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Efficient Depolymerization of Cellulosic Paper Towel Waste Using Organic Carbonate Solvents

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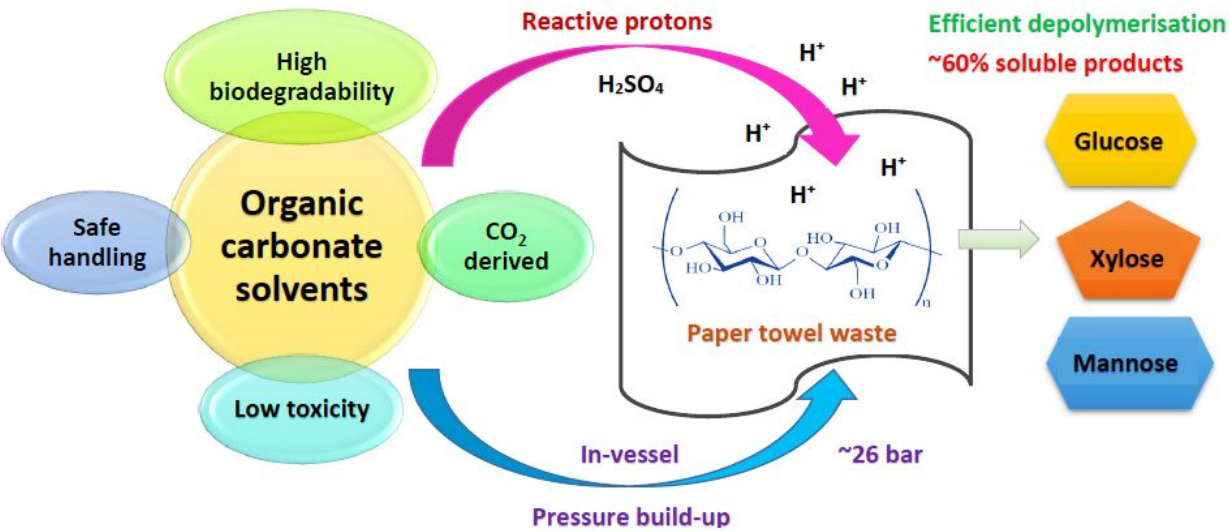
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Abstract

Efficient depolymerization of lignocellulosic biomass is a prerequisite for sugar production and its subsequent up-gradation to fuels and chemicals. Organic carbonate solvents, i.e., propylene carbonate (PC), ethylene carbonate (EC), and dimethyl carbonate (DMC), which are low in toxicity and biodegradable, were investigated as ‘green’ co-solvents (PC/H₂O, EC/H₂O, DMC/H₂O, solvent ratio 1:1) for depolymerization of cellulosic paper towel waste. PC/H₂O and EC/H₂O enhanced the depolymerization of paper towel waste and improved the total sugar yield (up to ~25 Cmol%) compared to H₂O only (up to ~11 Cmol%) at mild reaction conditions (130°C, 20 min). The higher performance of PC/H₂O and EC/H₂O can be attributed to higher availability of reactive protons in the catalytic system that facilitates efficient acid hydrolysis of recalcitrant cellulosic fibers. Moreover, a substantial build-up of in-vessel pressure by CO₂ release during the microwave-assisted reaction because of decomposition of PC or EC might have accelerated the conversion of paper towel wastes. PC and EC are prospective solvents for lignocellulosic biomass conversion considering their green features and notable catalytic performance, which have a good potential for substituting conventional organic solvents such as dimethylsulfoxide (DMSO) and tetrahydrofuran (THF) that are often considered hazardous in terms of health, safety, and environmental implications.

Keywords: Green solvent; propylene carbonate; ethylene carbonate; lignocellulose valorization; waste management; sustainable biorefinery.

Graphical Abstract



Synopsis

This study promotes the sustainable conversion of lignocellulosic biomass waste in green solvents for the production of value-added chemicals.

28 Introduction

29 Lignocellulosic waste-based feedstock offers a sustainable alternative to diminishing petroleum-
30 based resources considering environmental, economic, and political concerns. Considerable
31 research interests have been directed towards the effective utilization of waste biomass for
32 biorefinery applications in recent years¹⁻³. Depolymerization is a crucial step to obtain sugars from
33 lignocellulose which can be further upgraded to value-added chemicals and fuels in the biorefinery
34 industry. It is essential to develop cost-effective technologies for lignocellulose depolymerization
35 to achieve a high sugar yield using mild reaction conditions with low energy requirement^{4,5}.

36 In this study, we propose paper towel waste as a potential waste-based feedstock for the production
37 of sugars and chemicals. As the paper towel is a widely used sanitary product, a considerable
38 amount of paper towel wastes is generated worldwide, which, for example, contributed to 5% of
39 total waste generated at the Hong Kong International Airport. They are readily separated at source
40 (e.g., commercial building, institutions), and hence easy to collect and transfer for potential
41 valorization⁶. However, hygiene concerns and low biodegradability of highly cellulosic fibers
42 make paper towel waste unsuitable for pulp recycling and biological treatment options, e.g.,
43 anaerobic digestion and composting^{6,7}. In this case, thermo-catalytic treatment can be an effective
44 way for the sanitation and valorization of paper towel waste in a single process.

45 Depolymerization of cellulose-rich waste usually requires high reaction temperature or use of
46 concentrated mineral acid due to the recalcitrant nature of highly crystalline cellulosic fibers,
47 which can be detrimental to the environment^{4,8}. The use of organic solvents can facilitate
48 lignocellulose conversion under mild reaction conditions, such as dimethyl sulfoxide (DMSO),
49 tetrahydrofuran (THF), and ionic liquids⁹⁻¹¹. However, environmental and safety concerns have
50 been raised against these conventional solvents, and their substitution with greener solvents is

recommended^{12,13}. More research efforts are needed to explore green alternatives that are environmentally benign without compromising the lignocellulose conversion efficiency¹⁴. Recently, several studies have reported effective lignocellulose conversion using novel green solvents such as γ -valerolactone (GVL)¹⁵⁻¹⁷. Organic carbonate solvents, such as propylene carbonate (PC), ethylene carbonate (EC), and dimethyl carbonate (DMC) exhibit high biodegradability, low toxicity, and good safety score (stable under ambient conditions, low volatility, and flammability), while their synthesis involves the utilization of carbon dioxide (CO₂)^{12,18,19} (Table 1). These environment-friendly features imply their suitability as potential green solvents for biomass valorization. A few studies have reported the improved rate of catalytic biomass conversion using PC¹⁵, EC^{20,21}, and DMC²² in the reaction media. However, there is a lack of comparison among these carbonate solvents to understand their potential roles in assisting catalytic depolymerization of lignocellulosic waste.

Table 1: Properties of organic carbonate solvents

Properties	PC	EC	DMC	Reference
Boiling point (°C)	242	248	90	12
Flash point (°C)	132	143	16	
Polarity	0.83	-	0.45	36
LD ₅₀ (lethal dose) (oral) (rat) [mg kg ⁻¹]	34920	>5000	9000	18
Biodegradability [d ⁻¹]	94% (29)	readily	88% (28)	
Solubility with water [g L ⁻¹] (20°C)	240	214	139	

This study aims to investigate the use of PC, EC, and DMC as green co-solvents in a binary organic solvent-water system for the conversion of paper towel waste catalyzed by dilute sulfuric acid (H_2SO_4) in mild reaction conditions. The study provides insights into the role of organic carbonate solvents for the sustainable and efficient valorization of lignocellulosic feedstock in the biorefinery.

Experimental Section

Paper Towel Waste and Chemicals. Paper towel wastes were collected from the Hong Kong International airport (HKIA) and processed by drying (105°C , 48 h) and blending (German Pool, Pro-6). The paper towel wastes consist of 78.1% cellulose, 20.6% hemicellulose, and 1.3% lignin as reported in our recent studies⁶. PC (99%), EC (99%), and DMC (99%) solvents were purchased from Alfa Aesar. The standard chemical/compounds for calibration of the analytical equipment and catalytic reaction included glucose (99%, UNI-chem, China); fructose ($\geq 99\%$) and maltose monohydrate (98%) from WAKO; levoglucosan from Fluorochem; levulinic acid (LA) (98%), formic acid (FA) (98%), and cellobiose from Alfa Aesar; furfural (99%) and hydroxymethylfurfural (HMF; $\geq 99\%$) from Sigma Aldrich; and sulfuric acid (H_2SO_4 , 98%) Honeywell Fluka. All standard chemicals were used as received without any alteration.

Catalytic Conversion. The catalytic conversion of paper towel wastes was conducted in a microwave reactor (Ethos Up Microwave Reactor, Milestone, maximum power of 1.9 kW) in accordance with our previous studies^{6,15}. To perform the catalytic test, the substrate (5 wt.%) was loaded to a mixture of organic carbonate solvent (PC, EC, or DMC) and water (solvent mixture ratio 1:1, total volume 10 ml); and 0.135 M H_2SO_4 was used as the catalyst. Catalyst concentration and solvent mixture ratio were employed following our previous studies^{6,16}. The organic solvent-water binary systems were denoted as PC/ H_2O , EC/ H_2O , and DMC/ H_2O . The mixture of reactants

was placed in a Teflon vessel and sealed. It was subjected to heating to desired temperatures (120-150°C) at a constant ramp rate (32°C min⁻¹), followed by holding for 5-20 min. The in-vessel reaction temperature and autogenous pressure were recorded using a standard thermocouple and pressure data-logger, respectively in the microwave reactor. Apart from the mixed solvent systems, catalytic conversion of paper towel wastes was also performed in pure water as a baseline for comparison. To explore the role of carbonate solvents in depolymerization, paper towel waste was treated in PC/H₂O (140°C, 10 min) without acid addition and then oven-dried at 60°C overnight. The dried substrate was subjected to microwave-assisted conversion in H₂O (100%) (140°C, 10 min, 0.135 M H₂SO₄). Control runs without paper towel waste were carried out in all solvent systems at the same acid loading (0.135 M H₂SO₄) under selected reaction conditions.

Analysis of Samples. Liquid samples were obtained from each replicate, diluted with deionized water (DIW), and filtered through a 0.45 µm pore size membrane filter before analysis. In the case of biphasic layers emerging after reactions in PC/H₂O and DMC/H₂O solvent systems, samples were obtained from each layer for separate dilution in DIW and analysis. A water-insoluble top layer appeared for PC/H₂O solvent system at 150°C, which was dissolved firstly in ethanol and subsequently diluted in DIW for sample preparation following the steps above. Soluble products were analyzed by high-performance liquid chromatography (HPLC) using a Chromaster instrument equipped with a refractive index detector (Hitachi, Japan). Sugars were quantified by using an Agilent Hi-Plex Ca column and DIW (100%) as the mobile phase (0.4 ml min⁻¹, 80°C), after pH adjustment of samples (~7) by NaOH. Derivatives of sugars, including HMF, furfural, FA, and LA, were quantified using an Aminex HPX-87H column (Bio-Rad), where 0.01 M H₂SO₄ was used as a mobile phase (0.5 ml min⁻¹, 50°C). Standard compounds of known concentrations

were injected before sample analysis to ensure reliable calibration curves. The yield of sugars and derivatives were calculated based on the carbon content (Eqn. (1))^{6,16} of the paper towel waste.

$$\text{Product yield (Cmol\%)} = \frac{\text{Conc}_p (\text{mg ml}^{-1}) \times \text{Vol (ml)} / \text{MW}_p \times C_p}{C_s (\text{mol})} \times 100 \quad (1)$$

Where Conc_p denotes the concentration of the products; MW_p and C_p represent the molecular mass and mole number of carbons per mole of the product, respectively; C_s represents the total mole number of carbons in cellulose (13.03 mmol) and hemicellulose fraction (3.44 mmol) of paper towel (0.5 g) that is 16.47 mmol. A volume loss of 5-20% (at different temperatures) was recorded for the binary solvent systems, which was taken into account for the product yield calculation.

Post-reaction solid residues were collected through centrifugation followed by decantation. The solids were washed with DIW for three times and oven-dried for 48 hours at 60°C and then ground as a powder for characterization. Solid samples were characterized by X-ray diffraction (XRD) (Rigaku Smatlab, 10° to 50° 2θ, rate: 10° min⁻¹ at 45 kV and 200 mA), scanning electron microscope (SEM) (TESCAN VEGA3 XM), Brunauer–Emmett–Teller (BET) surface area analyzer (Micromeritics ASAP 2020 Plus Version 1.02.01), and Fourier-transform infrared spectroscopy (FTIR) (PerkinElmer, range: 4000cm⁻¹ to 400 cm⁻¹, total 25 scans). The crystallinity index (CrI) was calculated from XRD patterns for untreated paper towel waste and post-reaction solid residues according to the method reported in the literature⁶.

Results and Discussion

Depolymerization of paper towel waste in PC/H₂O solvent system.

Catalytic conversion of paper towel waste in PC/H₂O showed relatively slow depolymerization at 120°C, achieving approximately 1-4 Cmol% of glucose, 3-6 Cmol% xylose, and 2 Cmol% of

mannose during the 20-min reaction (Fig. 1a). The production of xylose and mannose were more efficient than glucose, suggesting a lower energy requirement for the depolymerization of hemicellulose compared to cellulose in PC/H₂O. As the temperature increased to 130-150°C, a sharp increase in the maximal glucose yield was observed (~21-25 Cmol%) in 10-20 min (Fig. 1b-d), which is promising and comparable to glucose yield obtained in previous studies using cellulosic substrate in the organic solvent-water system, for instance, ~10 Cmol% from vegetable waste (DMSO/H₂O, 120°C, 5 min, 0.5 g Amberlyst 36)¹⁰, ~20 Cmol% from paper towel waste (GVL/H₂O, 160°C, 5 min, 0.135 M H₂SO₄)¹⁶, and ~14 Cmol% from Chinese Pennisetum (GVL/H₂O, 180°C, 20 min, 1 M H₂SO₄)¹⁷.

It is noted that the rate of glucose production increased at the point where the xylose yield started to decline (fig. 1b-d). For instance, at 130°C, the glucose production rate was ~0.28 Cmol min⁻¹ during 0-15 min of reaction while xylose yield was increasing. However, after 15 min, xylose yield started to decline, and a rapid improvement in glucose production rate (~3.3 Cmol min⁻¹) was observed (Table 2). Cellulose fibers are usually covered by amorphous hemicellulose within lignocellulosic biomass, which needs to be dissolved to improve the accessibility of cellulosic fibers to protons in homogeneous catalytic condition²³. A sharp increase in glucose yield in parallel to the declining xylose yield might be because complete depolymerization of hemicellulose exposed more cellulose fibers for favorable proton attack to facilitate cellulose hydrolysis. Hemicellulose content is 21% of the total carbon in the paper towel waste, while the maximum total yield of hemicellulosic monomers and derivatives (i.e., xylose, mannose, and furfural) detected in PC/H₂O was ~16.5 Cmol% (140°C, 10 min) (Fig. 1c), which indicates highly efficient depolymerization of hemicellulose during the hydrolysis in the PC/H₂O solvent.

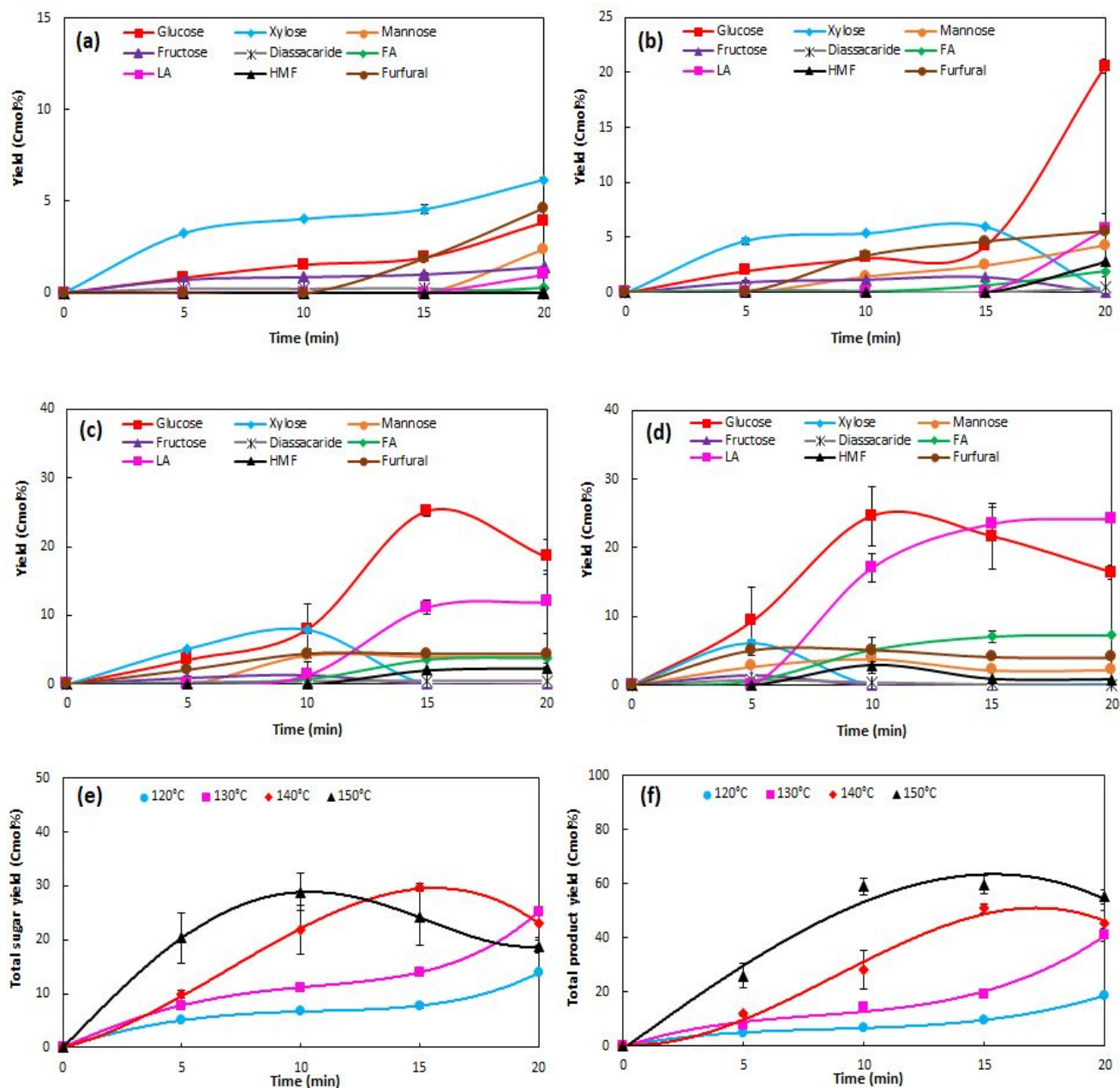


Fig. 1. Product yields versus time during the catalytic conversion of paper towel waste in PC/H₂O solvent system at different temperatures (a) 120°C, (b) 130°C, (c) 140°C, (d) 150°C, (e) total sugar yields at 120-150°C in PC/H₂O, and (f) total product yields at 120-150°C in PC/H₂O, (Reaction conditions: 5 wt% substrate loading, 0.135 M H₂SO₄, solvent ratio: 1:1)

Table 2: Rate of glucose production in PC/H₂O

Temperature	Rate of glucose production (Cmol min ⁻¹)	
	Before declining xylose yield	After declining xylose yield
130°C	0.28	3.26
140°C	0.80	3.45
150°C	1.86	3.06

The PC/H₂O solvent system generated a maximum total sugar yield of ~30 Cmol% (140°C, 15 min, and 150°C, 10 min) (Fig. 1e). A gradual decrease in total sugar yield was detected after 15 min at 140°C and after 10 min at 150°C, indicating the secondary reactions of sugars, e.g., dehydration to HMF and furfural and rehydration to LA. The negligible amount of fructose (~0.7-1.4 Cmol%) (Fig. 1a-d) suggests that glucose was converted to HMF via direct dehydration, without isomerization to fructose as the intermediate step. Strong Brønsted acids favor direct dehydration of glucose to HMF and have an insignificant effect on glucose-fructose isomerization^{10,24}. The direct glucose dehydration was less feasible than that of xylose (to furfural), which is consistent with the previous findings²⁵ and plausibly suggests a lower energy barrier for the latter reaction. The maximum total soluble product yield achieved was ~60 Cmol% (150°C, 10 min) (Fig. 1f), implying efficient depolymerization of paper towel waste in the PC/H₂O solvent.

The crystallinity index (*CrI*) was calculated from the XRD patterns of post-reaction solid residues⁶ in the PC/H₂O solvent system (120-150°C, 20 min) (Fig. 2). The *CrI* increased from 66.4% for the untreated sample to 74.2% for residues obtained after heating at 120°C for 20 min, suggesting that most of the amorphous fraction was consumed for sugar production, and the proportion of crystalline fraction relatively increased. The small increase in BET surface area (7.26 m² g⁻¹ at 120°C vs 1.53 m² g⁻¹ for untreated sample) possibly resulted from pores newly created along with the dissolution of the amorphous matrix. At higher temperatures, the crystalline fraction

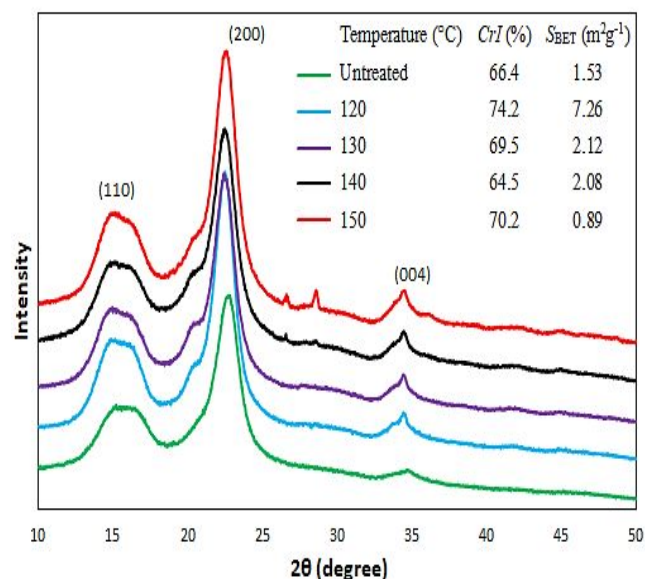


Fig. 2. XRD patterns, Crystallinity index (*CrI*) and BET surface area of untreated paper towel waste and post-reaction solid residue in PC/H₂O solvent system at different temperatures 120 $^{\circ}C$, 130 $^{\circ}C$, 140 $^{\circ}C$, and 150 $^{\circ}C$ (Reaction conditions: 5 wt% substrate loading, 0.135 M H₂SO₄, duration: 20 min, solvent ratio: 1:1)

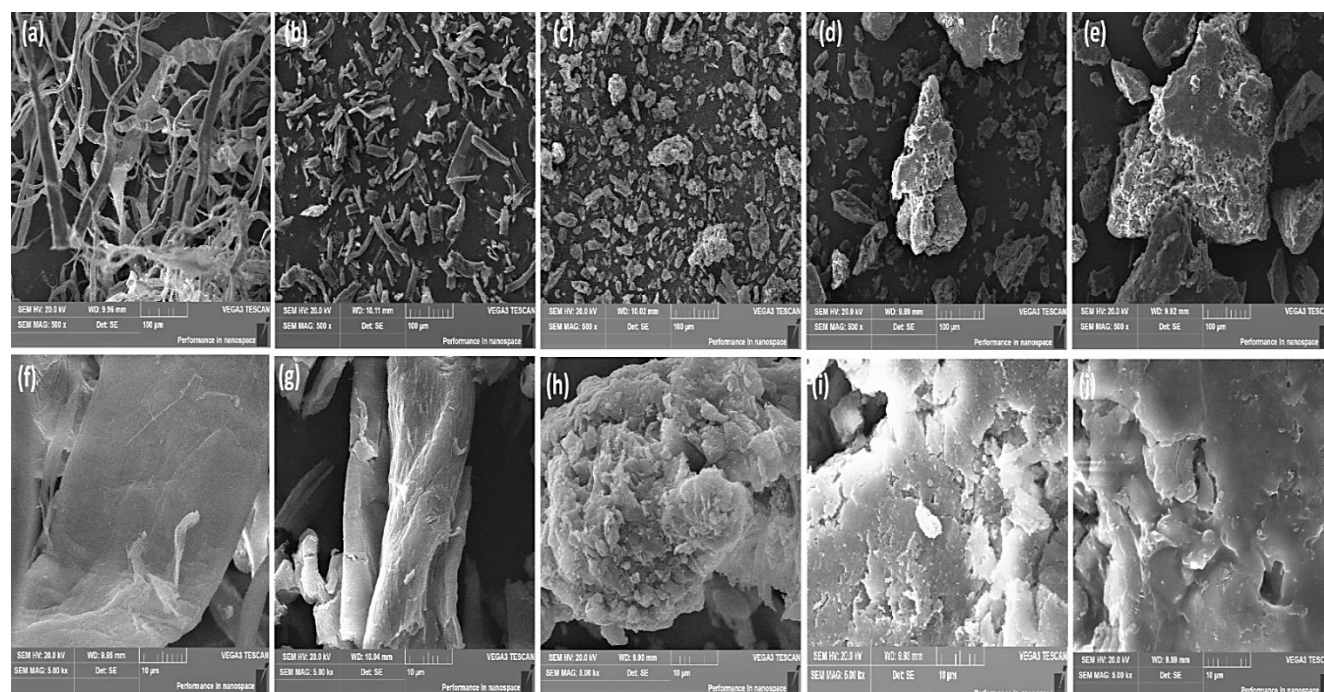


Fig. 3. Scanning electron microscope (SEM) images of untreated paper towel waste (a&f) and post-reaction solid residue in PC/H₂O solvent system at different temperatures 120 $^{\circ}C$ (b&g), 130 $^{\circ}C$ (c&h), 140 $^{\circ}C$ (d&i), and 150 $^{\circ}C$ (e&j) at 500x (a, b, c, d, e) and 5000x (f, g, h, i, j)) magnification (Reaction conditions: 5 wt% substrate loading, 0.135 M H₂SO₄, duration: 20 min, solvent PC/H₂O (1:1))

decomposed given the decrease in *CrI* to 69.5% at 130°C and to 64.5% at 140°C. The SEM images showed fiber breakdown with the increasing temperature in PC/H₂O (Fig. 3).

Comparative conversion in different carbonate solvent-water systems.

Among the solvents investigated, PC/H₂O and EC/H₂O demonstrated enhanced depolymerization of paper towel waste (total sugar yield up to ~25 Cmol% at 130°C) considering the conversion of paper towel waste in 100% H₂O as the baseline (total sugar up to ~11 Cmol%) (Fig. 4e). All solvents generated similar glucose yield (~1-2 Cmol%) after 5 min of reaction at 130°C. Unlike reaction in H₂O only, PC/H₂O and EC/H₂O demonstrated notable improvement in glucose yield when the reaction was extended to 20 min (up to ~20 Cmol% in PC/H₂O) (Fig. 4a-d). After 20-min reaction (130°C), four times higher total soluble product yield (~41 Cmol%) was observed in PC/H₂O compared to that of H₂O alone (~11 Cmol%) (Fig. 4f), demonstrating the effectiveness of carbonate solvent system for the deconstruction of lignocellulosic fibers of paper towel waste. Comparing the conversion in different carbonate solvent-water systems, EC/H₂O was the most efficient solvent in terms of total sugar yield (~19 Cmol%) and total product yield (~25 Cmol%) at 130°C in 10 min (Fig. 4e, f). Apart from the improved glucose yield (~4 Cmol%), EC/H₂O generated a higher yield of xylose (~12 Cmol%) and mannose (~2.5 Cmol%) than other solvent systems. Almost complete conversion of hemicellulose (i.e., 21% of the total carbon in the substrate) was achieved in EC/H₂O considering the total yield of xylose, mannose, and furfural (~19.5 Cmol%) at 130°C in 10 min (Fig. 4b).

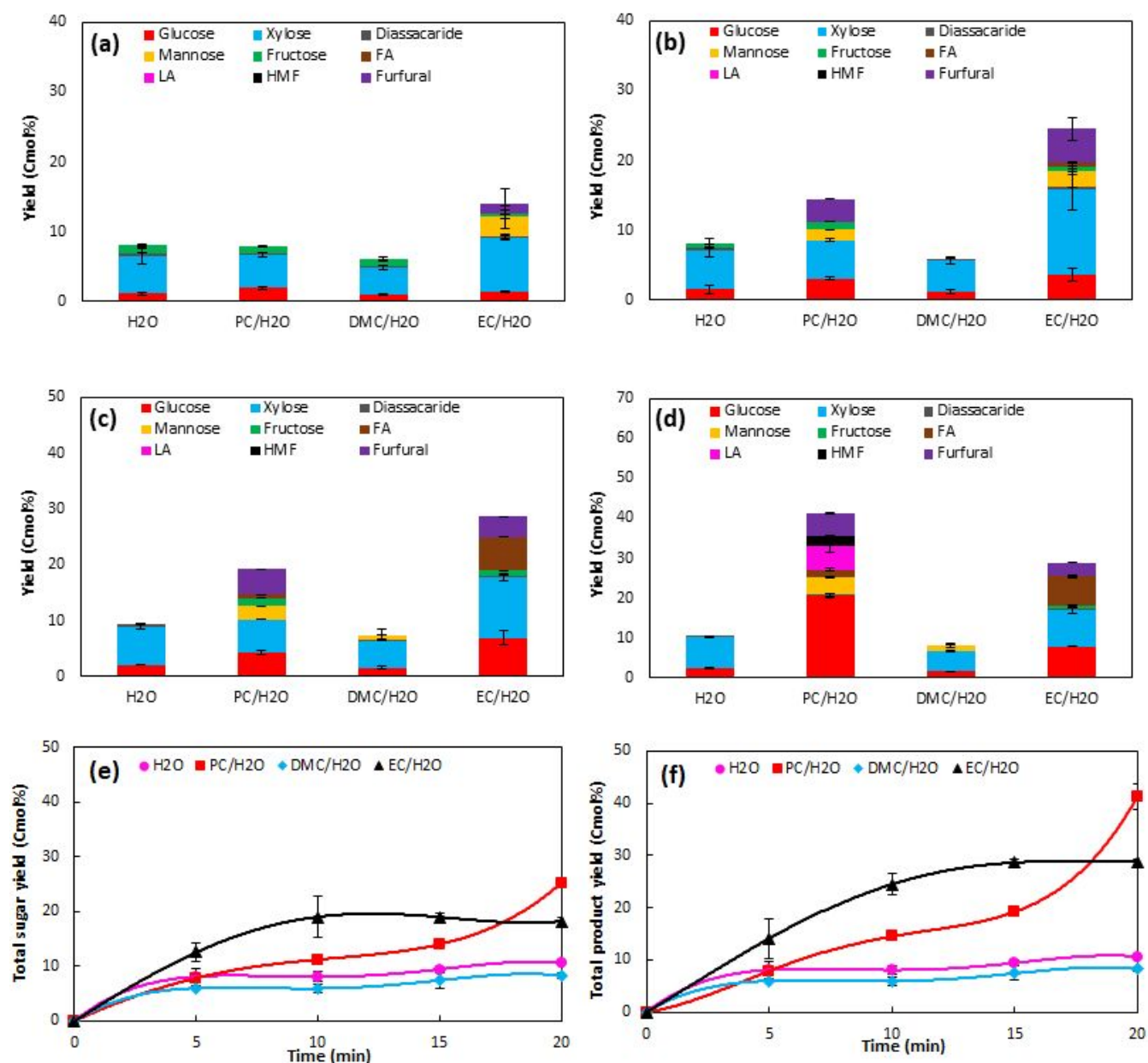


Fig. 4. Product yields during the catalytic conversion of paper towel waste in different solvent systems subject to reaction duration- (a) 5 min, (b) 10 min, (c) 15 min, (d) 20 min, (e) total sugar yields, and (f) total product yields (LA yield could not be quantified due to technical issue, and total product yield in EC/H₂O does not include the yield of LA) (Reaction condition: 5 wt% substrate loading, 0.135 M H₂SO₄, temperature: 130°C, solvent ratio: 1:1)

Characterization of post-reaction solid residues indicated higher conversion of paper towel waste in EC/H₂O solvent compared to other solvents under the same reaction conditions. Calculated *CrI* values of post-reaction solid residues (130°C, 20 min) (Fig. 5a) showed a slight increase in the crystallinity ranging from ~67-69% for H₂O (100%), PC/H₂O, and DMC/H₂O compared to untreated paper towel waste (66.4%), possibly because the decomposition of the amorphous fraction of cellulose led to a higher relative crystallinity¹⁰. In contrast, a substantial decrease in *CrI* value (~47.5%) was observed in the EC/H₂O system (Fig. 5a), which implies an efficient breakdown of recalcitrant cellulosic fibers of paper towel. Similarly, SEM images revealed a greater reduction in the fiber sizes (Fig. 6) in EC/H₂O compared to other solvents. Moreover, an increase in specific surface area (S_{BET} 4.01 m²g⁻¹ at 130°C, 20 min) was measured for solid residue in EC/H₂O compared to untreated paper towel waste (S_{BET} 1.53 m²g⁻¹) and solid residues in other solvent systems (Fig. 5a). Solid residues in PC/H₂O and EC/H₂O were further analyzed through FTIR (Fig. 5b), in which noticeable changes in transmittance were observed at 1425 cm⁻¹, 1160 cm⁻¹, and 848 cm⁻¹. The observed peak at 1425 cm⁻¹ is associated with the crystalline structure of cellulose²⁶, which was reduced to a greater extent in EC/H₂O compared to PC/H₂O indicating a significant alteration in the crystalline fraction of fibers. On the other hand, the observed peaks at 1160 cm⁻¹ and 848 cm⁻¹ can be attributed to C-O-C ring vibrational stretching of $\beta(1,4)$ linkage of cellulose^{27,28}, which was also significantly altered in the solid residue in the EC/H₂O solvent. Analysis of soluble samples and characterization of solid residues consistently indicate a higher conversion of paper towel waste in EC/H₂O compared to other solvent systems in this study.

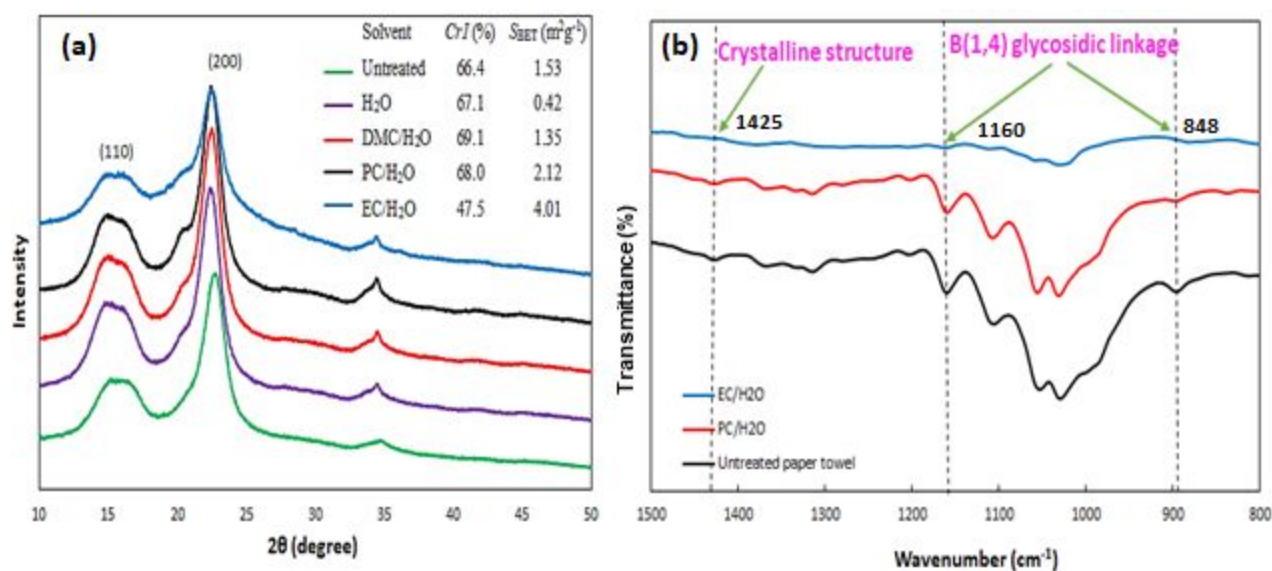


Fig. 5. (a) XRD patterns and (b) FTIR spectra of untreated paper towel waste and post-reaction solid residue in different solvent systems (Reaction conditions: 5 wt% substrate loading, temperature: 130°C, duration: 20 min, 0.135 M H₂SO₄, solvent ratio: 1:1)

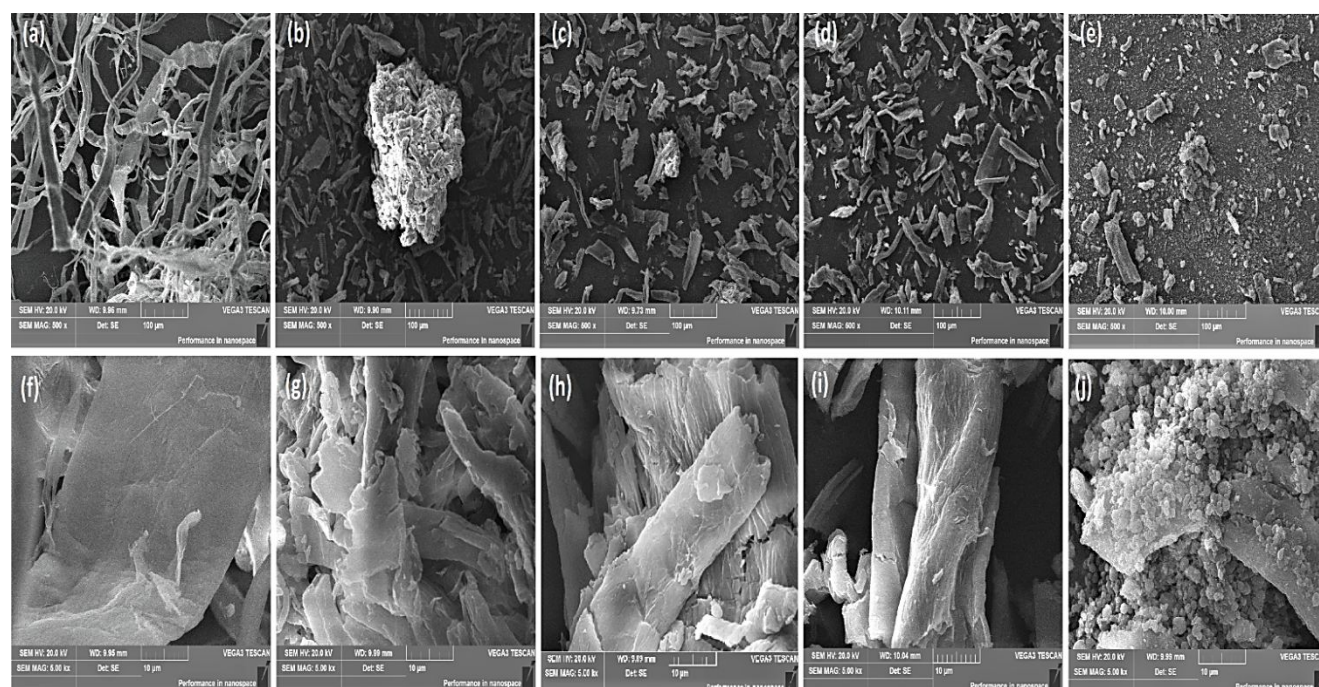


Fig. 6. Scanning electron microscope (SEM) images of untreated paper towel waste (a&f) and post-reaction solid residue in H₂O (100%) (b&g), DMC/H₂O (c&h), PC/H₂O (d&i), and EC/H₂O (e&j) at 500x (a, b, c, d, e) and 5000x (f, g, h, i, j)) magnification (Reaction conditions: 5 wt% substrate loading, 0.135 M H₂SO₄, temperature: 130°C, duration: 20 min, solvent ratio: 1:1)

254 **Role of carbonate solvents for effective depolymerization.**

255 Carbonate solvents might improve depolymerization through expansion and swelling of
256 lignocellulosic fibers or their participation in the catalytic process via activation of
257 protons/substrates, etc. To explore the potential roles of carbonate solvent, paper towel waste was
258 treated in PC/H₂O (140°C, 10 min, no acid addition) and specific surface area of the treated
259 substrate was compared to that of untreated paper towel waste. Untreated and PC/H₂O treated
260 paper towel waste showed similar S_{BET} values (1.03-1.5 m²g⁻¹). Furthermore, PC/H₂O treated paper
261 towel waste was subjected to the reaction in H₂O (100%) (140°C, 10 min, 0.135 M H₂SO₄). No
262 significant difference in the sugar yield was observed between untreated (~11 Cmol%) and solvent
263 treated (~12 Cmol%) substrate conversion (Fig. 7). These results suggest that carbonate solvents
264 on their own might not disrupt the structure or cause swelling of the paper towel waste. The
265 enhanced depolymerization of paper towel waste could be related to the higher activity of protons
266 in the presence of PC and EC as the aprotic solvents compared to that in water alone. The protons
267 from Brønsted acid catalyst tend to be more stabilized in H₂O compared to a solvent system
268 containing an aprotic solvent due to the increased solvation of protons by H₂O molecules, which
269 leads to the lower reactivity of Brønsted acid in H₂O than that of an aprotic solvent²⁹. Alternatively,
270 the organic solvent-water binary system can create a distinct phase near the surface of cellulose
271 through preferential binding of organic solvent molecules to the hydrophobic surface and binding
272 of water molecules with the hydrophilic surface. As a result, cellulose surfaces are chemically
273 modified and the induced bond cleavage can eventually enhance cellulose hydrolysis^{30,31}.

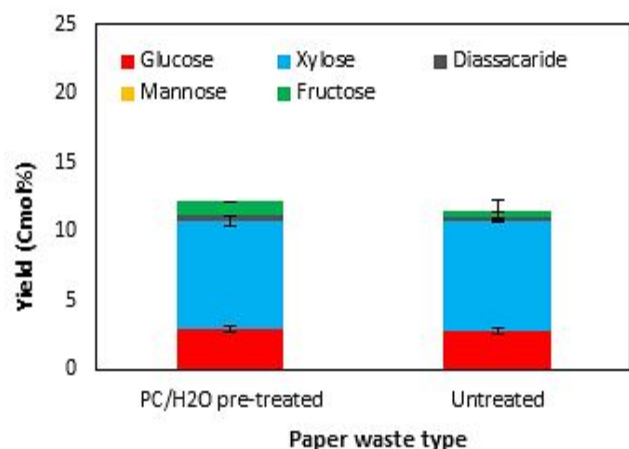


Fig. 7. Sugar yields during the catalytic conversion of untreated and PC/H₂O treated paper towel waste subject to the reaction in H₂O (100%) (Reaction condition: 5 wt% substrate loading, 0.135 M H₂SO₄, temperature: 140°C, duration: 10 min, solvent: H₂O (100%))

Improved depolymerization of substrates in the PC/H₂O and EC/H₂O solvents could also be attributed to the significant in-vessel pressure development during catalytic conversion in these solvents, which reached up to ~26 bar (130°C, 20 min), in contrast to the maximum ~5 bar recorded for H₂O only (Fig. 8). High *in situ* pressure during reaction has been reported to accelerate the conversion of lignocellulose in previous studies^{15,16,32}. High in-vessel pressure development in the PC/H₂O and EC/H₂O solvent systems was associated with the release of CO₂ from solvent degradation as PC and EC could decompose to CO₂ and propylene and ethylene glycol, respectively, under the acidic condition^{15,33}. A noticeable amount of gas bubbles was observed in the reacted solutions of PC/H₂O and EC/H₂O. At the same time, solvent loss of 5-20% was recorded depending on temperature and reaction duration, which suggests an irreversible production of CO₂ in the PC/H₂O and EC/H₂O solvent systems. An accelerated rate of acid-catalyzed reaction could be achieved when CO₂ was applied as an additive to reaction medium (high-temperature water), because the reaction between water and CO₂ produces carbonic acid that dissociates to increase the concentration of hydronium ion in the medium^{34,35}. Nevertheless,

quantifying the catalytic effect of CO₂ generated due to carbonate solvent degradation is beyond the scope of this study due to equipment and experimental limitations.

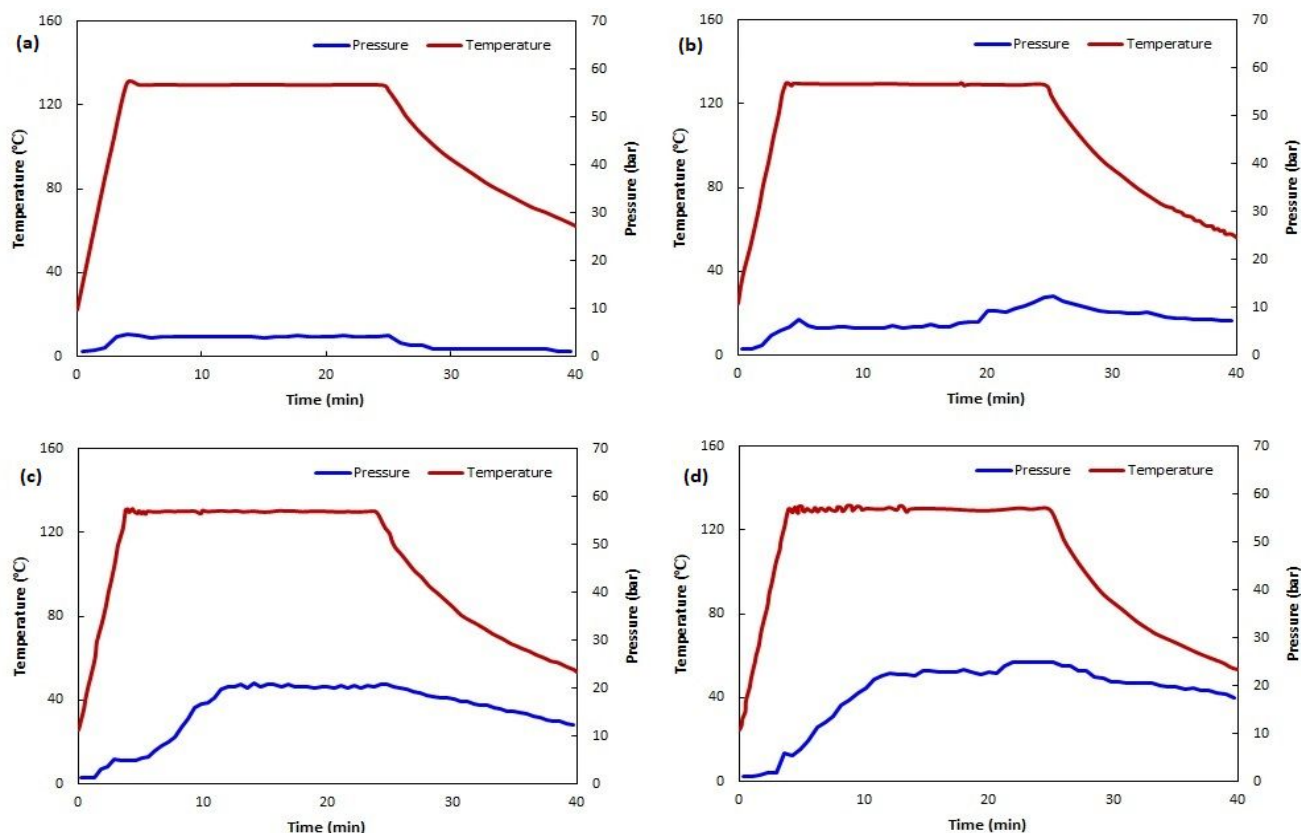


Fig. 8. In-vessel record of temperature and pressure during paper towel conversion (ramping and reaction) in different solvents (a) H₂O, (b) DMC/H₂O, (c) PC/H₂O, and (d) EC/H₂O (Reaction condition: 5 wt% substrate loading, 0.135 M H₂SO₄, temperature: 130°C, duration: 20 min, solvent ratio: 1:1)

Despite higher in-vessel pressure build-up during the reaction (~12 bar at 130°C, 20 min) (Fig. 8) compared to H₂O only, DMC/H₂O unexpectedly generated a lower yield of sugars (~8 Cmol% maximum) than that of H₂O (~10 Cmol%). DMC has a lower polarity ($\pi^* = 0.45$) than H₂O ($\pi^* = 1.09$) and PC ($\pi^* = 0.83$)³⁶, which might influence the biomass conversion efficiency in DMC/H₂O. In low-polarity solvents, the catalytic activity could be hindered due to strong pairing between the cation and anion, and active sites of the catalyst could be blocked by counter-ion. In contrast, the

cation and anion are typically separated from each other in polar solvents, leading to high solvation of ions that facilitate the catalytic activity, eliminating the interference of the counter-ion³⁷. DMC is considered as an effective methylation agent^{38,39}. Methylation of starch and lignin in basic conditions using DMC as the methylation agent has been reported in previous studies^{40,41}. Although little information exists regarding the reactions between cellulose (or its derivatives) and DMC³⁹, methylation of cellulose might occur to some extent under the given reaction conditions in this study. This could contribute to the lower yield of sugars in DMC solvent; however, further research is required to prove this postulation.

Tandem dehydration-rehydration reactions in solvent systems.

A noticeable amount of sugar derivatives, i.e., HMF, LA, and FA were observed after 20 min of reaction at 130°C and after 15 min at 140°C in PC/H₂O (Fig. 1b, c), while furfural was detected at a lower temperature (120°C, 15 min) (Fig. 1a) reflecting less energy-intensive dehydration of xylose to furfural. At 150°C treatment in PC/H₂O, LA yield (~23.5 Cmol%) surpassed glucose yield (~21.6 Cmol%) after 15 min of reaction (Fig. 1d), suggesting that PC/H₂O facilitated dehydration-rehydration reactions of sugars in parallel to hydrolysis of paper towel waste. Meanwhile, a decrease in the total detectable product yield in PC/H₂O was observed at 140°C after 15 min and 150°C after 10 min (Fig. 1f). This indicates the formation of insoluble humins due to polymerization between sugars and furan derivatives during the catalytic conversion of biomass at a higher temperature^{11,42}.

Comparing paper towel conversion at 130°C, no dehydration product was detected in the H₂O (100%) and DMC/H₂O solvents; conversely, dehydration-rehydration products were detected in the PC/H₂O and EC/H₂O solvents starting from 10 min of reaction time (Fig. 4b). This suggests the higher potential of PC and EC for tandem biomass hydrolysis and dehydration-rehydration

331 reactions. A notable LA yield (~6 Cmol%) generated in PC/H₂O under mild reaction conditions
332 (130°C, 20 min) suggests that PC might be a preferable solvent for LA synthesis from
333 lignocellulosic biomass. The yield of LA could not be determined for EC/H₂O solvent system due
334 to technical issues (LA peak overlapped solvent peak). However, a substantial yield of FA (~6-7
335 Cmol% at 130°C, 15-20 min) was detected in the EC/H₂O solvent, possibly inferring the yield of
336 LA in the solvent system as LA and FA are coproduced during the catalytic conversion of biomass
337 and sugars^{10,43,44}.

338 **Energy requirement for sugar production.**

339 Energy requirement for sugar production was estimated and compared for different solvent
340 systems (Reaction conditions: 5 wt.% substrate loading, temperature: 130°C, duration: 10 min,
341 0.135 M H₂SO₄, solvent ratio: 1:1) based on the power consumption rate recorded in the
342 microwave reactor (Table 3). Energy requirement for ramping (up to 130°C at a ramp rate of 32°C
343 min⁻¹) and reaction (holding at a constant temperature) were estimated separately and then added
344 up to determine the energy consumption per unit of sugar produced in different solvent systems.
345 The results revealed a lower energy requirement (~0.03 kWh) at the ramping stage for carbonate
346 solvent-water binary systems, in contrast, H₂O only required relatively higher energy (~0.05 kWh)
347 for heating up the reaction mixture. Furthermore, binary solvents exhibited a lower energy
348 consumption per unit of sugar production (Table 3) than that of H₂O, as low as 0.002 kWh mol⁻¹
349 in EC/H₂O, which was the most efficient solvent system in terms of energy requirement for sugar
350 production from paper towel waste.

Table 3: Energy consumption for sugar production in different solvent systems

Solvent	Energy consumption (kWh)			Sugar produced (mol) (per 5 g of paper towel)	Energy consumption per unit of sugar production (kWh mol ⁻¹)
	Ramp	Reaction	Total		
PC/H ₂ O	0.034	0.036	0.071	11.19	0.006
EC/H ₂ O	0.033	0.007	0.040	18.98	0.002
DMC/H ₂ O	0.037	0.035	0.073	5.91	0.012
H ₂ O	0.05	0.062	0.110	8.04	0.014

(Reaction conditions: 5 wt% substrate loading, temperature: 130°C, duration: 10 min, 0.135 M H₂SO₄, solvent ratio: 1:1)

Conclusions

The investigated organic carbonate binary solvents, i.e., PC/H₂O and EC/H₂O, effectively facilitated the depolymerization of lignocellulosic paper towel waste under mild reaction conditions. This study explored the potential roles of carbonate solvents in the catalytic system. Higher availability of reactive protons in these solvent systems and autogenous pressure development might favor the breakdown of cellulosic fibers compared to H₂O only. Besides, a considerable amount of sugar derivatives was detected in PC/H₂O and EC/H₂O (at a higher temperature and longer duration), suggesting the suitability of solvents for tandem hydrolysis and dehydration of biomass. The study implies that PC and EC have a high potential to be considered as greener alternatives to commonly used industrial solvents for the efficient valorization of biomass. However, these solvents have a high boiling point (242-248°C), which can be challenging for product separation and solvent recovery by distillation. Future research efforts can be directed to address this issue by selective adsorption for possible implementation of these alternative solvents on an industrial scale.

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