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process has an atom economy of 0.45, which means that 0.55 lb reactants are shunted to waste per 0.45 lb of product made. At 300 million lb/yr 4-ADPA production, this amounts 367 million lb/yr waste. The new process, with an atom economy of 0.84, produces 0.16 lb waste per 0.84 lb product.

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