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(54) Title: COUNTERCURRENT RARE EARTH SEPARATION PROCESS

(57) Abstract: A method for extracting a rare earth metal from a mixture of one or more rare earth metals, said method comprising countercurrently contacting an acidic solution of the rare earth metal with a composition which comprises an ionic liquid to form an aqueous phase and a non- aqueous phase into which the rare earth metal has been selectively extracted.

COUNTERCURRENT RARE EARTH SEPARATION PROCESS

The present invention relates to the extraction and separation of rare earth metals. In particular, the present invention relates to the extraction and separation of rare earth metals using specifically designed ionic liquids.

BACKGROUND

Rare earth metals, which include the lanthanides (La to Lu), Y, and Sc, have unique physicochemical properties which make them crucial components of numerous high-tech products and environmental technologies such as wind mills, LCD/LED displays, phosphors, magnet drives (hard disk), and others. These applications demand a continuous supply of high purity rare earth metals to the industries, which is currently met by mining and processing the natural ores of these metals. However, there are concerns that the exponentially increasing demand of these metals will surpass the supply in coming years and therefore, it has become attractive to explore other secondary sources of these valuable metals. One such source is the recovery of rare earth metals from end-of-life and manufacturing wastes materials (often referred to as "urban mining"), which, though quite challenging, can potentially provide a continuous supply of the rare earth metals. One of most important requirements of urban mining is the development of cost effective and robust separation processes/technologies which allow selective and efficient separation of rare earth metals from each other (intra-group separation) to provide high purity rare earth metals.

During the last five decades various processes such as liquid-liquid extraction (*e.g.* Rhône-Poulenc process), ion exchange, and precipitation have been developed. Among the various available technologies, liquid-liquid extraction has been found to be the most suitable commercial process owing to its scalability, adaptability, and recyclability. Additionally, the liquid-liquid extraction processes used to date employ commercial organophosphorus extractants which do not possess specific selectivity for individual rare earth metals, thereby leading to a number of stages to separate rare earth metals from each other (see Table 1). Furthermore, additional processing steps are generally required to recover the rare earth metal in high purity. These factors lead to manifold increase in processing costs thereby putting strain on overall costing of consumer products. Also, most employed methods for the separation of rare earth metals necessitate the use of organic solvents, which due to their toxicity, volatility and flammability are not considered environmentally friendly.

Some of the currently used industrial liquid-liquid extraction processes available for intra-group separation of rare earth metals (*e.g.* separation of dysprosium from neodymium) are compared in Table 1.

5   The separation factor for an individual rare earth metal pair is expressed as the ratio of the distribution ratios (D_M) of the rare earth metals, where the distribution ratio of an individual rare earth metal is determined as the ratio of its concentration in the non-aqueous phase to that in the aqueous phase *i.e.* $D_M = [M]_{N-Aq}/[M]_{Aq}$. For example, the separation factor of Dysprosium with respect to Neodymium = D_{Dy}/D_{Nd}.

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Table 1: Comparison of the separation factors of commonly used REM extractants.

Liquid-liquid extraction	Major component	Separation factor	Reference
HDEHP process	Bis-(2-ethylhexyl)-phosphoric acid	41.5 (Dy/Nd)	C. K. Gupta, N. Krishnamurthy, Extractive Metallurgy of Rare Earths, CRC, New York, 2005, pp. 1-484.
Cyanex 272 process	Bis-(2,4,4-trimethylpentyl) phosphinic acid	1.36 (Dy/Nd)	B. Swain, E.O. Otu, Separation and Purification Technology, 83, (2011), 82-90
Cyanex 302 process	Bis-(2,4,4-trimethylpentyl)-monothiophosphinic acid	239.3 (Dy/Nd)	M. Yuan, A. Luo, D. Li, Acta Metall. Sin. 1995, 8, 10-14.
Synergist process	2-ethylhexylphosphonic acid mono-(2-ethylhexyl)ester; *sec*-nonylphenoxy acetic acid	1.17 (Dy/Nd)	N. Song, S. Tong, W. Liu, Q.Jia, W.Zhoua and W.Liaob, J. Chem. Technol. Biotechnol., 2009, 84, 1798-1802.

Another of the most commonly used organophosphorous extractants, P507 (2-ethylhexyl phosphoric acid mono(2-ethylhexyl) ester), also gives low separation factors, with the

15   selectivity for heavy rare earth metals generally being lower than for light rare earth metals (*e.g.* Tm/Er (3.34), Yb/Tm (3.56), and Lu/Yb (1.78)). Another significant deficiency of many common rare earth metal extractants such as P507 is that it is difficult to strip heavy rare earth metals completely, especially for Tm(III), Yb(III), and Lu(III), even at higher acidity. Low selectivity for rare earth metals results in too many stages required for effective separation,

20   the low extractability of rare earth metals demanding the use of higher concentrations of the

extractant. The production of organophosphorous extractants also requires complicated synthetic procedures starting from hazardous starting materials and the stability and recyclability of these extractants is limited. Emulsification and leaching of extractants has been identified as another common problem.

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A chelating diamide extractant attached to a silica support was reported by Fryxell *et al.* for the separation of lanthanides (*Inorganic Chemistry Communications*, 2011, *14*, 971-974). However, this system was unable to extract rare earth metals under acidic conditions (pH < 5) and crucially showed very low uptake and separation factors between rare earth metals.

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Ionic liquids have also been used as potential extractants for rare earth metals. Binnemans *et al.* reported the extraction of Nd and Dy or Y and Eu from mixtures of transition metal compounds with a betainium bis(trifluoromethyl-sulfonyl)imide ionic liquid (*Green Chemistry*, 2015, *17*, 2150-2163; *Green Chemistry*, 2015, *17*, 856-868). However, this system was

15 unable to selectively perform intra-group separation between rare earth metals.

Chai *et al.* reported the use of an ionic liquid based on 2-ethylhexyl phosphonic acid mono(2-ethylhexyl) ester (P507) with a trioctylmethylammonium cation for separation of rare earth metals (*Hydrometallurgy*, 2015, *157(C)*, 256-260). In this case only low distribution factors

20 and separation factors were observed, indicating a lack of extractability and selectivity. In addition, during recovery of the rare earth metal from the ionic liquid, the acid added will decompose the acid-base pair ionic liquid, which must then be regenerated by metathesis.

Separation of Nd and Dy was reported by Schelter *et al.*, whereby separation was achieved

25 by precipitation using a tripodal nitroxide ligand to form Nd and Dy complexes with differing solubilities in benzene. However, precipitation is not considered to be a commercially viable process and, in addition, the process requires the use of specific rare earth metal precursors and an inert, moisture-free environment, which is highly impractical for commercial scale up. This method also relies on the use of benzene to achieve high separation, which is a very

30 toxic solvent.

SUMMARY

Therefore, there is a need for the development of effective processes that enhance separation

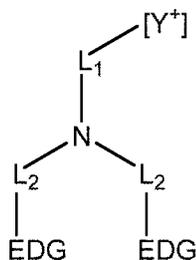35 selectivity and extractability, whilst minimizing environmental pollution.

By using an ionic liquid having a cation comprising particular features, it has been found that rare earth metals may be extracted and separated from each other with increased selectivity and extractability in comparison to known methods using different extractants. As the method uses an ionic liquid, the extractant can also provide decreased volatility and flammability, potentially leading to safer and more environmentally friendly rare earth metal extraction.

Thus, in a first aspect, the present invention provides a method for extracting a rare earth metal from a mixture of one or more rare earth metals, said method comprising countercurrently contacting an acidic solution of the rare earth metal with a composition which comprises an ionic liquid to form an aqueous phase and a non-aqueous phase into which the rare earth metal has been selectively extracted, wherein the ionic liquid has the formula:

$$[Cat^+][X^-]$$

in which:

$[Cat^+]$ represents a cationic species having the structure:

where: $[Y^+]$ comprises a group selected from ammonium, benzimidazolium, benzofuranium, benzothiophenium, benzotriazolium, borolium, cinnolinium, diazabicyclodecenium, diazabicyclononenium, 1,4-diazabicyclo[2.2.2]octanium, diazabicyclo-undecenium, dithiazolium, furanium, guanidinium, imidazolium, indazolium, indolinium, indolium, morpholinium, oxaborolium, oxaphospholium, oxazinium, oxazolium, iso-oxazolium, oxothiazolium, phospholium, phosphonium, phthalazinium, piperazinium, piperidinium, pyranium, pyrazinium, pyrazolium, pyridazinium, pyridinium, pyrimidinium, pyrrolidinium, pyrrolium, quinazolinium, quinolinium, iso-quinolinium, quinoxalinium, quinuclidinium, selenazolium, sulfonium, tetrazolium, thiadiazolium, iso-thiadiazolium, thiazinium, thiazolium, iso-thiazolium, thiophenium, thiuronium, triazinium, triazolium, iso-triazolium and uronium groups;

each EDG represents an electron donating group;

L_1 represents a linking group selected from $C_{1\text{-}10}$ alkanediyl, $C_{2\text{-}10}$ alkenediyl, $C_{1\text{-}10}$ dialkanylether and $C_{1\text{-}10}$ dialkanylketone groups; and

each L_2 represents a linking group independently selected from $C_{1\text{-}2}$ alkanediyl, C_2 alkenediyl, $C_{1\text{-}2}$ dialkanylether and $C_{1\text{-}2}$ dialkanylketone groups; and

[X⁻] represents an anionic species.

The term "ionic liquid" as used herein refers to a liquid that is capable of being produced by melting a salt, and when so produced consists solely of ions. An ionic liquid may be formed from a homogeneous substance comprising one species of cation and one species of anion, or it can be composed of more than one species of cation and/or more than one species of anion. Thus, an ionic liquid may be composed of more than one species of cation and one species of anion. An ionic liquid may further be composed of one species of cation, and one or more species of anion. Still further, an ionic liquid may be composed of more than one species of cation and more than one species of anion.

The term "ionic liquid" includes compounds having both high melting points and compounds having low melting points, *e.g.* at or below room temperature. Thus, many ionic liquids have melting points below 200°C, particularly below 100°C, around room temperature (15 to 30°C), or even below 0°C. Ionic liquids having melting points below around 30 °C are commonly referred to as "room temperature ionic liquids" and are often derived from organic salts having nitrogen-containing heterocyclic cations. In room temperature ionic liquids, the structures of the cation and anion prevent the formation of an ordered crystalline structure and therefore the salt is liquid at room temperature.

Ionic liquids are most widely known as solvents. Many ionic liquids have been shown to have negligible vapour pressure, temperature stability, low flammability and recyclability. Due to the vast number of anion/cation combinations that are available it is possible to fine-tune the physical properties of the ionic liquid (*e.g.* melting point, density, viscosity, and miscibility with water or organic solvents) to suit the requirements of a particular application.

Typically, when rare earth metals are extracted from sources such as ores or waste materials, the resulting product is a mixture of rare earth metals dissolved in an aqueous acidic solution. In the method according to the present invention, rare earth metals may be selectively extracted directly from an aqueous acidic feed, negating the need to apply significant processing to the feed prior to extraction.

It will be appreciated that in order to form an aqueous phase and a non-aqueous phase when countercurrently contacted with the acidic solution, the composition comprising an ionic liquid will be sufficiently hydrophobic such that a phase separation will occur between the aqueous solution and the composition.

By the use of the composition comprising an ionic liquid as defined herein, it has been surprisingly found that increased selectivity and extractability may be obtained in the extraction of rare earth metals from an acidic solution. The combination of high extractability (indicated by distribution ratio) and selectivity (indicated by separation factors) is key to a commercially effective separation process because the number of separation stages necessary to produce a product may be reduced without sacrificing purity. For example, according to the method of an embodiment of the present invention, mixtures of dysprosium and neodymium may be separated with a selectivity (separation factor) of over 1000:1 in a single contact. This represents a substantial increase over known systems as reported in Table 1.

Without wishing to be bound by any particular theory, it is believed that the presence of the central nitrogen donor atom in the ionic liquid allows for differing binding strengths to different rare earth metals as a result of differing ionic radii due to lanthanide contraction. In this way, some rare earth metals are preferentially bound by the hydrophobic ionic liquid extractant, which results in effective intra-group separation of the rare earth metals. It is believed that the arrangement of this variable nitrogen binding as part of an ionic liquid provides the particularly effective extraction of rare earth metals described herein. Nonetheless, it will be appreciated that the ionic liquid comprising a nitrogen donor, whilst discriminating between different rare earth metals, must have additional electron donating groups appended in order to provide sufficient extractability.

According to the present invention, the acidic solution and composition comprising ionic liquid are countercurrently contacted with one another to form an aqueous phase and a non-aqueous phase into which the rare earth metal has been selectively extracted. Countercurrent extraction is known in the art as a process in which two immiscible liquid phases flow in opposite directions to one another, in order that a concentration gradient is maintained between the liquid phases.

The acidic solution and ionic liquid composition may be continuously countercurrently contacted with one another, in a method in which the two phases flow – in substantially continuous contact with one another – in opposite directions through a vessel such as a pipe.

However, it is generally preferred that the acidic solution comprising the rare earth metal and the ionic liquid composition are intermittently countercurrently contacted with one another. For instance, the acidic solution and ionic liquid composition may be countercurrently contacted with one another in a series of (*i.e.* at least two) extraction stages. In each extraction stage,

5   the acidic solution and composition are contacted with one another and then separated, with the aqueous phase passed to the next extraction stage and the non-aqueous phase passed in the opposition direction, *i.e.* to the previous extraction stage. Thus, the rare earth metal concentration gradient is maintained between the aqueous and non-aqueous phase across the series of extraction stages. Since, in these embodiments, the acidic solution and ionic

10 liquid composition are only intermittently contacted, it will be appreciated that references to 'opposite' direction are intended to mean that one stream moves upstream relative to the other stream which moves downstream; the path of the streams may, however, vary.

The series of extraction stages comprises at least 2, and preferably at least 3 extraction

15 stages. The series of extraction stages may comprise up to 10, preferably up to 8, and more preferably up to 6 extraction stages. Thus, the series of extraction stages may comprise from 2 to 10, preferably from 3 to 8, and more preferably from 3 to 6 extraction stages. However, where rare earth metals having a close relative molecular mass are separated, higher numbers of extraction stages may be required, *e.g.* greater than 10.

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The passage of the aqueous and non-aqueous phases through the series of extraction stages may be assisted with one or pumps.

The composition may be countercurrenty contacted with the acidic solution in any suitable

25 ratio such that exchange of rare earth metals is achieved between the aqueous and non-aqueous phases. The composition is preferably contacted with the acidic solution in a volume ratio of from 0.5 : 1 to 2 : 1, preferably 0.7 : 1 to 1.5 : 1, more preferably 0.8 : 1 to 1.2 : 1, for example 1 : 1. Nonetheless, it will be appreciated that the volume ratio will vary depending on the manner in which the acidic solution is contacted with the composition comprising the

30 ionic liquid.

Preferably, the extraction method is carried out on an industrial scale. Thus, the flow rate of the acidic solution of the rare earth metal through the series of extraction stages may be at least 100 L/hr, preferably at least 200 L/hr, and more preferably at least 250 L/hr. The flow

35 rate may be up to 10000 L/hr, preferably up to 7500 L/hr, and more preferably up to 5000 L/hr. Thus, the flow rate may be from 100 to 10000 L/hr, preferably from 200 to 7500 L/hr, and more

preferably from 250 to 5000 L/hr. However, when the extraction is carried out a laboratory scale, the flow rate may be much smaller, *e.g.* as low as 0.5 L/hr.

Preferably, prior to contacting the composition with the acidic solution of the rare earth metal the composition is equilibrated with an acidic solution having the same pH as the acidic solution of the rare earth metal. In this way, the mixture of the composition and the acidic solution will generally remain at the desired pH level during the extraction.

The composition may be contacted with the acidic solution of the rare earth metal under any conditions suitable for extracting the rare earth metal.

It will be appreciated that the temperature employed during contacting of the acidic solution with the composition comprising the ionic liquid may be any suitable temperature and may vary according to the viscosity of the composition comprising the ionic liquid. For example, where a higher viscosity composition is used, a higher temperature may be necessary in order to obtain optimal results.

In embodiments, the acidic solution is contacted with the composition at ambient temperature, for instance without external heating or cooling, *e.g.* at a temperature of from 15 to 30 °C. It will nonetheless be appreciated that temperature changes may naturally occur during the extraction as a result of contacting the composition with the acidic solution.

However, it is generally preferred for the acidic solution to be contacted with the composition at a temperature of at least 35 °C, preferably at least 40 °C, and more preferably at least 50 °C. It is believed that elevated temperatures may give quicker extraction without the expected corresponding loss of selectivity. To ensure that the acidic solution does not boil, the acidic solution may be contacted with the composition at a temperature of up to 100 °C, preferably up to 70 °C, and more preferably up to 60 °C. Thus, the acidic solution may be contacted with the composition at a temperature of from 35 to 100 °C, preferably from 40 to 70 °C, and more preferably from 50 to 60 °C.

The composition may be contacted with the acidic solution of the rare earth metal for any length of time suitable to facilitate extraction of the rare earth metal into the non-aqueous phase. Preferably, the length of time will be such that an equilibrium is reached in each extraction stage and the proportions of rare earth metal in the aqueous and non-aqueous phases are constant. In preferred embodiments, the method comprises contacting the acidic solution of the rare earth metal and the composition for from 1 to 40 minutes, preferably from

5 to 30 minutes. It will be appreciated that the countercurrent extraction process is preferably a continuous process and, as such, these times correspond to the residence time in the series of extraction stages as a whole.

5   Preferably, the method comprises contacting and physically mixing the acidic solution of the rare earth metal and the composition. Such mixing will usually speed up extraction of the rare earth metal. Suitable mixing devices are well known in the art. For example, the mixture may be mixed using an agitator or stirrer. The mixing device may be specifically designed for multi-phase mixing such as high shear devices. Alternatively, mixing may comprise shaking the

10   mixture, for example, using a wrist action shaker.

The separation of the aqueous and non-aqueous phases in each extraction stage may be performed by any suitable method, for example by use of small scale apparatus such as a separating funnel, decanter or Craig apparatus. It will be appreciated that the phases will

15   normally be allowed to settle prior to separation. Settling may be under gravity or preferably accelerated by the use of additional equipment such as centrifuge. Preferably, aqueous and non-aqueous phases may be separated by the use of equipment which both contacts and separates the phases, for example a centrifugal extractor, a pulsed column, or a combined mixer-settler.

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Combined mixer-settlers comprise a mixing chamber in which the aqueous and non-aqueous phases are brought into contact with one another, typically with a mechanical agitator, and a settling chamber in which the two phases separate from one another. The aqueous and non-aqueous phases can then be separately drawn off from the combined mixer-settler. Suitable

25   combined mixer-settlers include Rousselet Robatel™ mixer-settlers.

Centrifugal extractors use centrifugal force to mix and separate the aqueous and non-aqueous phase. The aqueous and non-aqueous phases can then be separately drawn off from the centrifugal extractor. Suitable centrifugal extractors include the CINC™ V02 centrifugal

30   separator and Rousselet Robatel™ centrifugal separators. In some preferred embodiments, the centrifugal extractor may be operated at a speed of from 500 to 5000 RPM, preferably from 1000 to 4500 RPM, and more preferably from 1200 to 3600 RPM. 2400 RPM is an optimal speed, as this minimises emulsification that may be observed at higher speeds whilst still achieving good phase separation.

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It will be understood that in order to extract or separate some rare earth metals, multiple extractions and separations may be performed. This may involve multiple extractions of the

acidic solution of the rare earth metal with the composition, but could also involve multiple back-extractions of the non-aqueous phase with an aqueous acidic solution. Nevertheless, the method of embodiments of the present invention still requires fewer steps to separate rare earth metals due to the ionic liquid extractant giving separation factors and distribution ratios above those typically found in previous systems.

Preferably, the method further comprises recovering the rare earth metal from the non-aqueous phase. This recovery may be performed using any suitable means, however it is preferred that the rare earth metal is recovered from the non-aqueous phase by stripping with an acidic stripping solution.

It will be appreciated that the acidic stripping solution may be any acidic solution which liberates the rare earth metal from the ionic liquid. In most embodiments, the acidic stripping solution will be an aqueous acidic stripping solution and the acid will substantially remain in the aqueous phase on contact with the ionic liquid. Preferably, the acidic stripping solution comprises an aqueous hydrochloric acid or nitric acid solution.

The stripping of the rare earth metal may be conducted in any suitable manner. Preferably, the ionic liquid is contacted with an acidic stripping solution for 2 or more stripping cycles to completely strip the rare earth metal, more preferably 2 or 3 stripping cycles are used. In some embodiments, a single stripping cycle may be used. A "stripping cycle" as referred to herein will typically comprise contacting the acidic stripping solution with the composition, equilibrating for an amount of time, for example 5 to 30 minutes, and separating the aqueous and organic phases. A second cycle may be conducted by contacting the composition with another acidic stripping solution substantially free of rare earth metals.

However, in preferred embodiments, the ionic liquid is countercurrently contacted with the acidic stripping solution, for instance in a series of (*i.e.* at least two) stripping stages. In each stripping stage, the ionic liquid and acidic stripping solution are contacted with one another and then separated, with the acidic stripping solution passed to the next stripping stage and the ionic liquid passed in the opposition direction, *i.e.* to the previous extraction stage. Thus, the rare earth metal concentration gradient is maintained between the acidic stripping solution and the ionic liquid across the series of stripping stages.

The series of stripping stages comprises at least 2, and more preferably at least 3 stripping stages. The series of stripping stages may comprise up to 6, and preferably up to 5 stripping

stages. Thus, the series of stripping stages may comprise from 2 to 6, and preferably from 3 to 5 stripping stages.

The passage of the acidic stripping solution and ionic liquid through the series of stripping

5   stages may be assisted with one or pumps.

The ionic liquid may be contacted with the acidic stripping solution for any length of time suitable to facilitate stripping of the rare earth metal into the acidic stripping solution. Preferably, the length of time will be such that an equilibrium is reached in each stripping stage

10   and the proportions of rare earth metal in the ionic liquid and acidic stripping solution are constant. In preferred embodiments, the method comprises contacting the ionic liquid and the acidic stripping solution for from 1 to 40 minutes, preferably from 5 to 30 minutes. It will be appreciated that the countercurrent stripping process is preferably a continuous process and, as such, these times correspond to the residence time in the series of stripping stages as a

15   whole.

The separation of the ionic liquid and the acidic stripping solution in each stripping stage may be carried out using equipment which both contacts and separates the phases, for example the equipment described above as suitable for use in the extraction stages.

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Once the composition comprising the ionic liquid has been stripped of rare earth metal, it is preferably recycled and used as the feedstream, *i.e.* the composition comprising the ionic liquid $[Cat^+][X^-]$, in the countercurrent extraction. During recycling, the pH of the composition is preferably equilibrated with an acidic solution having the same pH as the acidic solution of

25   the rare earth metal.

One advantage of the ionic liquid extractant as described herein is that the rare earth metal may be stripped from the ionic liquid at a relatively high pH. This saves costs associated with both the amount and the strength of acid needed to strip the rare earth metals from the ionic

30   liquid and the equipment necessary to handle such strong acids. In addition, it is possible to completely strip rare earth metals from the ionic liquid at a relatively high pH, whilst for many known extractants such as P507 it is difficult to completely strip heavy rare earth metals (*e.g.* Tm(III), Yb(III), Lu(III)) even at low pH.

35   Thus, the acidic stripping solution preferably has a pH of 0 or higher. In preferred embodiments, the acidic stripping solution has a pH of 1 or lower. For complete stripping of the rare earth metal, the acidic stripping solution preferably has a pH which is lower than the

pH of the acidic solution in which the rare earth metal was original comprised, *e.g.* lower by at least 0.5, preferably at least 0.5, and more preferably at least 1 pH units.

In preferred embodiments, the method comprises extracting a rare earth metal from a mixture of two or more rare earth metals. Preferably, the acidic solution comprises a first and a second rare earth metal, and the method comprises:

(a)   preferentially partitioning the first rare earth metal into the non-aqueous phase using countercurrent extraction.

Preferably, the method further comprises, in step (a), separating the non-aqueous phase from the acidic solution; and

(b)   contacting the acidic solution depleted of the first rare earth metal with the composition which comprises an ionic liquid, and optionally recovering the second rare earth metal therefrom.

Step (b) is also preferably carried out using countercurrent extraction, *e.g.* as described above.

In some preferred embodiments the first rare earth metal is recovered from the non-aqueous phase in step (a), *e.g.* using countercurrent stripping, and said non-aqueous phase is recycled and used as the composition in step (b).

It will be appreciated that, because the extractability (distribution factor) for a particular rare earth metal varies with pH, it may be preferred to extract different rare earth metals at different pH levels. For example, the acidic solution may have a lower pH in step (a) in comparison to that in step (b). Preferably, the acidic solution has a pH of less than 3.5 in step (a), and the acidic solution has a pH of greater than 3.5 in step (b). Although the above embodiment describes extraction in only two different pH values, it will be appreciated that a separation of rare earth metals will usually be conducted across a range of pH values, with a gradual increase in pH and multiple extraction steps. For example, where three or more rare earth metals are separated, several separation steps may be conducted in across a particular pH range, for example from pH 1 to 4. Each separation step will preferably be conducted using countercurrent extraction.

The acidic solution from which the rare earth metal is extracted may have any suitable pH. Preferably, the rare earth metal is extracted at a pH of more than 1, more preferably at a pH of from 2 to 4.

The pH level of the acidic solution of the rare earth metal may be adjusted in any suitable way, as is well known to those skilled in the art. For example, the pH level of the acidic solution may be altered by the addition of acid scavengers such as mildly alkaline solutions including sodium carbonate, sodium bicarbonate, ammonia, CO_2, amines or alcohols.

The above embodiments refer to the separation of a particular rare earth metal from another directly from the acidic solution of the rare earth metal at varying pH levels. However, it will be understood that any suitable extraction sequence may be used to separate rare earth metals. For example, two or more rare earth metals may be extracted from the acidic solution to the non-aqueous phase simultaneously at a higher pH, followed by back-extraction of the non-aqueous phase with acidic solutions having a lower pH to separate individual rare earth metals. Thus, all or only some of the rare earth metals present in the acidic solution may initially be extracted from the acidic solution using the composition comprising the ionic liquid.

Accordingly, in some embodiments, the method of the present invention comprises back-extracting the second rare earth metal from the non-aqueous phase using an acidic back-extraction solution. The back-extraction solution preferably comprises the same acid as the acidic solution comprising a first and a second rare earth metal. Once the non-aqueous phase has been back-extracted, it may then be stripped of the first rare earth metal using the acidic stripping solution. The back-extraction solution preferably has a lower pH that the acidic solution comprising a first and a second rare earth metal, but a higher pH than the stripping solution.

In some embodiments, the non-aqueous phase may be countercurrently contacted with the acidic back-extraction solution, for instance in a series of (*i.e.* at least two) back-extraction stages. In each back-extraction stage, the non-aqueous phase and back-extraction solution are contacted with one another and then separated, with the back-extraction solution passed to the next back-extraction stage and the non-aqueous phase passed in the opposition direction, *i.e.* to the previous back-extraction stage. Thus, the second rare earth metal concentration gradient is maintained between the back-extraction solution and the non-aqueous phase across the series of back-extraction stages. However, in other embodiments, a single back-extraction stage is used.

It will be appreciated that the separation of certain pairs of rare earth metals are of particular importance due to their simultaneous recovery from valuable waste materials. For example, Nd and Dy are widely used in permanent magnets for numerous applications such as hard disks, MRI scanners, electric motors and generators. La and Eu are also an important pair

5 due to their common use in lamp phosphors, other phosphors include Y and Eu (YOX phosphors); La, Ce and Tb (LAP phosphors); Gd, Ce and Tb (CBT phosphors); and Ce, Tb (CAT phosphors).

Thus, in preferred embodiments, the first rare earth metal is dysprosium, and the second rare

10 earth metal is neodymium. In other preferred embodiments, the first rare earth metal is europium, and the second rare earth metal is lanthanum. In yet other preferred embodiments, the first rare earth metal is terbium, and the second rare earth metal is cerium.

The ionic liquid that is used in the present invention comprises a cationic species, $[Cat^+]$,

15 having the following structure:

$$
\begin{array}{c}
\diagup [Y^+] \\
L_1 \\
| \\
N \\
L_2 \diagup \quad \diagdown L_2 \\
| \qquad \qquad | \\
EDG \qquad EDG
\end{array}
$$

where: $[Y^+]$ comprises a group selected from ammonium, benzimidazolium, benzofuranium, benzothiophenium, benzotriazolium, borolium, cinnolinium, diazabicyclodecenium, diazabicyclononenium, 1,4-diazabicyclo[2.2.2]octanium, diazabicyclo-undecenium,

20 dithiazolium, furanium, guanidinium, imidazolium, indazolium, indolinium, indolium, morpholinium, oxaborolium, oxaphospholium, oxazinium, oxazolium, iso-oxazolium, oxothiazolium, phospholium, phosphonium, phthalazinium, piperazinium, piperidinium, pyranium, pyrazinium, pyrazolium, pyridazinium, pyridinium, pyrimidinium, pyrrolidinium, pyrrolium, quinazolinium, quinolinium, iso-quinolinium, quinoxalinium,

25 quinuclidinium, selenazolium, sulfonium, tetrazolium, thiadiazolium, iso-thiadiazolium, thiazinium, thiazolium, iso-thiazolium, thiophenium, thiuronium, triazinium, triazolium, iso-triazolium and uronium groups;

each EDG represents an electron donating group;

L_1 represents a linking group selected from C_{1-10} alkanediyl, C_{2-10} alkenediyl, C_{1-10}

30 dialkanylether and C_{1-10} dialkanylketone groups; and

each L_2 represents a linking group independently selected from C_{1-2} alkanediyl, C_2 alkenediyl, C_{1-2} dialkanylether and C_{1-2} dialkanylketone groups.

The term electron donating group (EDG) as used herein will be understood to include any group having a pair of electrons available to form a coordinate bond with an acceptor. In particular, it will be appreciated that an electron donating group, as defined herein, refers to groups having an available pair of electrons able to coordinate to a rare earth metal to form a metal-ligand complex. It will also be understood that the EDGs will typically have a single atom from which the electrons are donated to form a bond. However, electrons may alternatively be donated from one or more bonds between atoms, *i.e.* EDG may represent a ligand with a hapticity of 2 or more.

It will be understood that the arrangement of the EDGs and the linkers L_2 will be such that the EDGs and the central nitrogen atom are able to coordinate to a rare earth metal simultaneously.

Preferably, when the nitrogen linking L_1 to each L_2 and one of the EDG both coordinate to a metal, the ring formed by the nitrogen, L_2, the EDG and the metal is a 5 or 6 membered ring, preferably a 5 membered ring.

In preferred embodiments, $[Y^+]$ represents an acyclic cation selected from:

$$[-N(R^a)(R^b)(R^c)]^+, [-P(R^a)(R^b)(R^c)]^+ \text{ and } [-S(R^a)(R^b)]^+,$$

where: R^a, R^b and R^c are each independently selected from optionally substituted C_{1-30} alkyl, C_{3-8} cycloalkyl and C_{6-10} aryl groups.

In other preferred embodiments, $[Y^+]$ represents a cyclic cation selected from:
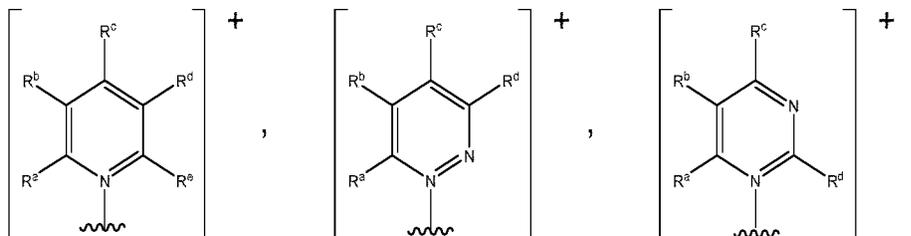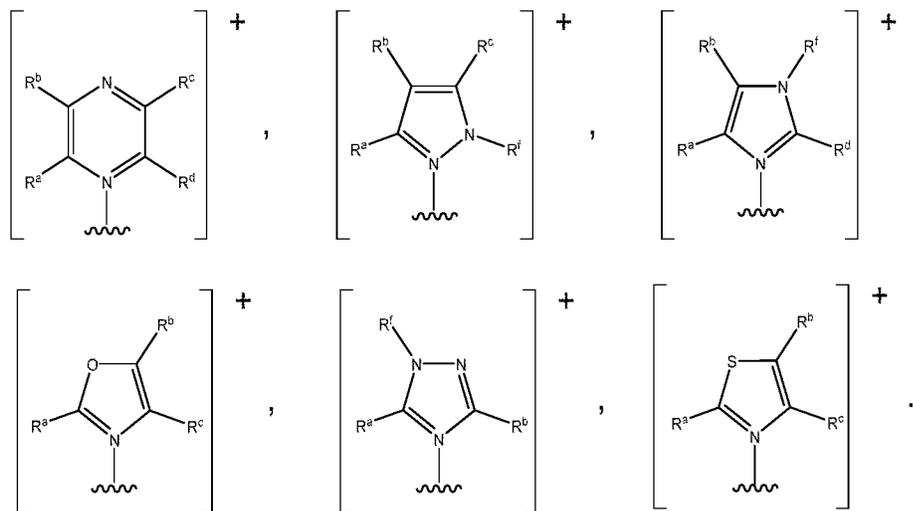
where: R^a, R^b, R^c, R^d, R^e and R^f are each independently selected from: hydrogen and optionally substituted C_{1-30} alkyl, C_{3-8} cycloalkyl and C_{6-10} aryl groups, or any two of R^a, R^b, R^c, R^d and R^e attached to adjacent carbon atoms form an optionally substituted methylene chain $-(CH_2)_q-$ where q is from 3 to 6.

Suitably, in preferred embodiments, at least one of R^a, R^b, R^c, R^d, R^e and R^f is a C_{1-5} alkyl group substituted with $-CO_2R^x$, $-OC(O)R^x$, $-CS_2R^x$, $-SC(S)R^x$, $-S(O)OR^x$, $-OS(O)R^x$, $-NR^xC(O)NR^yR^z$, $-NR^xC(O)OR^y$, $-OC(O)NR^yR^z$, $-NR^xC(S)OR^y$, $-OC(S)NR^yR^z$, $-NR^xC(S)SR^y$, $-SC(S)NR^yR^z$, $-NR^xC(S)NR^yR^z$, $-C(O)NR^yR^z$, $-C(S)NR^yR^z$, wherein R^x, R^y and R^z are independently selected from hydrogen or C_{1-6} alkyl.

In another preferred embodiment of the invention, $[Y^+]$ represents a saturated heterocyclic cation selected from cyclic ammonium, 1,4-diazabicyclo[2.2.2]octanium, morpholinium, cyclic phosphonium, piperazinium, piperidinium, quinuclidinium, and cyclic sulfonium.

Preferably, $[Y^+]$ represents a saturated heterocyclic cation having the formula:
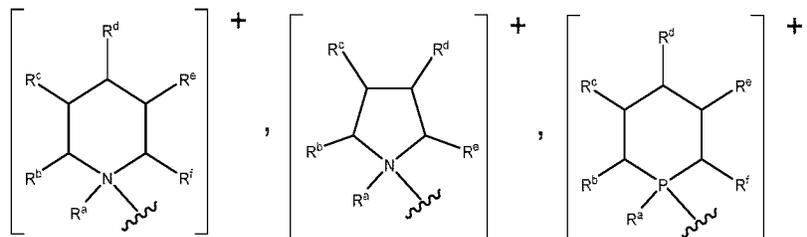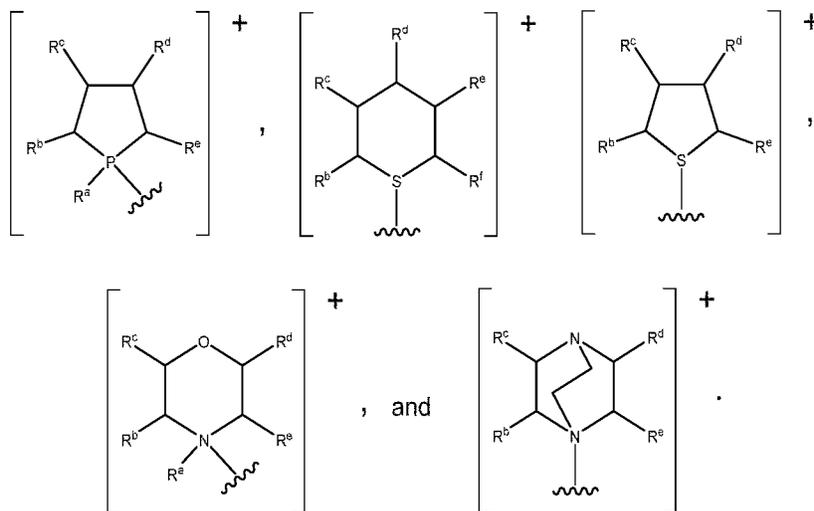
where: R^a, R^b, R^c, R^d, R^e and R^f, are as defined above.

Preferably, at least one of R^a, R^b, R^c, R^d, R^e and R^f is $C_{1\text{-}3}$ alkyl group substituted with $-CO_2R^x$, $-C(O)NR^yR^z$, wherein R^x, R^y and R^z are each independently selected from $C_{3\text{-}6}$ alkyl.

More preferably, at least one of R^a, R^b, R^c, R^d, R^e and R^f represents a group selected from:
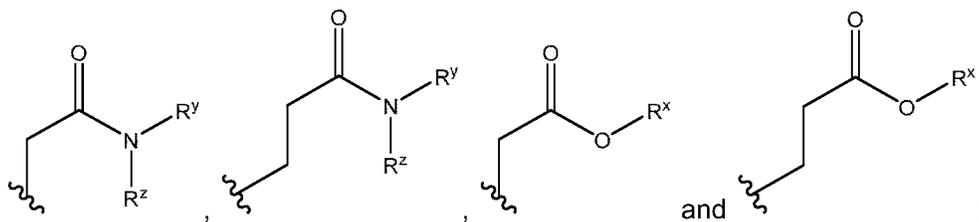
wherein $R^y = R^z$, and wherein R^x, R^y and R^z are each selected from $C_{3\text{-}6}$ alkyl, preferably C_4 alkyl, for example i-Bu.

Yet more preferably, at least one of R^a, R^b, R^c, R^d, R^e and R^f represents a group selected from:
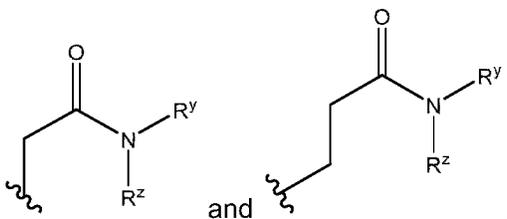
wherein $R^y = R^z$, and wherein R^y and R^z are selected from $C_{3\text{-}6}$ alkyl, preferably C_4 alkyl, for example i-Bu.

In preferred embodiments, one of R^a, R^b, R^c, R^d, R^e and R^f is a substituted C_{1-5} alkyl group, and the remainder of R^a, R^b, R^c, R^d, R^e and R^f are independently selected from H and unsubstituted C_{1-5} alkyl groups, preferably the remainder of R^a, R^b, R^c, R^d, R^e and R^f are H.

5   Preferably, [Y^+] represents a cyclic cation selected from:
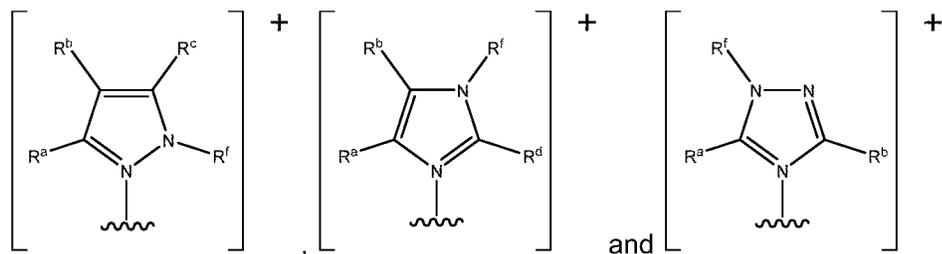
more preferably [Y^+] represents the cyclic cation:
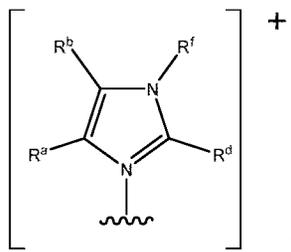
10   preferably wherein R^f is a substituted C_{1-5} alkyl group, and the remainder of R^a, R^b, R^c, R^d, R^e and R^f are independently selected from H and unsubstituted C_{1-5} alkyl groups.

In preferred embodiments, L_1 represents a linking group selected from C_{1-10} alkanediyl and C_{1-10} alkenediyl groups, more preferably selected from C_{1-5} alkanediyl and C_{2-5} alkenediyl groups,

15   and most preferably selected from C_{1-5} alkanediyl groups, for example a linking group selected from $-CH_2-$, $-C_2H_4-$ and $-C_3H_6-$.

In preferred embodiments, each L_2 represents a linking group independently selected from C_{1-2} alkanediyl and C_2 alkenediyl groups, preferably selected from C_{1-2} alkanediyl groups, for

20   example independently selected from $-CH_2-$ and $-C_2H_4-$.

Each EDG may be any suitable electron donating group able to form a coordinate bond with a rare earth metal to form a metal-ligand complex.

25   Preferably, each EDG represents an electron donating group independently selected from — CO_2R^x, $-OC(O)R^x$, $-CS_2R^x$, $-SC(S)R^x$, $-S(O)OR^x$, $-OS(O)R^x$, $-NR^xC(O)NR^yR^z$, $-$

$NR^xC(O)OR^y$, $-OC(O)NR^yR^z$, $-NR^xC(S)OR^y$, $-OC(S)NR^yR^z$, $-NR^xC(S)SR^y$, $-SC(S)NR^yR^z$, $-NR^xC(S)NR^yR^z$, $-C(O)NR^yR^z$, $-C(S)NR^yR^z$, wherein R^x, R^y and R^z are independently selected from H or C_{1-6} alkyl. More preferably, each EDG represents an electron donating group independently selected from $-CO_2R^x$ and $-C(O)NR^yR^z$, wherein R^x, R^y and R^z are each independently selected from C_{3-6} alkyl.

In preferred embodiments, each $-L_2-EDG$ represents an electron donating group independently selected from:
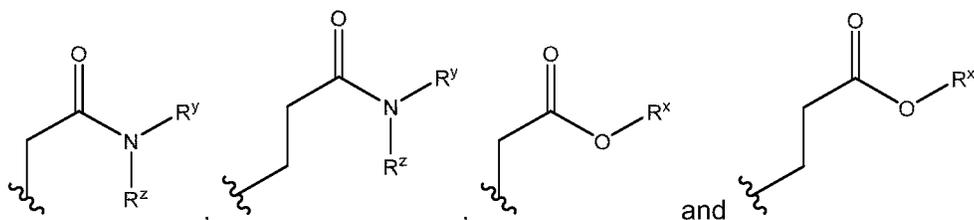
wherein $R^y = R^z$, and wherein R^x, R^y and R^z are each selected from C_{3-6} alkyl, preferably C_4 alkyl, for example i-Bu.

More preferably, each $-L_2-EDG$ represents an electron donating group independently selected from:
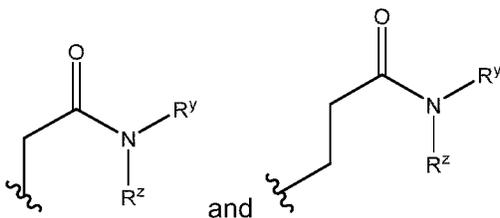
wherein $R^y = R^z$, and wherein R^y and R^z are selected from C_{3-6} alkyl, preferably C_4 alkyl, for example i-Bu.

It will be appreciated that, as set out previously, the extraction of rare earth metals is provided by the specific functionality of the cation of the ionic liquid. Thus, any suitable anionic species [X⁻] may be used as part of the ionic liquid used in the method of embodiments of the present invention.

Preferably, [X⁻] represents one or more anionic species selected from: hydroxides, halides, perhalides, pseudohalides, sulphates, sulphites, sulfonates, sulfonimides, phosphates, phosphites, phosphonates, phosphinates, methides, borates, carboxylates, azolates, carbonates, carbamates, thiophosphates, thiocarboxylates, thiocarbamates, thiocarbonates,

xanthates, thiosulfonates, thiosulfates, nitrate, nitrite, tetrafluoroborate, hexafluorophosphate and perchlorate, halometallates, amino acids, borates, polyfluoroalkoxyaluminates.

For example, [X⁻] preferably represents one or more anionic species selected from:

5

    a)   a halide anion selected from: F^-, Cl^-, Br^-, I^-;

    b)   a perhalide anion selected from: $[I_3]^-$, $[I_2Br]^-$, $[IBr_2]^-$, $[Br_3]^-$, $[Br_2C]^-$, $[BrCl_2]^-$, $[ICl_2]^-$, $[I_2Cl]^-$, $[Cl_3]^-$;

    c)   a pseudohalide anion selected from: $[N_3]^-$, $[NCS]^-$, $[NCSe]^-$, $[NCO]^-$, $[CN]^-$;

    d)   a sulphate anion selected from: $[HSO_4]^-$, $[SO_4]^{2-}$, $[R^2OSO_2O]^-$;

10

    e)   a sulphite anion selected from: $[HSO_3]^-$, $[SO_3]^{2-}$, $[R^2OSO_2]^-$;

    f)   a sulfonate anion selected from: $[R^1SO_2O]^-$;

    g)   a sulfonimide anion selected from: $[(R^1SO_2)_2N]^-$;

    h)   a phosphate anion selected from: $[H_2PO_4]^-$, $[HPO_4]^{2-}$, $[PO_4]^{3-}$, $[R^2OPO_3]^{2-}$, $[(R^2O)_2PO_2]^-$;

15

    i)   a phosphite anion selected from: $[H_2PO_3]^-$, $[HPO_3]^{2-}$, $[R^2OPO_2]^{2-}$, $[(R^2O)_2PO]^-$;

    j)   a phosphonate anion selected from: $[R^1PO_3]^{2-}$, $[R^1P(O)(OR^2)O]^-$;

    k)   a phosphinate anion selected from: $[R^1R^2P(O)O]^-$;

    l)   a methide anion selected from: $[(R^1SO_2)_3C]^-$;

    m) a borate anion selected from: [bisoxalatoborate], [bismalonatoborate] tetrakis[3,5-bis(trifluoromethyl)phenyl]borate, tetrakis(pentafluorophenyl)borate;

20

    n)   a carboxylate anion selected from: $[R^2CO_2]^-$;

    o)   an azolate anion selected from: [3,5-dinitro-1,2,4-triazolate], [4-nitro-1,2,3-triazolate], [2,4-dinitroimidazolate], [4,5-dinitroimidazolate], [4,5-dicyano-imidazolate], [4-nitroimidazolate], [tetrazolate];

25

    p)   a sulfur-containing anion selected from: thiocarbonates (*e.g.* $[R^2OCS_2]^-$, thiocarbamates (*e.g.* $[R^2_2NCS_2]^-$), thiocarboxylates (*e.g.* $[R^1CS_2]^-$), thiophosphates (*e.g.* $[(R^2O)_2PS_2]^-$), thiosulfonates (*e.g.* $[RS(O)_2S]^-$), thiosulfates (*e.g.* $[ROS(O)_2S]^-$);

30

    q)   a nitrate ($[NO_3]^-$) or nitrite ($[NO_2]^-$) anion;

    r)   a tetrafluoroborate ($[BF_4]^-$), hexafluorophosphate ($[PF_6]^-$), hexfluoroantimonate

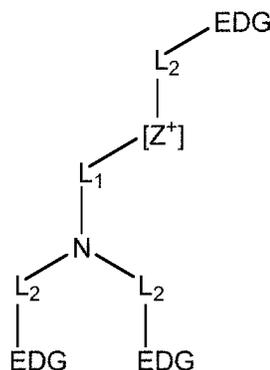([SbF$_6$]) or perchlorate ([ClO$_4^-$]) anion;

s) a carbonate anion selected from [CO$_3$]$^{2-}$, [HCO$_3$]$^-$, [R^{2}CO$_3$]$^-$; preferably [MeCO$_3$]$^-$;

t) polyfluoroalkoxyaluminate anions selected from [Al(OR^F)$_4^-$], wherein R^F is selected from C$_{1-6}$ alkyl substituted by one or more fluoro groups;

where: R^1 and R^2 are independently selected from the group consisting of C$_1$-C$_{10}$ alkyl, C$_6$ aryl, C$_1$-C$_{10}$ alkyl(C$_6$)aryl and C$_6$ aryl(C$_1$-C$_{10}$)alkyl each of which may be substituted by one or more groups selected from: fluoro, chloro, bromo, iodo, C$_1$ to C$_6$ alkoxy, C$_2$ to C$_{12}$ alkoxyalkoxy, C$_3$ to C$_8$ cycloalkyl, C$_6$ to C$_{10}$ aryl, C$_7$ to C$_{10}$ alkaryl, C$_7$ to C$_{10}$ aralkyl, -CN, -OH, -SH, -NO$_2$, -CO$_2$R^x, -OC(O)R^x, -C(O)R^x, -C(S)R^x, -CS$_2$R^x, -SC(S)R^x, -S(O)(C$_1$ to C$_6$)alkyl, -S(O)O(C$_1$ to C$_6$)alkyl, -OS(O)(C$_1$ to C$_6$)alkyl, -S(C$_1$ to C$_6$)alkyl, -S-S(C$_1$ to C$_6$ alkyl), -NR^{x}C(O)NR^{y}R^z, -NR^{x}C(O)OR^y, -OC(O)NR^{y}R^z, -NR^{x}C(S)OR^y, -OC(S)NR^{y}R^z, -NR^{x}C(S)SR^y, -SC(S)NR^{y}R^z, -NR^{x}C(S)NR^{y}R^z, -C(O)NR^{y}R^z, -C(S)NR^{y}R^z, -NR^{y}R^z, or a heterocyclic group, wherein R^x, R^y and R^z are independently selected from hydrogen or C$_1$ to C$_6$ alkyl, wherein R^1 may also be fluorine, chlorine, bromine or iodine.

While [X$^-$] may be any suitable anion, it is preferred that [X$^-$] represents a non-coordinating anion. The term "non-coordinating anion" used herein, which is common in the field of ionic liquids and metal coordination chemistry, is intended to mean an anion that does not coordinate with a metal atom or ion, or does so only weakly. Typically, non-coordinating anions have their charge dispersed over several atoms in the molecule which significantly limits their coordinating capacity. This limits the effect interference of the anion with the selective coordination of the cation [Cat$^+$] with the rare earth metal.

Thus, preferably, [X$^-$] represents one or more non-coordinating anionic species selected from: bistriflimide, triflate, bis(alkyl)phosphinates such as bis(2,4,4-trimethylpentyl)phosphinate, tosylate, perchlorate, [Al(OC(CF$_3$)$_3$)$_4^-$], tetrakis[3,5-bis(trifluoromethyl)phenyl]borate, tetrakis(pentafluorophenyl)borate, tetrafluoroborate, hexafluoroantimonate and hexafluorophosphate anions; and most preferably from bistriflimide, triflate and bis(2,4,4-trimethylpentyl)phosphinate anions. Phosphinate anions in particular have been shown to give high levels of extractability.

In some preferred embodiments, [Cat⁺] represents one or more ionic species having the structure:

$$
\begin{array}{c}
\text{EDG} \\
\diagup \\
L_2 \\
| \\
[Z^+] \\
\diagup \\
L_1 \\
| \\
N \\
\diagup \quad \diagdown \\
L_2 \qquad L_2 \\
| \qquad | \\
\text{EDG} \quad \text{EDG}
\end{array}
$$

where: [Z⁺] represents a group selected from ammonium, benzimidazolium, benzofuranium, benzothiophenium, benzotriazolium, borolium, cinnolinium, diazabicyclodecenium, diazabicyclononenium, 1,4-diazabicyclo[2.2.2]octanium, diazabicyclo-undecenium, dithiazolium, furanium, guanidinium, imidazolium, indazolium, indolinium, indolium, morpholinium, oxaborolium, oxaphospholium, oxazinium, oxazolium, iso-oxazolium, oxothiazolium, phospholium, phosphonium, phthalazinium, piperazinium, piperidinium, pyranium, pyrazinium, pyrazolium, pyridazinium, pyridinium, pyrimidinium, pyrrolidinium, pyrrolium, quinazolinium, quinolinium, iso-quinolinium, quinoxalinium, quinuclidinium, selenazolium, sulfonium, tetrazolium, thiadiazolium, iso-thiadiazolium, thiazinium, thiazolium, iso-thiazolium, thiophenium, thiuronium, triazinium, triazolium, iso-triazolium and uronium groups.

It will be understood that the composition may comprise the ionic liquid as defined above in combination with a diluent. Typically, a diluent may be used in order to decrease the viscosity of the composition where the ionic liquid has a high viscosity, which limits its practical use in liquid-liquid extraction. A diluent may also be used to save costs where the diluent is cheaper to produce than the ionic liquid. It will be understood that any diluent added to the composition will be sufficiently hydrophobic so as to allow the separation of the composition and the acidic solution of the rare earth metal into an aqueous and non-aqueous phase. In some embodiments, the diluent may enhance the hydrophobicity of the composition.

Thus, in preferred embodiments, the composition further comprises a lower viscosity ionic liquid. The term "lower viscosity ionic liquid" will be understood to mean that this ionic liquid

has a lower viscosity than the ionic liquid extractant described previously. As mentioned, it will be understood that the lower viscosity ionic liquid will be sufficiently hydrophobic so as to allow the separation of the composition and the acidic solution of the rare earth metal into an aqueous and non-aqueous phase. It will also be appreciated that the hydrophobicity may be provided by either of the cation or anion of the lower viscosity ionic liquid, or by both.

By the use of an ionic liquid as a diluent, the decreased volatility and flammability offered by the ionic liquid extractant may be maintained to give a potentially safer and more environmentally friendly rare earth metal extraction process.

In preferred embodiments, the cation of the lower viscosity ionic liquid is selected from ammonium, benzimidazolium, benzofuranium, benzothiophenium, benzotriazolium, borolium, cinnolinium, diazabicyclodecenium, diazabicyclononenium, 1,4-diazabicyclo[2.2.2]octanium, diazabicyclo-undecenium, dithiazolium, furanium, guanidinium, imidazolium, indazolium, indolinium, indolium, morpholinium, oxaborolium, oxaphospholium, oxazinium, oxazolium, iso-oxazolium, oxothiazolium, phospholium, phosphonium, phthalazinium, piperazinium, piperidinium, pyranium, pyrazinium, pyrazolium, pyridazinium, pyridinium, pyrimidinium, pyrrolidinium, pyrrolium, quinazolinium, quinolinium, iso-quinolinium, quinoxalinium, quinuclidinium, selenazolium, sulfonium, tetrazolium, thiadiazolium, iso-thiadiazolium, thiazinium, thiazolium, iso-thiazolium, thiophenium, thiuronium, triazinium, triazolium, iso-triazolium and uronium groups.

Preferably the cation of the lower viscosity ionic liquid is selected from phosphonium, imidazolium and ammonium groups.

In some preferred embodiments, the cation of the lower viscosity ionic liquid is selected from:

$$[N(R^3)(R^4)(R^5)(R^6)]^+ \text{ and } [P(R^3)(R^4)(R^5)(R^6)]^+,$$

where: R^3, R^4, R^5 and R^6 are each independently selected from optionally substituted C_{1-20} alkyl, C_{3-8} cycloalkyl and C_{6-10} aryl groups.

In more preferred embodiments, the cation of the lower viscosity ionic liquid is $[P(R^3)(R^4)(R^5)(R^6)]^+$, wherein R^3, R^4, R^5 are selected from C_{1-10} alkyl, preferably C_{2-6} alkyl, and R^6 is selected from C_{4-20} alkyl, preferably C_{8-14} alkyl. For example, the cation of the lower viscosity ionic liquid may be selected from triethyloctyl phosphonium ($P_{222(8)}]^+$), tributyloctyl phosphonium ($P_{444(8)}]^+$), trihexyloctyl phosphonium ($P_{666(8)}]^+$), trihexyldecyl phosphonium ($P_{666(10)}]^+$), and trihexyltetradecyl phosphonium ($P_{666(14)}]^+$).

In other more preferred embodiments, the cation of the lower viscosity ionic liquid is $[N(R^3)(R^4)(R^5)(R^6)]^+$, wherein R^3, R^4, R^5 are selected from C_{4-14} alkyl, preferably C_{6-10} alkyl, and R^6 is selected from C_{1-4} alkyl, preferably C_{1-2} alkyl. For example, the cation of the lower viscosity ionic liquid may be selected from trioctylmethyl ammonium, tris(2-ethylhexyl) methyl ammonium, and tetrabutyl ammonium.

In other preferred embodiments, the cation of the lower viscosity ionic liquid is selected from imidazolium cations substituted with one or more C_{1-20} alkyl, C_{3-8} cycloalkyl and C_{6-10} aryl groups, preferably substituted with two C_{1-10} alkyl groups, more preferably substituted with one methyl group and one C_{1-10} alkyl group. For example, the cation of the lower viscosity ionic liquid may be selected from 1-butyl-3-methyl imidazolium, 1-hexyl-3-methyl imidazolium and 1-octyl-3-methyl imidazolium.

It will be understood that any suitable anionic group may be used as the anion of the lower viscosity ionic liquid. Preferably, the anion of the lower viscosity ionic liquid is as described previously in relation to the anionic group [X⁻]. For example, it is most preferred that the anion of the lower viscosity ionic liquid is a non-coordinating anion as described previously. It will be appreciated that there may be an excess of anions from the lower viscosity ionic liquid in comparison to the ionic liquid extractant. Therefore, it is especially preferred that the anion of the lower viscosity ionic liquid is a non-coordinating anion.

For this reason, it is preferable to limit the total amount of halide or pseudohalide anions in the composition. For example, in preferred embodiments the composition comprises less than 25% halide or pseudohalide anions as a proportion of the total anions, preferably less than 20%, more preferably less than 15%, most preferably less than 10%, for example less than 5%. In some embodiments, the composition is substantially free of halide or pseudohalide anions.

The composition may alternatively or additionally further comprise one or more non-ionic liquid diluents. For example, in some preferred embodiments, the composition further comprises one or more organic solvents. It will be understood that suitable organic solvents will include hydrophobic and non-coordinating solvents. The term "non-coordinating solvent" used herein, which is common in the field of metal coordination chemistry, is intended to mean a solvent that does not coordinate with metal atoms or ions, or does so only weakly.

Suitable organic solvents include but are not limited to hydrocarbon solvents such as C_{1-20} alkanes, alkenes or cycloalkanes, aromatic solvents such as toluene or benzene, C_{6+} alcohols such as *n*-hexanol, etheric solvents such as diethyl ether, dipropyl ether, dibutyl ether and methyl-*t*-butyl ether, or halogenated solvents such as tetrachloromethane, tetrachloroethane,

5   chloroform, dichloromethane, chlorobenzene, or fluorobenzene.   Preferably the organic solvent is a hydrocarbon solvent.

The ionic liquid may be present in the composition in any concentration suitable for extracting rare earth metals and it will be appreciated that this concentration will vary depending on the

10   particular application and pH. In particular, it will be appreciated that for the separation of rare earth metals a competitive separation is desirable. For example the concentration of the ionic liquid should be low enough to avoid the extraction of all rare earth metals present. Therefore, the concentration of the ionic liquid will typically depend on the concentration of rare earth metals to be extracted and the pH at which the separation is conducted. In some preferred

15   embodiments, the ionic liquid is present in the composition in a concentration of at least 0.001 M, preferably from 0.005 M to 0.01 M.

In other embodiments, the composition may consist essentially of the ionic liquid.

20   It will be appreciated that the concentration of the ionic liquid in the composition may be varied in order to achieve a particular target viscosity for the composition. It will also be appreciated that the character of the lower viscosity ionic liquid or other diluent may be varied in order to obtain a particular viscosity level.

25   In preferred embodiments, the viscosity of the composition is in the range of from 50 to 500 mPa.s at 298K, when the composition comprises a solution of the ionic liquid in a lower viscosity ionic liquid. When the ionic liquid is in a solution of an organic solvent, it will be appreciated that the composition will likely have a lower viscosity, for example, less than 50 mPa.s. Viscosity may be measured by any suitable method, for example viscosity may be

30   measured using a rotating disk viscometer with variable temperature.

In some embodiments, the acidic solution is obtainable by leaching the rare earth metal from its source using an acid, for example a mineral acid such as hydrochloric, nitric, perchloric or sulfuric acid, typically hydrochloric or nitric acid. Preferably, the source of the rare earth metal

35   is a mineral or a waste material. However, it will be appreciated that the acidic solution of the rare earth metal or mixture of rare earth metals may be obtained in any suitable way from any rare earth metal source.

The concentration of rare earth metals in the acidic solution is typically from 60 ppm to 2000 ppm. Nonetheless, it will be appreciated that any suitable concentration of rare earth metals in the acid solution may be used.

5

Typically, rare earth metals are obtained from rare earth ores, which are mined and processed by a variety of methods depending on the particular ore. Such processes are well known in the art. Usually, following mining such processes may include steps such as grinding, roasting to remove carbonates, chemical processing (e.g alkali/hydroxide treatment), and ultimately

10   leaching with acid to obtain an aqueous acidic solution containing a mixture of rare earth metals.

Examples of rare earth metal bearing minerals contained in rare earth ores are aeschynite, allanite, apatite, bastnäsite, brannerite, britholite, eudialyte, euxenite, fergusonite, gadolinite,

15   kainosite, loparite, monazite, parisite, perovskite, pyrochlore, xenotime, yttrocerite, huanghoite, cebaite, florencite, synchysite, samarskite, and knopite.

Rare earth metals may also increasingly be obtained from recycled materials. As global demand for rare earth metals grows, it is increasingly attractive to obtain earth metals from

20   recycled waste materials, particularly in countries with a lack of minable rare earth ore deposits. Rare earth waste materials may be obtained from various sources, for example direct recycling of rare earth scrap/residues from pre-consumer manufacturing, "urban mining" of rare earth containing end of life products, or landfill mining of urban and industrial waste containing rare earths. As rare earth metals are increasingly being used in consumer

25   products, the amount of rare earth metals that can be obtained from such waste materials is also growing.

Waste materials that may contain rare earth metals include, magnetic swarf and rejected magnets, rare earth containing residues from metal production/recycling (*e.g.* postsmelter and

30   electric arc furnace residues or industrial residues such as phosphogypsum and red mud), phosphors such as those in fluorescent lamps, LEDs, LCD backlights, plasma screens and cathode ray tubes, permanent magnets (*e.g.* NdFeB) such as those used in automobiles, mobile phones, hard disk drives, computers and peripherals, electronic kitchen utensils, hand held tools, electric shavers, industrial electric motors, electric bicycles, electric vehicle and

35   hybrid vehicle motors, wind turbine generators, nickel-metal hydride batteries such as are used for rechargeable batteries and electric and hybrid vehicle batteries, glass polishing powders, fluid cracking catalysts and optical glass. Major end-of-life waste material sources

of rare earths in terms of value are permanent magnets, nickel-metal hydride batteries and lamp phosphors, as well as scrap in the form of magnetic swarf waste.

Rare earth metals will usually be extracted from waste materials by leaching with mineral acids
5   and optionally further processing to remove impurities such as transition metals. This results in an acidic solution of the rare earth metals, which may be used as a source for separation and purification of the individual rare earth metals.

Thus, it is an advantage of embodiments of the present invention that rare earth metals may
10   be extracted with high selectivity and extractability directly from an acidic solution of the rare earth metal, which may be conveniently obtained from the extraction process of an ore or a waste material.

In some embodiments, it will not always be desirable to separate the rare earth metal, for
15   example by stripping with acid, from the composition comprising the ionic liquid since an ionic liquid composition comprising a rare earth metal may be a valuable resource in itself.

For example, the method of embodiments of the present invention may further comprise the electrodeposition of one or more rare earth metals or precipitation of one or more rare earth
20   metals (*e.g.* with oxalic acid) from the non-aqueous phase.

Electrodeposition of rare earth metals from ionic liquids and precipitation of rare earth metals from solution are well known in the art any may be performed in any suitable way, as will be appreciated by one skilled in the art.
25

The ionic liquid defined herein may be prepared by a method which comprises reacting:

$$L_1 \overset{[Z]}{\underset{NH_2}{}} \qquad \text{with} \qquad L_2 \overset{EDG}{\underset{LG}{}} \quad ,$$
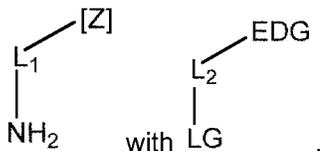
where: LG represents a leaving group.

30   A "leaving group" as used herein will be understood to mean a group that may be displaced from a molecule by reaction with a nucleophilic centre, in particular a leaving group will depart with a pair of electrons in heterolytic bond cleavage. A leaving group is usually one that is

able to stabilize the additional electron density that results from bond heterolysis. Such groups are well-known in the field of chemistry.

It will be understood that the group [Z] may be any group that is able to displace the leaving group to form a $[Z^+]$ cation as defined previously herein.

It will be appreciated that a leaving group as defined herein will be such that the primary amine coupled by L_1 to [Z] may displace the leaving group to form a bond between the nitrogen and an L_2 group, and such that the group [Z] can displace the leaving group to form a bond between [Z] and an L_2 group.

Leaving groups may, for example, include a group selected from dinitrogen, dialkyl ethers, perfluoroalkylsulfonates such as triflate, tosylate or mesylate, halogens such as Cl, Br and I, water, alcohols, nitrate, phosphate, thioethers and amines. Preferably, the leaving group LG is selected from halides, more preferably the leaving group LG is Cl.

Such substitution reactions as described herein are well-known in the art and could be performed by a skilled person without difficulty.

By preparing an ionic liquid by this method, an ionic liquid having advantageous rare earth metal extraction properties may be conveniently synthesised in a single step, reducing the increased costs associated with multiple step syntheses.

BRIEF DESCRIPTION OF THE DRAWINGS

The present invention will now be illustrated by way of the following examples and with reference to the following figures in which:

Figure 1 is a graph showing the distribution factors for the extraction of a selection of rare earth metals according to an embodiment of the present invention.

Figure 2 shows the crystal structure of the $[MAIL]^+$ cation coordinating to Nd after extraction from an acidic (HCl) solution containing $NdCl_3 \cdot 6H_2O$.

Figure 3 is a diagram showing an apparatus (10) suitable for carrying out an extraction process according to an embodiment of the present invention. An acidic solution (12) comprising a first and second rare earth metal is passed to a series of extraction stages (E) where it is

countercurrently contacted with a composition (14) which comprises an ionic liquid. The first metal is selectively extracted from the acidic solution (12) into the non-aqueous phase. The non-aqueous phase is then countercurrently contacted with an acidic solution in a series of back-extraction (B) phases, in which second rare earth metal that has undesirably been partitioned into the non-aqueous phase may be partitioned back into an aqueous phase. The second metal may be recovered (16) from the aqueous phase. The composition comprising the first metal is passed to a series of stripping stages (S) where it is countercurrently contacted with an acidic stripping solution (18). The first metal is extracted into the acidic stripping solution, from where it may be recovered (20).

Figure 4 is a diagram showing another apparatus (10) suitable for carrying out an extraction method according to an embodiment of the present invention. In the apparatus shown in Figure 4, countercurrent extraction is carried out in a series of 6 extraction stages (E1 to E6) and countercurrent stripping is carried out in a series of 4 stripping stages (S1 to S4). In each stage, the aqueous and non-aqueous phases are mixed and separated, with the aqueous phase passed to the next stage (e.g. from E2 to E3) and the non-aqueous phase passed in the opposite direction to the previous stage (e.g. from E2 to E1). Thus, the streams are countercurrently contacted and the rare earth metal concentration gradient is maintained between the aqueous and non-aqueous phase across the series of extraction / stripping stages. The stripped non-aqueous phase is recycled and used as the composition (14) comprising the ionic liquid in the countercurrent extraction. During recycling, the pH of the non-aqueous phase is equilibrated with an acidic solution (22) having the same pH as the acidic solution (12) of the rare earth metal in a pH adjustment stage (A1), with the spent aqueous effluent (24) withdrawn from the adjustment stage (A1) after equilibration.

Figure 5 is a diagram showing an extraction train having three countercurrent extraction stages (E1-E3) and two back-extraction stages (B1-B2). The apparatus in each extraction and back extraction stage comprises a mixing chamber (28) and a separating chamber (30). A composition (14) comprising an ionic liquid is introduced into the extraction train in the third countercurrent extraction stage (E3). An acidic back-extraction solution (26) is introduced into the extraction train in the second back-extraction stage (B2). An acidic solution (12) comprising first and second rare earth metals is introduced into the first extraction stage (E1), where it is mixed with the non-aqueous ionic liquid phase in a mixing chamber (28). The aqueous and non-aqueous phases are then separated in a separating chamber (30). The non-aqueous ionic liquid phase is passed to the first back-extraction stage (B1) – where any second rare earth metal that has been taken-up by the ionic liquid may be back-extracted into the acidic back-extraction solution – while the aqueous phase is passed to the second

countercurrent extraction stage (E2). The ionic liquid composition (14') that leaves the extraction train may be processed further, *e.g.* it may be stripped of first rare earth metal using an acidic stripping solution. The acidic solution (26') depleted of first rare earth metal may also be processed further, *e.g.* in a second rare earth metal recovery stage.

5

Figure 6 is a graph showing extraction of a selection of rare earth metals using [MAIL⁺][R₂P(O)O⁻].

Figure 7 is a graph showing extraction of a selection of rare earth metals using [MAIL-6C⁺][NTf₂⁻].

10

Figure 8 is a graph showing extraction of a selection of rare earth metals using [MAIL-Ph⁺][NTf₂⁻].

15 **EXAMPLES**

Example 1: Synthesis of ionic liquid

General procedure for the synthesis of an ionic liquid according to embodiments of the invention

20

A reaction mixture comprising 3 moles of an *N,N*-dialkyl-2-chloroacetamide and a substrate having the structure $H_2N-L_1-[Z]$ were stirred in a halogenated solvent (*e.g.* $CHCl_3$, CH_2Cl_2, *etc.*) or an aromatic solvent (*e.g.* toluene, xylene, *etc.*) at 60 to 70 °C for 7 to 15 days. After cooling,

25 the solid was filtered off and the organic phase was repeatedly washed with 0.1 to 0.2 M HCl until the aqueous phase showed milder acidity (pH ≥ 2). The organic phase was then washed with 0.1 M Na_2CO_3 (2-3 washes) and finally was washed with deionized water until the aqueous phase showed a neutral pH. The solvent was removed under high vacuum to give the ionic liquid product (with a chloride anion) as a highly viscous liquid. This ionic liquid could

30 be used as it was or the chloride anion could be exchanged with different anions (*e.g.* bistriflimide, triflate, hexafluorophosphate *etc.*) using conventional metathesis routes, for example, by reacting with an alkali metal salt of the desired anion with the ionic liquid in an organic solvent.

35 Synthesis of an imidazolium ionic liquid
[MAIL⁺][NTf₂⁻]:

[MAIL⁺]Cl⁻
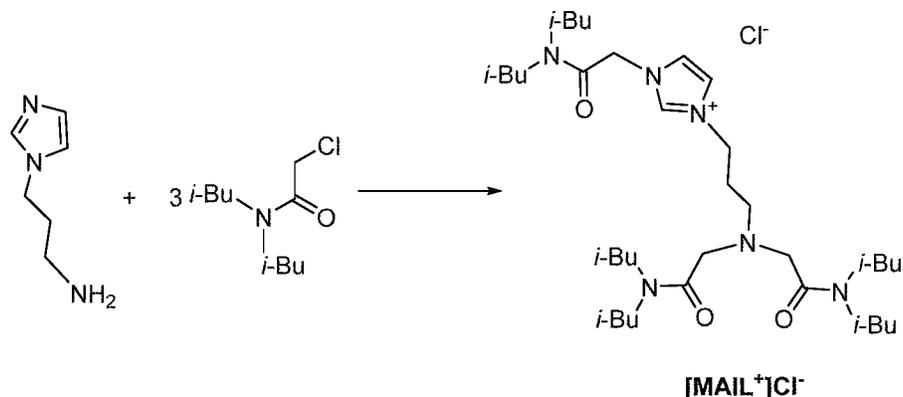
1-(3-Aminopropyl)-imidazole (0.05 mol) was added to of N,N-diisobutyl-2-chloroacetamide (0.15 mol) in a 500 ml three necked round bottom flask. Triethylamine (0.11 moles) was then added along with chloroform (200 ml). The reaction was stirred for 6 hours at room temperature and then stirred at 60 to 70 °C for 7 days. The reaction mixture was then cooled and after filtration it was successively washed with 0.1 M HCl, 0.1 M Na_2CO_3 and deionized water (as described in general procedure). The solvent was removed from the neutralised organic phase at 8 mbar (6 mm Hg) and finally at 60 °C and 0.067 mbar (0.05 mmHg). The ionic liquid [MAIL⁺]Cl⁻ was recovered as a highly viscous yellow liquid.

Ionic liquid [MAIL⁺]Cl⁻ (0.025 mol) was dissolved in chloroform and lithium bis-(trifluoromethane) sulfonamide (LiNTf₂) (0.03 mol) was added. The reaction mixture was stirred for 1 hour and then the organic phase was repeatedly washed with deionized water. Finally the solvent was removed from the organic phase under vacuum (0.13 mbar ,0.1 mm Hg) at 65 °C to yield the bistriflimide anion form of the ionic liquid ([MAIL⁺][NTf₂⁻]).

[MAIL-6C⁺][NTf₂⁻]:

[MAIL-6C⁺][NTf₂⁻]

3
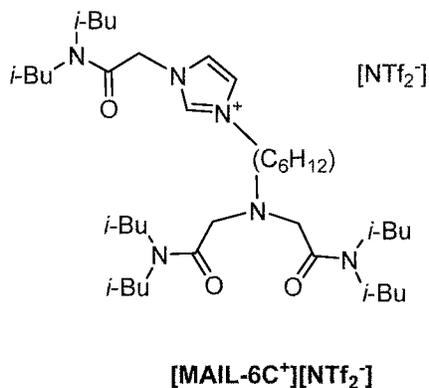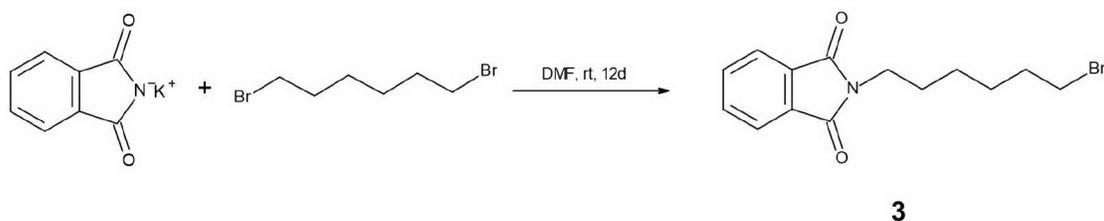
A mixture of potassium pthalimide (10.0 g, 54.0 mmol) and 1,6-dibromobutane (9.97 mL, 64.8 mmol) in dry DMF (100 mL) was stirred at room temperature for 12 days. The mixture was concentrated and extracted with chloroform (3x30 mL) and washed with deionised water (3x 80 mL) and brine (100 mL). The organic layer was dried over magnesium sulfate and concentrated to give a white syrup. The syrup was triturated with hexanes, filtered and dried to give a white solid product (**3**) (14.3 g, 85%).

3   **4**
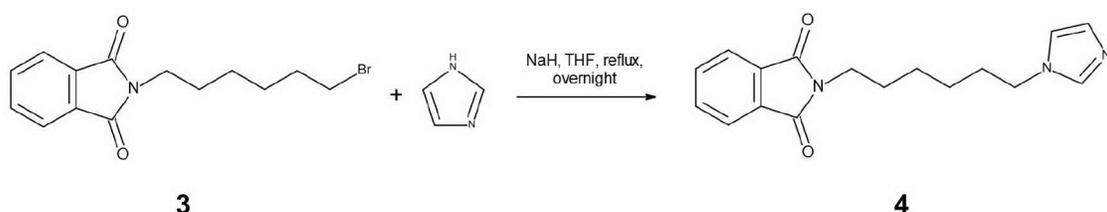
To NaH (0.645 g, 26.9 mmol) in THF was added at 0°C under N_2, imidazole (1.21 g, 17.7 mmol) in THF was added over 30mins, and stirred for a further 30mins at 0°C. **3** (5.00 g. 16.1 mmol) in THF was added at 0°C and the mixture stirred for 1 hour at room temperature, then refluxed at 70°C overnight. The mixture was filtered and the residual NaBr was washed with THF. The filtrate was concentrated to give a syrup which was dissolved in DCM to give a yellow solution which was then washed with water and dried over sodium sulfate and triturated with hexanes to precipitate a white solid which was filtered and washed with hexanes (**4**) (1.52 g, 32%).

4   **5**
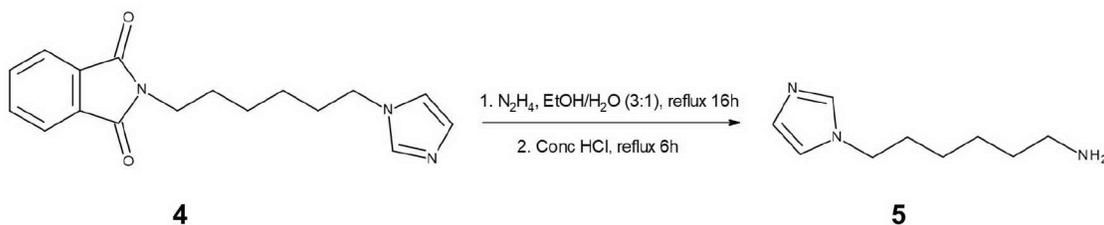
4 (0.750 g, 2.54 mmol) was dissolved in a EtOH:H_2O mixture (160 mL, 3:1) and hydrazine hydrate (50-60%, 0.174 mL, 5.55 mmol) was added at room temperature and the mixture refluxed overnight. The solution was cooled to room temperature and concentrated HCl (2 mL) was added, the reaction mixture changed from colourless to yellow to red to light yellow during the addition. The mixture was stirred at reflux for 6 hours and filtered. The solution was concentrated and dissolved in distilled water to give a yellow solution. Sodium hydroxide was

added until the mixture reached pH 11, it was then extracted with chloroform (4x 40 mL), dried over magnesium sulfate and concentrated to give an orange oil (**5**) (0.329 g, 78%).

5   **5**   **6**
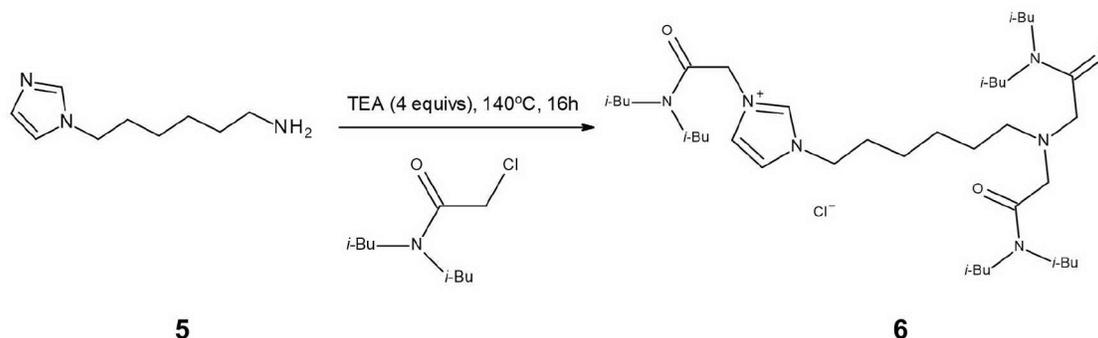
To a high pressure vessel was added **5** (0.257 g, 1.54 mmol), triethylamine (0.623 g, 6.16 mmol), *N,N*-diisobutyl-2-chloroacetamide (0.950 g, 4.62 mmol) and chloroform (5 mL). The vessel was stoppered and stirred at 140°C on an oil bath for 16 hours. The reaction mixture was washed with pH 1 HCl (40 mL), Na_2CO_3 (2x 40 mL) then water (4x 40 mL). The organic

10   layer was dried over magnesium sulfate and concentrated in vacuo to give a viscous dark brown liquid (**6**) (0.648 g, 59%).

6
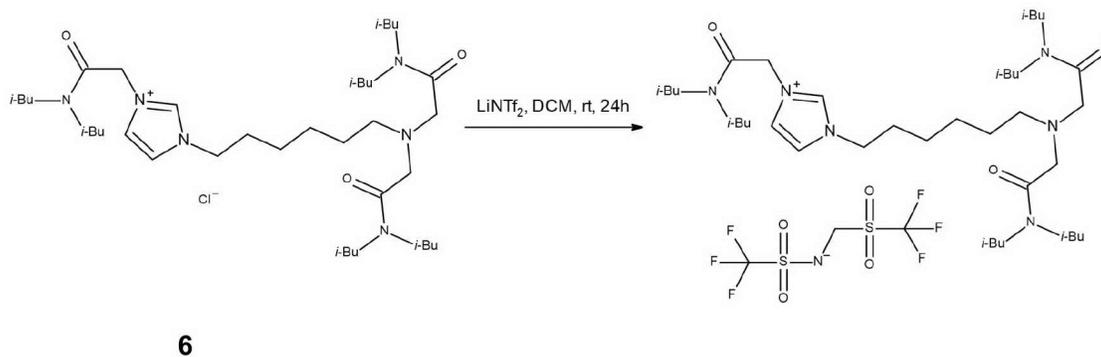
To a round bottom flask was added **6** (0.6255 g, 0.88 mmol) followed by DCM (50 mL). $LiNTf_2$

15   (0.7572 g, 2.64 mmol) was added followed by water (50 mL). The reaction mixture was stirred at room temperature for 24 hours. The aqueous layer was removed and the organic layer washed with deionised water (4x40 mL). The organic layer was dried over magnesium sulfate and concentrated. The product was dried overnight to give a black viscous liquid, [MAIL-6C$^+$][NTf$_2$$^-$], (0.7467 g, 89 %).

20

25

[MAIL-Ph⁺][NTf₂⁻]:

[MAIL-Ph⁺][NTf₂⁻]

7

5   To a high pressure vessel was added 1-(3-aminopropyl)imidazole (0.200 g, 1.60 mmol), triethylamine (0.647 g, 6.39 mmol), 2-chloro-N,N-diphenylacetamide (1.18 g, 4.49 mmol) and chloroform (5 mL). The vessel was stoppered and stirred at 145°C on an oil bath for 16 hours. The reaction mixture was washed with pH 1 HCl (15 mL), then water (4x 150 mL). The organic layer was dried over magnesium sulfate and concentrated in vacuo to give an orange/brown

10   solid (**7**) (0.883 g, 70 %).

7

To a 50 mL round-bottom flask was added **7** (0.444 g, 0.560 mmol) followed by DCM (20 mL). LiNTf$_2$ (0.484 g, 1.69 mmol) was added followed by deionised water (20 mL). The reaction mixture was stirred at room temperature for 24 hours. The aqueous layer was removed and the organic layer washed with deionised water (5x 15 mL). The organic layer was dried over magnesium sulfate and concentrated. The product was dried overnight to give a viscous brown liquid, [MAIL-Ph$^+$][NTf$_2^-$], (0.351 g, 65 %).

The phosphinate ionic liquid [MAIL$^+$][R$_2$P(O)O$^-$] (R = 2,4,4-trimethylpentyl) was also synthesised by ion exchange.

Synthesis of phosphonium ionic liquids

[MAIL-PPh$_3^+$][NTf$_2^-$]:

[MAIL-PPh$_3$$^+$][NTf$_2$$^-$]

To a 50 mL round-bottom flask equipped with a magnetic stir bar triphenylphosphine (0.836 g, 3.19 mmol), 3-bromopropylamine hydrobromide (1.00 g, 4.57 mmol), and acetonitrile (25 mL) were added. The suspension was then heated and stirred at reflux for 16 hours. The reaction was cooled to room temperature, and the solvent was removed under reduced pressure, and the resulting white solid was then dried in vacuo, and used in subsequent steps without further purification (1.01 g, 79 %).

To a 50 mL round-bottom flask was added (3-Aminopropyl)(triphenyl)phosphonium bromide (1.01 g, 0.252 mmol) followed by DCM (20 mL). LiNTf$_2$ (2.17 g, 7.55 mmol) was added followed by deionised water 20 mL). The reaction mixture was stirred at room temperature for 24 hours. The aqueous layer was removed and the organic layer washed with deionised water (5x 15 mL). The organic layer was dried over magnesium sulfate and concentrated. The product was dried overnight to give a white solid (1.26 g, 84 %).

To a high pressure vessel was added (3-Aminopropyl)(triphenyl)phosphonium bistriflimide (0.200 g, 0.333 mmol), triethylamine (0.135 g, 1.33 mmol), N,N-diisobutyl-2-chloroacetamide (0.137 g, 0.666 mmol) and chloroform (5 mL). The vessel was stoppered and stirred at 145°C on an oil bath for 48 hours. The reaction mixture was washed with pH 1 HCl (15 mL), then water (4x 150 mL). The organic layer was dried over magnesium sulfate and concentrated in vacuo to give a viscous dark brown liquid, [MAIL-PPh$_3$$^+$][NTf$_2$$^-$], (0.282 g, 90 %).
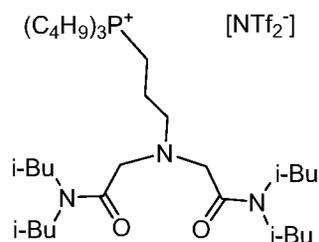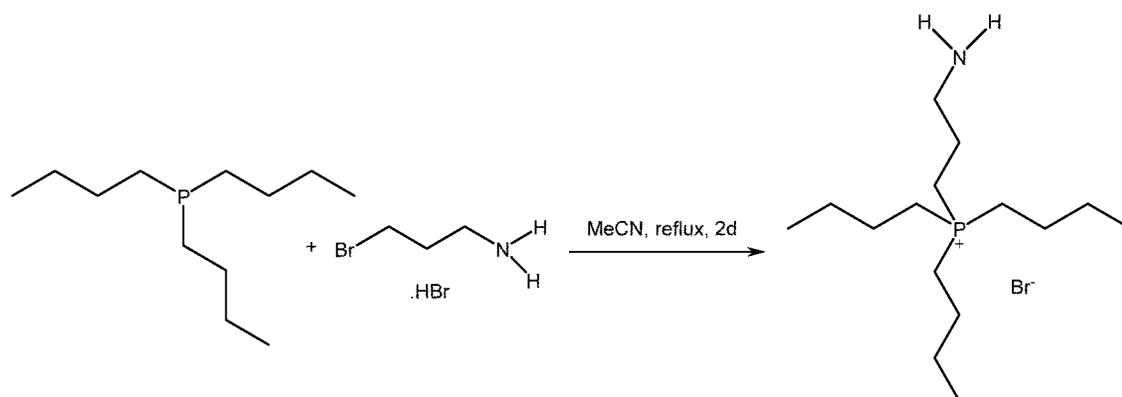
[MAIL-PPh$_3$$^+$][R$_2$P(O)O$^-$]:
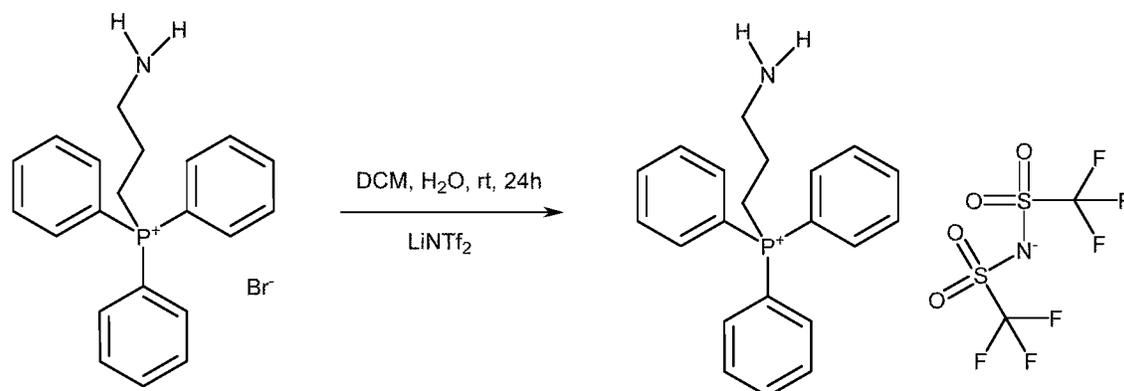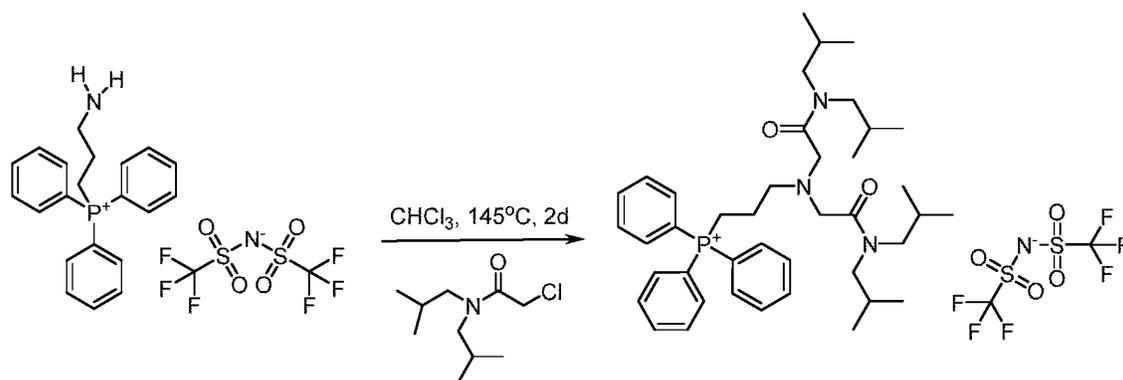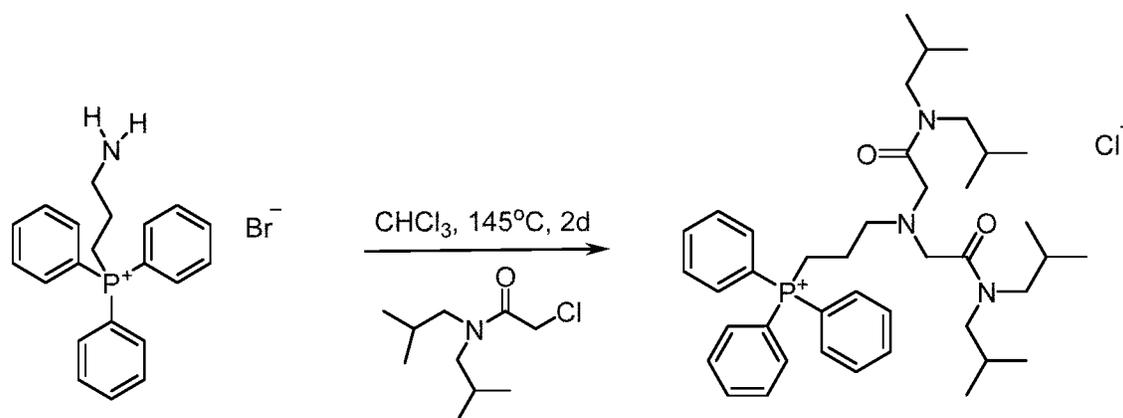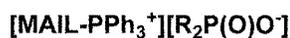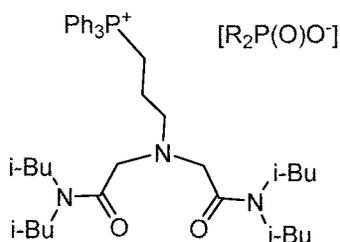
[MAIL-PPh$_3$$^+$][R$_2$P(O)O$^-$]

R = 2,4,4-trimethylpentyl

To a high pressure vessel was added (3-Aminopropyl)(triphenyl)phosphonium bromide (1.01 g, 2.53 mmol), triethylamine (1.03 g, 10.1 mmol), *N,N*-diisobutyl-2-chloroacetamide (1.04 g,

5   5.07 mmol) and chloroform (5 mL). The vessel was stoppered and stirred at 145°C on an oil bath for 48 hours. The reaction mixture was washed with pH 1 HCl (15 mL), then water (4x 150 mL). The organic layer was dried over magnesium sulfate and concentrated in vacuo to give a viscous dark brown liquid (0.981 g, 56 %).

10

To a 50 mL round-bottom flask was added the phosphonium diamide (0.898 g, 1.29 mmol) followed by DCM (20 mL). R$_2$P(O)OH (R = 2,4,4-trimethylpentyl) (0.356 g, 1.29 mmol) was added followed by a KOH solution (40%, 20mL). The reaction mixture was stirred at 50°C for 16 hours. The aqueous layer was removed and the organic layer washed with deionised water

(5x 15 mL). The organic layer was dried over magnesium sulfate and concentrated. The product was dried overnight to give a white solid, [MAIL-PPh$_3^+$][R$_2$P(O)O$^-$], (0.943 g, 77 %).

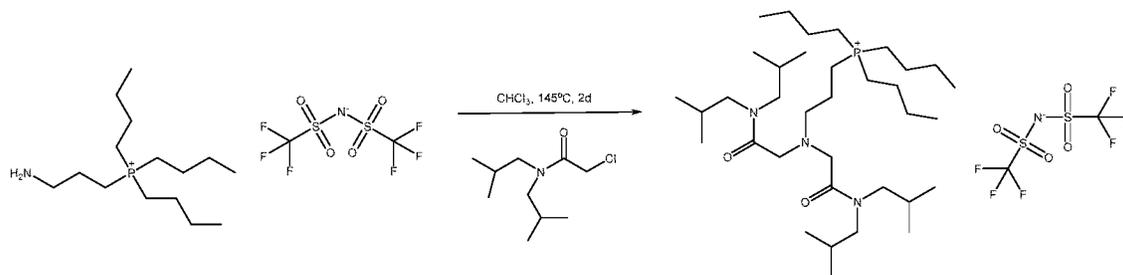[MAIL-P$_{444}^+$][NTf$_2^-$]:

[MAIL-P$_{444}^+$][NTf$_2^-$]

To a 50 mL round-bottom flask equipped with a magnetic stir bar tributylphosphine (0.823 g, 4.07 mmol), 3-bromopropylamine hydrobromide (0.890 g, 4.07 mmol), and acetonitrile (25 mL) were added. The suspension was then heated and stirred at reflux for 48 hours. The reaction was cooled to room temperature, and the solvent was removed under reduced pressure, and the resulting oil was then dried in vacuo, and used in subsequent steps without further purification (1.24 g, 89 %).

To a 50 mL round-bottom flask was added (3-Aminopropyl)(tributyl)phosphonium bromide (0.559 g, 1.64 mmol) followed by DCM (20 mL). LiNTf$_2$ (1.41 g, 4.93 mmol) was added followed by deionised water (20 mL). The reaction mixture was stirred at room temperature for 24 hours. The aqueous layer was removed and the organic layer washed with deionised water (5x 15 mL). The organic layer was dried over magnesium sulfate and concentrated. The product was dried overnight to give a colourless oil (0.304 g, 34 %).
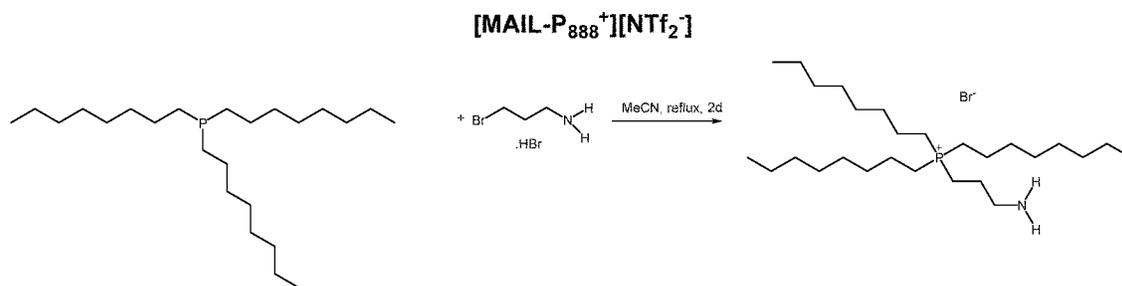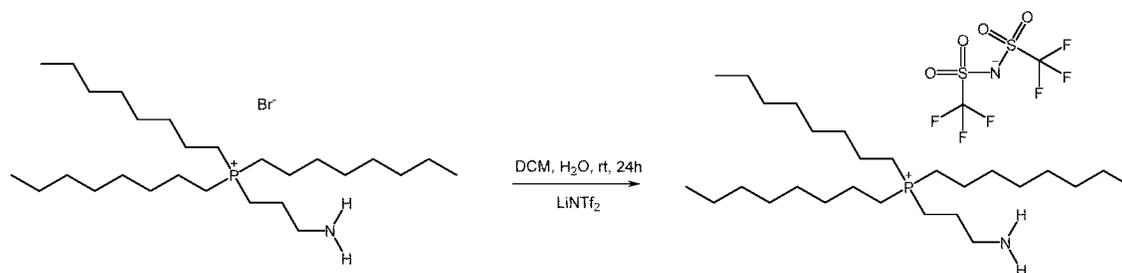
39

To a high pressure vessel was added (3-Aminopropyl)(tributyl)phosphonium bistriflimide (0.200 g, 0.370 mmol), triethylamine (0.150 g, 1.48 mmol), *N,N*-diisobutyl-2-chloroacetamide (0.152 g, 0.740 mmol) and chloroform (5 mL). The vessel was stoppered and stirred at 145°C on an oil bath for 48 hours. The reaction mixture was washed with pH 1 HCl (15 mL), then water (4x 150 mL). The organic layer was dried over magnesium sulfate and concentrated in vacuo to give a viscous dark brown liquid, [MAIL-P$_{444}$$^+$][NTf$_2$$^-$], (0.250 g, 77 %).

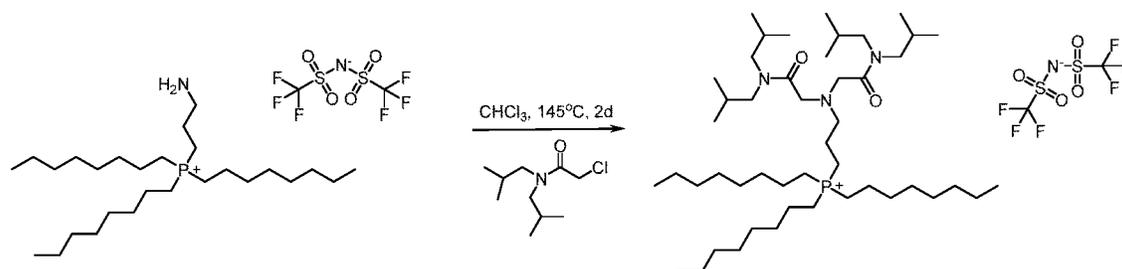[MAIL-P$_{888}$$^+$][NTf$_2$$^-$]:

[MAIL-P$_{888}$$^+$][NTf$_2$$^-$]

To a 50 mL round-bottom flask equipped with a magnetic stir bar trioctylphosphine (0.872 g, 2.35 mmol), 3-bromopropylamine hydrobromide (0.500 g, 2.28 mmol), and acetonitrile (25 mL) were added. The suspension was then heated and stirred at reflux for 48 hours. The reaction was cooled to room temperature, and the solvent was removed under reduced pressure, and the resulting oil was then dried in vacuo, and used in subsequent steps without further purification (0.889 g, 85 %).

To a 50 mL round-bottom flask was added (3-Aminopropyl)(trioctyl)phosphonium bromide (0.564 g, 1.11 mmol) followed by DCM (20 mL). LiNTf2 (0.954 g, 3.32 mmol) was added followed by deionised water (20 mL). The reaction mixture was stirred at room temperature for 24 hours. The aqueous layer was removed and the organic layer washed with deionised water (5x 15 mL). The organic layer was dried over magnesium sulfate and concentrated. The product was dried overnight to give a colourless oil (0.542 g, 69 %).

To a high pressure vessel was added (3-Aminopropyl)(trioctyl)phosphonium bistriflimide (0.200 g, 0.282 mmol), triethylamine (0.114 g, 1.13 mmol), *N,N*-diisobutyl-2-chloroacetamide (0.116 g, 0.564 mmol) and chloroform (5 mL). The vessel was stoppered and stirred at 145°C on an oil bath for 48 hours. The reaction mixture was washed with pH 1 HCl (15 mL), then water (4x 150 mL). The organic layer was dried over magnesium sulfate and concentrated in vacuo to give a viscous dark brown liquid, [MAIL-P_{888}^+][NTf_2^-], (0.313 g, 99 %).

Example 2: Liquid-liquid extraction of rare earth metals using [MAIL⁺][NTf2⁻]

General procedure for extraction of rare earth metals

Equal volumes (2 to 5 ml) of the ionic liquid extractant ([MAIL⁺][NTf2⁻] in [$P_{666(14)}^+$][NTf2⁻]) and an acidic aqueous feed solution containing rare earth metals in HCl were equilibrated for 15-30 minutes on a wrist action shaker. The phases were centrifuged and the aqueous phase was analysed for rare earth metal content using Inductively Coupled Plasma Optical Emission Spectroscopy (ICP-OES), though it will be appreciated that any suitable analysis technique

may be used. The proportion of the rare earth metals extracted into the ionic liquid (organic) phase was determined through mass balance using the ICP-OES measurement.

The distribution ratio of an individual rare earth metal was determined as the ratio of its concentration in the ionic liquid phase to that of it in the aqueous phase (raffinate). $D_M = [M]_{IL}/[M]_{Aq}$, where IL represents ionic liquid phase and Aq represents the aqueous phase (raffinate).

The separation factor (SF) with respect to an individual rare earth metal pair is expressed as the ratio of the distribution ratio of a first rare earth metal with the distribution ratio of a second rare earth metal. For example, the separation factor of dysprosium with respect to neodymium = D_{Dy}/D_{Nd}. It will be appreciated that separation factors estimated from independently obtained distribution ratios will be lower than the actual separation factors, obtained during the separation of mixtures of rare earth metals during a competitive separation (as exemplified below).

Distribution ratios for individual rare earth metals were obtained in separate extractions according to the general procedure above, using 0.0075 M $[MAIL^+][NTf_2^-]$ in $[P_{666(14)}^+][NTf_2^-]$ and a 200 mg/l (ppm) HCl solution of the relevant rare earth metal chloride (where 200 ppm refers to the concentration of the elemental metal in the solution). Figure 1 shows a plot of the distribution ratios for each rare earth metal as a function of pH, showing that the ionic liquid according to embodiments of the present invention may be used to extract rare earth metals across a range of pH values.

The separation of rare earth metals was also performed by the above method using 0.0075 M of the ionic liquids $[MAIL^+][R_2P(O)O^-]$, $[MAIL-6C^+][NTf_2^-]$ and $[MAIL-Ph^+][NTf_2^-]$ in $[P_{666(14)}^+][NTf_2^-]$. These ionic liquids were also found to differentially extract rare earth metals at pH 1 to pH4 as shown in Figures 6, 7 and 8.

Recycling of ionic liquid

Dy was extracted from an aqueous solution of Dy (180 ppm) at pH4 using 0.025 M $[MAIL^+][NTf_2^-]$ in $[P_{666(14)}^+][NTf_2^-]$ (>95% extracted) and the ionic liquid stripped at pH 1 using HCl (1:1 ionic liquid to stripping solution ratio) in 4 contacts. The ionic liquid was washed with deionised water to raise the pH to 7, and was used in further extractions. The amount of Dy extracted dropped by around 20% compared to the first extraction, but remained at a constant level over four subsequent extractions.

Separation of Dy and Nd

An aqueous HCl solution containing $DyCl_3.6H_2O$ (60 mg/l (ppm) Dy) and $NdCl_3.6H_2O$ (1400 mg/l (ppm) Nd) at pH 3 was extracted with the ionic liquid extractant (0.005 M $[MAIL^+][NTf_2^-]$ in $[P_{666(14)}^+][NTf_2^-]$) according to the general procedure above. A single contact (extraction) gave D_{Dy} = 13.45, D_{Nd} = 0.0124, giving a SF_{Dy-Nd} of 1085.

This separation factor (1085) is considerably higher than the separation factors obtained for Dy/Nd separation by the systems in the prior art shown in Table 1 (maximum 239).

The above separation was repeated using 0.0075M of an ionic liquid in $[P_{666(14)}^+][NTf_2^-]$ at pH2. The extraction was performed using $[MAIL^+][NTf_2^-]$, $[MAIL^+][R_2P(O)O^-]$, $[MAIL-6C^+][NTf_2^-]$, $[MAIL-P_{444}^+][NTf_2^-]$, $[MAIL-P_{888}^+][NTf_2^-]$, $[MAIL-PPh_3^+][NTf_2^-]$ and $[MAIL-PPh_3^+][R_2P(O)O^-]$ and the results are shown in Table 2. As can be seen, ionic liquids described herein can be used to completely selectively extract Dy from Nd. Completely selective extraction of Dy from Nd using $[MAIL^+][NTf_2^-]$, $[MAIL^+][R_2P(O)O^-]$ and $[MAIL-6C^+][NTf_2^-]$ was also observed at pH 1.8, with extraction of more than 50% Dy.

Table 2

Ionic liquid	Dy % Extraction	Nd % Extraction
$[MAIL^+][NTf_2^-]$	82	0
$[MAIL^+][R_2P(O)O^-]$	86.5	0
$[MAIL-6C^+][NTf_2^-]$	83	0
$[MAIL-P_{444}^+][NTf_2^-]$	89	0
$[MAIL-P_{888}^+][NTf_2^-]$	87	0
$[MAIL-PPh_3^+][NTf_2^-]$	90	0.6
$[MAIL-PPh_3^+][R_2P(O)O^-]$	90	0

Separation of Eu and La

An aqueous HCl solution containing $EuCl_3.6H_2O$ (65 mg/l (ppm) Eu) and $LaCl_3.7H_2O$ (470 mg/l (ppm) La) at pH 3 was extracted with the ionic liquid extractant (0.005 M $[MAIL^+][NTf_2^-]$ in $[P_{666(14)}^+][NTf_2^-]$) according to the general procedure above. A single contact (extraction) gave D_{Eu} = 9.3, D_{La} = 0.044, giving a SF_{Eu-La} of 211.

Separation of Tb and Ce

An aqueous HCl solution containing $TbCl_3.6H_2O$ (530 mg/l (ppm) Tb) and $CeCl_3.6H_2O$ (950 mg/l (ppm) Ce) at pH 3 was extracted with the ionic liquid extractant (0.0075 M [MAIL$^+$][NTf$_2$$^-$]

5   in [P$_{666(14)}$$^+$][NTf$_2$$^-$]) according to the general procedure above. A single contact (extraction) gave D_{Tb} = 11.2, D_{Ce} = 0.068, giving a SF_{Tb-Ce} of 162.

Example 3: Stripping of rare earth metals from [MAIL$^+$][NTf$_2$$^-$]

10   Dy(III) (80 ppm) was stripped from an organic phase at pH 0.25 comprising [MAIL$^+$][NTf$_2$$^-$] in [P$_{666(14)}$$^+$][NTf$_2$$^-$] (0.0075 M) in 3 successive contacts. The organic phase was contacted with an equal volume of an aqueous HCl solution (0.55 M) and was equilibrated for 15-30 minutes on a wrist action shaker. 67 ppm of Dy(III) was stripped in the first contact, 10 ppm was stripped in the second contact, and 2 ppm was stripped in the third contact.

15

In a further experiment, Dy(III) (160 ppm) was stripped from an organic phase at pH 1 comprising [MAIL$^+$][NTf$_2$$^-$] in [P$_{666(14)}$$^+$][NTf$_2$$^-$] (0.0225 M) in 5 successive contacts. The organic phase was contacted with an equal volume of an aqueous HCl solution (0.1 M) and was equilibrated for 15-30 minutes on a wrist action shaker. 98 ppm of Dy(III) was stripped in the

20   first contact, 38 ppm was stripped in the second contact, 16 ppm was stripped in the third contact, and 8 ppm was stripped in the fourth contact.

Similarly, from observation of the distribution ratios in Figure 1, it is clear that heavy rare earth metals such as Tm, Yb and Lu have significantly reduced distribution factors with increasing

25   acidity. Thus, it is also expected that heavy rare earth metals may be stripped from the ionic liquid of embodiments of the present invention at relatively high pH values.

The above examples show that a large increase in the separation factors between key rare earth metal pairs may be obtained by use of an ionic liquid according to embodiments of the

30   present invention (*e.g.* Nd/Dy: Nd-Dy magnet, Eu/La: white lamp phosphor, Tb/Ce: green lamp phosphor). The rare earth metals may also be advantageously stripped from the ionic liquid at relatively high pH compared to prior art systems.

Without wishing to be bound by any particular theory, it is believed that a more pronounced

35   increase in distribution ratios is observed for heavier rare earth metals than lighter rare earth metals as a result of increased formation of the more hydrophobic doubly coordinated rare earth metal species M.([MAIL$^+$][NTf$_2$$^-$])$_2$ over the singly coordinated species M.([MAIL$^+$][NTf$_2$$^-$]).

It is believed that the more hydrophobic species will be more easily extracted into the organic phase during separation, leading to increased distribution ratios.

Nuclear magnetic resonance, infra-red and mass spectrometry studies have shown that the doubly coordinated species is more abundant in solutions of Lu and the ionic liquid compared to solutions of La and the ionic liquid, highlighting the differentiation between the heavy and light rare earth metals achieved by the ionic liquid of embodiments of the present invention.

Furthermore, optimised geometries of the complexes $LaCl_3.([MAIL^+][Cl^-])_2$ and $LuCl_3.([MAIL^+][Cl^-])_2$ show that the distance between the tertiary central nitrogen of the ionic liquid cation and the metal is much longer in the case of La (~2.9 Å, non-bonding) than in the case of Lu (~2.6 Å, bonding), which also supports the weaker bonding of the ionic liquid to lighter rare earth metals. At the same time, the electron donating groups, in this case amides, linked to the nitrogen atom bond to the metal in a very similar way in both cases. This result shows that the central motif of the ionic liquid cation having a tertiary nitrogen donor is important for the differentiation obtained between the heavier and lighter rare earth metals and the improved selectivity that results therefrom.

Example 4: Comparison of extraction stage equipment

Extraction of rare earth metal from an acidic solution was carried out using a Rousselet Robatel™ mixer-settler, a CINC™ V02 centrifugal separator and a Rousselet Robatel™ centrifugal separator.

Each of the devices gave good levels of rare earth metal extraction. However, the centrifugal devices were preferred, since they gave better phase separation with no more than 10 % contamination of the aqueous phase with the non-aqueous phase. The CINC™ V02 centrifugal separator gave particularly good results, with less than 1 % contamination of the aqueous phase.

Example 5: Continuous laboratory-scale countercurrent extraction

An aqueous HCl solution containing $DyCl_3.6H_2O$ (60 mg/l (ppm) Dy) and $NdCl_3.6H_2O$ (1400 mg/l (ppm) Nd) was extracted with the ionic liquid extractant (0.0075 M $[MAIL^+][NTf_2^-]$ in $[P_{666(14)}^+][NTf_2^-]$) using a series of three CINC™ V02 centrifugal separators. The ionic liquid extract and aqueous solution were used in a phase ratio of 1 : 1, with each phase flowing

through the equipment at a rate of 5 L/hr. The experiment was repeated at three different pH levels. The results are shown in the following table:

pH	% Extraction	
	Dy	Nd
2	25 – 35	0.04
3	55 – 65	8.00
4	65 – 75	8.00

5   It can be seen that high levels of selectivity are achieved by countercurrently contacting the acidic solution and ionic liquid composition in a series of extraction stages.

Example 6: Simulation of larger-scale countercurrent extraction

10   A simulation of a Dy-Nd countercurrent extraction process was carried out. The simulation showed that over 99.99% purity can be obtained in both the Dy and Nd product streams under the following conditions:

	Volumetric flow rate	pH
Extraction and back-extraction stages		
Acidic solution comprising Dy and Nd	1.74 m^3 / h	2.5
Acidic back-extraction solution	1.74 m^3 / h	2.5
Composition comprising ionic liquid	1.74 m^3 / h	HCl free
Stripping stages		
Acidic stripping solution	1.74 m^3 / h	1

15

and with the following number of stages:

	Extraction	Back-extraction	Stripping
Number of stages	6	4	4

Example 7: Extraction of rare earth metals from a magnet sample

A magnet sample containing rare earth metals was obtained in powdered form and was converted to the chloride form as follows. The magnet feed was dissolved in 2 M H_2SO_4. The undissolved impurities were removed by filtration. The pH was raised to 1.5 using ammonium

5   hydroxide at 60 °C. At 60 °C the rare-earth sulphates crash out of solution leaving the iron sulphate impurity in solution. The separated rare-earth sulphate was converted to the oxalate (by contacting with oxalic acid to and washing the rare-earth oxalate with water) and calcined at 900 °C to form the rare-earth oxide. The rare-earth oxide is converted into the rare-earth chloride by leaching into a HCl solution and recrystallised.

10   A feed solution of 0.2 g rare-earth chloride salt in 50 mL pH 2 solution (HCl) was prepared. The feed solution had an initial concentration of 20.93 ppm Dy and 1573.81 ppm Nd.

Separate extractions were carried out as described in Example 2, using 0.0075 M $[MAIL^+][NTf_2^-]$ or $[MAIL^+][R_2P(O)O^-]$ in $[P_{666(14)}^+][NTf_2^-]$ at pH 2. The ionic liquids were both found to extract more than 90% of the Dy in the solution after 4 contacts, whilst extracting less

15   than 5% Nd.

It is to be understood that, if any prior art publication is referred to herein, such reference does not constitute an admission that the publication forms a part of the common general knowledge in the art, in Australia or any other country.

In the claims which follow and in the preceding description of the invention, except where the

20   context requires otherwise due to express language or necessary implication, the word "comprise" or variations such as "comprises" or "comprising" is used in an inclusive sense, i.e. to specify the presence of the stated features but not to preclude the presence or addition of further features in various embodiments of the invention.
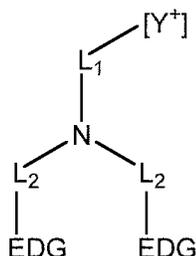
Claims

1.   A method for extracting a rare earth metal from a mixture of one or more rare earth metals, said method comprising countercurrently contacting an acidic solution of the rare earth metal with a composition which comprises an ionic liquid to form an aqueous phase and a non-aqueous phase into which the rare earth metal has been selectively extracted, wherein the ionic liquid has the formula:

$$[Cat^+][X^-]$$

in which:

$[Cat^+]$ represents a cationic species having the structure:

where: $[Y^+]$ comprises a group selected from ammonium, benzimidazolium, benzofuranium, benzothiophenium, benzotriazolium, borolium, cinnolinium, diazabicyclodecenium, diazabicyclononenium, 1,4-diazabicyclo[2.2.2]octanium, diazabicyclo-undecenium, dithiazolium, furanium, guanidinium, imidazolium, indazolium, indolinium, indolium, morpholinium, oxaborolium, oxaphospholium, oxazinium, oxazolium, iso-oxazolium, oxothiazolium, phospholium, phosphonium, phthalazinium, piperazinium, piperidinium, pyranium, pyrazinium, pyrazolium, pyridazinium, pyridinium, pyrimidinium, pyrrolidinium, pyrrolium, quinazolinium, quinolinium, iso-quinolinium, quinoxalinium, quinuclidinium, selenazolium, sulfonium, tetrazolium, thiadiazolium, iso-thiadiazolium, thiazinium, thiazolium, iso-thiazolium, thiophenium, thiuronium, triazinium, triazolium, iso-triazolium and uronium groups;

each EDG represents an electron donating group;

L_1 represents a linking group selected from C_{1-10} alkanediyl, C_{2-10} alkenediyl, C_{1-10} dialkanylether and C_{1-10} dialkanylketone groups; and

each L_2 represents a linking group independently selected from C_{1-2} alkanediyl, C_2 alkenediyl, C_{1-2} dialkanylether and C_{1-2} dialkanylketone groups; and

$[X^-]$ represents an anionic species.

2.   The method of Claim 1, wherein the method comprises countercurrently contacting the acidic solution and composition in a series of extraction stages.

3.   The method of Claim 2, wherein the acidic solution and composition are contacted and separated into an aqueous phase and a non-aqueous phase in each extraction stage.

4.   The method of any of Claims 1 to 3, wherein the composition is contacted with the acidic solution in a volume ratio of from 0.5 : 1 to 2 : 1, preferably 0.7 : 1 to 1.5 : 1, more preferably 0.8 : 1 to 1.2 : 1.

5.   The method of any of Claims 1 to 4, wherein the flow rate of the acidic solution is from 100 to 10000 L/hr, preferably from 200 to 7500 L/hr, and more preferably from 250 to 5000 L/hr.

6.   The method of any of Claims 1 to 5, wherein the acidic solution is contacted with the composition at a temperature of from 35 to 100 °C, preferably from 40 to 70 °C, and more preferably from 50 to 60 °C.

7.   The method of any of Claims 1 to 6, wherein the acidic solution from which the rare earth metal is extracted has a pH of from 2 to 4.

8.   The method of any of Claims 1 to 7, wherein the method comprises recovering the rare earth metal from the non-aqueous phase by stripping with an acidic stripping solution, the acidic stripping solution preferably having a pH of 1 or lower and preferably a pH of 0 or higher, and optionally wherein the method comprises recycling the stripped non-aqueous phase for use as the composition comprising the ionic liquid in the countercurrent extraction.

9.   The method of Claim 8, wherein the ionic liquid is countercurrently contacted with the acidic stripping solution in a series of stripping stages, and optionally wherein the method further comprises recycling the stripped non-aqueous phase for use as the composition comprising ionic liquid in the countercurrent extraction.

10. The method of any of Claims 1 to 9, wherein the acidic solution comprises a first and a second rare earth metal, and the method comprises:

(a) preferentially partitioning the first rare earth metal into the non-aqueous phase, preferably wherein the method further comprises, in step (a), separating the non-aqueous phase from the acidic solution; and

(b) contacting the acidic solution depleted of the first rare earth metal with the composition which comprises an ionic liquid, and optionally recovering the second rare earth metal therefrom;

and preferably wherein:

the first rare earth metal is recovered from the non-aqueous phase in step (a), and said non-aqueous phase is recycled and used as the composition in step (b); and/or

the acidic solution has a pH of less than 3.5 in step (a), and the acidic solution has a pH of greater than 3.5 in step (b).

11. The method of Claim 10, wherein:

the first rare earth metal is dysprosium, and the second rare earth metal is neodymium; or

the first rare earth metal is europium, and the second rare earth metal is lanthanum.

12. The method of any of Claims 1 to 11, wherein when the nitrogen linking L_1 to each L_2 and one of the EDG both coordinate to a metal, the ring formed by the nitrogen, L_2, the EDG and the metal is a 5 or 6 membered ring, preferably a 5 membered ring.

13. The method of any of Claims 1 to 12, wherein $[Y^+]$ represents:

an acyclic cation selected from:

$$[-N(R^a)(R^b)(R^c)]^+, \ [-P(R^a)(R^b)(R^c)]^+ \text{ and } [-S(R^a)(R^b)]^+,$$

where: R^a, R^b and R^c are each independently selected from optionally substituted C_{1-30} alkyl, C_{3-8} cycloalkyl and C_{6-10} aryl groups;

or a cyclic cation selected from:
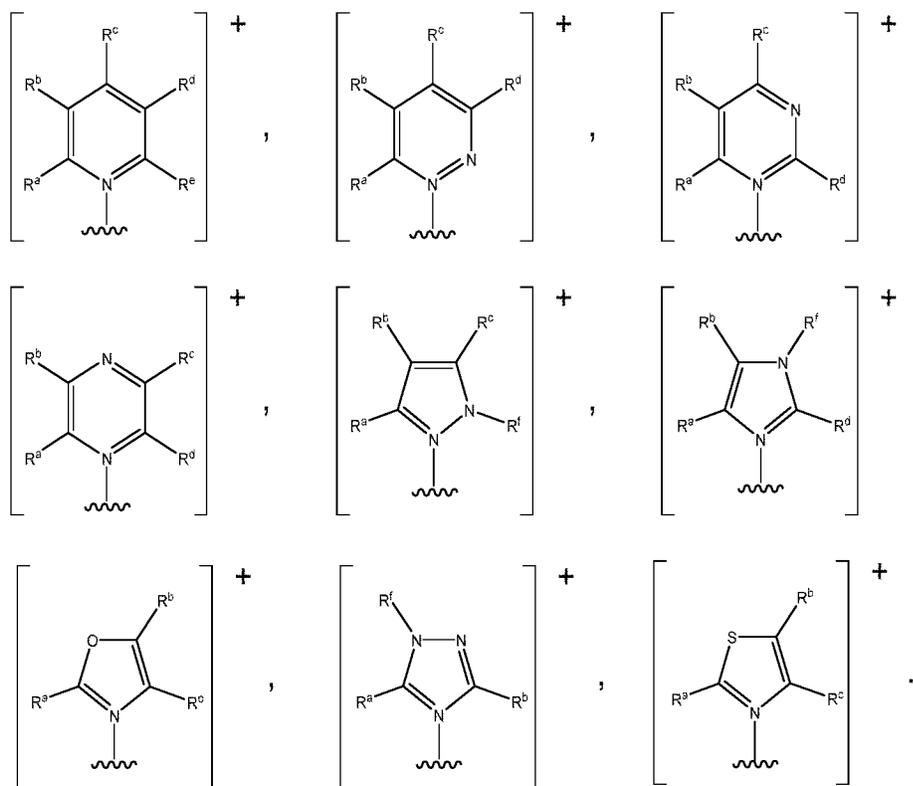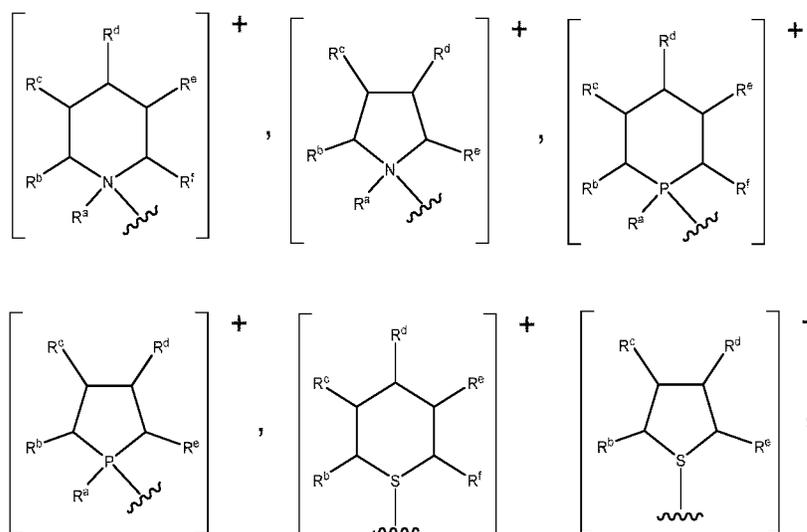
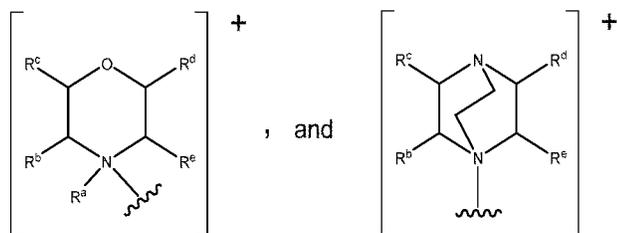where: R^a, R^b, R^c, R^d, R^e and R^f are each independently selected from: hydrogen and optionally substituted C_{1-30} alkyl, C_{3-8} cycloalkyl and C_{6-10} aryl groups, or any two of R^a, R^b, R^c, R^d and R^e attached to adjacent carbon atoms form an optionally substituted methylene chain $-(CH_2)_q-$ where q is from 3 to 6;

or a saturated heterocyclic cation having the formula:

, and

.

where: R^a, R^b, R^c, R^d, R^e and R^f are each independently selected from: hydrogen and optionally substituted C_{1-30} alkyl, C_{3-8} cycloalkyl and C_{6-10} aryl groups, or any two of R^a, R^b, R^c, R^d and R^e attached to adjacent carbon atoms form an optionally substituted methylene chain $-(CH_2)_q-$ where q is from 3 to 6,

preferably $[Y^+]$ represents a cyclic cation selected from:

,

and

;
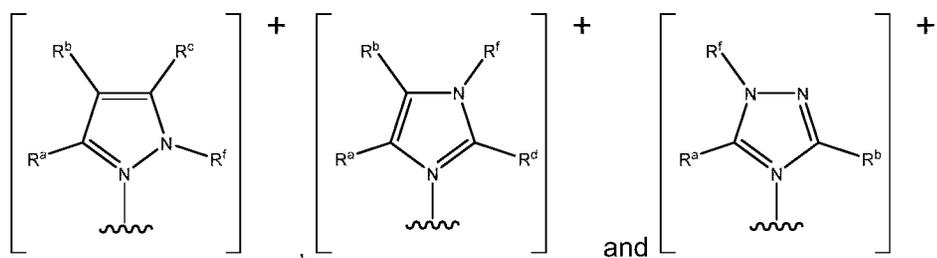
and more preferably represents the cyclic cation:

;
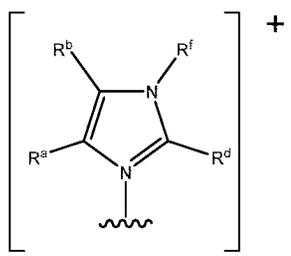
wherein preferably R^f is a substituted C_{1-5} alkyl group, and the remainder of R^a, R^b, R^c, R^d, R^e and R^f are independently selected from H and unsubstituted C_{1-5} alkyl groups.

14. The method of any of Claims 1 to 13, wherein L_1 represents:

a linking group selected from C_{1-10} alkanediyl and C_{1-10} alkenediyl groups;

preferably a linking group selected from C_{1-5} alkanediyl and C_{2-5} alkenediyl groups;

more preferably a linking group selected from C_{1-5} alkanediyl groups;

and still more preferably a linking group selected from $-CH_2-$, $-C_2H_4-$ and $-C_3H_6-$.

15. The method of any of Claims 1 to 14, wherein each L_2 represents:

a linking group independently selected from C_{1-2} alkanediyl and C_2 alkenediyl groups;

preferably a linking group independently selected from C_{1-2} alkanediyl groups;

and more preferably a linking group independently selected from $-CH_2-$ and $-C_2H_4-$.

16. The method of any of Claims 1 to 15, wherein each EDG represents:

an electron donating group independently selected from $-CO_2R^x$, $-OC(O)R^x$, $-CS_2R^x$, $-SC(S)R^x$, $-S(O)OR^x$, $-OS(O)R^x$, $-NR^xC(O)NR^yR^z$, $-NR^xC(O)OR^y$, $-OC(O)NR^yR^z$, $-NR^xC(S)OR^y$, $-OC(S)NR^yR^z$, $-NR^xC(S)SR^y$, $-SC(S)NR^yR^z$, $-NR^xC(S)NR^yR^z$, $-C(O)NR^yR^z$, $-C(S)NR^yR^z$, wherein R^x, R^y and R^z are independently selected from H or C_{1-6} alkyl;

and preferably an electron donating group independently selected from $-CO_2R^x$ and $-C(O)NR^yR^z$, wherein R^x, R^y and R^z are each independently selected from C_{3-6} alkyl,

17. The method of Claim 16 wherein each $-L_2-EDG$ represents an electron donating group independently selected from:
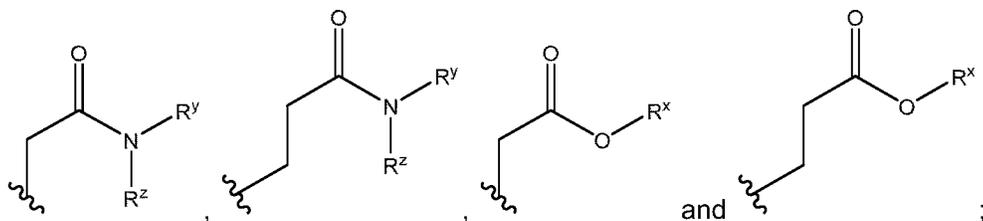
and preferably from:
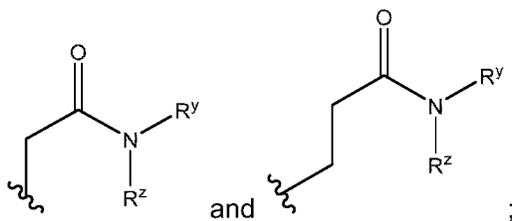
wherein $R^y = R^z$, and wherein R^x, R^y and R^z are each selected from C_{3-6} alkyl, preferably C_4 alkyl.

18.   The method of any of Claims 1 to 17, wherein [X⁻] represents one or more anionic species selected from:

hydroxides, halides, perhalides, pseudohalides, sulphates, sulphites, sulfonates, sulfonimides, phosphates, phosphites, phosphonates, phosphinates, methides, borates, carboxylates, azolates, carbonates, carbamates, thiophosphates, thiocarboxylates, thiocarbamates, thiocarbonates, xanthates, thiosulfonates, thiosulfates, nitrate, nitrite, tetrafluoroborate, hexafluorophosphate and perchlorate, halometallates, amino acids, borates, polyfluoroalkoxyaluminates;

preferably selected from:

bistriflimide, triflate, bis(alkyl)phosphinates such as bis(2,4,4-trimethylpentyl)phosphinate, tosylate, perchlorate, $[Al(OC(CF_3)_3)_4^-]$, tetrakis[3,5-bis(trifluoromethyl)phenyl]borate, tetrakis(pentafluorophenyl)-borate, tetrafluoroborate, hexfluoroantimonate and hexafluorophosphate anions;

and more preferably selected from:

bistriflimide, triflate and bis(2,4,4-trimethylpentyl)phosphinate anions.

19.   The method of any of Claims 1 to 18, wherein [Cat⁺] represents one or more ionic species having the structure:

where: [Z⁺] represents a group selected from ammonium, benzimidazolium, benzofuranium, benzothiophenium, benzotriazolium, borolium, cinnolinium, diazabicyclodecenium, diazabicyclononenium, 1,4-diazabicyclo[2.2.2]octanium, diazabicyclo-undecenium, dithiazolium, furanium, guanidinium, imidazolium, indazolium, indolinium, indolium,

morpholinium, oxaborolium, oxaphospholium, oxazinium, oxazolium, iso-oxazolium, oxothiazolium, phospholium, phosphonium, phthalazinium, piperazinium, piperidinium, pyranium, pyrazinium, pyrazolium, pyridazinium, pyridinium, pyrimidinium, pyrrolidinium, pyrrolium, quinazolinium, quinolinium, iso-quinolinium, quinoxalinium, quinuclidinium, selenazolium, sulfonium, tetrazolium, thiadiazolium, iso-thiadiazolium, thiazinium, thiazolium, iso-thiazolium, thiophenium, thiuronium, triazinium, triazolium, iso-triazolium and uronium groups.

20.   The method of any of Claims 1 to 19, wherein the composition further comprises a lower viscosity ionic liquid and/or one or more organic solvents.
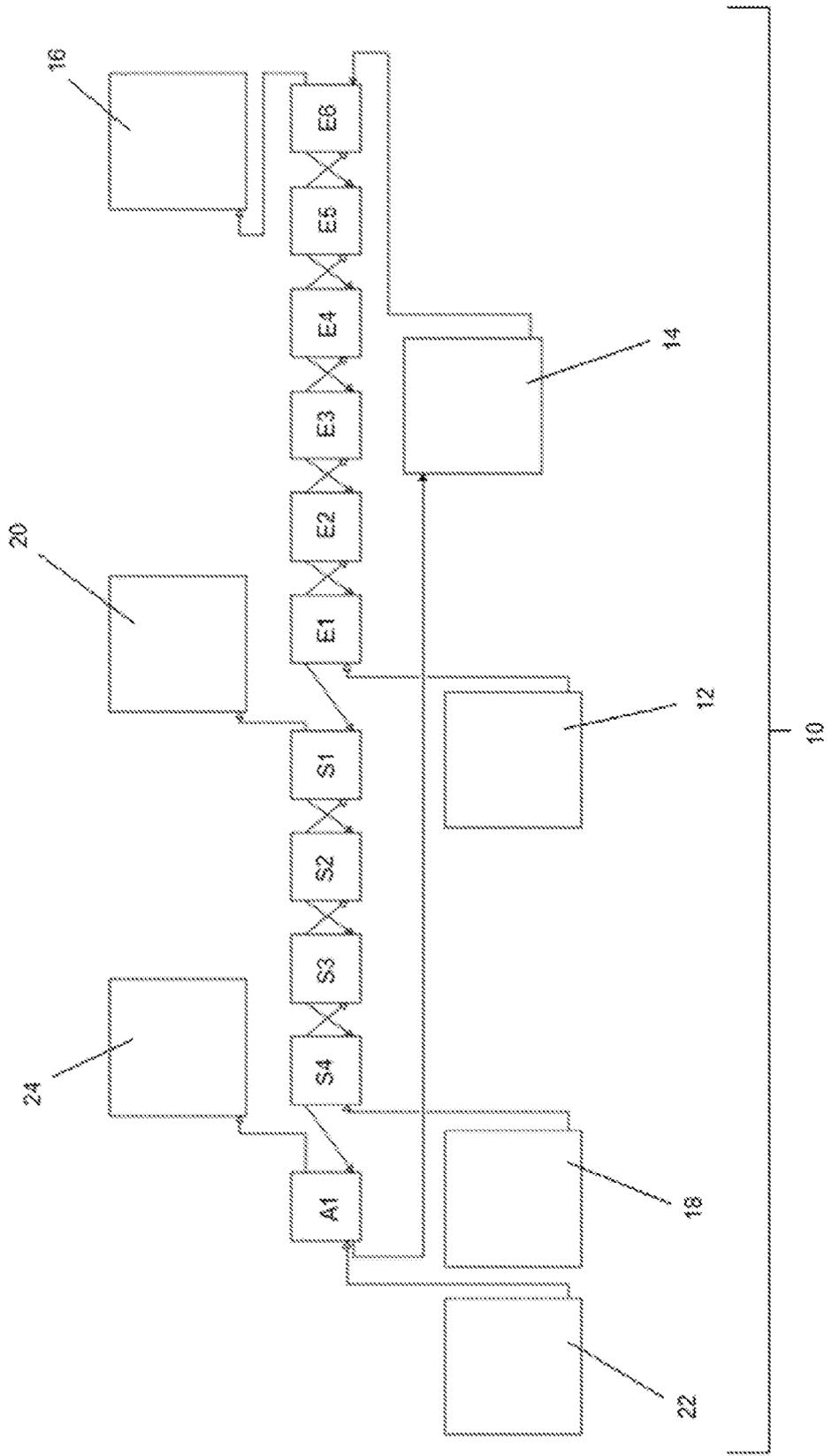
Fig. 1

Fig. 2
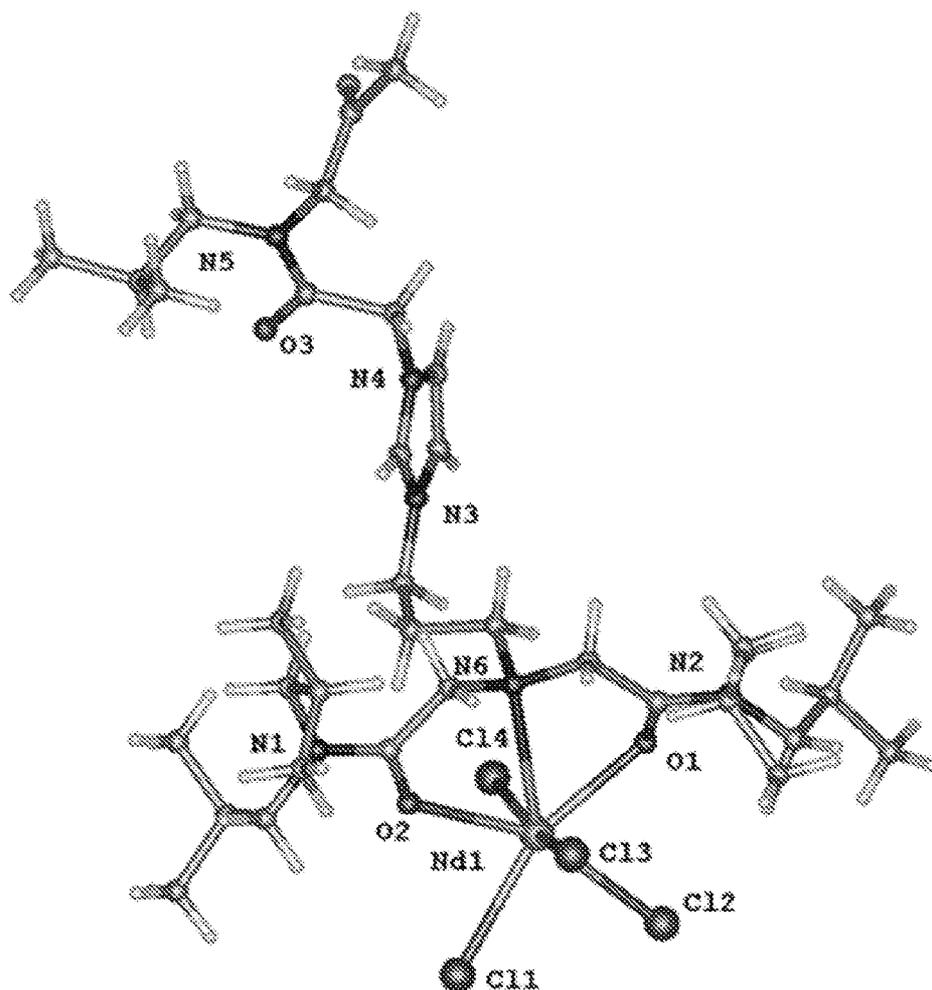
Fig. 3

Fig. 4

Fig. 5

Fig. 6

Fig. 7

Fig. 8

[MAIL-Ph][NTf$_2$]