

## The EPA's Twelve Principles of Green Chemistry

1. **Prevent waste:** Design chemical syntheses to prevent waste, leaving no waste to treat or clean up.
2. **Design safer chemicals and products:** Design chemical products to be fully effective, yet have little or no toxicity.
3. **Design less hazardous chemical syntheses:** Design syntheses to use and generate substances with little or no toxicity to humans and the environment.
4. **Use renewable feedstocks:** Use raw materials and feedstocks that are renewable rather than depleting. Renewable feedstocks are often made from agricultural products or are the wastes of other processes; depleting feedstocks are made from fossil fuels (petroleum, natural gas, or coal) or are mined.
5. **Use catalysts, not stoichiometric reagents:** Minimize waste by using catalytic reactions. Catalysts are used in small amounts and can carry out a single reaction many times. They are preferable to stoichiometric reagents, which are used in excess and work only once.
6. **Avoid chemical derivatives:** Avoid using blocking or protecting groups or any temporary modifications if possible. Derivatives use additional reagents and generate waste.
7. **Maximize atom economy:** Design syntheses so that the final product contains the maximum proportion of the starting materials. There should be few, if any, wasted atoms.
8. **Use safer solvents and reaction conditions:** Avoid using solvents, separation agents, or other auxiliary chemicals. If these chemicals are necessary, use innocuous chemicals.
9. **Increase energy efficiency:** Run chemical reactions at ambient temperature and pressure whenever possible.
10. **Design chemicals and products to degrade after use:** Design chemical products to break down to innocuous substances after use so that they do not accumulate in the environment.
11. **Analyze in real time to prevent pollution:** Include in-process real-time monitoring and control during syntheses to minimize or eliminate the formation of byproducts
12. **Minimize the potential for accidents:** Design chemicals and their forms (solid, liquid, or gas) to minimize the potential for chemical accidents including explosions, fires, and releases to the environment.

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