even be mechanically treated while
15 partially or fully submerged under a liquid, such as water, ethanol or isopropanol.

 The feedstock can also be mechanically treated under a gas (such as a stream or atmosphere of gas other than air), e.g., oxygen or nitrogen, or steam.

 Mechanical treatment systems can be configured to produce streams with specific morphology characteristics such as, for example, surface area, porosity, bulk density, and
20 length-to-width ratio.

 In some embodiments, a BET surface area of the mechanically treated material is greater than 0.1 m²/g, e.g., greater than 0.25 m²/g, greater than 0.5 m²/g, greater than 1.0 m²/g, greater than 1.5 m²/g, greater than 1.75 m²/g, greater than 5.0 m²/g, greater than 10 m²/g, greater than 25 m²/g, greater than 35 m²/g, greater than 50 m²/g, greater than 60
25 m²/g, greater than 75 m²/g, greater than 100 m²/g, greater than 150 m²/g, greater than 200 m²/g, or even greater than 250 m²/g.

 In some situations, it can be desirable to prepare a low bulk density material, densify the material (e.g., to make it easier and less costly to transport to another site), and then revert the material to a lower bulk density state. Densified materials can be
30 processed by any of the methods described herein, or any material processed by any of the methods described herein can be subsequently densified, e.g., as disclosed in U.S.

Serial No. 12/429, 045 now U.S. Patent No. 7,932,065 and WO 2008/073186, the full disclosures of which are incorporated herein by reference.

Radiation Treatment

One or more radiation processing sequences can be used to process the paper feedstock, and to provide a structurally modified material which functions as input to further processing steps and/or sequences. Irradiation can, for example, reduce the molecular weight and/or crystallinity of feedstock. Radiation can also sterilize the materials, or any media needed to bioprocess the material.

In some embodiments, the radiation may be provided by (1) heavy charged particles, such as alpha particles or protons, (2) electrons, produced, for example, in beta decay or electron beam accelerators, or (3) electromagnetic radiation, for example, gamma rays, x rays, or ultraviolet rays. In one approach, radiation produced by radioactive substances can be used to irradiate the feedstock. In another approach, electromagnetic radiation (e.g., produced using electron beam emitters) can be used to irradiate the feedstock. In some embodiments, any combination in any order or concurrently of (1) through (3) may be utilized. The doses applied depend on the desired effect and the particular feedstock.

In some instances when chain scission is desirable and/or polymer chain functionalization is desirable, particles heavier than electrons, such as protons, helium nuclei, argon ions, silicon ions, neon ions, carbon ions, phosphorus ions, oxygen ions or nitrogen ions can be utilized. When ring-opening chain scission is desired, positively charged particles can be utilized for their Lewis acid properties for enhanced ring-opening chain scission. For example, when maximum oxidation is desired, oxygen ions can be utilized, and when maximum nitration is desired, nitrogen ions can be utilized. The use of heavy particles and positively charged particles is described in U.S. Serial No. 12/417,699, now U.S. Patent No. 7,931,784, the full disclosure of which is incorporated herein by reference.

In one method, a first material that is or includes cellulose having a first number average molecular weight (M_{N1}) is irradiated, e.g., by treatment with ionizing radiation (e.g., in the form of gamma radiation, X-ray radiation, 100 nm to 280 nm ultraviolet (UV)

light, a beam of electrons or other charged particles) to provide a second material that includes cellulose having a second number average molecular weight (M_{N2}) lower than the first number average molecular weight. The second material (or the first and second material) can be combined with a microorganism (with or without enzyme treatment) that
5 can utilize the second and/or first material or its constituent sugars or lignin to produce an intermediate or product, such as those described herein.

Since the second material includes cellulose having a reduced molecular weight relative to the first material, and in some instances, a reduced crystallinity as well, the second material is generally more dispersible, swellable and/or soluble, e.g., in a solution
10 containing a microorganism and/or an enzyme. These properties make the second material easier to process and more susceptible to chemical, enzymatic and/or biological attack relative to the first material, which can greatly improve the production rate and/or production level of a desired product, e.g., ethanol.

In some embodiments, the second number average molecular weight (M_{N2}) is
15 lower than the first number average molecular weight (M_{N1}) by more than about 10 percent, e.g., more than about 15, 20, 25, 30, 35, 40, 50 percent, 60 percent, or even more than about 75 percent.

In some instances, the second material includes cellulose that has a crystallinity (C_2) that is lower than the crystallinity (C_1) of the cellulose of the first material. For
20 example, (C_2) can be lower than (C_1) by more than about 10 percent, e.g., more than about 15, 20, 25, 30, 35, 40, or even more than about 50 percent.

In some embodiments, the second material can have a level of oxidation (O_2) that is higher than the level of oxidation (O_1) of the first material. A higher level of oxidation of the material can aid in its dispersability, swellability and/or solubility, further
25 enhancing the material's susceptibility to chemical, enzymatic or biological attack. In some embodiments, to increase the level of the oxidation of the second material relative to the first material, the irradiation is performed under an oxidizing environment, e.g., under a blanket of air or oxygen, producing a second material that is more oxidized than the first material. For example, the second material can have more hydroxyl groups,
30 aldehyde groups, ketone groups, ester groups or carboxylic acid groups, which can increase its hydrophilicity.

Ionizing Radiation

Each form of radiation ionizes the paper feedstock via particular interactions, as determined by the energy of the radiation. Heavy charged particles primarily ionize matter via Coulomb scattering; furthermore, these interactions produce energetic
5 electrons that may further ionize matter. Alpha particles are identical to the nucleus of a helium atom and are produced by the alpha decay of various radioactive nuclei, such as isotopes of bismuth, polonium, astatine, radon, francium, radium, several actinides, such as actinium, thorium, uranium, neptunium, curium, californium, americium, and plutonium.

10 When particles are utilized, they can be neutral (uncharged), positively charged or negatively charged. When charged, the charged particles can bear a single positive or negative charge, or multiple charges, e.g., one, two, three or even four or more charges. In instances in which chain scission is desired, positively charged particles may be desirable, in part due to their acidic nature. When particles are utilized, the particles can
15 have the mass of a resting electron, or greater, e.g., 500, 1000, 1500, 2000, 10,000 or even 100,000 times the mass of a resting electron. For example, the particles can have a mass of from about 1 atomic unit to about 150 atomic units, e.g., from about 1 atomic unit to about 50 atomic units, or from about 1 to about 25, e.g., 1, 2, 3, 4, 5, 10, 12 or 15 amu. Accelerators used to accelerate the particles can be electrostatic DC,
20 electrodynamic DC, RF linear, magnetic induction linear or continuous wave. For example, cyclotron type accelerators are available from IBA, Belgium, such as the Rhodotron® system, while DC type accelerators are available from RDI, now IBA Industrial, such as the Dynamitron®. Ions and ion accelerators are discussed in Introductory Nuclear Physics, Kenneth S. Krane, John Wiley & Sons, Inc. (1988), Krsto
25 Prelec, FIZIKA B 6 (1997) 4, 177–206, Chu, William T., “Overview of Light-Ion Beam Therapy” Columbus-Ohio, ICRU-IAEA Meeting, 18-20 March 2006, Iwata, Y. et al., “Alternating-Phase-Focused IH-DTL for Heavy-Ion Medical Accelerators” Proceedings of EPAC 2006, Edinburgh, Scotland and Leaner, C.M. et al., “Status of the Superconducting ECR Ion Source Venus” Proceedings of EPAC 2000, Vienna, Austria.

30 Gamma radiation has the advantage of a significant penetration depth into a variety of materials. Sources of gamma rays include radioactive nuclei, such as isotopes

of cobalt, calcium, technicium, chromium, gallium, indium, iodine, iron, krypton, samarium, selenium, sodium, thalium, and xenon.

Sources of x rays include electron beam collision with metal targets, such as tungsten or molybdenum or alloys, or compact light sources, such as those produced commercially by Lyncean.

Sources for ultraviolet radiation include deuterium or cadmium lamps.

Sources for infrared radiation include sapphire, zinc, or selenide window ceramic lamps.

Sources for microwaves include klystrons, Slevin type RF sources, or atom beam sources that employ hydrogen, oxygen, or nitrogen gases.

In some embodiments, a beam of electrons is used as the radiation source. A beam of electrons has the advantages of high dose rates (e.g., 1, 5, or even 10 Mrad per second), high throughput, less containment, and less confinement equipment. Electrons can also be more efficient at causing chain scission. In addition, electrons having energies of 4-10 MeV can have a penetration depth of 5 to 30 mm or more, such as 40 mm.

Electron beams can be generated, e.g., by electrostatic generators, cascade generators, transformer generators, low energy accelerators with a scanning system, low energy accelerators with a linear cathode, linear accelerators, and pulsed accelerators. Electrons as an ionizing radiation source can be useful, e.g., for relatively thin sections of material, e.g., less than 0.5 inch, e.g., less than 0.4 inch, 0.3 inch, 0.2 inch, or less than 0.1 inch. In some embodiments, the energy of each electron of the electron beam is from about 0.3 MeV to about 2.0 MeV (million electron volts), e.g., from about 0.5 MeV to about 1.5 MeV, or from about 0.7 MeV to about 1.25 MeV.

Electron beam irradiation devices may be procured commercially from Ion Beam Applications, Louvain-la-Neuve, Belgium or the Titan Corporation, San Diego, CA. Typical electron energies can be 1 MeV, 2 MeV, 4.5 MeV, 7.5 MeV, or 10 MeV. Typical electron beam irradiation device power can be 1 kW, 5 kW, 10 kW, 20 kW, 50 kW, 100 kW, 250 kW, or 500 kW. The level of depolymerization of the feedstock depends on the electron energy used and the dose applied, while exposure time depends on the power and dose. Typical doses may take values of 1 kGy, 5 kGy, 10 kGy, 20 kGy,

50 kGy, 100 kGy, or 200 kGy. In a some embodiments energies between 0.25-10 MeV (e.g., 0.5-0.8 MeV, 0.5-5 MeV, 0.8-4 MeV, 0.8-3 MeV, 0.8-2 MeV or 0.8-1.5 MeV) can be used. In some embodiment doses between 1-100 Mrad (e.g., 2-80 Mrad, 5-50 Mrad, 5-40 Mrad, 5-30 Mrad or 5-20 Mrad) can be used. In some preferred embodiments, an
5 energy between 0.8-3 MeV (e.g., 0.8-2 MeV or 0.8-1.5 MeV) combined with doses between 5-50 Mrad (e.g., 5-40 Mrad, 5-30 Mrad or 5-20 Mrad) can be used.

Ion Particle Beams

Particles heavier than electrons can be utilized to irradiate paper feedstock materials. For example, protons, helium nuclei, argon ions, silicon ions, neon ions carbon
10 ions, phosphorus ions, oxygen ions or nitrogen ions can be utilized. In some embodiments, particles heavier than electrons can induce higher amounts of chain scission (relative to lighter particles). In some instances, positively charged particles can induce higher amounts of chain scission than negatively charged particles due to their acidity.

15 Heavier particle beams can be generated, e.g., using linear accelerators or cyclotrons. In some embodiments, the energy of each particle of the beam is from about 1.0 MeV/atomic unit (MeV/amu) to about 6,000 MeV/atomic unit, e.g., from about 3 MeV/ atomic unit to about 4,800 MeV/atomic unit, or from about 10 MeV/atomic unit to about 1,000 MeV/atomic unit.

20 In certain embodiments, ion beams used to irradiate paper feedstock can include more than one type of ion. For example, ion beams can include mixtures of two or more (e.g., three, four or more) different types of ions. Exemplary mixtures can include carbon ions and protons, carbon ions and oxygen ions, nitrogen ions and protons, and iron ions and protons. More generally, mixtures of any of the ions discussed above (or any other
25 ions) can be used to form irradiating ion beams. In particular, mixtures of relatively light and relatively heavier ions can be used in a single ion beam.

In some embodiments, ion beams for irradiating paper feedstock include positively-charged ions. The positively charged ions can include, for example, positively charged hydrogen ions (e.g., protons), noble gas ions (e.g., helium, neon, argon), carbon
30 ions, nitrogen ions, oxygen ions, silicon atoms, phosphorus ions, and metal ions such as

sodium ions, calcium ions, and/or iron ions. Without wishing to be bound by any theory, it is believed that such positively-charged ions behave chemically as Lewis acid moieties when exposed to materials, initiating and sustaining cationic ring-opening chain scission reactions in an oxidative environment.

5 In certain embodiments, ion beams for irradiating paper feedstock include negatively-charged ions. Negatively charged ions can include, for example, negatively charged hydrogen ions (e.g., hydride ions), and negatively charged ions of various relatively electronegative nuclei (e.g., oxygen ions, nitrogen ions, carbon ions, silicon ions, and phosphorus ions). Without wishing to be bound by any theory, it is believed
10 that such negatively-charged ions behave chemically as Lewis base moieties when exposed to materials, causing anionic ring-opening chain scission reactions in a reducing environment.

In some embodiments, beams for irradiating paper feedstock can include neutral atoms. For example, any one or more of hydrogen atoms, helium atoms, carbon atoms,
15 nitrogen atoms, oxygen atoms, neon atoms, silicon atoms, phosphorus atoms, argon atoms, and iron atoms can be included in beams that are used for irradiation. In general, mixtures of any two or more of the above types of atoms (e.g., three or more, four or more, or even more) can be present in the beams.

In certain embodiments, ion beams used to irradiate paper feedstock include
20 singly-charged ions such as one or more of H^+ , H^- , He^+ , Ne^+ , Ar^+ , C^+ , C^- , O^+ , O^- , N^+ , N^- , Si^+ , Si^- , P^+ , P^- , Na^+ , Ca^+ , and Fe^+ . In some embodiments, ion beams can include multiply-charged ions such as one or more of C^{2+} , C^{3+} , C^{4+} , N^{3+} , N^{5+} , N^{3-} , O^{2+} , O^{2-} , O_2^{2-} , Si^{2+} , Si^{4+} , Si^{2-} , and Si^{4-} . In general, the ion beams can also include more complex polynuclear ions that bear multiple positive or negative charges. In certain embodiments,
25 by virtue of the structure of the polynuclear ion, the positive or negative charges can be effectively distributed over substantially the entire structure of the ions. In some embodiments, the positive or negative charges can be somewhat localized over portions of the structure of the ions.

Electromagnetic Radiation

In embodiments in which the irradiating is performed with electromagnetic radiation, the electromagnetic radiation can have, e.g., energy per photon (in electron volts) of greater than 10^2 eV, e.g., greater than 10^3 , 10^4 , 10^5 , 10^6 , or even greater than 10^7 eV. In some embodiments, the electromagnetic radiation has energy per photon of between 10^4 and 10^7 , e.g., between 10^5 and 10^6 eV. The electromagnetic radiation can have a frequency of, e.g., greater than 10^{16} hz, greater than 10^{17} hz, 10^{18} , 10^{19} , 10^{20} , or even greater than 10^{21} hz. Typical doses may take values of greater than 1 Mrad (e.g., greater than 1 Mrad, greater than 2 Mrad). In some embodiments, the electromagnetic radiation has a frequency of between 10^{18} and 10^{22} hz, e.g., between 10^{19} to 10^{21} hz. In some embodiment doses between 1-100 Mrad (e.g., 2-80 Mrad, 5-50 Mrad, 5-40 Mrad, 5-30 Mrad or 5-20 Mrad) can be used.

Quenching and Controlled Functionalization

After treatment with ionizing radiation, any of the materials or mixtures described herein may become ionized; that is, the treated material may include radicals at levels that are detectable with an electron spin resonance spectrometer. If an ionized feedstock remains in the atmosphere, it will be oxidized, such as to an extent that carboxylic acid groups are generated by reacting with the atmospheric oxygen. In some instances with some materials, such oxidation is desired because it can aid in the further breakdown in molecular weight of the carbohydrate-containing biomass, and the oxidation groups, e.g., carboxylic acid groups can be helpful for solubility and microorganism utilization in some instances. However, since the radicals can “live” for some time after irradiation, e.g., longer than 1 day, 5 days, 30 days, 3 months, 6 months or even longer than 1 year, material properties can continue to change over time, which in some instances, can be undesirable. Thus, it may be desirable to quench the ionized material.

After ionization, any ionized material can be quenched to reduce the level of radicals in the ionized material, e.g., such that the radicals are no longer detectable with the electron spin resonance spectrometer. For example, the radicals can be quenched by the application of a sufficient pressure to the material and/or by utilizing a fluid in contact with the ionized material, such as a gas or liquid, that reacts with (quenches) the radicals.

Using a gas or liquid to at least aid in the quenching of the radicals can be used to functionalize the ionized material with a desired amount and kind of functional groups, such as carboxylic acid groups, enol groups, aldehyde groups, nitro groups, nitrile groups, amino groups, alkyl amino groups, alkyl groups, chloroalkyl groups or
5 chlorofluoroalkyl groups.

In some instances, such quenching can improve the stability of some of the ionized materials. For example, quenching can improve the resistance of the material to oxidation. Functionalization by quenching can also improve the solubility of any material described herein, can improve its thermal stability, and can improve material
10 utilization by various microorganisms. For example, the functional groups imparted to the material by the quenching can act as receptor sites for attachment by microorganisms, e.g., to enhance cellulose hydrolysis by various microorganisms.

In some embodiments, quenching includes an application of pressure to the ionized material, such as by mechanically deforming the material, e.g., directly
15 mechanically compressing the material in one, two, or three dimensions, or applying pressure to a fluid in which the material is immersed, e.g., isostatic pressing. In such instances, the deformation of the material itself brings radicals, which are often trapped in crystalline domains, in close enough proximity so that the radicals can recombine, or react with another group. In some instances, the pressure is applied together with the
20 application of heat, such as a sufficient quantity of heat to elevate the temperature of the material to above a melting point or softening point of a component of the material, such as cellulose or another polymer. Heat can improve molecular mobility in the material, which can aid in the quenching of the radicals. When pressure is utilized to quench, the pressure can be greater than about 1000 psi, such as greater than about 1250 psi, 1450
25 psi, 3625 psi, 5075 psi, 7250 psi, 10000 psi or even greater than 15000 psi.

In some embodiments, quenching includes contacting the ionized material with a fluid, such as a liquid or gas, e.g., a gas capable of reacting with the radicals, such as acetylene or a mixture of acetylene in nitrogen, ethylene, chlorinated ethylenes or chlorofluoroethylenes, propylene or mixtures of these gases. In other particular
30 embodiments, quenching includes contacting the ionized material with a liquid, e.g., a liquid soluble in, or at least capable of penetrating into the material and reacting with the

radicals, such as a diene, such as 1,5-cyclooctadiene. In some specific embodiments, quenching includes contacting the material with an antioxidant, such as Vitamin E. If desired, the feedstock can include an antioxidant dispersed therein, and the quenching can come from contacting the antioxidant dispersed in the feedstock with the radicals.

5 Functionalization can be enhanced by utilizing heavy charged ions, such as any of the heavier ions described herein. For example, if it is desired to enhance oxidation, charged oxygen ions can be utilized for the irradiation. If nitrogen functional groups are desired, nitrogen ions or anions that include nitrogen can be utilized. Likewise, if sulfur or phosphorus groups are desired, sulfur or phosphorus ions can be used in the
10 irradiation.

Doses

 In some instances, the irradiation is performed at a dosage rate of greater than about 0.25 Mrad per second, e.g., greater than about 0.5, 0.75, 1.0, 1.5, 2.0, or even greater than about 2.5 Mrad per second. In some embodiments, the irradiating is
15 performed at a dose rate of between 5.0 and 1500.0 kilorads/hour, e.g., between 10.0 and 750.0 kilorads/hour or between 50.0 and 350.0 kilorads/hour. In some embodiments, irradiation is performed at a dose rate of greater than about 0.25 Mrad per second, e.g., greater than about 0.5, 0.75, 1, 1.5, 2, 5, 7, 10, 12, 15, or even greater than about 20 Mrad per second, e.g., about 0.25 to 2 Mrad per second.

20 In some embodiments, the irradiating (with any radiation source or a combination of sources) is performed until the material receives a dose of 0.25 Mrad, e.g., at least 1.0, 2.5, 5.0, 8.0, 10, 15, 20, 25, 30, 35, 40, 50, or even at least 100 Mrad. In some embodiments, the irradiating is performed until the material receives a dose of between 1.0 Mrad and 6.0 Mrad, e.g., between 1.5 Mrad and 4.0 Mrad, 2 Mrad and 10 Mrad, 5
25 Mrad and 20 Mrad, 10 Mrad and 30 Mrad, 10 Mrad and 40 Mrad, or 20 Mrad and 50 Mrad. In some embodiments, the irradiating is performed until the material receives a dose of from about 0.1 Mrad to about 500 Mrad, from about 0.5 Mrad to about 200 Mrad, from about 1 Mrad to about 100 Mrad, or from about 5 Mrad to about 60 Mrad. In some embodiments, a relatively low dose of radiation is applied, e.g., less than 60 Mrad.

Sonication

Sonication can reduce the molecular weight and/or crystallinity of the polymers comprising the paper feedstock, e.g., cellulose. Sonication can also be used to sterilize the materials. As discussed above with regard to radiation, the process parameters used
5 for sonication can be varied depending on various factors.

In one method, a first material that includes cellulose having a first number average molecular weight (M_{N1}) is dispersed in a medium, such as water, and sonicated and/or otherwise cavitated, to provide a second material that includes cellulose having a second number average molecular weight (M_{N2}) lower than the first number average
10 molecular weight. The second material (or the first and second material in certain embodiments) can be combined with a microorganism (with or without enzyme treatment) that can utilize the second and/or first material to produce an intermediate or product.

Since the second material includes cellulose having a reduced molecular weight
15 relative to the first material, and in some instances, a reduced crystallinity as well, the second material is generally more dispersible, swellable, and/or soluble, e.g., in a solution containing a microorganism.

In some embodiments, the second number average molecular weight (M_{N2}) is lower than the first number average molecular weight (M_{N1}) by more than about 10
20 percent, e.g., more than about 15, 20, 25, 30, 35, 40, 50 percent, 60 percent, or even more than about 75 percent.

In some instances, the second material includes cellulose that has a crystallinity (C_2) that is lower than the crystallinity (C_1) of the cellulose of the first material. For example, (C_2) can be lower than (C_1) by more than about 10 percent, e.g., more than
25 about 15, 20, 25, 30, 35, 40, or even more than about 50 percent.

In some embodiments, the sonication medium is an aqueous medium. If desired, the medium can include an oxidant, such as a peroxide (e.g., hydrogen peroxide), a dispersing agent and/or a buffer. Examples of dispersing agents include ionic dispersing agents, e.g., sodium lauryl sulfate, and non-ionic dispersing agents, e.g., poly(ethylene
30 glycol).

In other embodiments, the sonication medium is non-aqueous. For example, the sonication can be performed in a hydrocarbon, e.g., toluene or heptane, an ether, e.g., diethyl ether or tetrahydrofuran, or even in a liquefied gas such as argon, xenon, or nitrogen.

5

Pyrolysis

One or more pyrolysis processing sequences can be used to process paper feedstock from a wide variety of different sources to extract useful substances from the materials, and to provide partially degraded materials which function as input to further processing steps and/or sequences. Pyrolysis can also be used to sterilize the materials. Pyrolysis conditions can be varied depending on the characteristics of the feedstock and/or other factors.

In one example, a first material that includes cellulose having a first number average molecular weight (M_{N1}) is pyrolyzed, e.g., by heating the first material in a tube furnace (in the presence or absence of oxygen), to provide a second material that includes cellulose having a second number average molecular weight (M_{N2}) lower than the first number average molecular weight.

Since the second material includes cellulose having a reduced molecular weight relative to the first material, and in some instances, a reduced crystallinity as well, the second material is generally more dispersible, swellable and/or soluble, e.g., in a solution containing a microorganism.

In some embodiments, the second number average molecular weight (M_{N2}) is lower than the first number average molecular weight (M_{N1}) by more than about 10 percent, e.g., more than about 15, 20, 25, 30, 35, 40, 50 percent, 60 percent, or even more than about 75 percent.

In some instances, the second material includes cellulose that has a crystallinity (C_2) that is lower than the crystallinity (C_1) of the cellulose of the first material. For example, (C_2) can be lower than (C_1) by more than about 10 percent, e.g., more than about 15, 20, 25, 30, 35, 40, or even more than about 50 percent.

In some embodiments, the pyrolysis of the materials is continuous. In other embodiments, the material is pyrolyzed for a pre-determined time, and then allowed to cool for a second pre-determined time before pyrolyzing again.

5 **Oxidation**

One or more oxidative processing sequences can be used to process paper feedstock from a wide variety of different sources to extract useful substances from the feedstock, and to provide partially degraded and/or altered feedstock which functions as input to further processing steps and/or sequences. The oxidation conditions can be
10 varied, e.g., depending on the lignin content of the feedstock, with a higher degree of oxidation generally being desired for higher lignin content feedstocks.

In one method, a first material that includes cellulose having a first number average molecular weight (M_{N1}) and having a first oxygen content (O_1) is oxidized, e.g., by heating the first material in a stream of air or oxygen-enriched air, to provide a second
15 material that includes cellulose having a second number average molecular weight (M_{N2}) and having a second oxygen content (O_2) higher than the first oxygen content (O_1).

The second number average molecular weight of the second material is generally lower than the first number average molecular weight of the first material. For example, the molecular weight may be reduced to the same extent as discussed above with respect
20 to the other physical treatments. The crystallinity of the second material may also be reduced to the same extent as discussed above with respect to the other physical treatments.

In some embodiments, the second oxygen content is at least about five percent higher than the first oxygen content, e.g., 7.5 percent higher, 10.0 percent higher, 12.5
25 percent higher, 15.0 percent higher or 17.5 percent higher. In some preferred embodiments, the second oxygen content is at least about 20.0 percent higher than the first oxygen content of the first material. Oxygen content is measured by elemental analysis by pyrolyzing a sample in a furnace operating at 1300 °C or higher. A suitable elemental analyzer is the LECO CHNS-932 analyzer with a VTF-900 high temperature
30 pyrolysis furnace.

Generally, oxidation of a material occurs in an oxidizing environment. For example, the oxidation can be effected or aided by pyrolysis in an oxidizing environment, such as in air or argon enriched in air. To aid in the oxidation, various chemical agents, such as oxidants, acids or bases can be added to the material prior to or during oxidation.

5 For example, a peroxide (e.g., benzoyl peroxide) can be added prior to oxidation.

Some oxidative methods of reducing recalcitrance in a paper feedstock employ Fenton-type chemistry. Such methods are disclosed, for example, in U.S. Serial No. 12/639,289, the complete disclosure of which is incorporated herein by reference.

10 Exemplary oxidants include peroxides, such as hydrogen peroxide and benzoyl peroxide, persulfates, such as ammonium persulfate, activated forms of oxygen, such as ozone, permanganates, such as potassium permanganate, perchlorates, such as sodium perchlorate, and hypochlorites, such as sodium hypochlorite (household bleach).

In some situations, pH is maintained at or below about 5.5 during contact, such as between 1 and 5, between 2 and 5, between 2.5 and 5 or between about 3 and 5.

15 Oxidation conditions can also include a contact period of between 2 and 12 hours, e.g., between 4 and 10 hours or between 5 and 8 hours. In some instances, temperature is maintained at or below 300 °C, e.g., at or below 250, 200, 150, 100 or 50 °C. In some instances, the temperature remains substantially ambient, e.g., at or about 20-25 °C.

20 In some embodiments, the one or more oxidants are applied as a gas, such as by generating ozone *in-situ* by irradiating the material through air with a beam of particles, such as electrons.

In some embodiments, the mixture further includes one or more hydroquinones, such as 2,5-dimethoxyhydroquinone (DMHQ) and/or one or more benzoquinones, such as 2,5-dimethoxy-1,4-benzoquinone (DMBQ), which can aid in electron transfer
25 reactions.

In some embodiments, the one or more oxidants are electrochemically-generated *in-situ*. For example, hydrogen peroxide and/or ozone can be electro-chemically produced within a contact or reaction vessel.

Other Processes To Solubilize, Reduce Recalcitrance Or To Functionalize

Any of the processes of this paragraph can be used alone without any of the processes described herein, or in combination with any of the processes described herein (in any order): steam explosion, chemical treatment (e.g., acid treatment (including concentrated and dilute acid treatment with mineral acids, such as sulfuric acid, hydrochloric acid and organic acids, such as trifluoroacetic acid) and/or base treatment (e.g., treatment with lime or sodium hydroxide)), UV treatment, screw extrusion treatment (see, e.g., U.S. Serial No. 13/099,151, solvent treatment (e.g., treatment with ionic liquids) and freeze milling (see, e.g., U.S. Serial No. 12/502,629 now U.S. Patent No. 7,900,857).

Saccharification

In order to convert the paper feedstock to fermentable sugars, the cellulose in the feedstock is hydrolyzed by a saccharifying agent, e.g., an enzyme, a process referred to as saccharification. The materials that include the cellulose are treated with the enzyme, e.g., by combining the material and the enzyme in a solvent, e.g., in an aqueous solution.

Enzymes and organisms that break down cellulose contain or manufacture various cellulolytic enzymes (cellulases), ligninases or various small molecule biomass-destroying metabolites. These enzymes may be a complex of enzymes that act synergistically to degrade crystalline cellulose. Examples of cellulolytic enzymes include: endoglucanases, cellobiohydrolases, and cellobiases (β -glucosidases). Referring to FIG. 3, a cellulosic substrate is initially hydrolyzed by endoglucanases at random locations producing oligomeric intermediates. These intermediates are then substrates for exo-splitting glucanases such as cellobiohydrolase to produce cellobiose from the ends of the cellulose polymer. Cellobiose is a water-soluble 1,4-linked dimer of glucose. Finally cellobiase cleaves cellobiose to yield glucose.

Suitable saccharifying agents are described, for example, in the Materials section below.

As noted above, a food-based nutrient source or nutrient package is preferably added prior to or during saccharification, and an enzyme is added that is selected to

release nutrients from the food-based nutrient source. Suitable enzymes are described, for example, in the Materials section below.

The saccharification process can be partially or completely performed in a tank (e.g., a tank having a volume of at least 4000, 40,000, 400,000 L or 1,000,000 L) in a manufacturing plant, and/or can be partially or completely performed in transit, e.g., in a rail car, tanker truck, or in a supertanker or the hold of a ship. The time required for complete saccharification will depend on the process conditions and the feedstock and enzyme used. If saccharification is performed in a manufacturing plant under controlled conditions, the cellulose may be substantially entirely converted to glucose in about 12-96 hours. If saccharification is performed partially or completely in transit, saccharification may take longer.

It is generally preferred that the tank contents be mixed during saccharification, e.g., using jet mixing as described in U.S. Applications Serial Nos. 12/782,694, 13/293,985 and 13/293,977, the full disclosure of which are incorporated by reference herein.

The addition of surfactants can enhance the rate of saccharification. Examples of surfactants include non-ionic surfactants, such as a Tween® 20 or Tween® 80 polyethylene glycol surfactants, ionic surfactants, or amphoteric surfactants.

It is generally preferred that the concentration of the resulting glucose solution be relatively high, e.g., greater than 40%, or greater than 50, 60, 70, 80, 90 or even greater than 95% by weight. This reduces the volume to be shipped, if saccharification and fermentation are performed at different locations, and also inhibits microbial growth in the solution. However, lower concentrations may be used, in which case it may be desirable to add an antimicrobial additive, e.g., a broad spectrum antibiotic, in a low concentration, e.g., 50 to 150 ppm. Other suitable antibiotics include amphotericin B, ampicillin, chloramphenicol, ciprofloxacin, gentamicin, hygromycin B, kanamycin, neomycin, penicillin, puromycin, streptomycin. Antibiotics will inhibit growth of microorganisms during transport and storage, and can be used at appropriate concentrations, e.g., between 15 and 1000 ppm by weight, e.g., between 25 and 500 ppm, or between 50 and 150 ppm. If desired, an antibiotic can be included even if the sugar concentration is relatively high.

A relatively high concentration solution can be obtained by limiting the amount of water added to the feedstock with the enzyme. The concentration can be controlled, e.g., by controlling how much saccharification takes place. For example, concentration can be increased by adding more feedstock to the solution. In order to keep the sugar that is
5 being produced in solution, a surfactant can be added, e.g., one of those discussed above. Solubility can also be increased by increasing the temperature of the solution. For example, the solution can be maintained at a temperature of 40-50°C, 60-80°C, or even higher.

In some embodiments, the feedstock is processed to convert it to a convenient and
10 concentrated solid material, e.g., in a powdered, granulate or particulate form. The concentrated material can be in a purified, or a raw or crude form. The concentrated form can have, for example, a total sugar concentration of between about 90 percent by weight and about 100 percent by weight, e.g., 92, 94, 96 or 98 percent by weight sugar. Such a form can be particularly cost effective to ship, e.g., to a bioprocessing facility, such as a
15 biofuel manufacturing plant. Such a form can also be advantageous to store and handle, easier to manufacture and becomes both an intermediate and a product, providing an option to the biorefinery as to which products to manufacture.

In some instances, the powdered, granulate or particulate material can also include one or more of the materials, e.g., additives or chemicals, described herein, such
20 as the food-based nutrient or nutrient package, a nitrogen source, e.g., urea, a surfactant, an enzyme, or any microorganism described herein. In some instances, all materials needed for a bio-process are combined in the powdered, granulate or particulate material. Such a form can be a particularly convenient form for transporting to a remote bioprocessing facility, such as a remote biofuels manufacturing facility. Such a form can
25 also be advantageous to store and handle.

In some instances, the powdered, granulate or particulate material (with or without added materials, such as additives and chemicals) can be treated by any of the physical treatments described in U.S. Serial No. 12/429,045, incorporated by reference
above. For example, irradiating the powdered, granulate or particulate material can
30 increase its solubility and can sterilize the material so that a bioprocessing facility can

integrate the material into their process directly as may be required for a contemplated intermediate or product.

In certain instances, the powdered, granulate or particulate material (with or without added materials, such as additives and chemicals) can be carried in a structure or a carrier for ease of transport, storage or handling. For example, the structure or carrier can include or incorporate a bag or liner, such as a degradable bag or liner. Such a form can be particularly useful for adding directly to a bioprocess system.

Fermentation

Microorganisms can produce a number of useful intermediates and products by fermenting a low molecular weight sugar produced by saccharifying the paper feedstock materials. For example, fermentation or other bioprocesses can produce alcohols, organic acids, hydrocarbons, hydrogen, proteins or mixtures of any of these materials.

Yeast and *Zymomonas* bacteria, for example, can be used for fermentation or conversion. Other microorganisms are discussed in the Materials section, below. The optimum pH for fermentations is about pH 4 to 7. For example, the optimum pH for yeast is from about pH 4 to 5, while the optimum pH for *Zymomonas* is from about pH 5 to 6. Typical fermentation times are about 24 to 168 hours (e.g., 24 to 96 hrs) with temperatures in the range of 20 °C to 40 °C (e.g., 26 °C to 40 °C), however thermophilic microorganisms prefer higher temperatures.

In some embodiments e.g., when anaerobic organisms are used, at least a portion of the fermentation is conducted in the absence of oxygen e.g., under a blanket of an inert gas such as N₂, Ar, He, CO₂ or mixtures thereof. Additionally, the mixture may have a constant purge of an inert gas flowing through the tank during part of or all of the fermentation. In some cases, anaerobic condition can be achieved or maintained by carbon dioxide production during the fermentation and no additional inert gas is needed.

In some embodiments, all or a portion of the fermentation process can be interrupted before the low molecular weight sugar is completely converted to a product (e.g, ethanol). The intermediate fermentation products include high concentrations of sugar and carbohydrates. The sugars and carbohydrates can be isolated as discussed below. These intermediate fermentation products can be used in preparation of food for

human or animal consumption. Additionally or alternatively, the intermediate fermentation products can be ground to a fine particle size in a stainless-steel laboratory mill to produce a flour-like substance.

The fermentations include the methods and products that are disclosed in U.S. Provisional Application Serial No. 61/579,559, filed December 22, 2012, and U.S. application 61/579,576, filed December 22, 2012 incorporated by reference herein in its entirety.

Mobile fermentors can be utilized, as described in U.S. Provisional Patent Application Serial 60/832,735, now Published International Application No. WO 2008/011598. Similarly, the saccharification equipment can be mobile. Further, saccharification and/or fermentation may be performed in part or entirely during transit.

Distillation

After fermentation, the resulting fluids can be distilled using, for example, a “beer column” to separate ethanol and other alcohols from the majority of water and residual solids. The vapor exiting the beer column can be, e.g., 35% by weight ethanol and can be fed to a rectification column. A mixture of nearly azeotropic (92.5%) ethanol and water from the rectification column can be purified to pure (99.5%) ethanol using vapor-phase molecular sieves. The beer column bottoms can be sent to the first effect of a three-effect evaporator. The rectification column reflux condenser can provide heat for this first effect. After the first effect, solids can be separated using a centrifuge and dried in a rotary dryer. A portion (25%) of the centrifuge effluent can be recycled to fermentation and the rest sent to the second and third evaporator effects. Most of the evaporator condensate can be returned to the process as fairly clean condensate with a small portion split off to waste water treatment to prevent build-up of low-boiling compounds.

25

Other Possible Processing of Sugars

Processing during or after saccharification can include isolation and/or concentration of sugars by chromatography e.g., simulated moving bed chromatography, precipitation, centrifugation, crystallization, solvent evaporation and combinations thereof. In addition, or optionally, processing can include isomerization of one or more of

30

the sugars in the sugar solution or suspension. Additionally, or optionally, the sugar solution or suspension can be chemically processed e.g., glucose and xylose can be hydrogenated to sorbitol and xylitol respectively. Hydrogenation can be accomplished by use of a catalyst e.g., Pt/ γ -Al₂O₃, Ru/C, Raney Nickel in combination with H₂ under high pressure e.g., 10 to 12000 psi.

Some possible processing steps are disclosed in in U.S. Provisional Application Serial No. 61/579,552, filed December 22, 2012, and in U.S. Provisional Application Serial No. 61/579,576 filed December 22, 2012, incorporated by reference herein in its entirety above.

REMOVING OF FILLERS, INKS, AND COATINGS

Paper feedstock used in the processes described can contain fillers, coatings, laminated material, pigments, inks and binders. These can be removed and either discarded or recycled as described here.

Inorganic fillers and coatings e.g., those described in the materials section below can be removed at any point during the process. For example, the inorganic filler and coating can be removed from the feedstock after a mechanical, physical or chemical treatment to reduce the recalcitrance of the feedstock; after combination with a fluid; after, during or before saccharification; after, during or before a purification step; after, during or before a fermentation step; and/or after, during or before a chemical conversion step. The fillers and coatings can be removed by any means e.g., by sedimentation, precipitation, ligand sequestration, filtration, floatation, chemical conversion and centrifugation. Some of the physical treatments discussed herein (see Physical Treatment section) can aid in separating the cellulosic materials from the inorganic fillers and coatings (e.g., mechanical treatments, chemical treatments, irradiation, pyrolysis, sonication and/or oxidation). The recovered inorganic fillers can be recycled or discarded.

Inks that are present can be removed from the feedstock at any point during the process. Inks can be a complex medium composed of several components e.g., solvents, pigments, dyes, resins, lubricants, solubilizers, surfactants, particulate matter and/or fluorescers. For example, printed papers, e.g., magazines and catalogs, may include high

levels of the pigments generally used in printing inks. In some cases the papers include metal-based pigments, organic pigments, and/or Lake pigments. For example, pigments that can be used are Yellow Lakes, Tartrazine Yellow Lake, Hansa Yellows, Diarylide Yellows, Yellow azo pigments, Fluorescent Yellow, Diarylide Orange, DNA Orange, Pyrazolone Orange, Fast Orange F2G, Benzimidazolone Orange HL, Ethyl Lake Red C, Para Reds, Toluidine Red, Carmine F.B., Naphthol Reds and Rubines, Permanent Red FRC, Bordeaux FRR, Rubine Reds, Lithol Reds, BON Red, Lithol Rubine 4B, BON Maroon, Rhodamine 6G, Lake Red C, BON Arylamide Red, Quinacrinone Magentas, Copper Ferrocyanide Pink, Benzimidazolone Carmines and Reds, Azo Magenta G, Anthraquinone Scarlet, Madder Lakes, Phthalocyanine Blues, PMTA Victoria Blue, Victoria Blue CFA, Ultramarine Blue, Indanthrene Blue, Alkali Blues, Peacock Blue, *Benzimidazolone Bordeaux HF 3R*, PMTA Rhodamine, PMTA Violet, Dioxazine Violet, Carbazole Violet, Crystal Violet, Dioxazine Violet B, Thioindigoid Red, Phthalocyanine Greens, PMTA Greens, *Benzimidazolone Brown HFR*, Cadmium Red, Cadmium Yellow, Cadmium Oranges, Cadmium-Mercury Reds, Iron Oxide Yellows, Irons Oxide Blues, Iron Oxide browns, Iron Oxide Reds, Ultramarine Blues, Ultramarine Violet, Chromium Antimony Titanium Buff, copper phthalocyanine blue, green copper phthalocyanine pigments, potash blue and soda blue pigments. The removal of ink may help improve certain parts in the process. For example, some ink can be toxic to microorganisms used in the process. The inks can also impart an undesirable coloration or toxicity to the final product. Furthermore, removing the inks may allow these to be recycled, improving the cost benefits to the process and lessening the environmental impact of the paper feedstock. The inks can be removed by any means. For example, removal may include dispersion, floatation, pressing and/or washing steps, extraction with solvents (e.g., supercritical CO₂, alcohol, water and organic solvents), settling, chemical means, sieving and/or precipitation. Some of the physical treatments discussed herein (see Physical Treatment section) can aid in separating the cellulosic materials from the inks (e.g., mechanical treatments, chemical treatments, irradiation, pyrolysis, sonication and/or oxidation). In addition enzymatic deinking technologies such as those disclosed in U.S. patent 7,297,224 hereby incorporated by reference herein, can be used.

Coating materials, e.g., those found in poly-coated paper described in the materials section below, can be removed from the feedstock at any point during the process. This can be done by, for example, the methods mentioned above for removal of pigments and inks and inorganic materials. In some cases, where polycoated paper is a laminate, de-lamination can be done by, for example, chemical and/or mechanical means. The non-cellulosic laminate portions can then be separated from the cellulose containing layers and discarded and/or recycled.

INTERMEDIATES AND PRODUCTS

The processes and nutrients discussed herein can be used to convert paper feedstocks to one or more products, such as energy, fuels, foods and materials. Specific examples of products include, but are not limited to, hydrogen, sugars (e.g., glucose, xylose, arabinose, mannose, galactose, fructose, disaccharides, oligosaccharides and polysaccharides), alcohols (e.g., monohydric alcohols or dihydric alcohols, such as ethanol, n-propanol, isobutanol, *sec*-butanol, tert-butanol or n-butanol), hydrated or hydrous alcohols, e.g., containing greater than 10%, 20%, 30% or even greater than 40% water, sugars, biodiesel, organic acids (e.g., acetic acid and/or lactic acid), hydrocarbons, e.g., methane, ethane, propane, isobutene, pentane, n-hexane, biodiesel, bio-gasoline and mixtures thereof, co-products (e.g., proteins, such as cellulolytic proteins (enzymes) or single cell proteins), and mixtures of any of these in any combination or relative concentration, and optionally in combination with any additives, e.g., fuel additives. Other examples include carboxylic acids, such as acetic acid or butyric acid, salts of a carboxylic acid, a mixture of carboxylic acids and salts of carboxylic acids and esters of carboxylic acids (e.g., methyl, ethyl and n-propyl esters), ketones, aldehydes, alpha, beta unsaturated acids, such as acrylic acid and olefins, such as ethylene. Other alcohols and alcohol derivatives include propanol, propylene glycol, 1,4-butanediol, 1,3-propanediol, sugar alcohols (e.g., erythritol, glycol, glycerol, sorbitol, threitol, arabitol, ribitol, mannitol, dulcitol, fucitol, iditol, isomalt, maltitol, lactitol, xylitol and other polyols), methyl or ethyl esters of any of these alcohols. Other products include methyl acrylate and methylmethacrylate. The product may also be an organic acid, e.g., lactic acid, formic acid, acetic acid, propionic acid, butyric acid, succinic acid, valeric acid, caproic,

palmitic acid, stearic acid, oxalic acid, malonic acid, glutaric acid, oleic acid, linoleic acid, glycolic acid, γ -hydroxybutyric acid, a mixture thereof, a salt of any of these acids, or a mixture of any of the acids and their respective salts.

Other intermediates and products, including food and pharmaceutical products,
5 are described in U.S. Serial No. 12/417,900, the full disclosure of which is hereby incorporated by reference herein.

MATERIALS

Paper Feedstocks

Suitable paper feedstocks include paper that is highly pigmented, coated or filled
10 and can have a low calorific value. Sources of such paper include magazines, catalogs, books, manuals, labels, calendars, greeting cards and other high quality printed materials such as prospectuses, brochures and the like. The papers may include at least 0.025% by weight of pigment, filler or coating, e.g., from 0 to 80%, 0 to 50%, 0.1 to 50%, 0.1 to 30%, 0.1 to 20%, 0.5 to 2.5%, 0.2 to 15%, 0.3 to 10%, 0.5 to 5%.

15 Other suitable paper feedstocks include high basis weight coated paper and/or paper with a high filler content i.e., at least 10 wt.%. These papers can be printed or unprinted. Examples of this type of feedstock include paper having a basis weight, as defined as the weight in pounds (lb) for a ream (500 sheets) of 25" X 38" sheets, of at least 35 lb., for example at least 45 lb., at least 50 lb., at least 60 lb, at least 70 lb. or at
20 least 80 lb. The feedstock includes paper having a basis weight below 330 lb., for example below about 300 lb, below about 250 lb, below about 200 lb, below about 150 lb, below about 120 lb, below about 110 lb, below about 105 lb or below about 100 lb. For example the basis weight may be between 35 lb and 330 lb, 35 lb and 120 lb, between 35 lb and 110 lb, between 35 lb and 100 lb, between 35 lb and 90 lb, between 45
25 lb and 120 lb, between 45 lb and 110 lb, between 45 lb and 100 lb, between 45 lb and 90 lb, between 50 lb and 120 lb, between 50 lb and 110 lb, between 50 lb and 100 lb, between 50 lb and 90 lb, between 60 lb and 120 lb, between 60 lb and 110 lb, between 60 lb and 100 lb, between 60 lb and 90 lb, between 60 lb and 120 lb, between 60 lb and 110 lb, between 60 lb and 100 lb, between 60 lb and 90 lb, between 70 lb and 120 lb, between
30 70 lb and 110 lb, between 70 lb and 100 lb, between 70 lb and 90 lb, between 90 lb and

330 lb, between 90 lb and 300 lb, between 90 lb and 250 lb, between 90 lb and 200 lb, between 90 lb and 150 lb, between 90 lb and 110 lb, between 110 lb and 330 lb, between 110 lb and 300 lb, between 110 lb and 250 lb, between 110 lb and 200 lb, between 110 lb and 150 lb, between 130 lb and 330 lb, between 130 lb and 300 lb, between 130 lb and 250 lb, between 130 lb and 200 lb, or between 130 lb and 150 lb, In some embodiments, the papers have relatively high density, e.g., greater than 1.11 g/cm^3 , in some cases from about 1.11 to 2 g/cm^3 e.g., 1.11 to 1.8 g/cm^2 , 1.11 to 1.6 g/cm^2 , 1.11 to 1.52 g/cm^2 , 1.2 to 1.8 g/cm^2 , 1.2 to 1.6 g/cm^2 , 1.2 to 1.52 g/cm^2 , 1.3 to 1.8 g/cm^2 , 1.3 to 1.6 g/cm^2 or 1.3 to 1.52 g/cm^2 Such papers often have a high ash content e.g., at least 8wt.%, at least 10 wt.%, at least 15 wt.% , at least 20 wt.% or at least 50 wt.%. The ash content can be between 8 and 50%, e.g., between 10 and 50%, between 20 and 50%, between 30 and 50%, between 10 and 40%, between 20 and 40%, between 10 and 30% or between 10 and 20%. The papers can have a high filler content, e.g., at least 10% by weight, e.g., at least 20 wt%, at least 30 wt%, at least 40 wt% or at least 50 wt%. Filler contents can be between 10 and 80%, e.g., between 20 and 80%, between 30 and 80%, between 40 and 80%, between 10 and 70%, between 20 and 70%, between 30 and 70%, between 40 and 70%, between 10 and 60%, between 20 and 60%, between 30 and 60% and between 40 and 60%. Suitable fillers include clays, oxides (e.g., titania, silica, alumina), carbonates (e.g., calcium carbonate), silicates (e.g., Talc) and aluminosilicates (e.g., Kaolin). One suitable grade of coated paper is referred to in the industry as Machine Finished Coated (MFC) paper. In other embodiments the paper can have a high surface density (i.e., Grammage), for example, at least 50 g/m^2 , at least 60 g/m^2 , at least 70 g/m^2 , at least 80 g/m^2 or at least 90 g/m^2 . The Grammage can be between 50 g/m^2 and 200 g/m^2 , between 50 g/m^2 and 175 g/m^2 , between 50 g/m^2 and 150 g/m^2 , between 50 g/m^2 and 125 g/m^2 , between 50 g/m^2 and 100 g/m^2 , between 60 g/m^2 and 200 g/m^2 , between 60 g/m^2 and 175 g/m^2 , between 60 g/m^2 and 150 g/m^2 , between 60 g/m^2 and 125 g/m^2 , between 60 g/m^2 and 100 g/m^2 , between 70 g/m^2 and 200 g/m^2 , between 70 g/m^2 and 175 g/m^2 , between 70 g/m^2 and 150 g/m^2 , between 70 g/m^2 and 125 g/m^2 , between 70 g/m^2 and 100 g/m^2 , between 80 g/m^2 and 200 g/m^2 , between 80 g/m^2 and 175 g/m^2 , between 80 g/m^2 and 150 g/m^2 , between 80 g/m^2 and 125 g/m^2 , between 80 g/m^2 and 100 g/m^2 , between 130 g/m^2 and 500 g/m^2 , between 130 g/m^2 and 450 g/m^2 , between 130 g/m^2 and 350 g/m^2 , between

130 g/m² and 300 g/m², between 130 g/m² and 250 g/m², between 130 g/m² and 200 g/m², between 130 g/m² and 175 g/m², between 130 g/m² and 150 g/m², between 200 g/m² and 500 g/m², between 200 g/m² and 450 g/m², between 200 g/m² and 350 g/m², between 200 g/m² and 300 g/m², between 200 g/m² and 250 g/m², between 250 g/m² and 500 g/m², between 250 g/m² and 450 g/m², between 250 g/m² and 350 g/m², between 250 g/m² and 300 g/m², between 200 g/m² and 250 g/m², between 300 g/m² and 500 g/m², between 300 g/m² and 450 g/m², or between 300 g/m² and 350 g/m².

Coated papers are well known in the paper art, and are disclosed, for example, in U.S. Patent Nos. 6,777,075; 6,783,804, and 7,625,441, the full disclosures of which are incorporated herein by reference.

Coated papers suitable as feedstock can include paper coated with an inorganic material, for example the same materials used as fillers can be used in coatings. Additionally, coated papers can include paper coated with a polymer (poly-coated paper). Such paper can be made, for example, by extrusion coating, brush coating, curtain coating, blade coating, air knife coating, cast coating or roller coating paper. For example, sources of such poly-coated paper include a variety of food containers, including juice cartons, condiment pouches (e.g., sugar, salt, pepper), plates, pet food bags, cups, bowls, trays and boxes for frozen foods. The poly-coated paper can, in addition to paper, contain, for example, polymers, (e.g., polyethylene, polypropylene, biodegradable polymers, silicone), latexes, binders, wax, and, in some cases, one or more layers of aluminum. The poly coated papers can be multi layered laminate, for example, made with one or more, e.g., two, three, four, five or more, layers of polyethylene and paper and one or more, e.g., two, three or more layers of aluminum.

The paper feedstocks typically have a low gross caloric value e.g., below 7500 Btu/lb e.g, below 7400 Btu/lb, below 7200 Btu/lb, below 7000 Btu/lb, below 6800 Btu/lb, below 6600 Btu/lb, below 6400 Btu/lb, below 6200 Btu/lb, below 6000 Btu/lb, below 5800 Btu/lb, below 5600 Btu/lb, below 5400 Btu/lb or below 5200 Btu/lb. The gross calorific value can be between about 5200 and 7500 Btu/lb e.g., between 6800 and 7000 Btu/lb, between 6700 and 7100 Btu/lb, between 6400 and 7100 Btu/lb, between 6600 and 6800 Btu/lb, between 6100 and 6700 Btu/lb, between 6100 and 6300 Btu/lb, between 6000 and 6350 Btu/lb, between 5600 and 6400 Btu/lb or between 5200 and 5500 Btu/lb.

The gross calorific value can be measure using a bomb calorimeter e.g., as outlined in ASTM method E711.

The paper feedstock can have a basis weight between 35 lb and 330 lb, e.g. 45 lb and 330 lb, 60 and 330 lb, 80 and 330 lb, 60 and 200 lb, 60 and 100 lb; optionally a filler content greater than about 10 wt.%, e.g., between 10 and 80 wt.%, between 20 and 80 wt.%, between 30 and 80 wt.%, between 30 and 70 wt.%, between 230 and 60 wt.%; optionally a grammage between 50 and 500 g/m², e.g., 70 and 500 g/m², 90 and 500 g/m², 90 and 400 g/m², 90 and 300 g/m², 90 and 200 g/m²; and optionally a calorific value between 7500 and 4000 Btu/lb, e.g., 7000 and 4000 Btu/lb, 6500 and 4000 Btu/lb, 5000 and 4000 Btu/lb, 6000 and 4500 Btu/lb; optionally an ash content between 8 and 50 wt.%, e.g., 10 and 80 wt.%, 10 and 60 wt.%, 10 and 50 wt.%, 20 and 50 wt.%.

Some suitable paper feedstock can include a homogeneous sheet formed by irregularly intertwining cellulose fibers. These can include, for example, Abrasive Papers, Absorbent Paper, Acid Free Paper, Acid Proof Paper, Account Book Paper, Adhesive Paper, Air Dried Paper, Air Filter Paper, Album Paper, Albumin Paper, Alkaline Paper, Alligator Imitation Paper, Aluminum Foil Laminated paper, Ammunition Paper, Announcement Card Paper, Anti Rust Paper, Anti-Tarnish Paper, Antique Paper, Archival Paper, Art Paper, Asphalt Laminated Paper, Azurelaid Paper, Back Liner Paper, Bacon Paper, Bagasse Paper, Bakers' Wrap, Balloon Paper, Banknote or Currency Paper, Barograph Paper, Barrier Paper, Baryta Paper, Beedi Wrap Paper, Bible Paper, Black Waterproof Paper, Blade Wrapping Paper, Bloodproof Paper or Butcher Paper, Blotting Paper, Blueprint Paper, Board, Bogus Paper, Bond Paper, Book Paper, Boxboard, Braille Printing Paper, Bread Wrapping Paper, Bristol Board, Business Form Paper, Butter Wrapping Paper, Burnt Paper, Cable Paper, Calf Paper, Calico Paper, Candy Twisting Tissue, Canvas Paper, Carbonless Paper, Cardboard, Corrugated Cardboard, Carton board, Cartridge paper, Cast Coated Paper, Catalogue Paper, Chart Paper, Check Paper, Cheese Wrapping Paper, Chipboard, Chromo, Coarse Paper (also Industrial Paper), Coated freesheet, Coated Paper, Coated White Top Liner, Cockle Finish Paper, Color-fast papers, Commodity Paper, Colored Kraft, Condenser Tissue, Construction Paper, Containerboard, Copier Paper or Laser Paper, Correspondence Papers, Corrugated Board, Corrugated Medium or Fluting Media or Media, Cotton Paper or Rag Paper, Cover Paper

or Cover Stock, Creamwove Paper, Cut Sheet, Damask Paper, Decalcomania Paper,
 Diazo Base Paper, Document Paper, Drawing Paper, Duplex Board, Duplex Paper, End-
 leaf Paper, Envelop Paper, Esparto Paper, Extensible Kraft, Extrusion Coated Board, Fax
 Base Paper, Flame Resistant, Flocked Paper, Fluorescent Paper, Folding Boxboard, Form
 5 Bond, Freesheet, Fruit Wrapping Paper, Gasket Board, Glassine Paper, Glazed Paper,
 Granite Paper, Gravure Paper, Gray Board, Greaseproof Paper, Green Paper,
 Groundwood Papers, Gummed Paper, Gypsum Board, Handmade Paper, Hanging Paper,
 Hard Sized Paper, Heat Seal Paper, Heat Transfer Paper, Hi-Fi (High Finish) Paper,
 Industrial Papers, Insect Resistant, Insulating Board, Ivory Board, Japan Paper, Jute
 10 Paper, Kraft Bag Paper, Kraft liner, Kraft Paper, Kraft Waterproof Paper, Kraft Wrapping
 Paper, Label Paper, Lace Paper, Laid Paper, Laminated Paper, Laminated Linerboard,
 Latex Paper, Ledger Paper, Lightproof Paper, Liner, Linerboard, Litmus Paper, On
 Machine Coated, Magazine Paper, Manila, Map Paper, Marble Paper, Matrix Paper, Matt
 Finished Paper, Mechanical Paper, Mellow Paper, Metalization Base Paper, Machine
 15 Finished Paper, Machine glazed Paper, Millboard, Mulberry Paper, Natural Colored
 Papers or Self Colored Papers, Newsprint, Oatmeal Paper, Offset Paper, Packaging
 Paper, Paperboard, Pattern Paper, Permanent Paper, Photographic Paper, Playing Card
 Stock, Pleading Paper, Poly Extrusion Paper, Postcard Board, Post-Consumer Waste
 Paper, Poster Paper, Pre-Consumer Waste Paper, Pressure Sensitive Coated Paper,
 20 Publishing Paper, Pulp Board, Release Paper, Roofing Paper, Safety Paper, Security
 paper, Self Adhesive Paper, Self Contained Paper, Silicon Treated Paper, Single Faced
 Corrugated Board, Sized Paper, Stamp Paper, Strawboard, Suede Paper, Supercalendered
 Paper, Surface-Sized, Super Art Paper, Synthetic Fiber Paper, Tag Paper, Testliner, Text
 Paper, Thermal Paper, Translucent Drawing Paper, Transparent Paper, Treated Paper,
 25 Union Kraft, Unglazed Paper, Un-sized Paper, Vaporproof Paper, Varnish-Label Paper,
 Vegetable Parchment, Vellum Paper, Velour Paper, Velvet Finish Paper, Vulcanizing
 Paper, Wadding, Wall Paper, Water-Color Paper, Water Finished Paper, Water Resistant
 Paper, Waterleaf, Waxed Paper, Wet Strength Paper, White Top Liner, Willesden Paper,
 Wipes or Wiper, Wove, Wrapper, Writing Paper and Xerographic Paper.

30 The feedstocks described herein can be used in combination with any of the

biomass feedstocks described in U.S. Application Serial No. 12/417,880, filed April 3, 2009, incorporated by reference herein in its entirety.

Saccharifying Agents

5 Suitable enzymes include cellobiases and cellulases capable of degrading biomass.

 Suitable cellobiases include a cellobiase from *Aspergillus niger* sold under the tradename NOVOZYME 188™.

 Cellulases are capable of degrading biomass, and may be of fungal or bacterial
10 origin. Suitable enzymes include cellulases from the genera *Bacillus*, *Pseudomonas*,
Humicola, *Fusarium*, *Thielavia*, *Acremonium*, *Chrysosporium* and *Trichoderma*, and
include species of *Humicola*, *Coprinus*, *Thielavia*, *Fusarium*, *Myceliophthora*,
Acremonium, *Cephalosporium*, *Scytalidium*, *Penicillium* or *Aspergillus* (see, e.g., EP
458162), especially those produced by a strain selected from the species *Humicola*
15 *insolens* (reclassified as *Scytalidium thermophilum*, see, e.g., U.S. Patent No. 4,435,307),
Coprinus cinereus, *Fusarium oxysporum*, *Myceliophthora thermophila*, *Meripilus*
giganteus, *Thielavia terrestris*, *Acremonium* sp., *Acremonium persicinum*, *Acremonium*
acremonium, *Acremonium brachypenium*, *Acremonium dichromosporum*, *Acremonium*
obclavatum, *Acremonium pinkertoniae*, *Acremonium roseogriseum*, *Acremonium*
20 *incoloratum*, and *Acremonium furatum*; preferably from the species *Humicola insolens*
DSM 1800, *Fusarium oxysporum* DSM 2672, *Myceliophthora thermophila* CBS 117.65,
Cephalosporium sp. RYM-202, *Acremonium* sp. CBS 478.94, *Acremonium* sp. CBS
265.95, *Acremonium persicinum* CBS 169.65, *Acremonium acremonium* AHU 9519,
Cephalosporium sp. CBS 535.71, *Acremonium brachypenium* CBS 866.73, *Acremonium*
25 *dichromosporum* CBS 683.73, *Acremonium obclavatum* CBS 311.74, *Acremonium*
pinkertoniae CBS 157.70, *Acremonium roseogriseum* CBS 134.56, *Acremonium*
incoloratum CBS 146.62, and *Acremonium furatum* CBS 299.70H. Cellulolytic enzymes
may also be obtained from *Chrysosporium*, preferably a strain of *Chrysosporium*
lucknowense. Additionally, *Trichoderma* (particularly *Trichoderma viride*, *Trichoderma*
30 *reesei*, and *Trichoderma koningii*), alkalophilic *Bacillus* (see, for example, U.S. Patent
No. 3,844,890 and EP 458162), and *Streptomyces* (see, e.g., EP 458162) may be used.

Enzyme complexes may be utilized, such as those available from Genencor® under the tradename ACCELLERASE®, for example, Accellerase® 1500 enzyme complex. Accellerase 1500 enzyme complex contains multiple enzyme activities, mainly exoglucanase, endoglucanase (2200-2800 CMC U/g), hemi-cellulase, and beta-glucosidase (525-775 pNPG U/g), and has a pH of 4.6 to 5.0. The endoglucanase activity of the enzyme complex is expressed in carboxymethylcellulose activity units (CMC U), while the beta-glucosidase activity is reported in pNP-glucoside activity units (pNPG U). In one embodiment, a blend of Accellerase® 1500 enzyme complex and NOVOZYME™ 188 cellobiase is used.

Fermentation Agents

The microorganism(s) used in fermentation can be natural microorganisms and/or engineered microorganisms. For example, the microorganism can be a bacterium, e.g., a cellulolytic bacterium, a fungus, e.g., a yeast, a plant or a protist, e.g., an algae, a protozoa or a fungus-like protist, e.g., a slime mold. When the organisms are compatible, mixtures of organisms can be utilized.

Suitable fermenting microorganisms have the ability to convert carbohydrates, such as glucose, fructose, xylose, arabinose, mannose, galactose, oligosaccharides or polysaccharides into fermentation products. Fermenting microorganisms include strains of the genus *Sacchromyces spp.* e.g., *Sacchromyces cerevisiae* (baker's yeast), *Saccharomyces distaticus*, *Saccharomyces uvarum*; the genus *Kluyveromyces*, e.g., species *Kluyveromyces marxianus*, *Kluyveromyces fragilis*; the genus *Candida*, e.g., *Candida pseudotropicalis*, and *Candida brassicae*, *Pichia stipitis* (a relative of *Candida shehatae*, the genus *Clavispora*, e.g., species *Clavispora lusitaniae* and *Clavispora opuntiae*, the genus *Pachysolen*, e.g., species *Pachysolen tannophilus*, the genus *Bretannomyces*, e.g., species *Bretannomyces clausenii* (Philippidis, G. P., 1996, Cellulose bioconversion technology, in Handbook on Bioethanol: Production and Utilization, Wyman, C.E., ed., Taylor & Francis, Washington, DC, 179-212). Other suitable microorganisms include, for example, *Zymomonas mobilis*, *Clostridium thermocellum* (Philippidis, 1996, *supra*), *Clostridium saccharobutylaceticum*, *Clostridium saccharobutylicum*, *Clostridium Puniceum*, *Clostridium beijerinckii*,

Clostridium acetobutylicum, *Moniliella pollinis*, *Yarrowia lipolytica*, *Aureobasidium* sp., *Trichosporonoides* sp., *Trigonopsis variabilis*, *Trichosporon* sp., *Moniliellaacetoabutans*, *Typhula variabilis*, *Candida magnoliae*, *Ustilaginomycetes*, *Pseudozyma tsukubaensis*, yeast species of genera *Zygosaccharomyces*, *Debaryomyces*, *Hansenula* and *Pichia*, and
5 fungi of the dematioid genus *Torula*.

Commercially available yeasts include, for example, Red Star®/Lesaffre Ethanol Red (available from Red Star/Lesaffre, USA), FALI® (available from Fleischmann's Yeast, a division of Burns Philip Food Inc., USA), SUPERSTART® (available from Alltech, now Lalemand), GERT STRAND® (available from Gert Strand AB, Sweden)
10 and FERMOL® (available from DSM Specialties).

Nutrient Package Ingredients

As discussed above, it may be preferred to include a nutrient package in the system during saccharification and/or fermentation. Preferred nutrient packages contain a food-based nutrient source, a nitrogen source, and in some cases other ingredients, e.g.,
15 phosphates. Suitable food-based nutrient sources include grains and vegetables, including those discussed above and many others. The food-based nutrient source may include mixtures of two or more grains and/or vegetables. Such nutrient sources and packages are disclosed in U.S. Application Serial No. 13/184,138, incorporated by reference herein in its entirety above.

Enzymes for Releasing Nutrients

When a food-based nutrient source is utilized, it is preferred that the saccharification and/or fermentation mixture further include an enzyme system selected to release nutrients, e.g., nitrogen, amino acids, and fats, from the food-based nutrient source. For
25 example, the enzyme system may include one or more enzymes selected from the group consisting of amylases, proteases, and mixtures thereof. Such systems are disclosed in U.S. Application Serial No. 13/184,138, incorporated by reference herein in its entirety.

Fuel Cells

30 Where the methods described herein produce a sugar solution or suspension, this solution or suspension can subsequently be used in a fuel cell. For example, fuel cells utilizing

sugars derived from cellulosic or lignocellulosic materials are disclosed in U.S. Provisional Application Serial No. 61/579,568, filed December 22, 2011, the complete disclosure of which is incorporated herein by reference.

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OTHER EMBODIMENTS

A number of embodiments of the invention have been described. Nevertheless, it will be understood that various modifications may be made without departing from the spirit and scope of the invention.

For example, while it is possible to perform all the processes described herein at one physical location, in some embodiments, the processes are completed at multiple sites, and/or may be performed during transport.

Accordingly, other embodiments are within the scope of the following claims.

CLAIMS:

1. A method of producing a sugar comprising
 - providing a paper with a filler content of greater than 10 wt.% and an ash content of at least 8 wt.%;
 - 5 combining the paper with a saccharifying agent comprising an enzyme, in a tank, and using jet mixing to mix the tank contents during saccharification.
 2. The method of claim 1 wherein the filler content is at least 20 wt.%;
 3. The method of claim 1 or 2 wherein the paper further comprises a printing ink.
 4. The method of any one of claims 1 to 3 wherein the paper is in the form of magazines.
 - 10 5. The method of any one of claims 1 to 4 further comprising adding a food-based nutrient source to the mixture.
 6. The method of any one of claims 1 to 5 further comprising adding a microorganism to the paper and producing a product or intermediate.
 7. The method of claim 5 wherein the food-based nutrient source is selected from the
 - 15 group consisting of grains, vegetables, residues of grains, residues of vegetables, and mixtures thereof.
 8. The method of claim 6 wherein the product comprises a fuel selected from the group consisting of hydrogen, alcohols, organic acids, hydrocarbons, and mixtures thereof.
 9. The method of claim 6 wherein the microorganism comprises a yeast and/or a bacteria.
 - 20 10. The method of any one of claims 1 to 9 further comprising physically treating the paper.
 11. The method of any one of claims 1 to 10 further comprising processing the sugar.

12. The method of claim 11 wherein processing comprises separating xylose and/or glucose from the sugar.

13. The method of any one of claims 1 to 12 wherein saccharification is conducted at a pH of about 3.8 to 4.2.

5 14. The method of claim 10 wherein the physical treatment comprises mechanically treating the paper to reduce the bulk density of the paper and/or increase the BET surface area of the paper.

15. The method of claim 5 wherein the food-based nutrient source is selected from the group consisting of wheat, oats, barley, soybeans, peas, legumes, potatoes, corn, rice bran, corn
10 meal, wheat bran, and mixtures thereof.

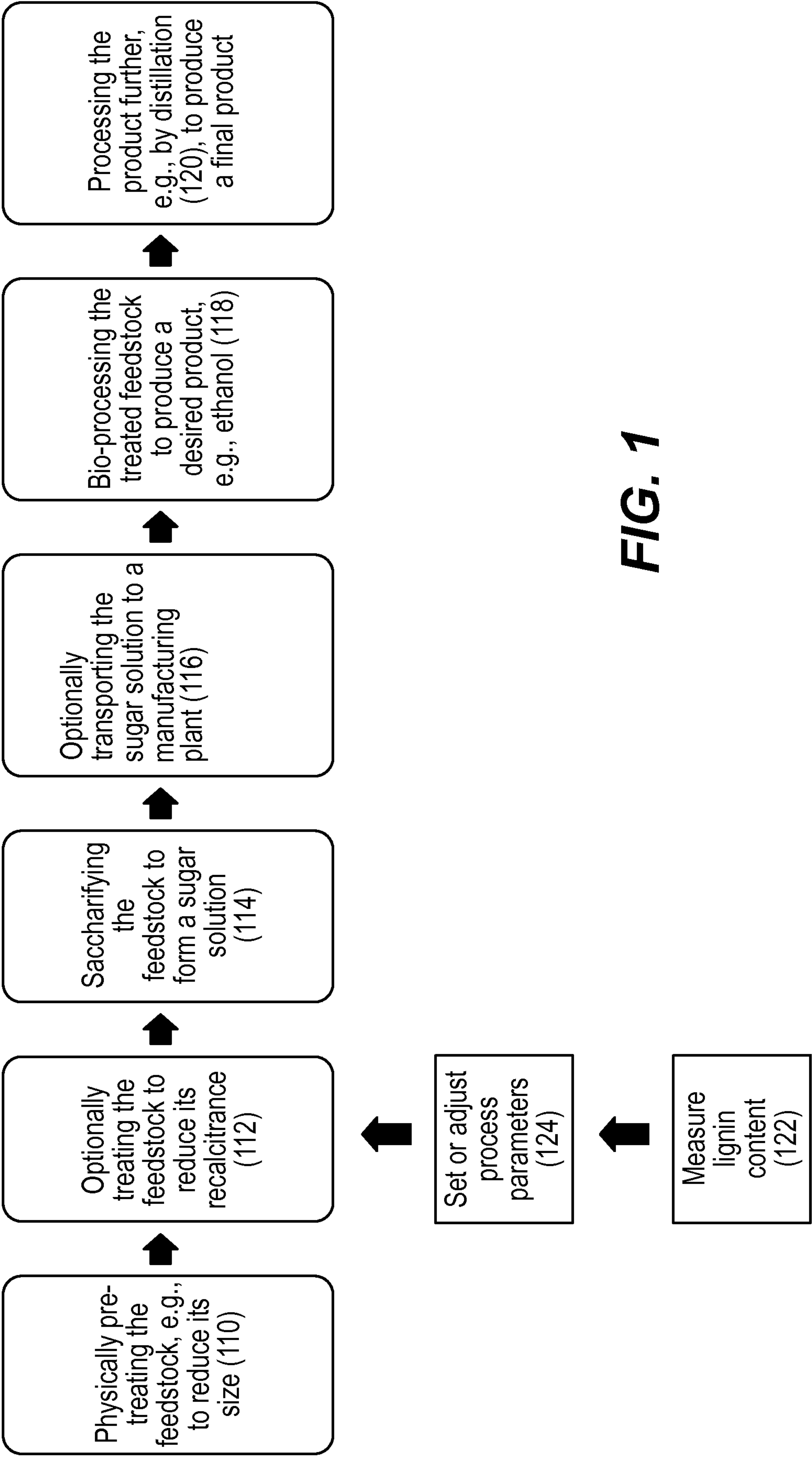
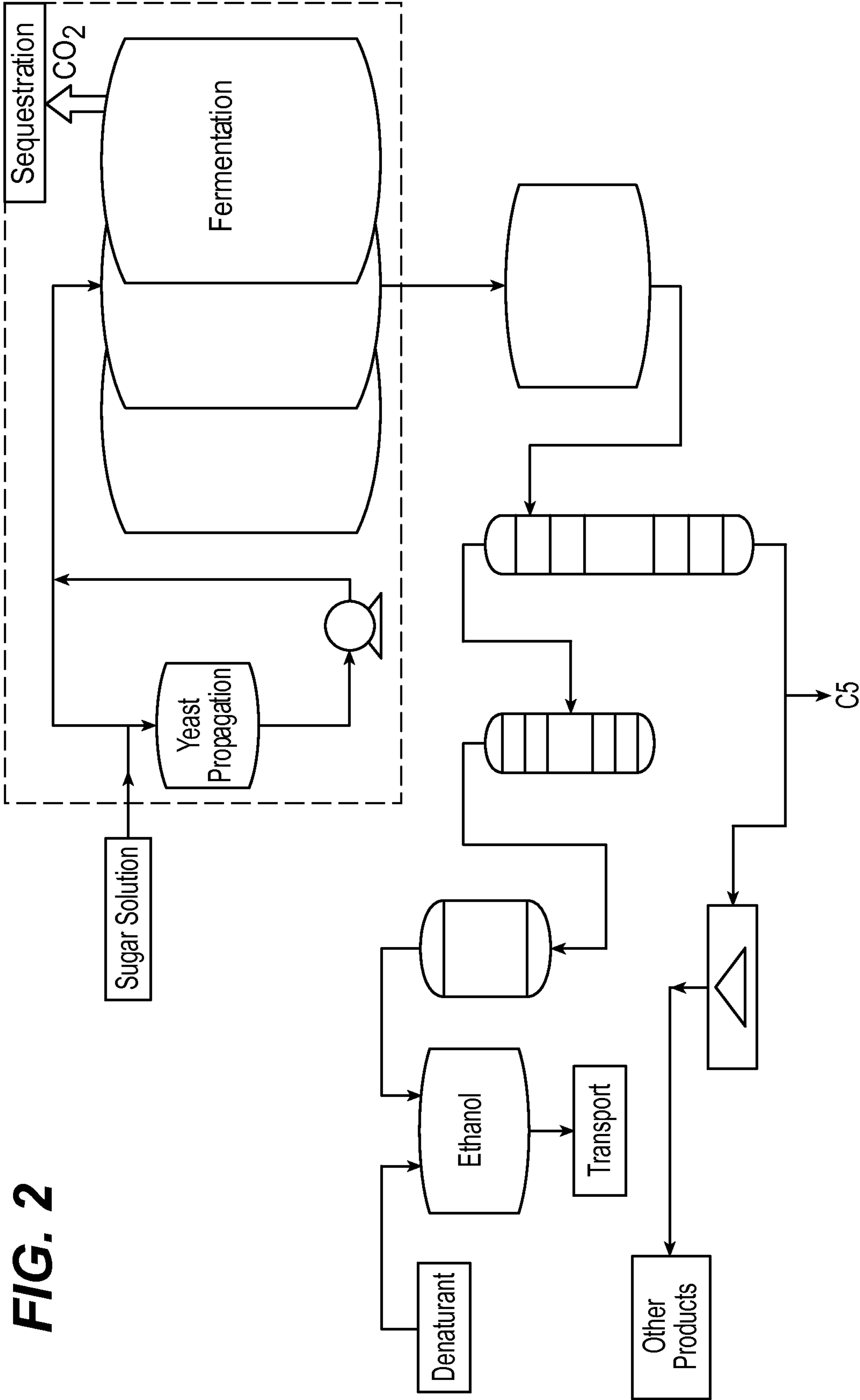


FIG. 1



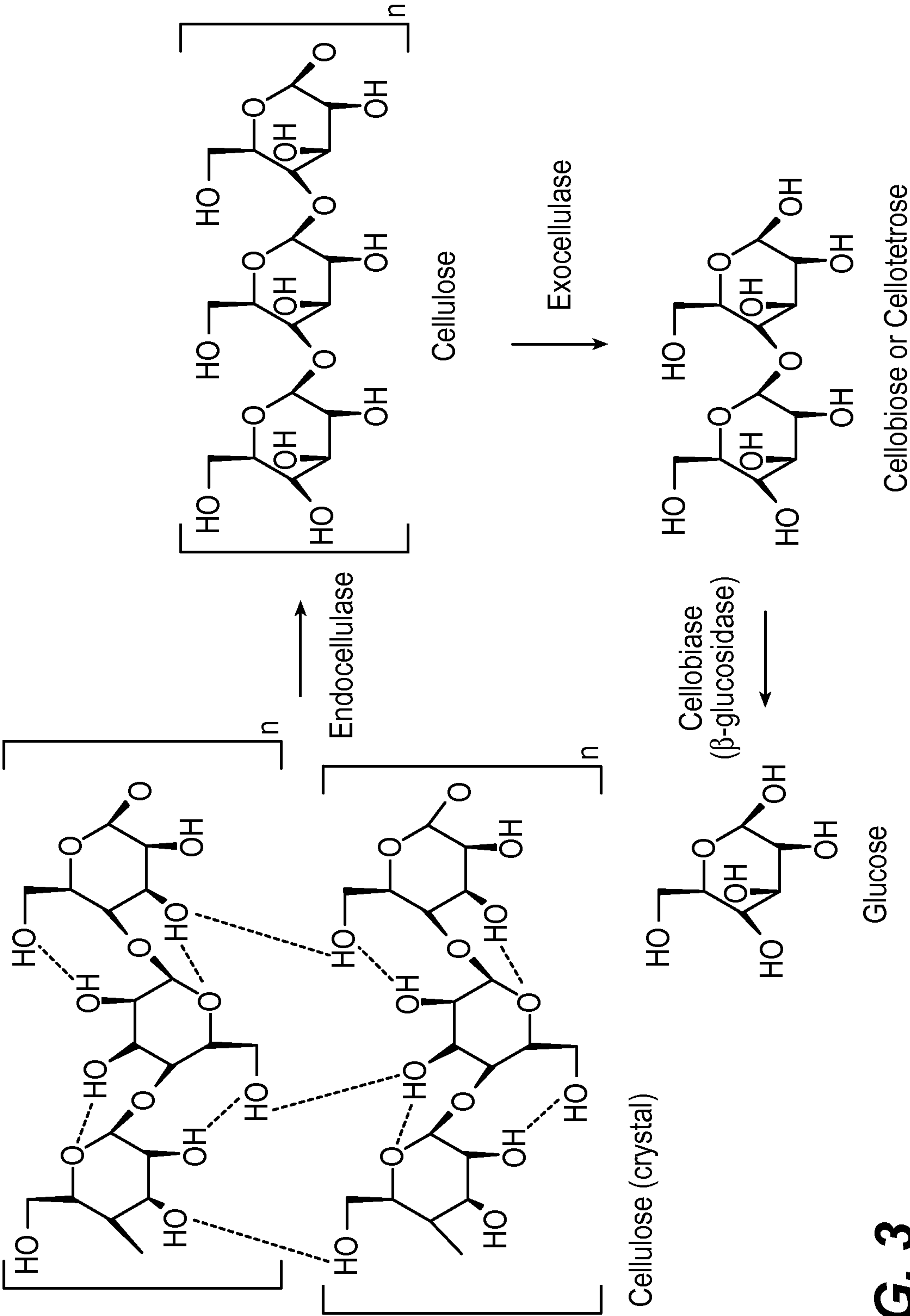


FIG. 3

