

ACID CONTACTED ENHANCED ADSORBENT AND/OR CATALYST AND BINDER SYSTEM

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BACKGROUND OF THE INVENTION

CROSS-REFERENCE TO RELATED APPLICATIONS

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(I) This application is (1) a continuation-in-part of U.S. application serial No. 08/662,331, filed June 12, 1996, pending, which is a continuation-in-part of U.S. application serial No. 08/351,600, filed December 7, 1994, abandoned; (2) a continuation-in-part of U.S. application serial No. 08/662,331, filed June 12, 1996, pending, which is a continuation-in-part of PCT/US95/15829, filed December 6, 1995, which is a continuation-in-part of U.S. application serial No. 08/351,600, filed December 7, 1994, abandoned; (3) a continuation-in-part of U.S. application serial No. 08/662,331, filed June 12, 1996, pending, which is a continuation-in-part of U.S. application serial No. 08/426,981, filed April 21, 1995, abandoned; and (4) a continuation-in-part of U.S. application serial No. 08/662,331, filed June 12, 1996, pending, which is a continuation-in-part of PCT/US96/05303, filed April 17, 1996, which is a continuation-in-part of U.S. application serial No. 08/426,981, filed April 21, 1995, abandoned.

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(II) This application is also (1) a continuation-in-part of U.S. application serial No. 08/734,331, filed October 21, 1996, pending, which is a continuation-in-part of U.S. application serial No. 08/662,331, filed June 12, 1996, pending, which is (a) a continuation-in-part of U.S. Application Serial No. 08/351,600, filed December 7, 1994, abandoned, (b) a continuation-in-part of PCT/US95/15829, filed December 6, 1995, which is a continuation-in-part of U.S. Application Serial No. 08/351,600, filed December 7, 1994, abandoned, (c) a continuation-in-part of U.S. Application Serial No. 08/426,981, filed April 21, 1995, abandoned, and (d) a continuation-in-part of PCT/US96/05303, filed April 17,

1996, which is a continuation-in-part of U.S. Application Serial No. 08/426,981, filed April 21, 1995, abandoned and (2) a continuation-in-part of U.S. application serial No. 08/734,331, filed October 21, 1996, pending, which is a continuation-in-part of PCT/US95/15829, filed June 12, 1995, which is a continuation-in-part of U.S. application serial No. 08/351,600, filed December 7, 1994, abandoned.

(III) This application is also (1) a continuation-in-part of U.S. application serial No. 08/734,330, filed October 21, 1996, pending, which is a continuation-in-part of PCT/US96/05303, filed April 17, 1996, pending, which is a continuation-in-part of U.S. application serial No. 08/426,981, filed April 21, 1995, pending; (2) a continuation-in-part of U.S. application serial No. 08/734,330, filed October 21, 1996, pending, which is a continuation-in-part of U.S. application serial No. 08/426,981, filed April 21, 1995, pending; (3) a continuation-in-part of U.S. application serial No. 08/734,330, filed October 21, 1996, pending, which is a continuation-in-part of U.S. application serial No. 08/662,331, filed June 12, 1996, pending, which is (a) a continuation-in-part of U.S. Application Serial No. 08/351,600, filed December 7, 1994, abandoned, (b) a continuation-in-part of PCT/US95/15829, filed December 6, 1995, which is a continuation-in-part of U.S. Application Serial No. 08/351,600, filed December 7, 1994, abandoned, (c) a continuation-in-part of U.S. Application Serial No. 08/426,981, filed April 21, 1995, abandoned, and (d) a continuation-in-part of PCT/US96/05303, filed April 17, 1996, which is a continuation-in-part of U.S. Application Serial No. 08/426,981, filed April 21, 1995, abandoned; and (4) a continuation-in-part of U.S. application serial No. 08/734,330, filed October 21, 1996, pending, which is a continuation-in-part of PCT/US95/15829, filed June 12, 1995, pending, which is a continuation-in-part of U.S. application serial No. 08/351,600, filed December 7, 1994, abandoned.

All of the above applications are hereby incorporated by this reference in their entireties for all of their teachings.

FIELD OF THE INVENTION

This invention relates generally to enhanced adsorbent particles, particularly particles that have been adsorbent enhanced by contacting with acid. This invention also relates generally to an adsorbent and/or catalyst particle that has improved adsorbent properties and/or improved or newly existing catalytic properties by the use of the particle in combination with a particular binder to produce a particle/binder system. The binder can either cross-link to the particle, cross-link to itself and envelope the particle or both. This invention also relates to a binder/adsorbent and/or catalyst system that can be used as an anchored catalyst system.

BACKGROUND ART

Oxides of metals and certain non-metals are known to be useful for removing constituents from a gas or liquid stream by adsorbent mechanisms. For example, the use of activated alumina is considered to be an economical method for treating water for the removal of a variety of pollutants, gasses, and some liquids. Its highly porous structure allows for preferential adsorptive capacity for moisture and contaminants contained in gasses and some liquids. It is useful as a desiccant for gasses and vapors in the petroleum industry, and has also been used as a catalyst or catalyst-carrier, in chromatography and in water purification. Removal of contaminants such as phosphates by activated alumina are known in the art. See, for example, Yee, W., "Selective Removal of Mixed Phosphates by Activated Alumina," *J. Amer. Waterworks Assoc.*, Vol. 58, pp. 239-247 (1966).

U.S. Patent No. 4,795,735 to Liu *et al.* discloses an activated carbon/alumina composite and a process for producing the composite. The composite is prepared by blending powders of each of the activated carbon and activated alumina constituents. After the blend is thoroughly mixed, an aqueous solution is added to permit the activated alumina to rehydratably bond to the carbon particles. The amount of water added does not exceed that which prevents the mix from being extruded or agglomerated. After the water is added, the mix is subjected to a shaping or a forming process using extrusion, agglomeration, or pelletization to form a green body. The green body is then heated to a temperature of 25-100°C or higher. The composite may be strengthened by peptizing by adding nitric acid to the mixture. It is disclosed that the alumina can serve as the binder as well as the absorbent. This patent does not use a calcined alumina. Liu *et al.* discloses an amorphous alumina trihydrate powder, such as CP2 obtained from Alcoa and an amorphous alumina trihydrate powder such as CP-1 or CP-7, which are recited in U.S. Patent No. 4,579,839, incorporated by reference in Liu *et al.* Liu *et al.*'s use of the term active refers to the surface water being dried and does not refer to a calcined particle. Liu *et al.* uses acid to strengthen the particle and not to enhance its adsorbent properties. Liu *et al.* uses an alumina precursor, which is an absorbent and not an adsorbent.

U.S. Patent No. 3,360,134 to Pullen discloses a composition having adsorption and catalytic properties. Example 2 discloses an alumina hydrate formed by partially dehydrating alpha-alumina trihydrate in a rotary dryer by counter-current flow with a heated gas and an inlet temperature of about 1200°F and an outlet temperature of about 300°F. The resulting product was washed with 5% sulfuric acid, rinsed with water and dried to about 2% free water content. Solid sucrose was mixed with the hydrate and the mixture heated. Example 4 discloses that the procedure of Example 2 was repeated except that calcined alumina was used. The product was unsuitable when calcined alumina was used. Thus, the acid washed product of Example 2 was not a calcined alumina.

U.S. Patent No. 4,051,072 to Bedford *et al.* discloses a ceramic alumina that can be treated with very dilute acid to neutralize the free alkaline metal, principally Na₂O, to enable impregnation with catalytic material to a controlled depth of from at least 90 to about 250 microns. This patent does not use a crystallized aluminum oxide that has been calcined in accordance with the instant invention. This patent calcines the particle at a temperature of from about 1700°F to about 1860°F (927°C to 1016°C) to form a ceramic material, specifically what is referred to herein as an alpha alumina.

U.S. Patent No. 5,242,879 to Abe *et al.* discloses that activated carbon materials, which have been subjected to carbonization and activation treatments, and then further subjected to an acid treatment and a heat treatment, have a high catalytic activity and are suitable as catalysts for the decomposition of hydrogen peroxide, hydrazines or other water pollutants such as organic acids, quaternary ammonium-salts, and sulfur-containing compounds. Acid is used to remove impurities and not to enhance the adsorbent features. This patent also does not utilize a particle of the instant invention.

Adsorbent particles of the prior art have not achieved the ability to remove particular contaminants from a liquid or gas stream, such as, for example, a waste stream or drinking water, to acceptably low levels. Additionally, the adsorbent particles of the prior art have not been able to bind tightly to particular contaminants so that the adsorbent

particle/contaminant composition can be safely disposed of in a landfill. Thus, there has been a need in the art for adsorbents that have improved ability to adsorb particular materials, particularly contaminants from a gas or liquid stream, to thereby purify the stream. There has been a need in the art for the adsorbent particles to tightly bind to the adsorbed contaminant. Applicants have discovered that acid enhanced particle solves the above problems in the art.

U.S. Patent No. 5,422,323 to Banerjee *et al.* discloses the preparation of a pumpable refractory insulator composition. The composition consists of the combination of a wet component of colloidal silica (40%) in water, and a dry component consisting of standard refractory material. Examples of refractory material include clay, kaolinite, mullite, alumina and alumina silicates. The resulting insulating composition was cast into shape, dried and baked to form an insulating layer.

Japanese Patent No. 63264125 to Fumikazu *et al.* discloses the preparation of dry dehumidifying materials. Moisture is removed from room air or gas as it passes through a dehumidifying rotor of zeolite (70% by weight) and an inorganic binder (2-30% by weight). The inorganic binder includes colloidal silica, colloidal alumina, silicates, aluminates and bentonite. Wet air was passed through the dehumidifying rotor, and the amount of dried air was assessed.

Japanese Patent No. 60141680 to Kanbe *et al.* discloses the preparation of a refractory lining repair material. The material was prepared by adding a solution of phosphoric acid with ultra fine silica powder to a mixture of refractory clay and refractory aggregates composed of grog, alumina, silica, zircon and pyrophyllite. The refractory material has improved bonding strength and minute structure, and are useful for molten metal vessels such as ladles, tundishes, and electric furnaces.

Adsorbent particles of the prior art have not achieved the ability to remove particular contaminants from a liquid or gas stream, such as, for example, a waste stream or drinking water, to acceptably low levels. Additionally, the adsorbent particles of the prior

art have not been able to bind tightly to particular contaminants so that the adsorbent particle/contaminant composition can be safely disposed of in a landfill. Thus, there has been a need in the art for adsorbents that have improved ability to adsorb particular materials, particularly contaminants from a gas or liquid stream, to thereby purify the stream. There has been a need in the art for the adsorbent particles to tightly bind to the adsorbed contaminant. Also, there has been a need in the art for catalysts that have the ability or that have an improved ability to catalyze the reaction of contaminants into non-contaminant by-products.

Typically in the art, binders block active sites on the adsorbent and catalyst particles, thereby reducing the efficiency of such particles. Therefore, there is a need in the art for a binder system that binds adsorbent and/or catalytic particles together without reducing the performance of the particles.

Applicants have discovered that by using a special binder for adsorbent and/or catalytic particles, improved or new adsorbent and/or catalytic properties can be achieved due to the synergy between the binder and adsorbent and/or catalyst particle.

None of the above-cited documents discloses the compositions or processes such as those described and claimed herein.

SUMMARY OF THE INVENTION

In accordance with the purpose(s) of this invention, as embodied and broadly described herein, this invention, in one aspect, relates to a process for producing an enhanced adsorbent particle comprising contacting a non-amorphous, non-ceramic, crystalline, porous, calcined, aluminum oxide particle that was produced by calcining at a particle temperature of from 300° C to 700° C, with an acid for a sufficient time to increase the adsorbent properties of the particle.

The invention further provides a process for producing an enhanced adsorbent particle comprising contacting a non-ceramic, porous, oxide adsorbent particle with an acid for a sufficient time to increase the adsorbent properties of the particle.

In yet another aspect, the invention provides for particles made by the process of the instant invention.

In yet another aspect, the invention provides for a process for reducing or eliminating the amount of contaminants in a stream comprising contacting the particle of the invention with the stream for a sufficient time to reduce or eliminate the contamination from the stream.

In still yet another aspect, the invention provides a composition comprising the particles of the invention.

In another aspect, the invention relates to a method for producing an adsorbent and/or catalyst and binder system comprising

- i) mixing components comprising
 - a) a binder comprising a colloidal metal oxide or colloidal metalloid oxide;
 - b) an oxide adsorbent and/or catalyst particle, and
 - c) an acid,

- ii) removing a sufficient amount of water from the mixture to cross-link components a and b to form an adsorbent and/or catalyst and binder system.

In another aspect, the invention provides for an adsorbent and/or catalyst system made by the processes of the invention.

In one aspect, the invention provides an adsorbent and/or catalyst and binder system comprising a binder that has been cross-linked with at least one type of oxide adsorbent and/or catalyst particle.

In yet another aspect, the invention provides a method for reducing or eliminating the amount of a contaminant from a liquid or gas stream comprising contacting the adsorbent and/or catalyst binder system with the contaminant in the stream for a sufficient time to reduce or eliminate the amount of contaminant from the stream.

In yet another aspect, the invention provides a method for catalyzing the degradation of an organic compound comprising contacting the organic compound with the adsorbent and/or catalyst system for a sufficient time to catalyze the degradation of an organic compound.

In yet another aspect, the invention provides a method for reducing or eliminating the amount of a contaminant from a gas stream by catalysis comprising contacting the adsorbent and/or catalyst binder system with a gas stream containing a contaminant comprising an oxide of nitrogen, an oxide of sulfur, carbon monoxide, hydrogen sulfide, or mixtures thereof for a sufficient time to reduce or eliminate the contaminant amount.

In yet another aspect, the invention provides a method for producing an adsorbent and/or catalyst and binder system comprising

- i) mixing components comprising

- a) a binder comprising a colloidal metal oxide or colloidal metalloid oxide,
- b) a first adsorbent and/or catalyst particle that does not cross-link with the binder, and
- c) an acid,

5 ii) removing a sufficient amount of water from the mixture to cross-link component a to itself, thereby entrapping and holding component b within the cross-linked binder, to form an adsorbent and/or catalyst and binder system.

10 In another aspect the invention relates to a composition for binding adsorbent and/or catalytic particles to produce an agglomerated particle comprising (a) a colloidal metal oxide or colloidal metalloid oxide and (b) an acid.

15 In another aspect the invention relates to a kit for binding adsorbent and/or catalytic particles to produce an agglomerated particle comprising (a) a colloidal metal oxide or colloidal metalloid oxide and (b) an acid.

20 In yet another aspect, the invention provides a method for binding adsorbent and/or catalytic particles, comprising the steps of:

- (a) mixing colloidal alumina or colloidal silica with the particles and an acid;
- (b) agitating the mixture to homogeneity; and
- (c) heating the mixture for a sufficient time to cause cross-linking of the aluminum oxide in the mixture.

25 In still yet another aspect, the invention relates to an adsorbent and/or catalyst and binder system, comprising:

- (a) a pendant ligand substituted or unsubstituted binder, and
- (b) a pendant ligand substituted or unsubstituted oxide adsorbent and/or oxide catalyst particle,

wherein at least one of components (a) and (b) is pendant ligand substituted, and wherein component (a) is cross-linked with component (b).

In another aspect, the invention relates to a method of using the above system as a catalyst support system comprising binding the above system with a second catalyst particle.

In still yet another aspect, the invention relates to an anchored adsorbent and/or catalyst and binder system, comprising:

- (a) a pendant ligand substituted or unsubstituted binder, and
- (b) a pendant ligand substituted or unsubstituted oxide adsorbent and/or oxide catalyst particle, and
- (c) a metal complex,

wherein at least one of components (a) and (b) is pendant ligand substituted, wherein component (a) is cross-linked with component (b), and wherein the metal complex (c) is bound to component (a) and/or (b).

In still yet another aspect, the invention relates to a method for producing a pendant ligand substituted adsorbent and/or catalyst system, comprising:

- (i) mixing components, comprising:
 - (a) a pendant ligand substituted or unsubstituted binder comprising a colloidal metal oxide or a colloidal metalloid oxide,
 - (b) a pendant ligand substituted or unsubstituted oxide adsorbent and/or oxide catalyst particle, and
 - (c) an acid,

wherein at least one of components (a) and (b) is pendant ligand substituted, and

- (ii) removing a sufficient amount of water from the mixture to cross-link components (a) and (b) to form a pendant ligand substituted adsorbent and/or catalyst and binder system.

This method can further comprise (iii) binding a metal complex onto the resulting system of step (ii) to form the anchored catalyst system.

In still yet another aspect, the invention relates to a method for producing an adsorbent and/or catalyst and binder system comprising

- 5 (i) mixing components comprising
 - (a) a binder comprising a colloidal metal oxide or colloidal metalloid oxide,
 - (b) an oxide adsorbent and/or catalyst particle, and
 - (c) an acid,
- 10 (ii) removing a sufficient amount of water from the mixture to cross-link components a and b to form an adsorbent and/or catalyst and binder system, and
- 15 (iii) reacting the resultant oxide adsorbent and/or oxide catalyst particle and the binder system of step (ii) with a hydroxyl-reactive compound to form a pendant ligand substituted oxide adsorbent and/or oxide catalyst and binder system.

In another aspect, the invention relates to the above method further comprising after step (iii) binding a metal complex onto the resulting system of step (iii) to form an anchored catalyst system.

In another aspect, the invention relates to an anchored adsorbent and/or catalyst and binder system, comprising:

- 25 (a) a binder, and
- (b) an oxide adsorbent and/or oxide catalyst particle, and
- (c) a metal complex,

wherein component (a) is cross-linked with component (b), and wherein the metal complex (c) is bound directly to component (a) and/or (b).

In still yet another aspect, the invention relates to a method for producing an anchored adsorbent and/or catalyst system, comprising:

- (i) mixing components, comprising:
 - (a) a binder comprising a colloidal metal oxide or a colloidal metalloid oxide,
 - (b) an oxide adsorbent and/or oxide catalyst particle, and
 - (c) an acid,
- (ii) removing a sufficient amount of water from the mixture to cross-link components (a) and (b) to form an adsorbent and/or catalyst and binder system, and
- (iii) binding a metal complex directly onto the resulting system of step (ii) to form the anchored catalyst system.

In another aspect, the invention relates to a method of encapsulating a contaminant within an adsorbent particle comprising heating the particle of the invention that has adsorbed a contaminant to a temperature sufficient to close the pores of the particle to thereby encapsulate the contaminant within the particle.

In another aspect, the invention relates to a method for regenerating the adsorbent particle that has adsorbed a contaminant.

Additional advantages of the invention will be set forth in part in the description which follows, and in part will be obvious from the description, or may be learned by practice of the invention. The advantages of the invention will be realized and attained by means of the elements and combinations particularly pointed out in the appended claims. It is to be understood that both the foregoing general description and the following detailed description are exemplary and explanatory only and are not restrictive of the invention, as claimed.

BRIEF DESCRIPTION OF THE FIGURES

Fig. 1 is a graph showing the reduction in concentration of lead ions using a particle of the invention.

5 Fig. 2 is a graph showing surface area vs. curing temperature of alumina-alumina composites.

Fig. 3 is a graph showing the oxidation of CO over time using $\text{CuO/MnO}_2/\text{Al}_2\text{O}_3$ -colloidal alumina binder.

10 Fig. 4 is a graph showing the reduction of NO_x over time using $\text{CuO/Ga}_2\text{O}_3/\text{Al}_2\text{O}_3$ -colloidal alumina binder.

DETAILED DESCRIPTION

The present invention may be understood more readily by reference to the following detailed description of preferred embodiments of the invention and the Examples included therein.

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Before the present compositions of matter and methods are disclosed and described, it is to be understood that this invention is not limited to specific synthetic methods or to particular formulations, as such may, of course, vary. It is also to be understood that the terminology used herein is for the purpose of describing particular embodiments only and is not intended to be limiting.

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In this specification and in the claims which follow, reference will be made to a number of terms which shall be defined to have the following meanings:

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The singular forms "a," "an" and "the" include plural referents unless the context clearly dictates otherwise.

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"Optional" or "optionally" means that the subsequently described event or circumstance may or may not occur, and that the description includes instances where said event or circumstance occurs and instances where it does not.

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The term "particle" as used herein is used interchangeably throughout to mean a particle in the singular sense or a combination of smaller particles that are grouped together into a larger particle, such as an agglomeration of particles.

The term "ppm" refers to parts per million and the term "ppb" refers to parts per billion.

The term "and/or" in "adsorbent and/or catalyst" refers to a particle that either acts as a catalyst, an adsorbent, or can act as both an adsorbent and catalyst under different circumstances due to, for example, the composition and the type of contaminant.

I. ACID ENHANCED OXIDE ADSORBENT AND/OR CATALYST PARTICLE

5 In accordance with the purpose(s) of this invention, as embodied and broadly described herein, this invention, in one aspect, relates to a process for producing an enhanced adsorbent particle comprising contacting a non-amorphous, non-ceramic, crystalline, porous, calcined, aluminum oxide particle that was produced by calcining at a
10 particle temperature of from 300° C to 700° C, with an acid for a sufficient time to increase the adsorbent properties of the particle. This process can also consist essentially of or consist of the particular process steps as described above or further including the additional features described below.

15 The invention further provides a process for producing an enhanced adsorbent particle comprising contacting a non-ceramic, porous, oxide adsorbent particle with an acid for a sufficient time to increase the adsorbent properties of the particle. This process can also consist essentially of or consist of the particular process steps as described above or further including the additional features described below. In one embodiment, this particle
20 is calcined.

In yet another aspect, the invention provides for particles made by the process of the instant invention.

25 In yet another aspect, the invention provides for a process for reducing or eliminating the amount of contaminants in a stream comprising contacting the particle of the invention with the stream for a sufficient time to reduce or eliminate the contamination from the stream.

In still yet another aspect, the invention provides a composition comprising the particles of the invention.

The particles of this invention have improved or enhanced adsorptive features. The particles of this invention can adsorb a larger amount of adsorbate per unit volume or weight of adsorbent particles than a non-enhanced particle. Also, the particles of this invention can reduce the concentration of contaminants or adsorbate material in a stream to a lower absolute value than is possible with a non-enhanced particle. In particular embodiments, the particles of this invention can reduce the contaminant concentration in a stream to below detectable levels, believed to be never before achievable with prior art particles. Enhanced adsorptive features is intended to particularly include ion capture and ion exchange mechanisms. Ion capture refers to the ability of the particle to irreversibly bind to other atoms by covalent or ionic interactions. In this invention, the ion capture typically predominates over the ion exchange property, and it is typically the improved ion capture property that improves the adsorbent performance of the particle. Adsorption is a term well known in the art and should be distinguished from absorption. The adsorbent particles of this invention chemically bond to and very tightly retain the adsorbate material. These chemical bonds are ionic and/or covalent bonds.

Not wishing to be bound by theory, it is believed that the acid contacting of the particle enhances the adsorptive capacity of the particle by increasing the number of hydroxyl groups on the particle. With cationic and anionic contaminants, the hydroxyl groups provide sites for chemical bonding or replacement, such that the contaminants bond irreversibly with the particle. In general, the increased amount of hydroxyl groups generate more active sites for the contaminant to bond with.

The invention contemplates the use of any prior art adsorbent and/or catalyst particle or composite particle of two or more types of particles. In a preferred embodiment, the particle comprises an oxide particle, even more preferably a non-ceramic, porous oxide particle. The particle in one embodiment comprises a metal or metalloid oxide particle. Examples of such particles include, but are not limited to, oxide complexes, such

as transition metal oxides, lanthanide oxides, thorium oxide, as well as oxides of Group IIA (Mg, Ca, Sr, Ba), Group IIIA (B, Al, Ga, In, Tl), Group IVA (Si, Ge, Sn, Pb), and Group VA (As, Sb, Bi). In another embodiment, the particle comprises an oxide of aluminum, titanium, copper, vanadium, silicon, manganese, iron, zinc, zirconium, tungsten, rhenium, arsenic, magnesium, thorium, silver, cadmium, tin, lead, antimony, ruthenium, osmium, cobalt or nickel or zeolite. Typically, any oxidation state of the oxide complexes may be useful for the present invention. The oxide can be a mixture of at least two metal oxide particles having the same metal with varying stoichiometry and oxidation states. In one embodiment, the particle comprises Al_2O_3 , TiO_2 , CuO , Cu_2O , V_2O_5 , SiO_2 , MnO_2 , Mn_2O_3 , Mn_3O_4 , ZnO , WO_2 , WO_3 , Re_2O_7 , As_2O_3 , As_2O_5 , MgO , ThO_2 , Ag_2O , AgO , CdO , SnO_2 , PbO , FeO , Fe_2O_3 , Fe_3O_4 , Ru_2O_3 , RuO , OsO_4 , Sb_2O_3 , CoO , Co_2O_3 , NiO or zeolite. In a further embodiment, the particle further comprises a second type of adsorbent and/or catalyst particles of an oxide of aluminum, titanium, copper, vanadium, silicon, manganese, iron, zinc, zirconium, tungsten, rhenium, arsenic, magnesium, thorium, silver, cadmium, tin, lead, antimony, ruthenium, osmium, cobalt or nickel or zeolite, activated carbon, including coal and coconut carbon, peat, zinc or tin. In another embodiment, the particle further comprises a second type of adsorbent and/or catalyst particles of aluminum oxide, titanium dioxide, copper oxide, vanadium pentoxide, silicon dioxide, manganese dioxide, iron oxide, zinc oxide, zeolite, activated carbon, peat, zinc or tin particle. Typical zeolites used in the present invention include "Y" type, "beta" type, mordenite, and ZSM5. In a preferred embodiment, the particle comprises non-amorphous, non-ceramic, crystalline, porous, calcined aluminum oxide that was produced by calcining the precursor to the calcined aluminum oxide at a particle temperature of from 300 or 400°C to 700°C, preferably in the gamma, chi-rho, or eta form. The precursor to calcined aluminum oxide can include but is not limited to boehmite, bauxite, pseudo-boehmite, scale, $\text{Al}(\text{OH})_3$, and alumina hydrates. In the case of other metal oxide complexes, these complexes can also be calcined or uncalcined.

In another embodiment of the invention, in the particle of this invention, typically any adsorbent particle that is non-ceramic, porous, is an oxide can be used. Some of the particles of this invention are in the crystalline form and are therefore non-amorphous.

Adsorbent particles that are very rigid or hard, are not dissolved to any detrimental degree by the acid, and which have initially high, pre-enhanced adsorptive properties are preferred. Examples of such particles include, but are not limited to, metal oxides, such as transition metal oxides and Group IIA, Group IIIA, and Group IVA metal oxides (CAS Group notation), and oxides of non-metals such as silicon and germanium. Preferred adsorbents include oxides of aluminum, silicon, including zeolites, both natural and synthetic, manganese, copper, vanadium, zirconium, iron, and titanium. Even more preferred adsorbents include aluminum oxide (Al_2O_3), silicon dioxide (SiO_2), manganese oxides (MnO , MnO_2 , Mn_2O_3 , and Mn_3O_4), copper oxides (CuO and Cu_2O), vanadium pentoxide (V_2O_5), zirconium oxide (ZrO_2), iron oxides (FeO , Fe_2O_3 , and Fe_3O_4), and titanium dioxide (TiO_2). In a preferred embodiment, the particle is microporous, even more preferably substantially microporous, having a median micropore size preferably of from 3.5 nm to 35 nm (35 Å to 350 Å) diameter.

In an even more preferred embodiment, the oxide is aluminum oxide (Al_2O_3) that has been produced by calcining at a particle temperature of from 300°C to 700°C. In other embodiments, the lower limit of calcining temperature is 400°C, 450°C, 500°C, 550°C, 600°C, or 650°C and the upper limit is 650°C, 600°C, 550°C, 500°C, or 450°C. These preferred aluminum oxide particles are preferably in the gamma, chi-rho, or eta forms. The ceramic form of Al_2O_3 , such as the alpha form, are not included as a part of this invention. In a preferred embodiment, the Al_2O_3 particles of this invention are substantially microporous, having a median micropore size of from 3.5 nm to 35 or 50 nm diameter, even more preferably 60 nm, and a BET surface area of from 120 to 350 m^2/g .

In one embodiment, the particle is aluminum oxide that has been pre-treated by a calcination process. Calcined aluminum oxide particles are well known in the art. They are particles that have been heated to a particular temperature to form a particular crystalline structure. Processes for making calcined aluminum oxide particles are well known in the art as disclosed in, e.g., *Physical and Chemical Aspects of Adsorbents and Catalysts*, ed. Linsen *et al.*, Academic Press (1970), which is incorporated by reference herein. In one embodiment, the Bayer process can be used to make aluminum oxide precursors. Also,

pre-calcined aluminum oxide, that is, the aluminum oxide precursor (e.g., $\text{Al}(\text{OH})_3$ or aluminum trihydrate, boehmite, pseudo-boehmite, bauxite), and calcined aluminum oxide are readily commercially available. Calcined aluminum oxide can be used in this dried, activated form or can be used in a partially or near fully deactivated form by allowing water to be adsorbed onto the surface of the particle. However, it is preferable to minimize the deactivation to maximize the adsorbent capability. In some references in the prior art, "activated" refers only to the surface water being removed from the particle to increase its adsorbent ability. However, as used in reference to the instant invention, "activated" oxide particles refer to an oxide particle that has first been calcined and is then also preferably but not necessarily maintained in its dried state. Thus, as used herein, all active particles of the invention have also been calcined. The particles are not limited to any physical form and can be in the particulate, powder, granular, pellet, or the like form.

In another embodiment, in addition to being acid enhanced, the adsorbent, catalyst, and adsorbent and catalyst particles used in this invention can be enhanced by other processes known in the art or described below. For example the particles can be dried to be activated or can be treated by processes disclosed in the prior filed parent applications of and in applicants' copending application filed on October 21, 1996, U.S. Serial No. 08/734,329, entitled "Enhanced Adsorbent and Room Temperature Catalyst Particle and Method of Making and Using Therefor," which is a continuation-in-part of PCT/US96/05303, filed April 17, 1996, pending, which is a continuation-in-part of U.S. application serial No. 08/426,981, filed April 21, 1995, pending. These applications are herein incorporated by this reference in their entireties for all of their teachings.

The acid that can be used in this invention can be any acid or mixture of acids that can catalyze the formation of hydroxyl groups onto the surface of the pores of the oxide particle. Examples of such acids include, but are not limited to, nitric acid, sulfuric acid, hydrochloric acid, boric acid, acetic acid, formic acid, phosphoric acid, and mixtures thereof. In one embodiment, the acid is an aliphatic or aromatic carboxylic acid. In another embodiment, the acid is acetic acid. Examples of aliphatic and aromatic carboxylic acids include but are not limited to acetic acid, benzoic acid, butyric acid, citric acid, fatty

acids, lactic acid, maleic acid, malonic acid, oxalic acid, salicylic acid, stearic acid, succinic acid, tartaric acid, propionic acid, valeric acid, hexanoic acid, heptanoic acid, caprylic acid, pelargonic acid, capric acid, undecanoic acid, lauric acid, tridecanoic acid, myristic acid, pentadecanoic acid, palmitic acid, heptadecanoic acid, nonadecanoic acid, arachidic acid, heneicosanoic acid, behenic acid, triosanoic acid, lignoceric acid, pentacosanoic acid, cerotic acid, heptasanoic acid, montanic acid, nonacosanoic acid, melissic acid, phthalic acid, glutaric acid, adipic acid, azelaic acid, sebacic acid, cinnamic acid, acrylic acid, crotonic acid, linoleic acid or a mixture thereof. In a preferred embodiment, the acid is acetic acid because it is relatively safer to handle than most other acids and because of its cost effectiveness.

Typically the acid is diluted with water to prevent dissolution of the particle and for cost effectiveness. In general, only a dilute solution of the acid is required to achieve maximum or saturated loading of the ion moieties on the particle. For example, a 0.5 wt. % (0.09 N; pH of about 2.9) and even a 0.1 wt. % (0.02 N; pH of about 3.25) acetic acid solution has been found effective. However, a wide range of concentrations of acid can be used in this invention from very dilute to very concentrated depending on the hazards involved and the economics of production. However, if the acid is too concentrated, it will etch the particle causing an increase in macropores while eliminating micropores, which is detrimental to the particles of this invention. Thus, the acid treatment is preferably of a concentration (i.e. acid strength as measured by, e.g., normality or pH), acid type, temperature and length of time to be more than a mere surface wash but less than an etching. In particular embodiments, the etching of the particle is minimized or is only nominal by selection of the acid treatment conditions, such as acid strength, acid type, and temperature and time of treatment, such that the reduction in overall surface area, as preferably measured by the BET method, is less than 20%, less than 15%, less than 10%, less than 5%, less than 2%, less than 1%, or less than 0.5%. Strong acids, such as for example hydrochloric, nitric or sulfuric, should preferably be used at a concentration or strength lower than a weak acid, such as for example acetic acid, because the strong acid tends to chemically react with and etch the particle to a much greater degree than a weak acid of comparable concentration.

In a particular embodiment, the acid is of an upper strength equivalent to a 0.5 N (normality) aqueous solution of acetic acid. In other embodiments, the upper strength of the acid is equivalent to a 0.25 N, 0.1 N, 0.09 N, 0.075 N, 0.05 N, 0.02 N, 0.01 N, 0.005 N or 0.001 N aqueous acetic acid solution. The lower strength of the acid should be that which provides more than a surface washing but imparts enhanced adsorbent effects to the particle. In particular embodiments, the lower strength of the acid is equivalent to a 0.25 N, 0.1 N, 0.09 N, 0.075 N, 0.05 N, 0.02 N, 0.01 N, 0.005 N, 0.001 N, 0.0005 N, or 0.0001 N aqueous acetic acid solution.

After acid treatment, the resultant particle of the invention substantially retains the micropores originally present and the acid does not etch the particle to any appreciable degree and does not create any appreciable amount of new macropores (median pore diameter greater than about 35 nm). In a preferred embodiment, when the particle is aluminum oxide, the acid treated aluminum oxide maintains its microporous nature, having a median pore size of 3.5 nm to 35 nm diameter and a BET surface area of from 120 to 350 m²/g.

Additionally, the acid preferably has some water present to provide OH⁻ and/or H⁺ ions, which bond with the particle. When the acid is diluted with water, the water is preferably distilled water to minimize the amount of impurities contacting the particle.

The particle of the invention is made by the following process. The particle is contacted with an acid. The particle can be contacted with the acid by various means including by the particle being dipped in, extensively washing with, or submerged in the acid. The length of time the particle must be contacted with the acid varies according to the ability of the particular particle to generate hydroxyl groups on the surface and pores of the particle. The time can be as low as 30 seconds, a few (three) minutes, at least 15 minutes, at least one hour, at least 6 hours, at least 12 hours, or at least one day, to achieve adequate adsorption results and/or to preferably assure saturation. The time must be sufficient to at least increase the adsorbent properties of the particle by adding increasing the number of hydroxyl groups on the particle. In one embodiment, the particle is

submerged in the acid, and saturation is typically complete when is full adsorption of the alumina pores with the acid solution. The contacting should be substantial enough to provide penetration of the acid throughout the pores of the particle thereby increasing the number of hydroxyl groups on the pore surface of the particle. Mere washing the outside surface of the particle to remove impurities is not sufficient to provide adequate penetration of the acid into and throughout the pores of the particle.

Typically, the acid contacting is preformed at room temperature. The higher the acid temperature and concentration, the more likely the acid will detrimentally etch the particle.

The acid contacted particle is then optionally rinsed, preferably with water. Rinsing of the acid contacted particle does not reduce the enhanced adsorptive capability of the particle. When rinsed, the particle is preferably rinsed with distilled water to minimize impurity contact. Rinsing of the particle serves two purposes. First, any residual acid that is remaining on the surface or pores of the particle is removed, which will make the particle easier to handle when it is in the dry form. Second, rinsing the particle will remove the counter-ion of the acid that may be on the surface or pores of the particle.

Optionally, the particle is dried by a low to moderate heat treatment to remove excess liquid, such as acid or water, from the rinsing step to thereby increase the activity of adsorption. Typically, the drying is from about 50° C to about 200° C. Drying of the particle also reduces the transfer cost of particle. However, the particle is preferably not calcined or recalcined after acid treatment and prior to contacting with a contaminant. Such recalcining would detrimentally change the surface characteristics by closing up the micropores. However, the particle can be heated to calcining temperatures or above after the particle has been contacted with a contaminant for encapsulating the contaminant as described below. Additionally, the particles of the invention are preferably not sintered, either before or after the acid treatment step, as this would detrimentally affect the micropores by closing up the micropores and would detrimentally decrease the pore volume and surface area. Any other process, such as a heat treatment, that would increase

the size or eliminate micropores, enlarge the size of, create or destroy macropores, or would decrease the surface area available for adsorption or catalysis should preferably be avoided, particularly, after the particle is acid treated.

5 The size of the particles used in this invention can vary greatly depending on the end use. Typically, for adsorption or catalytic applications, a small particle size such as 20 μm is preferable because they provide a larger surface area per unit volume than large particles. Typically for adsorption or catalytic applications, the particle size range is from 50 μm to 5000 μm .

10 The particle of this invention can be used in any adsorption or ion capture application known to those of ordinary skill in the art. In one embodiment, the particle is used for environmental remediation applications. In this embodiment, the particle can be used to remove contaminants, such as, but not limited to, heavy metals, organics, including hydrocarbons, chlorinated organics, including chlorinated hydrocarbons, inorganics, or
15 mixtures thereof. Specific examples of contaminants include, but are not limited to, acetone, microbials such as cryptosporidium, ammonia, benzene, chlorine, dioxane, ethanol, ethylene, formaldehyde, hydrogen cyanide, hydrogen sulfide, methanol, methyl ethyl ketone, methylene chloride, propylene, styrene, sulfur dioxide, toluene, vinyl chloride, arsenic, lead, iron, phosphates, selenium, cadmium, uranium, such as U_3O_8 , radon, 1,2-
20 dibromo-3-chloropropane (DBCP), chromium, tobacco smoke, cooking fumes, zinc, trichloroethylene, and PCBs. The particle can remediate an anion, an oxoanion, a cation, or a poly-oxoanion. The particle of this invention can remediate individual contaminants or multiple contaminants from a single source. In essence, anywhere adsorbents are used to capture pollutants, this invention achieves improved efficiency by adsorbing a higher
25 amount of contaminants and by reducing the contamination level to a much lower value than by non-enhanced particles.

30 For environmental remediation applications, particles of the invention are typically placed in a container, such as a filtration unit. The contaminated stream enters the container at one end, contacts the particles within the container, and the purified stream

exits through the other end of the container. The particles contact the contaminants within the stream and bond to and remove the contamination from the stream. Typically, the particles become saturated with contaminants over a period of time, and the particles must be removed from the container and replaced with fresh particles. The contaminant stream can be a gas stream or liquid stream, such as an aqueous stream. The particles can be used to remediate, for example, waste water, production facility effluent, smoke stack gas, auto exhaust, drinking water, and the like.

The particle of the invention can be used alone, in combination with other particles prepared by the process of the invention, and/or in combination with other adsorbent, catalytic, or contaminant remediation particles known in the art. The particles can be combined in a physical mixture or agglomerated using techniques known in the art, such as with a binder, to form a multifunctional composite particle.

The particle/binder system of the invention can be used preferably as the adsorbent or catalytic medium itself. In an alternate embodiment, the system is used as an adsorbent or catalytic support.

In one embodiment, the acid enhanced particle is used in combination with a particle that has been pretreated to improve its adsorbent and/or to improve or impart catalyst properties, such as an ion or electron enhancement, in accordance with applicants' copending application filed on October 21, 1996, U.S. Serial No. 08/734,329, entitled "Enhanced Adsorbent and Room Temperature Catalyst Particle and Method of Making and Using Therefor," which is a continuation-in-part of PCT/US96/05303, filed April 17, 1996, pending, which is a continuation-in-part of U.S. patent application Serial No. 08/426,981, filed April 21, 1995, pending, all applications of which are herein incorporated by this reference for all of its teachings.

In another embodiment, the acid enhanced particle of the invention is used in combination with a noble metal known in the art for adsorbent or particularly catalytic properties. Such noble metals include gold, silver, platinum, palladium, iridium, rhenium,

rhodium, cobalt, copper, ruthenium, and osmium, preferably gold, silver platinum, and palladium. Such a combination can be used to take advantage of the adsorbent properties of the acid enhanced particle and the catalytic properties of the noble metal.

In one embodiment, the invention is directed to a composition comprising an aluminum oxide particle made by the acid enhancing process of the invention. In a further embodiment, this composition further comprises a co-particle. This co-particle is preferably any adsorbent or catalyst particle known in the art. Such co-particles can be preferably non-ceramic, porous, oxide adsorbent particles or activated carbon, more preferably silicon dioxide, or a metal oxide, such as manganese oxides (MnO , MnO_2 , Mn_2O_3 , and Mn_3O_4), copper oxides (CuO and Cu_2O), vanadium pentoxide (V_2O_5), zirconium oxide (ZrO_2), iron oxides (FeO , Fe_2O_3 , and Fe_3O_4), titanium dioxide (TiO_2) and zeolites, both natural and synthetic and activated carbon. The co-particle can be acid-enhanced or non-acid enhanced. In a preferred embodiment, the co-particle is not initially acid-enhanced although it may be contacted with acid during the binding step.

In a preferred embodiment, the composition comprises aluminum oxide made by the acid enhanced process of the invention, copper oxide, and manganese oxide. Preferably, these components are in a proportion of from 50-98 parts by weight, more preferably 80-95 parts by weight, even more preferably 88 parts by weight acid enhanced aluminum oxide; and 1-49 parts by weight, more preferably 4-19 parts by weight, even more preferably 6 parts by weight of each of copper oxide and manganese oxide. Preferably, the copper oxide is CuO and the manganese oxide is MnO_2 . Preferably, the composition is held together using a colloidal alumina binder that has been crosslinked as described below. In a preferred embodiment, this composition can be used to remediate organics, including but not limited to hydrocarbons and chlorinated organics, even more preferably, trichloroethylene (TCE).

Not wishing to be bound by theory, it is believed that at least some and possibly all of the ability of the acid-enhanced aluminum oxide/co-particle embodiment of the invention described above to remediate organic contaminants is due to a catalytic degradation of the

organic contaminant, even at room temperature. This catalytic activity is evident because the inventive co-particle of Example 5 was challenged with a high concentration of organic contaminants and no organic contaminants were found the residual solution after TCLP analysis (*see* Example 6). In a preferred embodiment, the acid-enhanced Al_2O_3 in combination with one or more oxides of manganese, copper, and/or iron is particularly suited to catalytically degrade organics, such as hydrocarbons, chlorinated hydrocarbons and chlorinated organics, such as trichloroethylene. Even more preferably, the catalytic composition comprises 50-98 parts by weight, more preferably 80-95 parts by weight, even more preferably 88 parts by weight acid enhanced aluminum oxide; and 1-49 parts by weight, more preferably 4-19 parts by weight, even more preferably 6 parts by weight of each of copper oxide and manganese oxide.

Binders for binding the individual particles to form an agglomerated particle are known in the art or are described herein. In a preferred embodiment, the binder can also act as an adsorbent and/or a catalyst.

A preferred binder that can be used with the particles of this invention is a colloidal metal oxide or colloidal metalloid oxide binder as disclosed in applicants' copending U.S. application filed on October 21, 1996, U.S. Serial No. 08/734,330, entitled "Adsorbent and/or Catalyst and Binder System and Method of Making and Using Therefor," which is (1) a continuation-in-part of PCT/US96/05303, filed April 17, 1996, pending, which is a continuation-in-part of U.S. application serial No. 08/426,981, filed April 21, 1995, pending; (2) a continuation-in-part of U.S. application serial No. 08/426,981, filed April 21, 1995, pending; (3) a continuation-in-part of U.S. application serial No. 08/662,331, filed June 12, 1996, pending, which is a continuation-in-part of PCT/US95/15829, filed June 12, 1995, pending, which is a continuation-in-part of U.S. application serial No. 08/351,600, filed December 7, 1994, abandoned; and (4) a continuation-in-part of PCT/US95/15829, filed June 12, 1995, pending, which is a continuation-in-part of U.S. application serial No. 08/351,600, filed December 7, 1994, abandoned. All of the above applications are hereby incorporated by this reference in their entireties for all of their teachings. This colloidal

metal oxide or colloidal metalloid oxide binder and binder system is also described in detail below in the following section II.

5 Additionally, this colloidal metal oxide or colloidal metalloid oxide binder can be used with an untreated (non-acid enhanced) particle of this invention and/or an acid treated (acid enhanced) particle of this invention described above in section I. This binder can be used on any of the particle compositions of this invention referred to above or below, whether acid enhanced or not. Additionally, the particles and systems described below under section II and section III can be untreated or acid treated (acid enhanced) as described above in section I.

10 A preferred binder for the agglomerated particle is colloidal alumina or colloidal silica. The colloidal alumina goes through a transformation stage and cross-links with itself from 25°C to 400°C, preferably 250°C and/or can cross-link with the particle. Colloidal silica cross-links with itself if it is sufficiently dried to remove water typically at
15 temperatures of from 25°C to 400°C. Preferably, from about 1 to 99.9 by weight, 20% to 99% or 10 to 35% by weight of the total mixture is colloidal alumina or colloidal silica to provide the necessary crosslinking during heating to bind the agglomerated particle into a water-resistant particle. The particle can then withstand exposure to all types of water for an extended time and not disintegrate.

20 The binder can be mixed with the particle before or after the acid treatment of this invention. In one embodiment, the agglomerated particle is made by mixing colloidal alumina with the adsorbent particles. Typically, from about 1 to about 99.9% by weight, 10 to 35% by weight, or from 20 to 99% by weight of the mixture is colloidal alumina. In
25 one embodiment, the particle mixture is then mixed with an acid solution such as, for example, nitric, sulfuric, hydrochloric, boric, acetic, formic, phosphoric, and mixtures thereof. In one embodiment the acid is 5% nitric acid solution. In another embodiment, the acid is an aliphatic or aromatic carboxylic acid. In a preferred embodiment, the acid is acetic acid. The colloidal alumina and adsorbent and/or catalytic particles are thoroughly
30 mixed so as to create a homogenous blend of all elements. The additional acid solution is

added and further mixing is performed until the mixture reaches a suitable consistency for agglomeration. After agglomeration is complete, the agglomerated particles are heated or dehydrated to cause the colloidal alumina crosslinking to occur.

5 The particle of this invention bonds with the contaminant so that the particle and contaminant are tightly bound. This bonding makes it difficult to remove the contaminant from the particle, allowing the waste to be disposed of into any public landfill. Measurements of contaminants adsorbed on the particles of this invention using an EPA Toxicity Characteristic Leachability Procedure (TCLP) test known to those of skill in the art showed that there was a very strong interaction between the particles of this invention
10 and the contaminants such that the contaminant is held very tightly.

II. BINDER AND OXIDE ADSORBENT AND/OR OXIDE CATALYST SYSTEM

15 In accordance with the purpose(s) of this invention, as embodied and broadly described herein, this invention, in one aspect, relates to a method for producing an adsorbent and/or catalyst and binder system comprising

- i) mixing components comprising
 - a) a binder comprising a colloidal metal oxide or colloidal metalloid
20 oxide,
 - b) an oxide adsorbent and/or catalyst particle, and
 - c) an acid,
- ii) removing a sufficient amount of water from the mixture to cross-link
25 components a and b to form an adsorbent and/or catalyst and binder system.

In another aspect, the invention provides for an adsorbent and/or catalyst system made by the processes of the invention.

In one aspect, the invention provides an adsorbent and/or catalyst and binder system comprising a binder that has been cross-linked with at least one type of oxide adsorbent and/or catalyst particle.

5 In yet another aspect, the invention provides a method for reducing or eliminating the amount of a contaminant from a liquid or gas stream comprising contacting the adsorbent and/or catalyst binder system with the contaminant in the stream for a sufficient time to reduce or eliminate the amount of contaminant from the stream.

10 In yet another aspect, the invention provides a method for catalyzing the degradation of an organic compound comprising contacting the organic compound with the adsorbent and/or catalyst system for a sufficient time to catalyze the degradation of an organic compound.

15 In yet another aspect, the invention provides a method for reducing or eliminating the amount of a contaminant from a gas stream by catalysis comprising contacting the adsorbent and/or catalyst binder system with a gas stream containing a contaminant comprising an oxide of nitrogen, an oxide of sulfur, carbon monoxide, hydrogen sulfide, or mixtures thereof for a sufficient time to reduce or eliminate the contaminant amount.

20 In yet another aspect, the invention provides a method for producing an adsorbent and/or catalyst and binder system comprising

- 25
- i) mixing components comprising
 - a) a binder comprising a colloidal metal oxide or colloidal metalloid oxide,
 - b) a first adsorbent and/or catalyst particle that does not cross-link with the binder, and
 - c) an acid,
 - ii) removing a sufficient amount of water from the mixture to cross-link component a to itself, thereby entrapping and holding component b within

the cross-linked binder, to form an adsorbent and/or catalyst and binder system.

In another aspect the invention relates to a composition for binding adsorbent and/or catalytic particles to produce an agglomerated particle comprising (a) a colloidal metal oxide or colloidal metalloid oxide and (b) an acid.

In another aspect the invention relates to a kit for binding adsorbent and/or catalytic particles to produce an agglomerated particle comprising (a) a colloidal metal oxide or colloidal metalloid oxide and (b) an acid.

In yet another aspect, the invention provides a method for binding adsorbent and/or catalytic particles, comprising the steps of:

- (a) mixing colloidal alumina or colloidal silica with the particles and an acid;
- (b) agitating the mixture to homogeneity; and
- (c) heating the mixture for a sufficient time to cause cross-linking of the aluminum oxide in the mixture.

When the system acts as an adsorbent, the adsorbent and binder system of this invention has improved or enhanced adsorptive features. In one embodiment, the system of this invention can adsorb a larger amount of adsorbate per unit volume or weight of adsorbent particles than a prior art system. In another embodiment, the adsorbent and binder system of this invention can reduce the concentration of contaminants or adsorbate material in a stream to a lower absolute value than is possible with a non-bound or prior art-bound particle. In particular embodiments, the adsorbent and binder system of this invention can reduce the contaminant concentration in a stream to below detectable levels. Adsorption is a term well known in the art and should be distinguished from absorption. The adsorbent particles of this invention chemically bond to and very tightly retain the adsorbate material. These chemical bonds are ionic and/or covalent in nature.

The catalyst and binder system of the invention can also be used for the catalytic decomposition or remediation of contaminants. The catalyst system achieves improved catalytic performance or catalytic properties never seen before for a particular contaminant. The adsorbent and/or catalyst and binder system can be prepared by techniques set forth below to form a multifunctional composite particle. The catalysis can be at room temperature for certain applications.

The binder comprises an oxide particle that can react, preferably cross-link, with the other oxide complexes. This binder can also react, preferably cross-link, with itself. The binder forms cross-links with other oxide complexes upon drying by forming chemical bonds with itself and with other oxides. Under acidic conditions, the binder has a large number of surface hydroxyl groups. In one embodiment, the binder, which is designated as B-OH, cross-links with itself upon the loss of water to generate B-O-B. In addition cross-linking with itself, the binder B-OH can also cross-link with an adsorbent and/or catalyst oxide complex (M-O) or hydroxyl complex (M-OH) to produce B-O-M. The adsorbent and/or catalyst complexes are referred to herein as oxide adsorbent and/or catalyst particles or oxide adsorbent and/or oxide catalyst particles, both intending that the particle, which can have adsorbent, catalytic, or adsorbent and catalytic properties, has an oxide and/or hydroxide complex. The resulting binder system consists of a three dimensional network or matrix wherein the component particles are bound together with B-O-B and B-O-M bonds. The resulting system can be used as an adsorbent and/or catalyst system. The resultant system is sometimes referred to as an agglomerated particle.

"Colloidal metal or metalloid oxide (i.e. colloidal metal oxide or colloidal metalloid oxide) binder" as defined herein means a particle comprising a metal or metalloid mixed hydroxide, hydroxide oxide or oxide particle, such that the weight loss from the colloidal metal or metalloid oxide binder due to loss of water upon ignition is from 1 to 100%, 5 to 99%, 10 to 98%, or 50 to 95% of the theoretical water weight loss on going from the pure metal or metalloid hydroxide to the corresponding pure metal or metalloid oxide. The loss of water on going from the pure metal or metalloid hydroxide to the corresponding pure metal or metalloid oxide (e.g. the conversion of $n M(OH)_x$ to M_nO_m and $y H_2O$ or more

specifically from 2 Al(OH)_3 to Al_2O_3 and $3 \text{ H}_2\text{O}$) is defined as 100% of the water weight loss. Thus, the weight loss refers to loss of water based on the initial weight of water (not the total initial binder weight). There is a continuum of metal or metalloid hydroxides, hydroxide oxides, and oxides in a typical commercial product, such that, loss or removal of water from the metal or metalloid hydroxides produces the corresponding hydroxide oxides which upon further loss or removal of water give the corresponding metal or metalloid oxides. Through this continuum the loss or removal of water produces M-O-M bonds, where M is a metal or metalloid. The particles of this continuum, except for the pure metal or metalloid oxides, are suitable to serve as colloidal metal or colloidal oxide binders in this invention.

In another embodiment, the binder system involves the use of a binder in combination with a particle with few or no surface hydroxyl groups, such that the particle does not cross-link or only nominally cross-links with the binder. Examples of particles that possess only nominal amounts or that do not possess surface hydroxyl groups include particles of metals, such as, but not limited to tin or zinc, or carbon. In another embodiment, component b does not contain an oxide particle. Metal alloys such as bronze can also be used. In a preferred embodiment, the particle is activated carbon. In this embodiment, the binder cross-links with itself in a manner described above to form a three dimensional network or matrix that physically entraps or holds component b without cross-linking or cross-linking only to a very small degree with component b. The resulting binder system can be used as an adsorbent and/or catalyst system.

In another embodiment, the invention is directed to a method for producing an adsorbent and/or catalyst and binder system comprising

- i) mixing components comprising
 - a) a binder comprising a colloidal metal oxide or colloidal metalloid oxide,
 - b) a first adsorbent and/or catalyst particle that does not cross-link with the binder, and
 - c) an acid,

- ii) removing a sufficient amount of water from the mixture to cross-link component a to itself, thereby entrapping and holding component b within the cross-linked binder, to form an adsorbent and/or catalyst and binder system,

5 further comprising a second adsorbent and/or catalyst particle that cross-links with the binder, thereby cross-linking the binder and the second particle and thereby entrapping and holding the first particle within the cross-linked binder and/or within the cross-linked binder and second particle. In this embodiment, the system comprises a binder and oxide adsorbent and/or catalyst particles that cross-links with the binder as well as particles that have a limited amount of surface hydroxyl groups, which do not cross-link with the binder.
10 In this case, the binder cross links to itself and to the oxide complex particles, and the binder also forms a network or matrix around the particles that have a limited number of surface hydroxyl groups.

15 Binders that can be used in the present invention are colloidal metal or metalloid oxide complexes. Colloidal as used herein is defined as an oxide group that has a substantial number of hydroxyl groups that can form a dispersion in aqueous media. This is to be distinguished from the other use of the term colloid as used in regard to a size of less than 1 μm . The binders herein are typically small in size, *e.g.* less than 150 μm , but they do not have to be all less than 1 μm . Typically, the binder is un-calcined to maximize
20 the hydroxyl group availability. Moreover, they must have a substantial number of hydroxyl groups that can form a dispersion in aqueous media, which is not always true of colloid particles merely defined as being less than 1 μm . Examples of binders include but are not limited to any metal or metalloid oxide complex that has a substantial number of hydroxyl groups that can form a dispersion in aqueous media. In one embodiment, the
25 binder is colloidal alumina, colloidal silica, colloidal metal oxide where the metal is iron, or a mixture thereof, preferably colloidal alumina or colloidal silica. In another embodiment the binder is not colloidal alumina or colloidal silica. Colloidal alumina can be a powder, sol, gel or aqueous dispersion. Colloidal alumina may be further stabilized with an acid, preferably nitric acid, and even more preferably 3 to 4% nitric acid. In a preferred
30 embodiment, the colloidal alumina is un-calcined with a sufficient number of hydroxyl

groups such that the total particle weight loss (as distinguished from just water weight loss discussed above) upon ignition is between from 5% to 34%, more preferably from 20% to 31%. The colloidal alumina size is preferably from 5 nm to 400 μm , preferably at least 30 wt% is less than 25 μm and 95 wt% is less than 100 μm . The colloidal silica is preferably un-calcined with a sufficient number of hydroxyl groups such that the total particle weight loss upon ignition is between from 5% to 37%, more preferably from 20% to 31%. The colloidal silica size is preferably from 5 nm to 250 μm , preferably at least 30 wt% is less than 25 μm and 95 wt% is less than 100 μm . In one embodiment, the binder is from 1% to 99.9% by weight of the mixture, preferably from 10% to 35% by weight. As used herein, the binder will be referred to as "colloidal" to distinguish it from particle b, as the composition types can be the same, e.g. both can contain aluminum oxides.

Although prior art binders can be used in combination with the binder system of the present invention, these prior art binders lack certain advantages. In the present invention, the activity is not degraded when exposed to aqueous solutions. The system is also very durable and not subject to falling apart when exposed to a waste stream, unlike other prior art adsorbent and/or catalyst and binder systems, such as polyvinyl pyrrolidone, starch, or cellulose.

The invention contemplates the use of any prior art oxide adsorbent and/or catalyst particle or composite particle of two or more types of particles and binder system, but replacing the prior art binder with the binder of the present invention. In one aspect, the invention provides an adsorbent and/or catalyst and binder system comprising a binder that has been cross-linked with at least one type of oxide adsorbent and/or catalyst particles. In one embodiment, component b comprises at least two different types of oxide adsorbent and/or catalyst particles, to form a cross-linking between the binder and both particles to thereby form a composite particle. In another embodiment, component b comprises at least three different types of adsorbent and/or catalyst particles. In a preferred embodiment, component b comprises an oxide particle, preferably a metal oxide particle, and even more preferably a non-ceramic, porous metal oxide particle. Examples of such particles include, but are not limited to, oxide complexes, such as transition metal oxides, lanthanide oxides,

thorium oxide, as well as oxides of Group IIA (Mg, Ca, Sr, Ba), Group IIIA (B, Al, Ga, In, Tl), Group IVA (Si, Ge, Sn, Pb), and Group VA (As, Sb, Bi). In general, any oxide complex that is a basic anhydride is suitable for component b. In another embodiment, component b comprises an oxide of aluminum, titanium, copper, vanadium, silicon, manganese, iron, zinc, zirconium, tungsten, rhenium, arsenic, magnesium, thorium, silver, cadmium, tin, lead, antimony, ruthenium, osmium, cobalt or nickel or zeolite. Typically, any oxidation state of the oxide complexes may be useful for the present invention. The oxide can be a mixture of at least two metal oxide particles having the same metal with varying stoichiometry and oxidation states. In one embodiment, component b comprises Al_2O_3 , TiO_2 , CuO , Cu_2O , V_2O_5 , SiO_2 , MnO_2 , Mn_2O_3 , Mn_3O_4 , ZnO , WO_2 , WO_3 , Re_2O_7 , As_2O_3 , As_2O_5 , MgO , ThO_2 , Ag_2O , AgO , CdO , SnO_2 , PbO , FeO , Fe_2O_3 , Fe_3O_4 , Ru_2O_3 , RuO , OsO_4 , Sb_2O_3 , CoO , Co_2O_3 , NiO or zeolite. In a further embodiment, component b further comprises a second type of adsorbent and/or catalyst particles of an oxide of aluminum, titanium, copper, vanadium, silicon, manganese, iron, zinc, zirconium, tungsten, rhenium, arsenic, magnesium, thorium, silver, cadmium, tin, lead, antimony, ruthenium, osmium, cobalt or nickel or zeolite, activated carbon, including coal and coconut carbon, peat, zinc or tin. In another embodiment, component b further comprises a second type of adsorbent and/or catalyst particles of aluminum oxide, titanium dioxide, copper oxide, vanadium pentoxide, silicon dioxide, manganese dioxide, iron oxide, zinc oxide, zeolite, activated carbon, peat, zinc or tin particle. Typical zeolites used in the present invention include "Y" type, "beta" type, mordenite, and ZSM5. In a preferred embodiment, component b comprises non-amorphous, non-ceramic, crystalline, porous, calcined aluminum oxide that was produced by calcining the precursor to the calcined aluminum oxide at a particle temperature of from 300 or 400°C to 700°C, preferably in the gamma, chi-rho, or eta form. The precursor to calcined aluminum oxide can include but is not limited to boehmite, bauxite, pseudo-boehmite, scale, $\text{Al}(\text{OH})_3$ and alumina hydrates. In the case of other metal oxide complexes, these complexes can also be calcined or uncalcined.

The adsorbent and/or catalyst particles used in this invention can be unenhanced or enhanced by processes known in the art or described below. For example, the particles can be dried to be activated or can be of a composition or treated by ion or electron beam or

acid activation or enhancement treatment processes disclosed in applicants' two applications filed on October 21, 1996 and entitled (1) "Enhanced Adsorbent and Room Temperature Catalyst Particle and Method of Making and Using Therefor," U.S. Serial No. 08/734, 329, which is a continuation-in-part of PCT/US96/05303, filed April 17, 1996, pending, which is a continuation-in-part of U.S. application serial No. 08/426,981, filed April 21, 1995, pending, and (2) "Acid Contacted Enhanced Adsorbent Particle and Method of Making and Using Therefor," U.S. Serial No. 08/734,331, which is a continuation-in-part of U.S. application serial No. 08/662,331, filed June 12, 1996, pending, which is a continuation-in-part of PCT/US95/15829, filed June 12, 1995, pending, which is a continuation-in-part of U.S. application serial No. 08/351,600, filed December 7, 1994, abandoned, the disclosures of both of these applications and all of their prior filed priority applications are herein incorporated by this reference in their entireties for all of their teachings, including, but not limited to particle compositions and methods of treatment. The acid treatment or enhancement method and particles is described above in section I. In one embodiment the oxide adsorbent and/or catalyst particle has not been acid enhanced treated.

An acid is required to cross-link the binder with component b. The addition of an acid to the binder facilitates or enables the reaction between the binder and the oxide particle. A strong or dilute acid can be used. A dilute acid is preferred to minimize etching of certain particles. Typically the acid is diluted with water to prevent dissolution of the particle and for cost effectiveness. The acid treatment is preferably of a concentration (*i.e.* acid strength as measured by, *e.g.*, normality or pH), acid type, temperature and length of time to cross-link the binder and component b.

In one embodiment, the acid comprises nitric acid, sulfuric acid, hydrochloric acid, boric acid, acetic acid, formic acid, phosphoric acid or mixtures thereof, preferably acetic acid or nitric acid. In another embodiment, the acid is an aliphatic or aromatic carboxylic acid. Examples of aliphatic and aromatic carboxylic acids include but are not limited to acetic acid, benzoic acid, butyric acid, citric acid, fatty acids, lactic acid, maleic acid,

malonic acid, oxalic acid, salicylic acid, stearic acid, succinic acid, tartaric acid, propionic acid, valeric acid, hexanoic acid, heptanoic acid, caprylic acid, pelargonic acid, capric acid, undecanoic acid, lauric acid, tridecanoic acid, myristic acid, pentadecanoic acid, palmitic acid, heptadecanoic acid, nonadecanoic acid, arachidic acid, heneicosanoic acid, behenic acid, triosanoic acid, lignoceric acid, pentacosanoic acid, cerotic acid, heptasanoic acid, montanic acid, nonacosanoic acid, melissic acid, phthalic acid, glutaric acid, adipic acid, azelaic acid, sebacic acid, cinnamic acid, acrylic acid, crotonic acid, linoleic acid or a mixture thereof. In another embodiment, the concentration of the acid is from 0.15 N to 8.5 N, preferably from 0.5 N to 1.7 N. The volume of dilute acid used must be high enough so that the adsorbent and/or catalyst particle of the present invention can be used as is or further processed, such as extruded or filter pressed.

In order to ensure efficient cross-linking between the binder and the oxide particle component, water is removed from the resulting binder system. This is typically performed by using a drying agent or heating the system. The cross-linking temperature as used herein is the temperature at which cross-linking between the binder and the oxide adsorbent and/or catalyst component occurs at an acceptable rate or the temperature at which the binder reacts with itself at an acceptable rate. In one embodiment, the cross-linking temperature is from 25°C to 400°C. Thus, in one embodiment, the cross-linking temperature for certain binders is at room temperature and requires no heating, although the rate of cross-linking at this temperature is slow. In various embodiments, the cross-linking temperature, and thus the heating step, is from 50°C, 70°C, 110°C, or 150°C to 200°C, 250°C, 300°C, or 350°C, preferably 150°C to 300°C, even more preferably about 250°C. The cross-linking process can take place in open air, under an inert atmosphere or under reduced pressure. The cross-linking temperature can effect the activity of the adsorbent and/or catalyst and binder system. When cross-linking occurs in the open air, then the particle is more susceptible to oxidation as the cross-linking temperature is increased. Oxidation of the particle can ultimately reduce the activity of the particle.

Preferably, during or after step (i), the mixture of step (i) is not heated above the cross-linking temperature of the colloidal metal oxide or colloidal metalloid oxide.

Preferably, during or after step (i), the mixture of step (i) is not heated to or above the calcining temperature of the colloidal metal oxide or colloidal metalloid oxide. Preferably, during or after step (i), the mixture of step (i) is not heated to or above the calcining temperature of the particle. In various embodiments, during or after step (i), the mixture of step (i) is not heated above 500° C, 450° C, 400° C, 350° C, 300° C, or 250° C, preferably not above 400° C. Cross-linking should be distinguished from calcining. Calcining typically involves heating a particle to remove any residual water that may be on the particle as well as change the lattice structure of the particle to form a crystalline particle. For example for producing a crystalline aluminum oxide particle, the calcining temperature is about 300 or 400° C to about 700° C. Calcining also removes the hydroxyl groups on the binder that are required for cross-linking. Therefore, heating the system during or after step (i) above the cross-linking temperature into the particle or binder calcining temperature range or above is detrimental to the system. Thus, prior art systems, where mixtures of colloidal alumina and/or colloidal silica are (1) calcined or recalcined or (2) heated to form a refractory material are not a part of this invention.

In another aspect, the invention provides for an adsorbent and/or catalyst system made by the process of the invention.

The binder system of the invention is made in one embodiment by the following general process. The (1) binder and (2) adsorbent and/or catalyst particles are pre-mixed in dry form. The colloidal binder can be added or prepared *in situ*. For example, alum could be added as a dry powder and converted to colloidal alumina *in situ*. Other aluminum based compounds can be used for the *in situ* process, such as aluminum chloride, aluminum secondary butoxide, and the like. A solution of the acid is added to the mixture, and the mixture is stirred or agitated, typically from 1 minute to 2 hours, preferably from 10 minutes to 40 minutes, until the material has a homogeneous "clay" like texture. The mixture is then ready for cross-linking or can be first fed through an extruder and then cut or chopped into a final shape, preferably spheres, pellets or saddles, typically of a size from 0.2 mm to 3 mm, preferably 0.5 to 1.5 mm. After the final shape is made, the product is transferred to a drying oven where they are dried from 15 minutes to 4 hours, preferably

from 30 minutes to 2 hours. Once the binder is added to the adsorbent and/or catalyst particles (component b), the mixture is not heated to calcine or recalcine the particle b or binder. Such calcining or recalcining would detrimentally change the surface characteristics of component b by closing up the micropores. Additionally, the particles of the invention are preferably not sintered, as this would detrimentally affect the micropores by closing up the micropores and would detrimentally decrease the pore volume and surface area. The particles and binder system are also not heated above the calcining temperature to form a refractory material. Any other process that would increase the size or eliminate micropores, enlarge the size of, create macropores at the expense of micropores or destroy macropores, or would decrease the surface area available for adsorption or catalysis should preferably be avoided.

The size and shape of the particles used in this invention prior to extruding can vary greatly depending on the end use. Typically, for adsorption or catalytic applications, a small particle size such as 5 μm or greater to about 250 μm are preferable because they provide a larger surface area than large particles.

In yet another aspect, the invention provides a method for reducing or eliminating the amount of a contaminant from a liquid or gas stream comprising contacting the adsorbent and/or catalyst binder system with the contaminant in the stream for a sufficient time to reduce or eliminate the amount of contaminant from the stream. In one embodiment, the stream is a liquid, preferably water. In another embodiment, the stream is a gas, preferably comprising air or natural gas.

The adsorbent and/or catalyst binder system of this invention can be used for environmental remediation applications. In this embodiment, contaminants from a liquid or gas stream can be reduced or eliminated by a catalysis reaction. In another embodiment, contaminants from a liquid or gas stream can be reduced or eliminated by an adsorption reaction. The particle can be used to remove contaminants, such as, but not limited to, heavy metals, organics, including hydrocarbons, chlorinated organics, including chlorinated hydrocarbons, inorganics, or mixtures thereof. Specific examples of contaminants include,

but are not limited to, acetone, ammonia, benzene, carbon monoxide, chlorine, hydrogen sulfide, trichloroethylene, 1,4-dioxane, ethanol, ethylene, formaldehyde, hydrogen cyanide, hydrogen sulfide, methanol, methyl ethyl ketone, methylene chloride, oxides of nitrogen such as nitrogen oxide, propylene, styrene, oxides of sulfur such as sulfur dioxide, toluene, vinyl chloride, arsenic, cadmium, chlorine, 1,2-dibromochloropropane (DBCP), iron, lead, phosphate, radon, selenium, an anion, an oxoanion, a poly-oxoanion or uranium, such as U_3O_8 . The adsorbent and/or catalyst binder system of this invention can remediate individual contaminants or multiple contaminants from a single source. This invention achieves improved efficiency by adsorbing a higher amount of contaminants and by reducing the contamination level to a much lower value than by non-enhanced particles.

In yet another aspect, the invention provides a method for catalyzing the degradation of an organic compound comprising contacting the organic compound with the adsorbent and/or catalyst system for a sufficient time to catalyze the degradation of an organic compound. In one embodiment, the catalysis reaction is at room temperature. In a one embodiment, the organic compound is a chlorinated organic compound, such as trichloroethylene (TCE). In one embodiment, the catalyst and binder system catalyzes the hydrolysis of the chlorinated organic compounds.

In yet another aspect, the invention provides a method for reducing or eliminating the amount of a contaminant from a gas stream by catalysis comprising contacting the adsorbent and/or catalyst binder system with a gas stream containing a contaminant comprising an oxide of nitrogen, an oxide of sulfur, carbon monoxide, hydrogen sulfide, or mixtures thereof for a sufficient time to reduce or eliminate the contaminant amount. In one embodiment, the catalysis reaction is at room temperature.

For environmental remediation applications, adsorbent and/or catalyst particles of the invention are typically placed in a container, such as a filtration unit. The contaminated stream enters the container at one end, contacts the particles within the container, and the purified stream exits through another end of the container. The particles contact the contaminants within the stream and bond to and remove the contamination from the stream.

Typically, the particles become saturated with contaminants over a period of time, and the particles must be removed from the container and replaced with fresh particles. The contaminant stream can be a gas stream or liquid stream, such as an aqueous stream. The particles can be used to remediate, for example, waste water, production facility effluent, smoke stack gas, auto exhaust, drinking water, and the like.

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The particle/binder system of the invention can be used preferably as the adsorbent or catalytic medium itself. In an alternate embodiment, the system is used as an adsorbent or catalytic support. In another embodiment, it is not used as a catalyst support.

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When the particle adsorbs a contaminant, the particle of this invention bonds with the contaminant so that the particle and contaminant are tightly bound. This bonding makes it difficult to remove the contaminant from the particle, allowing the waste to be disposed of into any public landfill. Measurements of contaminants adsorbed on the particles of this invention using an EPA Toxicity Characteristic Leachability Procedure (TCLP) test known to those of skill in the art showed that there was a very strong interaction between the particles of this invention and the contaminants such that the contaminant is held very tightly.

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Although the particle system bonds tightly to the contaminant, the system of the invention can be regenerated by various techniques. In one embodiment, the acid enhanced particle of section I above can be regenerated. In another embodiment, the binder and oxide adsorbent and/or catalyst system can be regenerated. In one embodiment, the particle can be regenerated by roasting it in air to reoxidize the particle. In another embodiment, the contaminant can be removed by contacting the particle having the adsorbed contaminant with a reagent wash. The reagent wash can include but is not limited to aqueous ammonia, phosphines or detergents. In yet another embodiment, the use of a pH swing can remove the contaminant from the particle. Various pH ranges can be used to remove the contaminant from the particle depending upon the type of contaminant. In one embodiment, an acidic solution can be used to remove a cation from the particle. In another embodiment, a basic solution can be used to remove an anion from the particle. In

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another embodiment, Lewis acids and bases can be used to remove the contaminant from the adsorbent particle.

In one embodiment, component b comprises aluminum oxide, copper oxide, and manganese dioxide. In this embodiment, the binder is preferably colloidal alumina. In this embodiment, the acid is preferably acetic acid. In this embodiment, the binder is from 1 to 97 parts by weight, preferably from 5 to 35 parts by weight, the aluminum oxide is from 1 to 97 parts by weight, preferably from 55 to 85 parts by weight, the copper oxide is from 1 to 97 parts by weight, preferably from 1 to 20 parts by weight, and the manganese oxide is from 1 to 97 parts by weight, preferably from 1 to 20 parts by weight. In another embodiment, the binder is 20 parts by weight, aluminum oxide is 70 parts by weight, copper oxide is 5 parts by weight, and manganese dioxide is 5 parts by weight.

In another embodiment, component b comprises aluminum oxide and activated carbon. In this embodiment, the binder is preferably colloidal alumina. In this embodiment, the acid is preferably acetic acid. In this embodiment, the binder is from 1 to 98 parts by weight, preferably from 5 to 35 parts by weight, the aluminum oxide is from 1 to 98 parts by weight, preferably from 45 to 75 parts by weight, and the activated carbon is from 1 to 98 parts by weight, preferably from 35 to 55 parts by weight. In another embodiment, the binder is 20 parts by weight, aluminum oxide is 60 parts by weight, and activated carbon is 5 parts by weight.

In another embodiment, component b comprises copper oxide and manganese dioxide. In this embodiment, the binder is preferably colloidal alumina. In this embodiment, the acid is preferably acetic acid. In this embodiment, the binder is from 1 to 98 parts by weight, preferably from 5 to 35 parts by weight, the copper oxide is from 1 to 98 parts by weight, preferably from 35 to 55 parts by weight, and the manganese dioxide is from 1 to 98 parts by weight, preferably from 25 to 55 parts by weight. In another embodiment, the binder is 20 parts by weight, copper oxide is 40 parts by weight, and manganese dioxide is 40 parts by weight.

In another embodiment, component b comprises aluminum oxide, copper oxide, manganese dioxide and activated carbon. In this embodiment, the binder is preferably colloidal alumina. In this embodiment, the acid is preferably acetic acid. In this embodiment, the binder is from 1 to 96 parts by weight, preferably from 5 to 35 parts by weight, the aluminum oxide is from 1 to 96 parts by weight, preferably from 45 to 75 parts by weight, the copper oxide is from 1 to 96 parts by weight, preferably from 1 to 20 parts by weight, the manganese dioxide is from 1 to 96 parts by weight, preferably from 1 to 20 parts by weight, and activated carbon is from 1 to 96 parts by weight, preferably from 1 to 25 parts by weight. In another embodiment, the binder is 19.9 parts by weight, aluminum oxide is 60 parts by weight, copper oxide is 5.98 parts by weight, manganese dioxide is 4.98 parts by weight, and activated carbon is 9.95 parts by weight.

In another embodiment, the component b comprises aluminum oxide, silicon dioxide and activated carbon. In a further embodiment, the particle comprises from 1 to 97 parts, preferably 5-35 parts, more preferably 20 parts by weight aluminum oxide, from 1 to 97 parts, preferably 5-35 parts, more preferably 20 parts by weight silicon dioxide and 1-99 parts, preferably 25-55 parts, more preferably 40 parts by weight activated carbon. In this embodiment, the binder is preferably colloidal alumina and the acid is preferably acetic acid. The binder is from 1 to 97 parts by weight, preferably from 5 to 35 parts by weight.

In another embodiment, the catalyst and binder system can be used as an oxidation catalyst. In one embodiment, the system comprises colloidal alumina as a binder, Al_2O_3 , and one or more of the following oxide particles of V_2O_5 , WO_2 , WO_3 , TiO_2 , Re_2O_7 , As_2O_3 , As_2O_5 , OsO_4 , or Sb_2O_3 . In another embodiment, the colloidal alumina is from 10 to 30 parts by weight, Al_2O_3 is from 1 to 90 parts by weight, and V_2O_5 , WO_2 , WO_3 , TiO_2 , Re_2O_7 , As_2O_3 , As_2O_5 , OsO_4 , or Sb_2O_3 are each from 1 to 90 parts by weight.

In another embodiment, the catalyst and binder system can be used as a Lewis acid catalyst. In one embodiment, the system comprises colloidal alumina as a binder, Al_2O_3 , and one or more of the following oxide particles of V_2O_5 , ZrO_2 , TiO_2 , MgO , ThO_2 or lanthanide oxides. In another embodiment, the colloidal alumina is from 10 to 30 parts by

weight, Al_2O_3 is from 1 to 90 parts by weight, and V_2O_5 , ZrO_2 , TiO_2 , MgO , ThO_2 or lanthanide oxides are each from 1 to 90 parts by weight.

In another embodiment, the catalyst and binder system can be used as a cracking catalyst. In one embodiment, the system comprises colloidal alumina as a binder, Al_2O_3 , and one or more of the following oxide particles of CuO , ZnO , Ag_2O , AgO , CdO , SnO_2 , PbO , V_2O_5 , ZrO_2 , MgO , ThO_2 or lanthanide oxides. In another embodiment, the colloidal alumina is from 10 to 30 parts by weight, Al_2O_3 is from 1 to 90 parts by weight, and CuO , ZnO , Ag_2O , AgO , CdO , SnO_2 , PbO , V_2O_5 , ZrO_2 , MgO , ThO_2 or lanthanide oxides are each from 1 to 90 parts by weight.

In another embodiment, the catalyst and binder system can be used as a reduction catalyst. In one embodiment, the system comprises colloidal alumina as a binder, Al_2O_3 , and one or more of the following oxide particles of MnO_2 , Fe_2O_3 , Fe_3O_4 , Ru_2O_3 , OsO_4 , CoO , Co_2O_3 , RuO or NiO . In another embodiment, the colloidal alumina is from 10 to 30 parts by weight, Al_2O_3 is from 1 to 90 parts by weight, and MnO_2 , Fe_2O_3 , Fe_3O_4 , Ru_2O_3 , OsO_4 , CoO , Co_2O_3 , RuO or NiO are each from 1 to 90 parts by weight.

In another embodiment, the catalyst and binder system can be used as a catalyst for the reduction and removal of nitrogen oxides. In one embodiment, the binder is colloidal alumina and the particle comprises aluminum oxide, gallium oxide and copper oxide. In another embodiment, the colloidal alumina is from 1 to 98% by weight, the aluminum oxide is from 1 to 98% by weight, the gallium oxide is from 1 to 98% by weight, and the copper oxide is from 1 to 99% by weight. In yet another embodiment, the colloidal alumina is from 5 to 40% by weight, the aluminum oxide is from 40 to 99% by weight, the gallium oxide is from 1 to 10% by weight, and the copper oxide is from 1 to 10% by weight. In a preferred embodiment, the colloidal alumina is 20% by weight, Al_2O_3 , preferably acid enhanced, is 70% by weight, Ga_2O_3 is 5% by weight, and CuO is 5% by weight, wherein the particle is cross-linked with acetic acid at 350°C. In another embodiment, the binder is colloidal alumina and the particle comprises aluminum oxide, copper oxide and zirconium oxide. In yet another embodiment, the colloidal alumina is from 1 to 97% by weight, the

aluminum oxide is from 1 to 97% by weight, and the copper oxide is from 1 to 97% by weight, and the zirconium oxide is from 1 to 97% by weight. In a preferred embodiment, the colloidal alumina is from 10 to 40% by weight, the aluminum oxide is from 30 to 70% by weight, the copper oxide is from 10 to 20% by weight, and the zirconium oxide is from 1 to 20% by weight. In an even more preferred embodiment, the colloidal alumina is 20% by weight, the Al_2O_3 , preferably acid enhanced, is 70% by weight, CuO is 5% by weight, and ZrO_2 is 5% by weight, wherein the particle is cross-linked with acetic acid at 350°C . In another embodiment, the binder is colloidal alumina and the particle comprises aluminum oxide and silver nitrate. In yet another embodiment, the colloidal alumina is from 1 to 98% by weight, the aluminum oxide is from 1 to 98% by weight, and the silver nitrate is from 1 to 98% by weight. In a preferred embodiment, the colloidal alumina is from 10 to 40% by weight, the aluminum oxide is from 30 to 70% by weight, and the silver nitrate is from 1 to 20% by weight. In a preferred embodiment, the colloidal alumina is 20% by weight, Al_2O_3 , preferably acid enhanced, is 75% by weight, and AgNO_3 is 5% by weight, wherein the particle is cross-linked with acetic acid at 350°C . In another embodiment, the binder is colloidal alumina and the particle comprises aluminum oxide, a mixed oxide complex, and copper oxide. Mixed oxides complexes are defined as particles comprising at least two or more oxide complexes. In yet another embodiment, the colloidal alumina is from 1 to 97% by weight, the aluminum oxide is from 1 to 97% by weight, the mixed oxide is from 1 to 97% by weight, and the copper oxide is from 1 to 97% by weight. In a preferred embodiment, the colloidal alumina is from 10 to 40% by weight, the aluminum oxide is from 30 to 70% by weight, the mixed oxide is from 1 to 20% by weight, and the copper oxide is from 1 to 20% by weight. A mixed oxide particle that is useful for this embodiment is MOLECULITE[®], which is supplied by Molecular Products LTD., Essex, UK. MOLECULITE[®] contains from 60 to 75% by weight oxides of manganese compounds, including MnO_2 , Mn_2O_3 , and/or Mn_3O_4 , 11 to 14% by weight copper oxide, and about 10% by weight lithium hydroxide. In one embodiment, the system comprises colloidal alumina as a binder, and the particle comprises aluminum oxide and copper oxide. In an even more preferred embodiment, the colloidal alumina is 20% by weight, the Al_2O_3 , preferably acid enhanced, is 70% by weight, the MOLECULITE[®] is 5% by weight, CuO is 5% by weight, wherein the particle is cross-

linked with acetic acid at 350°C. In another embodiment, the binder is colloidal alumina and the particle comprises aluminum oxide, copper oxide, manganese dioxide and magnesium oxide. In yet another embodiment, the colloidal alumina is from 1 to 96% by weight, the aluminum oxide is from 1 to 96% by weight, the manganese dioxide is from 1 to 96% by weight, the copper oxide is from 1 to 96% by weight, and the magnesium oxide is from 1 to 96%. In a preferred embodiment, the colloidal alumina is from 10 to 40% by weight, the aluminum oxide is from 30 to 70% by weight, the manganese dioxide is from 1 to 20% by weight, the copper oxide is from 1 to 20% by weight, and the magnesium oxide is from 1 to 30%. In an even more preferred embodiment, the colloidal alumina is 20% by weight, Al_2O_3 , preferably acid enhanced, is 50% by weight, the MnO_2 is 5% by weight, CuO is 5% by weight, and MgO is 20%, wherein the particle is cross-linked with acetic acid at 350°C. In yet another embodiment, the colloidal alumina is from 1 to 98% by weight, the aluminum oxide is from 1 to 98% by weight, and the copper oxide is from 1 to 98% by weight. In a preferred embodiment, the colloidal alumina is from 10 to 40% by weight, the aluminum oxide is from 30 to 70% by weight, and the copper oxide is from 1 to 20% by weight. In an even more preferred embodiment, the colloidal alumina is 25% by weight, Al_2O_3 , preferably acid enhanced, is 65% by weight, and CuO is 10% by weight, wherein the particle is cross-linked with acetic acid at 350°C.

In another embodiment, the catalyst and binder system can be used as a catalyst for oxidation of CO and hydrocarbons. In one embodiment, the binder is colloidal alumina and the particle comprises aluminum oxide, a mixed oxide and copper oxide. In yet another embodiment, the colloidal alumina is from 1 to 98% by weight, the aluminum oxide is from 1 to 98% by weight, and the mixed oxide is from 1 to 98% by weight. In a preferred embodiment, the colloidal alumina is from 10 to 40% by weight, the aluminum oxide is from 10 to 40% by weight, and the mixed oxide is from 20 to 70% by weight. A mixed metal oxide that is useful in this embodiment is CARULITE® 300, which is supplied by Carus Chemical Company, LaSalle, Illinois, USA. CARULITE® 300 contains from 60 to 75% by weight manganese dioxide, 11 to 14% copper oxide, and 15 to 16% aluminum oxide. In an even more preferred embodiment, the

colloidal alumina is 20% by weight, Al_2O_3 , preferably acid enhanced, is 20% by weight, and CARULITE® 300 is 60% by weight, wherein the particle is cross-linked with nitric acid at 350°C.

5 In another embodiment, the catalyst and binder system can be used as an adsorbent for sulfur oxygen compounds. In one embodiment, the system comprises colloidal alumina as a binder, and the particle comprises aluminum oxide and copper oxide. In another embodiment, the colloidal alumina is from 1 to 98% by weight, the aluminum oxide is from 1 to 98% by weight, and the copper oxide is from 1 to 98% by weight. In a preferred embodiment, the colloidal alumina is from 10 to 40% by weight, the aluminum oxide is from 30 to 70% by weight, and the copper oxide is from 1 to 20% by weight.

15 In another embodiment, the binder and oxide adsorbent and/or catalyst system can remove chlorinated hydrocarbons from a liquid stream. In one embodiment, the binder and oxide adsorbent and/or catalyst system comprises (1) colloidal alumina, (2) aluminum oxide, (3) a mixed oxide, such as mixed oxides of manganese, for example MOLECULITE®, and (4) carbon. In a preferred embodiment, the composition comprises or consists of colloidal alumina from 10 to 30, preferably 20% by weight, Al_2O_3 , which is preferably acid enhanced, from 50 to 70, preferably 60% by weight, MOLECULITE® from 5 to 15, preferably 10% by weight, and carbon from 5 to 15, preferably 10% by weight.

25 In another embodiment, the catalyst and binder system can be used as a coal gasification catalyst. In one embodiment, the system comprises colloidal alumina as a binder, Al_2O_3 , and one or more of the following oxide particles of Fe_2O_3 , Fe_3O_4 , CoO or Co_2O_3 . In another embodiment, the colloidal alumina is from 10 to 30 parts by weight, Al_2O_3 is from 1 to 90 parts by weight, and Fe_2O_3 , Fe_3O_4 , CoO , or Co_2O_3 , are each from 1 to 90 parts by weight.

30 In another embodiment, the catalyst and binder system can be used as a coal gas reforming catalyst. In one embodiment, the system comprises colloidal alumina as a binder,

Al_2O_3 , and one or more of the following oxide particles of Fe_2O_3 , Fe_3O_4 , CoO or Co_2O_3 . In another embodiment, the colloidal alumina is from 10 to 30 parts by weight, Al_2O_3 is from 1 to 90 parts by weight, and Fe_2O_3 , Fe_3O_4 , CoO , or Co_2O_3 , are each from 1 to 90 parts by weight.

5 In another embodiment, the catalyst and binder system can be used as a hydrogenation catalyst. In one embodiment, the system comprises colloidal alumina as a binder, Al_2O_3 , and one or more of the following oxide particles of Fe_2O_3 , Fe_3O_4 , CoO or Co_2O_3 . In another embodiment, the colloidal alumina is from 10 to 30 parts by weight, Al_2O_3 is from 1 to 90 parts by weight, and Fe_2O_3 , Fe_3O_4 , CoO or Co_2O_3 are each from 1 to 10 90 parts by weight.

In another embodiment, the catalyst and binder system can be used as a desiccant. In one embodiment, the system comprises colloidal alumina as a binder, Al_2O_3 , and one or more of the following oxide of zeolite, MgO , or ThO_2 . In another embodiment, the 15 colloidal alumina is from 10 to 30 parts by weight, Al_2O_3 is from 1 to 90 parts by weight, and zeolite, MgO , or ThO_2 are each from 1 to 90 parts by weight.

In another embodiment, the catalyst and binder system can be used as a catalyst support. In one embodiment, the system comprises colloidal alumina as a binder, Al_2O_3 , 20 and one or more of the following oxide particles of MgO or ThO_2 . In another embodiment, the colloidal alumina is from 10 to 30 parts by weight, Al_2O_3 is from 1 to 90 parts by weight, and MgO or ThO_2 are each from 1 to 90 parts by weight.

In another embodiment, the catalyst and binder system can be used to adsorb ions 25 from a gas or liquid stream. In one embodiment, the system comprises colloidal alumina as a binder, aluminum oxide and copper oxide. In yet another embodiment, the colloidal alumina is from 1 to 98% by weight, the aluminum oxide is from 1 to 98% by weight, and the copper oxide is from 1 to 98% by weight. In a preferred embodiment, the colloidal alumina is from 10 to 40% by weight, the aluminum oxide is from 30 to

70% by weight, and the copper oxide is from 1 to 20% by weight. The ion that is adsorbed includes but is not limited to an anion, an oxo-anion, a poly-oxoanion or a mixture thereof.

In another embodiment, the system comprises colloidal alumina binder and the particle comprises aluminum oxide, zinc oxide and copper oxide. In another embodiment the system comprises a colloidal alumina binder and the particle comprises aluminum oxide and copper oxide.

In another embodiment, the catalyst and binder system can encapsulate a contaminant within an adsorbent particle. The acid enhanced adsorbent and/or catalyst particle of section I above and the binder and oxide adsorbent and/or oxide particle of this section II may be used to encapsulate a contaminant. Upon heating the adsorbent particle that has adsorbed a contaminant to a sufficient temperature, the pores of the particle will close and encapsulate the contaminant within the particle. In one embodiment, the curing temperature is from 450°C to 1200°C, preferably from 600°C to 1200°C. Upon heating the particle or the binder-particle system, the pores of the particle, binder or both will close and encapsulate the contaminant.

The acid that is used to enhance the particle of section I above and the acid used to cross-link the binder and oxide adsorbent and/or catalyst particle of this section can also behave as a blowing agent. The term blowing agent is defined herein as any reagent that can modify a physical property of the particle. Examples of physical properties that can be modified include but are not limited to surface area, pore area, bulk density, skeletal density and porosity. In one embodiment, the blowing agent can be an acid, preferably acetic and nitric acid. Not to be bound by theory, it is believed that the acid can bind with the particle of section I during acid treatment or enhancement or the acid can bind to the binder and/or oxide adsorbent and/or catalyst system of this section during the kneading and extrusion steps. The complex then decomposes during the curing step to produce gasses. The resultant gas departs from the particle, which results in an increase in surface area, pore area bulk density, skeletal density and porosity. By varying the physical properties of the particle, the activity of the adsorbent and/or activity of the catalyst can be enhanced.

In another embodiment, the invention relates to a composition for binding adsorbent and/or catalytic particles to produce an agglomerated particle comprising (a) a colloidal metal oxide or colloidal metalloid oxide and (b) an acid. In this composition, in one embodiment, the colloidal metal oxide or colloidal metalloid oxide comprises colloidal alumina or colloidal silica. In this composition, in one embodiment, the acid is acetic acid or nitric acid.

In another embodiment, the invention relates to a method for binding adsorbent and/or catalytic particles, comprising the steps of:

- (a) mixing colloidal alumina or colloidal silica with the particles and an acid;
- (b) agitating the mixture to homogeneity; and
- (c) heating the mixture for a sufficient time to cause cross-linking of the aluminum oxide in the mixture.

In one embodiment, the colloidal alumina or colloidal silica is colloidal alumina. In another embodiment, the colloidal alumina is from 20% to 99% by weight of the mixture. In another embodiment, the acid is nitric acid.

III. ANCHORED ADSORBENT AND/OR CATALYST SYSTEM

The use of organic and inorganic materials as catalyst systems is known in the art. These catalyst support systems are capable of binding with a homogeneous catalyst. A homogeneous catalyst is defined as a catalyst that is in the same phase as the reactants. There are two main advantages to using a catalyst support system in combination with a homogeneous catalyst. First, the homogeneous catalyst that is bound or complexed to the support is recoverable after the reaction is complete. A number of homogeneous catalysts that are used in the art are expensive to manufacture; therefore, the recovery of these materials is important. Second, the support can enhance the activity of the anchored homogeneous catalyst. An anchored catalyst is defined as a catalyst that is bound to a support system.

The complexation of a catalyst to an inert support, for example, a polymer such as polystyrene has been the focus of extensive research in the prior art. The use of metal oxides as catalyst supports have also been used extensively in catalytic reactions. A review of anchored catalysts systems is disclosed in Valentine *et al.*, "Technological Perspective for Anchored Catalysts Preparation," Am. Chem. Soc., Div. Pet. Chem., Vol. 27(3), pp. 608-10, 1982; Pittman *et al.* "Unusual Selectivities in Hydroformylations Catalyzed by Polymer-Attached Carbonylhydrotris(triphenylphosphine)rhodium," J. Am. Chem. Soc. Vol. 98(17), pp 5402-5, 1976; Jacobson *et al.*, "Selective Hydrogenation of 4-Vinylcyclohexene Catalyzed by Polymer-Anchored Carbonylchlorobis(triphenylphosphine)iridium," J. Mol. Catal. Vol. 1(1), pp 73-6, 1975; Pittman *et al.* "The Vinyl Reactivity of (5-Vinylcyclopentadienyl)dicarbonylnitrosylchromium. A Novel Vinyl Organometallic Monomer", Macromolecules Vol. 11, pp 560-565, 1978; and Cotton *et al.* "Advanced Inorganic Chemistry, A Comprehensive Text," 3rd edition, pp 620-801, 1962.

Although a number of support systems are known in the art, they are limited in that current polymer supports systems are limited to reaction conditions where the polymer is stable. The prior art support systems are composed of an organic polymer backbone, or a single component metal oxide system.

In one embodiment, the invention relates to an adsorbent and/or catalyst and binder system, comprising:

- (a) a pendant ligand substituted or unsubstituted binder, and
- (b) a pendant ligand substituted or unsubstituted oxide adsorbent and/or oxide catalyst particle,

wherein at least one of components (a) and (b) is pendant ligand substituted, and wherein component (a) is cross-linked with component (b).

The unsubstituted binder and unsubstituted oxide adsorbent and/or oxide catalyst particle is defined herein as a particle that has free hydroxyl groups that have not been substituted with an organic or inorganic pendant ligand moiety. The binder and oxide adsorbent and/or oxide catalyst particles and system discussed in the previous section

entitled "Binder and Oxide Adsorbent and/or Oxide Catalyst System" can be used as the unsubstituted binder and unsubstituted oxide adsorbent and/or oxide catalyst particles and systems.

5 In one embodiment, the binder can be a colloidal metal oxide or a colloidal metalloid oxide, preferably colloidal alumina, colloidal silica, a colloidal metal oxide wherein the metal is iron, or a mixture thereof, and even more preferably colloidal alumina, colloidal silica, or a mixture thereof, and even more preferably colloidal alumina.

10 In one embodiment, the oxide adsorbent and/or oxide catalyst particle is pendant ligand substituted. In another embodiment, the binder is pendant ligand substituted. In another embodiment, the oxide adsorbent and/or oxide catalyst particle and the binder are both pendant ligand substituted.

15 The substituted binder and oxide adsorbent and/or oxide catalyst system independently contains at least one pendant ligand. A pendant ligand is defined herein as a moiety having at least one complexing group and, optionally, a tether end. The complexing group is typically the moiety of the pendant ligand used to attach or bind to a metal complex, wherein the metal complex can be a homogeneous catalyst that is known in the art and are disclosed, for example, in Collman *et al.*, "Principles and Applications of
20 Organotransition Metal Chemistry," Ch. 2, 1987, can be used herein. In one embodiment, the complexing group is a group with a lone-pair of electrons. In this case, the complexing group can bind to another moiety by way of a Lewis acid-base interaction. Examples of groups that possess lone-pairs of electrons and can behave as complexing agents include but are not limited to a hydroxyl group, an ether, a thiol, a thioether, an amine, a mono- or
25 disubstituted amine, a phosphine, a mono- or disubstituted phosphine or a mixture thereof. Typically, the pendant ligand has a tether group (or "tether end"), but herein there are embodiments wherein the complexing group can direct bond to the binder/oxide adsorbent and/or catalyst system without a tether.

In another embodiment, the complexing group can be an unsaturated organic moiety. The unsaturated organic moiety can be but is not limited to a cyclic, acyclic or aromatic moiety. In one embodiment, the acyclic unsaturated organic moiety can include but is not limited to an olefin, an allyl, a diene, a triene or a mixture thereof. In yet another embodiment, the acyclic unsaturated organic moiety has the formula $-(CH=CH)_nCH=CH_2$, wherein n is from 1 to 5, preferably from 1 to 3.

In another embodiment, the complexing group can be a cyclic unsaturated organic moiety. Examples of cyclic unsaturated organic moieties include but are not limited to cyclopentadiene, cycloheptatriene, cyclooctadiene, cyclooctetraene or a mixture thereof.

In another embodiment, the complexing agent can be an aromatic unsaturated organic moiety. Examples of aromatic unsaturated organic moieties include but are not limited to benzene, naphthalene, anthracene or mixtures thereof.

The pendant ligand moiety can also have a tether end. The tether end connects the complexing group end of the ligand to the binder or oxide adsorbent and/or oxide catalyst particle. If no tether is present, the complexing group is directly attached to the binder or oxide adsorbent and/or oxide catalyst particle. The tether end can comprise an aliphatic group, an aromatic group, a silyl group, a siloxy group or a combination thereof or an oligomer or polymer thereof. The length of the tether end can vary depending upon the end-use. In one embodiment, the tether end can be an aliphatic or aromatic group that is from 1 to 20 carbons, preferably from 1 to 10 carbons, and even more preferably from 1 to 5 carbons. The tether end can be branched or unbranched and substituted or unsubstituted. In another embodiment, the tether end can be a silane, a polysiloxane, a mixed hydrocarbon-silane, a hydrocarbon-siloxane, or a mixture thereof.

In another embodiment, the invention relates to an anchored adsorbent and/or catalyst and binder system, comprising:

- (a) a pendant ligand substituted or unsubstituted binder, and

(b) a pendant ligand substituted or unsubstituted oxide adsorbent and/or oxide catalyst particle, and

(c) a metal complex,

wherein at least one of components (a) and (b) is pendant ligand substituted, wherein component (a) is cross-linked with component (b), and wherein the metal complex (c) is bound to component (a) and/or (b).

The pendant ligand substituted binder and oxide adsorbent and/or catalyst system described above can be incorporated with a metal complex. As discussed above, the pendant ligand possesses a complexing group which can bind to a metal complex (c). Examples of metal complexes that can be bound to the substituted binder and/or catalyst system include but are not limited to a metal salt, metal carbonyl complex, metal phosphine complex, metal amine complex, a metal hydride complex, a metal olefin complex, a metal acetylene complex, a metal polyene complex, a metal halide complex or a mixture thereof. In one embodiment, the metals that can be used in metal carbonyl complexes, metal phosphine complexes, metal amine complexes, metal olefin complexes, metal acetylene complexes, metal polyene complexes, and metal halide complexes include the transition, lanthanide and actinide metals.

In one embodiment, the metal salt can be a halide, a carbonate, an oxalate, a bicarbonate, or a carboxylate as the counterion and lithium, sodium, potassium, rubidium, cesium, francium, magnesium, calcium, strontium, barium, radon, the transition metals, the lanthanide metals or the actinide metals as the metal moiety.

In another embodiment, the metal carbonyl can be a mono-nuclear or poly-nuclear binary carbonyl of a transition metal. Examples of metal carbonyls useful in the present invention include but are not limited a mono-nuclear or poly-nuclear mixed carbonyl-phosphine, carbonyl-phosphite, carbonyl-olefin, carbonyl-acetylene, carbonyl-cyclopentadienyl complexes, carbonyl-hydride, or carbonyl-halide of a transition metal.

The substituted binder and oxide adsorbent and/or catalyst system can be used as a support system and bind to a metal complex, which acts as a second catalyst. In one embodiment, the second catalyst can be a homogeneous catalyst. A number of homogeneous catalysts are known in the art and are disclosed in Parshall, "Homogeneous Catalysis," 1980. Examples of homogeneous catalysts that can be anchored to the substituted binder and oxide adsorbent and/or catalyst system include but are not limited to a hydrogenation catalyst, an oxidation catalyst, a hydroformylation catalyst, a reduction catalyst, an isomerization catalyst, a polymerization, a carbonylation catalyst, a reforming catalyst, an olefin metathesis catalyst, a Fischer-Tropsch catalyst, a gasification catalyst or a mixture thereof.

In another embodiment, the invention relates to a method for producing a pendant ligand substituted adsorbent and/or catalyst system, comprising:

- (i) mixing components, comprising:
 - (a) a pendant ligand substituted or unsubstituted binder comprising a colloidal metal oxide or a colloidal metalloid oxide,
 - (b) a pendant ligand substituted or unsubstituted oxide adsorbent and/or oxide catalyst particle, and
 - (c) an acid,wherein at least one of components (a) and (b) is pendant ligand substituted, and
- (ii) removing a sufficient amount of water from the mixture to cross-link components (a) and (b) to form a pendant ligand substituted adsorbent and/or catalyst and binder system.

The method further comprises (iii) binding a metal complex onto the resulting system of step (ii) to form the anchored catalyst system.

The unsubstituted binder and unsubstituted oxide adsorbent and/or oxide catalyst particles of the present invention can be converted to the pendant ligand substituted analogs using techniques well known in the art and are disclosed in Eisen *et al.*, "Catalytic Activity

of Some Immobilized Dirhodium Complexes with One Bridging Thiolato and One Bridging Chloro Ligand" J. Mol. Catal. Vol. 43(2), pp 199-212, 1987; Cermak *et al.*, "Hydrogenation Catalytic Activity of Substituted Cyclopentadienyl Titanium Complexes Anchored on Polysiloxanes Prepared by a Sol-Gel Procedure," J. Organomet. Chem. Vol. 509(1), pp 77-84, 1996; Doi *et al.* "Metal Cluster Catalysis: Preparation and Catalytic Properties of Anionic Triruthenium Clusters Anchored to Functionalized Silica," Inorg. Chim. Acta, Vol 105(1), pp 69-73, 1985; Doi *et al.* "Metal Cluster Catalysis: Preparation and Catalytic Properties of a Tetraruthenium Cluster Anchored to Silica via Phosphine Ligands," J. Mol. Catal., Vol 19(3), pp 359-63, 1983, which are hereby incorporated by these references.

The reaction between the unsubstituted 1) binder and/or 2) oxide adsorbent and/or oxide catalyst particle and a hydroxyl-reactive compound produces the substituted binder and oxide adsorbent and/or oxide catalyst particle. In one embodiment, the unsubstituted binder reacts with a hydroxyl-reactive compound to produce a pendant ligand substituted binder. In another embodiment, the unsubstituted oxide adsorbent and/or oxide catalyst particle reacts with a hydroxyl-reactive compound to produce a pendant ligand substituted oxide adsorbent and/or oxide catalyst particle. In another embodiment, the unsubstituted binder and an unsubstituted oxide adsorbent and/or oxide catalyst particle react with a hydroxyl-reactive compound to produce a pendant ligand substituted binder and a pendant ligand substituted oxide adsorbent and/or oxide catalyst particle. The pendant ligand substituted binder and a pendant ligand substituted oxide adsorbent and/or oxide catalyst particle may have free hydroxyl groups that have not been substituted with the pendant ligand. Once the substituted binder and/or oxide adsorbent and/or catalyst particle have been prepared, they can be combined using the techniques described above for preparing the binder and oxide adsorbent and/or catalyst system.

The hydroxyl-reactive compound is any compound that is capable of reacting with the free hydroxyl groups of the unsubstituted binder and oxide adsorbent and/or oxide catalyst particle. The hydroxyl-reactive compound also possesses a complexing group and can have a tether end as described above. In one embodiment, the hydroxyl-reactive

compound can be an alkylating agent, an alcohol, a carboxylic acid, an organic ester, an organic anhydride, an organic tosylate, a trialkyloxonium cation, a silane, a silyl halide, a siloxy compound, an organic acid halide, an organic orthformate or a mixture thereof. In a preferred embodiment, the hydroxyl-reactive compound is an alkylating agent. In an even more preferred embodiment, the alkylating agent is an aliphatic or araliphatic halide. In one embodiment, the aliphatic or araliphatic group can be from 1 to 20 carbons, preferably from 1 to 10 carbons, and even more preferably from 1 to 5 carbons. The aliphatic and araliphatic groups can be branched or unbranched and substituted or unsubstituted. In another embodiment, a silylating agent can be used. Silylating agents useful in the present invention include but are not limited to alkyl and aryl silyl halides. In another embodiment, the silylating agent can be a silane, a polysiloxane, a mixed hydrocarbon-silane, a hydrocarbon-siloxane, or a mixture thereof.

Once the substituted binder and oxide adsorbent and/or catalyst system has been prepared, a metal complex can be bound, such as complexing, coordinating, chelating, bonding, to the resulting system. Techniques for incorporating or binding the metal complex in the support are disclosed in Gates, "Catalytic Materials," Chapter 12, pp 301-320, in "Materials Chemistry; An Emerging Discipline," Edited by Interrante, L. V.; Casper *et al.* in "Advances in Chemistry Series 245, American Chemical Society, Washington, D.C. 1995, which are hereby incorporated by these references. Examples of techniques used to incorporate the metal complex onto the support include but are not limited to vapor deposition, incipient wetness, aqueous impregnation or non-aqueous impregnation.

In another embodiment, the invention relates to a method for producing an adsorbent and/or catalyst and binder system comprising

- i) mixing components comprising
 - a) a binder comprising a colloidal metal oxide or colloidal metalloid oxide,
 - b) an oxide adsorbent and/or oxide catalyst particle, and
 - c) an acid,

- ii) removing a sufficient amount of water from the mixture to cross-link components a and b to form an adsorbent and/or catalyst and binder system.
- iii) reacting the resultant adsorbent and/or catalyst and binder system of step (ii) with a hydroxyl-reactive compound to form a pendant ligand substituted oxide adsorbent and/or oxide catalyst and binder system.

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Treatment of the unsubstituted binder and oxide adsorbent and/or catalyst system with the hydroxyl-reactive compound produces the pendant ligand substituted binder and oxide adsorbent and/or catalyst system. In one embodiment, the unsubstituted binder reacts with a hydroxyl-reactive compound to produce a pendant ligand substituted binder. In another embodiment, the unsubstituted oxide adsorbent and/or oxide catalyst particle reacts with a hydroxyl-reactive compound to produce a pendant ligand substituted oxide adsorbent and/or oxide catalyst particle. In another embodiment, the unsubstituted binder and an unsubstituted oxide adsorbent and/or oxide catalyst particle react with a hydroxyl-reactive compound to produce a pendant ligand substituted binder and a substituted oxide adsorbent and/or oxide catalyst particle.

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Once the pendant ligand substituted binder and oxide adsorbent and/or catalyst system has been prepared, a metal complex can be incorporated or bound onto the support using the techniques described above to produce an anchored catalyst system.

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In another aspect, the invention relates to an anchored adsorbent and/or catalyst and binder system, comprising:

- (a) a binder, and
- (b) an oxide adsorbent and/or oxide catalyst particle, and
- (c) a metal complex,

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wherein at least one of components (a) and (b) is pendant ligand substituted, wherein component (a) is cross-linked with component (b), and wherein the metal complex (c) is bound directly to component (a) and/or (b).

In still yet another aspect, the invention relates to a method for producing an anchored adsorbent and/or catalyst system, comprising:

- (i) mixing components, comprising:
 - (a) a binder comprising a colloidal metal oxide or a colloidal metalloid oxide,
 - 5 (b) an oxide adsorbent and/or oxide catalyst particle, and
 - (c) an acid,
- (ii) removing a sufficient amount of water from the mixture to cross-link components (a) and (b) to form a pendant ligand substituted adsorbent and/or catalyst and binder system, and
- 10 (iii) binding a metal complex directly onto the resulting system of step (ii) to form the anchored catalyst system.

In this embodiment of direct binding, the metal complex is bound directly to the (1) binder and/or (2) the oxide adsorbent and/or catalyst particle. The hydroxyl groups on the binder and the particle can behave as a complexing group as described above and can directly bind a metal complexes.

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EXPERIMENTAL

The following examples are put forth so as to provide those of ordinary skill in the art with a complete disclosure and description of how the compounds claimed herein are made and evaluated, and are intended to be purely exemplary of the invention and are not intended to limit the scope of what the inventors regard as their invention. Efforts have been made to ensure accuracy with respect to numbers (e.g., amounts, temperature, etc.) but some errors and deviations should be accounted for. Unless indicated otherwise, parts are parts by weight, and % is in weight %, temperature is in °C or is at room temperature and pressure is at or near atmospheric.

Example 1

Enhanced aluminum oxide was made by the process of this invention using the following steps:

i) Gamma aluminum oxide particles were produced by calcining $\text{Al}(\text{OH})_3$ at a temperature of 550-560°C to produce calcined Al_2O_3 of the gamma form.

ii) 20 liters of this aluminum oxide were submerged in a tank containing 0.5% by weight acetic acid in distilled water. The total volume of solution was 98.7 liters. The alumina was allowed to sit in the acid solution for approximately 15 minutes to allow saturation of the solution. The acid solution was drained off and the remaining alumina was rinsed in a tank of 30 liters of distilled water. The distilled water was drained and the remaining alumina was dried at a temperature of 121°C for 90 minutes.

The performance of enhanced aluminum oxide particles of this invention was tested. Two chromatographic columns, each 25 cm. long and 1 cm. inner diameter, equipped with a solvent reservoir were used for this experiment. Each column was packed with 20 cc of the above produced enhanced aluminum oxide particles. Each column was flushed with 100 ml of water using pressure from the nitrogen cylinder to obtain a flow rate

of approximately 20 ml per minute. A test solution of approximately 200 ppb of lead was prepared using lead acetate trihydrate. A total of 200 ml (10 bed volumes) of test solution was passed through each column using the same flow rate. The influent, the total effluent from the 10 bed volumes, and the effluent sample collected during the tenth bed volume were analyzed for lead, and the results are summarized in Table 1.

TABLE 1		
TEST NUMBER	STREAM TESTED	TOTAL LEAD* ($\mu\text{gm/liter}$)
1	Influent	211
	Total effluent	< 5
	Effluent end (10th bed volume)	< 5
2	Influent	229
	Total effluent	< 5
	Effluent end (10th bed volume)	< 5

*Lower limit of lead detection was 5 $\mu\text{gm/liter}$.

This particle was also tested using the TCLP method (EPA method # 6010), and the particle of the invention passed the TCLP test for lead.

Example 2

A comparison was made between acid enhanced alumina of this invention and non-acid-treated alumina for removing lead. Both aluminum oxide particles were calcined at 550°C prior to the experiment. Enhanced gamma aluminum oxide particles of the present invention were made according to the procedures of Example 1. Two identical five gallon containers were filled with the alumina oxide for lead removal. One container was filled with 16 liters of the treated alumina of this invention. The other was filled with 16 liters of untreated alumina. Two tanks were prepared each containing 100 gallons of lead acetate tri-hydrate spiked distilled water. The tanks were mixed thoroughly for 30 minutes. After 30 minutes of mixing, the concentrations of the lead in the water were determined. The lead containing water from each tank was passed through the containers of alumina. a total of 80 gallons of spiked water (19 bed volumes) were passed through each of the containers

at a flow rate of 62 gallons per minute. An effluent water sample was taken on the 19th bed volume and was analyzed for total lead. The percent reductions were then calculated. The results of the tests are set forth in Table 2 below.

TABLE 2			
PARTICLE Calcined @ 550° C before acid treated	INITIAL LEAD CONCENTRATION (mg/l)	EFFLUENT CONCENTRATION AFTER CONTACTING PARTICLE (mg/l)	PERCENT REDUCTION OF LEAD (%)
Non-acid-treated aluminum oxide	1.24	0.58	53
Acid treated aluminum oxide of the invention	1.44	0.39	73

Example 3

a comparison was made between treated alumina of this invention and non-treated alumina for removing phosphate. Chi-rho aluminum oxide particles were produced by calcining $\text{Al}(\text{OH})_3$ at a particle temperature of 480-520°C. Enhanced chi-rho aluminum oxide particles of the present invention were acid treated according to the procedure of step (ii) in Example 1. The performance of the particles was measured using the same procedures of Example 1, except that one chromatographic column was filled with 20 cc of the treated alumina and the other column was filled with 20 cc of the untreated alumina and the test solution was 9.3 mg/l of KH_2PO_4 , and the results are summarized in Table 3.

TABLE 3			
PARTICLE Calcined @ 480° C before acid treated	INITIAL PHOSPHATE CONCENTRATION (mg/l)	EFFLUENT CONCENTRATION AFTER CONTACTING PARTICLE (mg/l)	PERCENT REDUCTION OF PHOSPHATE (%)
Non-acid treated aluminum oxide	9.3	0.16	98.3
Acid reated aluminum oxide of the invention	9.3	0.04	99.6

This particle of this invention from the experiment was also tested using the TCLP method (EPA method # 1311), and the particle of the invention passed the TCLP test for phosphate.

Example 4

The ability of the particle of this invention to remove selenium was tested. Acid enhanced gamma aluminum oxide particles (100% Al_2O_3) were made by the procedure of Example 1.

5 columns were prepared using 0.875" I.D. x 12" long glass columns, each with a bed volume of ~95 mls of the above acid enhanced Al_2O_3 particles of this invention of various particle sizes, ranging from 500 μm to 4,000 μm . Each bed was flushed with ~5 bed volumes of D.I. water by downward pumping at 5-6 gpm/ft^2 cross sectional flow rate (*i.e.*, ~95 ml/min). a test solution was prepared with a calculated 1.5 mg/L selenium concentration. a total of ~10 bed volumes (*i.e.*, ~1 L per column) test solution was pumped through each column using the same flow rate. During the test, the test solution was continuously stirred at a low speed. During the tenth bed volume, an effluent sample

from each column was collected and analyzed for selenium. Also a single influent sample was collected and analyzed for selenium. The results are set forth below.

TABLE 4	
Sample I.D. (particle size μm)	Total Selenium ^a mg/L
Influent	1.45
606 EFF (4,000 μm)	0.101
404 EFF (1,000 μm)	0.073
303 EFF (2,000 μm)	0.477
202 EFF (500 μm)	0.003 ^b
101 EFF (3,300 μm)	0.121

^a = Selenium detection limit was 0.002 mg/l

^b = Estimated value, less than calibration limit

Example 5

a combination particle of this invention was made and tested for its ability to remove trichloroethylene (TCE). 70 g of acid enhanced gamma aluminum oxide particles made by the procedure of Example 1 were mixed with 20 g of colloidal alumina, 5 g of MnO_2 , and 5 g of CuO until the mixture was homogeneous. The particle mixture was then mixed with 5% acetic acid solution until the mixture reached a suitable consistency for agglomeration. The mixture was extruded and cut into a particle size of about 1,000 μm and heated to 150°C for 15 minutes to crosslink the colloidal alumina.

The particle as formed above was tested for its ability to remove TCE from water. Particles of the invention were challenged with various concentrations of TCE in water as indicated in Table 1. Two custom made columns (40 cm X 20 mm) equipped with coarse glass frits were dried packed with 10 mL volumes (measured with a 10 mL graduated

cylinder) of particles. The columns were challenged with five 10 mL aliquots (5 bed volumes) of the TCE solution. The fifth bed volume from each column was collected in a 50 mL Erlenmeyer flask, stoppered, and immediately analyzed by purge and trap-GC/MS technique using a Finnigan MAT Magnum ion trap GC/MS equipped with a Tekmar liquid sample concentrator (LSC 2000). The results are summarized in Table 5.

TABLE 5		
Sorbate	Trichloroethylene concentration	
	Influent (ppm)	Effluent (ppb)
TCE in water	1.0	<50

Example 6

TCE adsorption and TCLP extraction procedures were performed as follows. a 20.0114-gram (about 24.50 mL bed volume) sample of the $\text{Al}_2\text{O}_3/\text{CuO}/\text{MnO}_2$ combination particle of Example 5 (designated as 0307595TCE1) after treatment with TCE was wet packed into a 50-mL buret (with removable stopcock) plugged with glass wool. The sample was charged with five bed volumes of water. The sorbent material was then quantitatively transferred into the Zero Headspace Extractor (ZHE) apparatus into which 200 mL of water was added, appropriately sealed and agitated for 18 hours. The filtered solution was collected in two 100 mL vials, stored in the refrigerator at 4°C until analysis by GC/MS. The Finnigan MAT Magnum ion trap GC/MS equipped with a Tekmar liquid sample concentrator (LSC 2000) was used for analysis.

The calibration curve procedure was as follows. a freshly prepared 50 ppm TCE stock solution was obtained by dissolving 34.2 μL spectrophotometric grade TCE (Aldrich) in 20 mL HPLC grade methanol (Fisher) followed by dilution to a liter. Dilution of this solution (1000 μL : 1L) resulted in a 50 ppb TCE stock solution. All dilutions were accomplished using deionized water. a calibration curve was constructed by purging 1.0, 0.50, 0.20, 0.10, and 0.050 ppb TCE solutions.

The results are set forth below.

TABLE 6		
Sorbent Sample	TCE found, ppb	TCE Detection limit, ppb
0307595TCE1	Nd ^a	0.0050

^a = Not detected. The fact that TCE in the sample is less than 500 ppb (EPA TCLP limit) characterizes it as a nonhazardous waste with respect to TCE.

Example 7

a 100 ml. portion of 1000 ppm phosphorous (potassium hydrogen phosphate and water) standard (Lab Chem, Inc.) was diluted to 2 litres. Aliquots (200 ml) of the resulting stock solution containing 50 ppm phosphorous were tumbled for 24 h with duplicate approximately 2 ml (dry) volumes (both volumes and mass measured) of each alumina sample, and centrifuged. Acid enhanced gamma alumina oxide particles of samples Pb1k (CU), and Polk (CT) and acid enhanced chi-rho alumina oxide particles Pb1k (AU) and Pohk (At) were made by procedures of Example 1 except that the starting alumina "type" is different as shown in Table 7, and that the calcining temperatures were different for the four samples as shown in Table 7 below. These materials were challenged to determine the capacity of the alumina to remove phosphate (PO_4^{3-}) given the variables in starting materials and treatment. Aliquots (0.4 ml) of the supernatant were diluted to 20 ml. To each of these solutions was added, with shaking, 2 drops phenolphthalein (Fisher), followed by 1 ml of ammonium molybdate reagent I and then 2 drops of stannous chloride reagent I (LabChem Inc.). Determination of aqueous phosphate was achieved by the measurement of color, photometrically at 690 nm (path length, 0.5 cm) in a quartz cell and read in a Shimadzu UV-2101PC, UV/VIS scanning spectrophotometer. All dilutions were accomplished using deionized water. The results are set forth below.

TABLE 7								
ID#	Starting Material	Calcining Temp. (time)	Wash Treatent After heat treatment	Pore Area M ² /gram	Median Pore Diameter (Vol) μm :	Median Pore Diameter (Area) μm :	Average Pore (4V/a) μm	Capacity PO ₄ ⁻³ g/Kg BULK
Pbhk (AU)	Boehmite	400° C (60 min)	0.5 % Acetic Acid 15 min	23	102	0.0088	0.11	13.56
Pohk (AT)	Boehmite	475° C (60 min)	0.5 % Acetic Acid 15 min	14	90	0.0078	0.079	14.47
Pblk (CU)	Scale Alumina (Bayerite)	500° C (60 min)	0.5 % Acetic Acid 15 min	7	93	0.0146	0.2591	11.56
Polk(CT)	Scale Alumina (Bayerite)	550° C (60 min)	0.5 % Acetic Acid 15 min	6.3	69	0.075	0.12	10.93

Example 8

Acid enhanced gamma alumina oxide particles of samples Pbhk (AU), Pohk (At), Pblk(CU), and Polk(CU) were made by procedures of Example 7. These materials were challenged to determine the capacity of the alumina to remove lead (Pb⁺⁺) given the variables in starting materials and treatment. A 500 ml portion of 400ppm of lead (0.6392 g Pb(NO₃)₂ dissolved in 10ml concentrated nitric acid and diluted to one liter with deionized water) was diluted to two liters with deionized water. Aliquots (450ml) of the resulting stock solution containing 50 ppm Pb, were tumbled for 24h with approximately 2ml (dry) volumes (both volume and mass measured) of each alumina sample, centrifuged,

and stored prior to GFAA analysis. The instrument used was a Shimadzu AA-6501F atomic absorption spectrophotometer. The results are shown below.

TABLE 8	
ID#	Capacity Pb ⁺⁺ , g/K BULK
Pbhk (AU)	1.9
Pohk (AT)	1.7
Pblk (CU)	3.0
Polk(CT)	1.3

Example 9

Acid enhanced gamma alumina oxide particles of samples Pbhk (AU), Pohk (AT), Pblk(CU), and Polk (CT) were made by procedures of Example 7. These materials were challenged to determine the capacity of the alumina to remove arsenic(AsO_3^{-2}) given the variables in starting materials and treatment. A 200 ml portion of 1000 ppm of arsenic (arsenic trioxide in 10% nitric acid) standard (Fisher SA449-500) diluted to 4 liters with deionized water was used. Aliquots (450 ml) of the resulting stock solution containing 50 ppm As, were tumbled for 24 h with duplicate approximately 2 ml (dry) volumes (both volume and mass measured) of each alumina sample, centrifuged, and stored prior to GFAA analysis. The instrument used was a Shimadzu AA-6501F atomic absorption spectrophotometer. The results are shown below.

TABLE 9	
ID#	Capacity As as AsO_3^{-2} g/Kg, BULK
Pbhk (AU)	11.9
Pohk (AT)	10.6
Pblk (CU)	8.9
Polk(CT)	8.1

Example 10

In a large scale test a 2,300 gallon tank was filled with approximately 2,000 gallons of tap water and 147.8 g of $\text{Pb}(\text{OAc})_2 \cdot 3\text{H}_2\text{O}$ was added, the pH was adjusted to 6.7, and the tank was sampled and found to be 8,750 ppb in Pb^{++} . A canister was filled with 19.6 Kg of Polk (CT) as described in Example 7. The lead spiked water from the tank was pumped through the canister at a rate of 1.5 gallons per min. to remove the lead. Samples of the effluent were collected after each 250 gallons and the lead concentration was determined and plotted as shown in Figure 1. The tank was refilled with another approximately 2,000 gallons of tap water and 147.8 g of $\text{Pb}(\text{OAc})_2 \cdot 3\text{H}_2\text{O}$ was added to give a 9,160 ppb solution. The pH was adjusted to 7.00 and the spiked solution was pumped through the same canister at a flow rate at 1.5 gallons per min. Samples of the effluent were collected after each 250 gallons and the lead concentration was determined and plotted as shown in Figure 1. Samples lead concentration for samples obtained at 2,000 - 3,500 were found to be below the detection limit of 0.2 ppb. The lead removal capacity of Polk (CT) was determined in this test to be 6 g/Kg.

Example 11

Various adsorbent and/or catalytic binder systems as set forth in Table 10 in Example 12 below were made in accordance with the general procedures of this invention as follows as well as various systems not a part of the invention.

The binder and adsorbent and/or catalytic particles were combined into a mixing vessel, the amount of each varied according to the size batch desired. However, the component ratios remained constant as indicated in Table 10 below. This "dry" combination was pre-mixed to ensure a homogenous mixture of all of the components. After this was accomplished, a solution containing 5% acetic acid in distilled water was added to the mixture. The amount of the acid compared to the other components varied depending on extruding parameters and other processing variables, but for the procedures herein the range was typically between 35 and 45 wt. % of the total mixture.

This solution was added to the dry materials and mixed until the material had a homogenous "modeling clay" like consistency. The mixing was performed utilizing a Hobart "A-300" mixer. The material was then ready for extrusion. The mixed product containing the acetic acid solution was fed through an extruder, such as a DGL-1 dome granulator manufactured by LCI Corporation of Charlotte, N.C., U.S.A. The extrudates were fed through a QJ-230 marumarizer, also manufactured by LCI Corporation, which turned the extrudates as "Rods" into small spheres. The extruding and marumarizing steps provided a finished product suitable to use for a specific application. However, the marumarizing is optional and does not alter the performance of the product. After the spheres were made, the product was transferred to a drying oven where it was dried for one (1) hour at a temperature of 250° Celsius. The product was then ready for use in an application.

Example 12

The particles as formed of the constituents listed below in Table 10 were tested for their ability to remove TCE. Adsorbent and/or catalyst and binder systems of Table 10 were challenged with various concentrations of TCE as indicated in Table 10. Two custom
5 made columns (40 cm X 20 mm) equipped with coarse glass frits were dried packed with 10 mL volumes (measured with a 10 mL graduated cylinder) of particles. The columns were challenged with five 10 mL aliquots (5 bed volumes) of the trichloroethylene (TCE) solution. The fifth bed volume from each column was collected in a 50 mL Erlenmeyer flask, stoppered, and immediately analyzed by purge and trap-GC/MS technique using a
10 Finnigan MAT Magnum ion trap GC/MS equipped with a Tekmar liquid sample concentrator (LSC 2000).

The particles in Table 10 were prepared as described in Example 11. The percent composition of each component as well as the nature of the binder are presented in Table
15 10. Prior to mixing with the other components, the aluminum oxide particle was first calcined at 500°C or 550°C as indicated in Table 10, then acid treated by substantially contacting with 0.5% acetic acid at room temperature for 15 minutes as generally set forth in applicants' copending application filed on even date entitled "Acid Contacted Enhanced
20 Adsorbent Particle and Method of making and Using Therefor" and as set forth in the parent applications to that application as listed above, and then dried at 121°C for 90 minutes.

The removal of TCE from aqueous solution was investigated using a number of adsorbent and/or catalyst and binder systems of the present invention, and these results are
25 summarized in Table 10. In Entry 8, 99% reduction of TCE was observed when the particle consisted of 40% CuO, 40% MnO₂, and 20% colloidal alumina as the binder. When no binder was used, however, the CuO/MnO₂ particle removed only 0-1% of TCE (Entries 9A 9B). These results indicate the necessity of the binder material to enhance or provide adsorbent and/or catalytic properties of or to the particle. Other particles demonstrated the
30 ability to remove TCE. For example, entry 1 removed > 95% of TCE. Entry 7 removed

99% of TCE. The particle of entry 7 had two adsorbent and/or catalyst particles, one of which was carbon. Carbon was also used in conjunction with multiple metal oxide components (Entry 24A and B) to remove TCE (>90%).

Although Entry 3 removed 96% of TCE, the PVP binder does not hold the particle together as long as the binders of the present invention. Particles with the PVP binder disintegrated over time, which reduced the usefulness of the particle. In the case of Entries 5A, 5B and 6, TCE removal was very high (98%); however, the activated peat also breaks apart much faster than the particles of the present invention. The contaminants adsorbed by the peat may also leach into the environment.

Not wishing to be bound by theory, two plausible mechanisms can account for the catalytic degradation of TCE using the particles of the present invention. The first mechanism involves redox chemistry between TCE and the metal oxide components of the particle. TCE is electrophilic, and can stabilize a negative charge if reduced. Electron transfer from a metal oxide component to TCE may be the first step toward the degradation of TCE. A second mechanism involves a Lewis acid-base interaction between TCE and the metal oxide component, which increases the rate of nucleophilic attack of TCE by water. Due to the lone pair electrons on the chlorine groups of TCE, a metal oxide component can initially coordinate to the chlorine group. This initial coordination may also be the first step toward the catalytic degradation of TCE.

Table 10										
Entry	Binder (Wt %)	Drying/ Crosslinking temperature °C (time min)	Al ₂ O ₃ wt% (Calcining temperature, °C), Acid treated	CuO (Wt %)	MnO ₂ (Wt%)	Other Component(s) (wt %)	TCE influent concentration Run A	TCE effluent concentration 5th bed volume (% reduction) Run A	TCE influent concentration Run B	TCE effluent concentration 5th bed volume (% reduction) Run B
1	V-900 (20)	150 (15)	70 (550)	5	5		1.0 ppm	< 50 ppb (>95%)		
2	PVP (3.2)	150 (30)	91.3 (550)	2.5	2.5	MethylCellulose (0.5)	50.0 ppm	29.4 ppm (59)	5.0 ppm	0.5 ppm (90)
3	PVP (3.2)	150 (30)	91.3 (550)	2.5	2.5	MethylCellulose (0.5)	5.0 ppb	0.20 ppb (96)		
4		NA				Zeolite (100)	rejected*			
5		NA				Acid treated Peat (100)	50.0 ppm	1.0 ppm (98)	5.0 ppm	0.1 ppb (98)
6		NA				Acid treated Peat (100)	5.0 ppb	0.07 ppb (98)		
7	V-900 (20)	250 (60)	40 (500)			WPH Carbon (40)	5.0 ppb	0.06 ppb (99)		
8	V-900 (20)	250 (60)		40	40		5.0 ppb	0.07 ppb (99)		
9		250 (60)		50	50		50.0 ppb	50.4 ppb (0)	50.0 ppm	49.6 ppm (1)
10	V-900 (20)	250 (60)	60 (500)	10	10		50 ppm	39.5 ppm (21)	50.0 ppb	39.9 ppm (20)
11	V-900 (20)	250 (60)	70 (500)	5	5		50.0 ppm	39.3 ppm (21)	50.0 ppb	45.8 ppm (8)
12	V-900 (20)	250 (60)		10	10	Zeolite (60)	50.0 ppm	37.2 ppm (26)	50.0 ppb	41.0 ppb (18)
13		250 (60)	100 (550)				50.0 ppm	21.2 ppm (58)	50.0 ppb	34.0 ppb (32)
14	V-900 (20) PVP (3)	250 (60)	67 (550)	5	5		rejected**			
15	V-900 (20) PVP (3)	250 (60)	71.6 (550)	2.5	2.5	MethylCellulose (0.4)	rejected**			
16	V-900 (17)	250 (60)	13.6 (550)	1.7	1.7	Tin (66)	rejected**			
17	V-900 (13.6)	250 (60)	17 (550)	1.7	1.7	Zinc (66)	rejected**			
18	V-900 (13.6)	250 (60)	17 (550)	1.7	1.7		50.0 ppm	42.8 ppm (14)	50.0 ppb	44.4 ppb (11)
19	V-900 (20)	250 (60)	17 (550)	1.7	1.7	Tin (66)	50.0 ppm	36.3 ppm (27)	50.0 ppb	41.9 ppb (16)
20	V-900 (20)	250 (60)	17 (550)	1.7	1.7	Zinc (59.6)	50.0 ppm	27.8 ppm (44)	50.0 ppb	27.0 ppb (46)
21	V-900 (20)	250 (60)	70 (550)	5	5		50.0 ppm	24.8 ppm (50)	50.0 ppb	17.5 ppb (65)
22	V-900 (20)	550 (60)	70 (550)	5	5#		50.0 ppm	42.7 ppm (15)	50.0 ppb	20.3 ppb (59)
23		NA				WPH Carbon (100)	rejected*			
24	V-900 (19.9)	250 (60)	59.7 (550)	5.98	4.98	WPH Carbon (9.95) Avicel Cellulose (0.5)	50.0 ppm	<5.0 ppm (>90)	50.0 ppb	3.9 ppb (92)
25	Sol P2 (20)	250 (60)	70 (550)	5	5		50.0 ppm	5.8 ppm (88)	50.0 ppb	11.3 ppb (77)

* sample did not allow water flow

** particle fell apart upon use

PVP = GAF PVP K-60 Polyvinylpyrrolidone

V-900 = LaRoche V-900 gel alumina (colloidal alumina)

Sol P2 = Condea Disperal Sol P2 (colloidal alumina) Zeolite = Zeolyst international CBV 100 CuO = Fisher C472 MnO₂ = Kerr-McGee KM[®] Electrolytic Manganese Dioxide 92 % MnO₂ X-ray powder diffraction studies indicate this to be a mixture of manganese oxides.

Tin = Fisher T128 Zinc = Fisher Z16

MethylCellulose = Fisher M352 WHP Carbon = Calgon WPH powdered activate carbon # particle heated to 550°C in air to convert MnO₂ to Mn₂O₃

NA = not applicable

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Example 13

Various adsorbent and/or catalyst and binder systems of Table 11 were prepared according to the procedures of Examples 11 and Example 12 (aluminum oxide preparation). Samples were tested to determine if they reacted with hydrogen sulfide at room temperature. Hydrogen sulfide was generated by treating sodium sulfide with sulfuric acid and vacuum transferred into an IR cell which had been loaded with 1.00 g of adsorbent and/or catalyst binder system to be tested. The IR cell used was 9 cm long by 4 cm in diameter (~120 mL volume). The cell was filled to approximately 170 torr H_2S and observed visually and IR spectra recorded.

The percent composition of each component as well as the nature of the binder are presented in Table 11. The aluminum oxide particle was first calcined at 550°, then acid treated using 0.5% acetic acid and dried at 121°C for 90 minutes using the same procedure described in Example 12. The cross-linking temperature for each particle was 250°C for 1 hour.

The removal of hydrogen sulfide using the adsorbent and/or catalyst and binder systems of the present invention was investigated, and these results are summarized in Table 11. The removal of hydrogen sulfide by the adsorbent and/or catalyst binder systems was monitored by infrared spectroscopy. Based on these results, adsorbent and/or catalyst and binder systems of colloidal aluminum binder, acid treated aluminum oxide, and copper oxide provided the best results with regards to the removal of hydrogen sulfide.

Table 11							
Entry	Binder (Wt %)	Al ₂ O ₃ wt%	ZnO wt %	CuO wt %	Length of Experiment to Remove H ₂ S	H ₂ S reacted	Comments
1	V-900 (40)	50	10		16 h	Yes	Virtually all absorbed as determined IR
2	V-900 (50)	40	10		24 h	Yes	Virtually all absorbed as determined IR
3	V-900 (60)	30	10		42 h	Yes	Discoloration observed after 4 h Virtually all absorbed as determined IR
4	V-900 (20)	60	10	10	24 h	Yes	Virtually all absorbed as determined IR
5	V-900 (20)	60	20		2 h	Yes	Discoloration observed after 2 h Virtually all absorbed as determined IR
6	V-900 (25)	70		5	2 h	Yes	Discoloration observed after 2 h Virtually all absorbed as determined IR
7	V-900 (38)	60		2	3 h	Yes	Discoloration observed after 3 h Virtually all absorbed as determined IR
8	V-900 (30)	50		20	1.5 h	Yes	Discoloration observed after 1.5 h Virtually all absorbed as determined IR
9	V-900 (30)	20		50	16.5 h	Yes very slowly	Very slow little change after 2 h
10	V-900 (30)	69		1	4 h	Yes	Discoloration observed after 2 h Virtually all absorbed as determined IR

Al₂O₃ = calcined at 550°C and then acid treated

V-900 = LaRoach V-900 gel alumina (colloidal alumina)

Example 14

TCE adsorption and TCLP extraction procedures were performed as follows. A 20.0114-gram (about 24.50 mL bed volume) sample of the colloidal alumina and $\text{Al}_2\text{O}_3/\text{CuO}/\text{MnO}_2$ combination particle of Table 11, entry 1, after treatment with TCE was wet packed into a 50-mL buret (with removable stopcock) plugged with glass wool. The sample was charged with five bed volumes of water. The sorbent material was then quantitatively transferred into the Zero Headspace Extractor (ZHE) apparatus into which 200 mL of water was added, appropriately sealed and agitated for 18 hours. The filtered solution was collected in two 100 mL vials, stored in the refrigerator at 4°C until analysis by GC/MS. The Finnigan MAT Magnum ion trap GC/MS equipped with a Tekmar liquid sample concentrator (LSC 2000) was used for analysis.

The calibration curve procedure was as follows. A freshly prepared 50 ppm TCE stock solution was obtained by dissolving 34.2 μL spectrophotometric grade TCE (Aldrich) in 20 mL HPLC grade methanol (Fisher) followed by dilution to a liter. Dilution of this solution (1000 μL : 1L) resulted in a 50 ppb TCE stock solution. All dilutions were accomplished using deionized water. A calibration curve was constructed by purging 1.0, 0.50, 0.20, 0.10, and 0.050 ppb TCE solutions.

The results are set forth below in Table 12.

Table 12		
Sorbent Sample	TCE found, ppb	TCE Detection limit, ppb
Table 11, entry 1	Nd ^a	0.0050

^a = Not detected. The fact that TCE in the sample is less than 500 ppb (EPA TCLP limit) characterizes it as a nonhazardous waste with respect to TCE.

Example 15

Adsorbent and/or catalyst and catalyst supports were prepared as described in Example 11 utilizing Bayerite alumina (calcined 550° C for 1 hr, then treated with 0.5% acetic acid for 15 min), 25% by weight colloidal alumina, using 7 % HNO₃, 1 hour curing time, extruded and cured at temperatures of 300°, 350°, 400°, 450°, 500°, 550°, 600°, and 650°. Table 13 gives the curing temperature and properties of these materials determined by BET surface area measurements, mercury porosimetry and thermal gravimetric analysis.

Example 16

Various adsorbent and/or catalyst and catalyst supports were formed as described in Example 11 utilizing Bayerite alumina (calcined 550° C for 1 hr, then treated with 0.5% Acetic Acid for 15 min.), 25% colloidal alumina, using 7 % acetic acid, 1 hour curing time, extruded and cured at temperatures of 300°, 350°, 400°, 450°, 500°, and 600°. Table 14 give the curing temperature and properties of these materials

determined by BET surface area measurements, mercury porosimetry and thermal gravimetric analysis.

Figure 2 gives the surface area of Alumina-Alumina composites prepared as described in Experiment 15 and 16 as a function of curing temperature. Figure 2 also gives the surface area the particle upon curing for 7 hours and 14 hours). In addition, Figure 2 gives the surface area of Alumina-Alumina composites prepared as described in Experiments 15 and 16, upon curing for 2 hours and 4 hours at 350° C.

The data in Tables 13 and 14 and Figure 2 indicate how the surface area, surface morphology and acid properties (Lewis vs Bronsted sites) can be controlled by this invention. The surface area, pore area, bulk density, skeletal density, porosity, and acid properties obtained are dependent upon curing time and curing temperature.

TABLE 13

Characterization of Alumina-Alumina Composite

Starting Material: Bayerite (calcined 550° C for 1 hr, then treated with 0.5% acetic acid for 15 min.)

% Binder: 25 weight %

Curing Temperature: Variable

Curing Time: 1Hr

Acid Type (concentration): HNO₃ (7 %)

Curing Temp. °C	BET Surface Area m ² /g	BET Pore Volume cc/g	Pore Area M ² /gram	Median Pore Diameter (Vol) μm:	Median Pore Diameter (Area) μm:	Average Pore (4V/A) μm	Bulk Density g/mL	Skeletal Density g/mL	Porosity %	TGA % Wt Loss 25-250	TGA % Wt Loss 250-700
300	244.2	0.1743	105.8	0.4074	0.0040	0.0127	1.35	2.45	45.08	4.2	8.4
350	249.9	0.1786								2.9	6.6
400	258.0	0.1858	149.1	0.2380	0.0043	0.0110	1.28	2.70	52.62	3.2	4.1
450	243.4	0.1780	194.1	0.0467	0.0039	0.0092	1.270	2.95	56.93	2.3	2.4
500	215.7	0.1587	197.9	0.0163	0.0048	0.0101	1.201	3.05	60.50	3.5	1.2
550	192.0	0.1414								3.8	0.6
600	171.4	0.1263	219.2	0.0251	0.0040	0.0092	1.19	2.980	59.95	2.2	0.4
650	158.1	0.1165								3.2	0.2

TABLE 14

Characterization of Alumina-Alumina Composite

Starting Material: Bayerite (calcined 550° C for 1 hr, then treated with 0.5% acetic acid for 15 min.)

% Binder: 25 weight %

Curing Temperature: Variable

Curing Time: 1Hr

Acid Type (concentration): HOAc (7 %)

Curing Temp. °C	BET Surface Area m ² /g	BET Pore Volume cc/g	Pore Area M ² /gram	Median Pore Diameter r (Vol) µm:	Median Pore Diameter (Area) µm:	Average Pore (4V/A) µm	Bulk Density	Skeletal Density	Porosity	TGA % Wt Loss 25-250	TGA % Wt Loss 250-700
300	274.1	0.1919	48.8	1.60	0.0039	0.0257	1.31	2.21	41.00	2.8	8.5
350	303.2	0.2132								1.3	6.2
400	316.2	0.2241	97.4	1.53	0.0036	0.0160	1.27	2.50	49.27	2.2	4.7
450	298.4	0.2160	170.2	0.946	0.0037	0.0113	1.15	2.66	55.26	1.7	2.2
500	259.9	0.1909	213.2	0.72	0.0038	0.0104	1.11	2.87	61.33	2.0	1.0
600	202.2	0.1419	203.8	0.30	0.0044	0.0109	1.15	3.20	64.07	2.0	0.0

Example 17

A CuO/MnO₂/Al₂O₃-colloidal Al₂O₃ binder 5/5/70/20 weight % catalyst was prepared as described in Example 11. The catalyst (0.933 g) was loaded into a "U-tube" flow reactor, was attached to a gas cylinder with a synthetic mixture of 60 ppm of CO, and 0.6 % pentane in air. The CO/pentane/air mixture was passed over that catalyst with a flow rate of 80 mL/min. Figure 3 gives a plot of CO concentration and temperature vs time. The data indicate that there is an induction period, after which the catalyst oxidizes CO at room temperature.

Experiment 18

A CuO/Ga₂O₃/Al₂O₃-colloidal Al₂O₃ binder 5/5/70/20 weight % catalyst was prepared as described in Example 11. The catalyst (1.007 g) was loaded into a "U-tube" flow reactor, was attached to a gas cylinder with a synthetic mixture of 81 ppm of NO, 910 ppm CO in nitrogen. The NO/CO/nitrogen mixture was passed over that catalyst at a flow rate of 80 mL/min. Figure 4 gives a light-off curve determined under these conditions.

Experiment 19

Runoff water was pumped through a 5-gallon canister of aluminum oxide that was calcined at 550° C for 2.5 hours then acid washed with a 0.5% solution of acetic acid. The water flow rate was approximately 1 gpm. The pH was 8.5. After 24 hours or the equivalent of approximately 1,440 gallons of contaminated water the effluent was tested for uranium, and the results are in Table 15.

TABLE 15					
	U ₃ O ₈	TDS	SO ₄ ⁻	Se	Mo
influent concentration (mg/L)	50.5	15720	7609	2.04	65.44
effluent concentration (mg/L)	0.08	---	---	---	---

Example 20

A particle with the following composition was prepared in a manner similar to Example 13 in order to test its efficiency in removing chlorinated hydrocarbons from a ground water source: 60% Al₂O₃ (Acid enhanced alumina), 5% CuO, 10% MOLECULITE®, 20% alumina binder (colloidal alumina) and 10% carbon. A partial groundwater profile contained the following contaminants at pH 6.7:

1,1-Dichloroethene	7,100ppb
Acetone	40,000
Methylene Chloride	90,000
1,1-Dichloroethane	1100
1,1,1-Trichloroethane	27,000
Trichloroethene	830
Toluene	1100
Tetrachloroethene	1400

Thirty three gallons of the binder and catalyst system was placed into a 55gallon drum. The groundwater was pumped through the media at a rate of 4 gpm. The effluent was

analyzed for volatile organics after pumping 40,320 and 70,000 gallons of the groundwater. The results are shown in Table 16.

TABLE 16				
contaminant	effluent concentration at 43,100 gallons (ppb)	% reduction	effluent concentration at 70,000 gallons (ppb)	% reduction
1,1,1- trichloroethane	1280	95	3819	86
trichloroethene	ND	100	10	99
tetrachloroethene	6	99.6	42	97

These results demonstrate that the level of chlorinated hydrocarbons in the groundwater were reduced significantly when the groundwater was contacted with the binder and catalyst system.

Example 21

Using the identical binder catalyst system in Example 20, the removal of tetrachloroethene from ground water was investigated. A 55-gallon drum was filled with 36 gallons of the binder catalyst system. The contaminated water was pumped from three wells through the media at a combined flow rate of approximately 4gpm. The pH of the ground water was 6.5. Approximately 90,000 gallons of contaminated water had been pumped through the binder catalyst system. The results of the experiment are shown in Table 17.

TABLE 17					
contaminant	influent concentration	effluent concentration at 43,100 gallons (ppb)	% reduction	effluent concentration at 72,679 gallons (ppb)	% reduction
cis-1,2-dichloroethene	160	130	19	310	-93.7
2-butanone	48	ND	100	ND	100
trichloroethene	130	---	---	ND	100
tetrachloroethene	7900	---	---	120	98.5

The increase in concentration of cis-1, 2-dichloroethene is a result of and an indication of the degradation of tetrachloroethene. Cis-1,2-dichloroethene is an intermediate product of the degradation of tetrachloroethene, which is a non-hazardous waste material.

Throughout this application, various publications are referenced. The disclosures of these publications in their entireties are hereby incorporated by reference into this application in order to more fully describe the state of the art to which this invention pertains.

It will be apparent to those skilled in the art that various modifications and variations can be made in the present invention without departing from the scope or spirit of the invention. Other embodiments of the invention will be apparent to those skilled in the art from consideration of the specification and practice of the invention disclosed herein. It is intended that the specification and examples be considered as exemplary only, with a true scope and spirit of the invention being indicated by the following claims.



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What is claimed is:

1. A process for producing an acid enhanced adsorbent particle comprising contacting a particle comprising a non-amorphous, non-ceramic, crystalline, porous, calcined, aluminum oxide particle that was produced by calcining at a particle temperature of from 300°C to 700°C, with a dilute acid for a sufficient time to increase the adsorbent properties of the particle, wherein the resultant acid treated aluminum oxide is not subsequently calcined.
2. The method of Claim 1, wherein the particle temperature is from 400°C to 700°C.
3. The method of Claim 1, wherein the acid comprises an aliphatic or aryl carboxylic acid.
4. The process of Claim 1, wherein the acid comprises acetic, nitric, sulfuric, hydrochloric, boric, formic, or phosphoric acid, or mixtures thereof.
5. The process of Claim 1, wherein the acid comprises acetic acid.
6. The process of Claim 1, wherein the contacting is by dipping or submerging the particle in acid.
7. The process of Claim 7, further comprising the step of rinsing the particle to remove excess acid.
8. The process of Claim 1, further comprising the step of drying the particle.
9. The process of Claim 7, wherein the contacting is for at least 15 minutes.

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10. The process of Claim 1, wherein the dilute acid strength is equivalent to an aqueous acetic acid solution at less than or equal to 0.09 N.
11. The process of Claim 1, wherein the dilute acid strength is equivalent to an aqueous acetic acid solution at less than or equal to 0.02 N.
12. The process of Claim 1, wherein the dilute acid strength is equivalent to an aqueous acetic acid solution at less than or equal to 0.01 N.
13. The process of Claim 1, wherein the dilute acid strength is equivalent to an aqueous acetic acid solution at less than or equal to 0.005 N.
14. The process of Claim 1, wherein the dilute acid strength is equivalent to an aqueous acetic acid solution at less than or equal to 0.001 N.
15. The process of Claim 1, wherein the calcined aluminum oxide is in the gamma, chi-rho, or eta form.
16. The process of Claim 1, wherein the aluminum oxide prior to or after acid treatment is not sintered.
17. The process of Claim 1, wherein the particle consists essentially of aluminum oxide.
18. The process of Claim 1, wherein the particle consists of aluminum oxide.
19. The process of Claim 1, wherein the resultant acid treated aluminum oxide is substantially microporous.

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20. The process of Claim 1, wherein the aluminum oxide is not an adsorbent or catalyst support.
21. The process of Claim 1, wherein the acid contacting is more than a surface wash but less than an etching of the particle.
22. A process for producing an acid enhanced adsorbent particle consisting essentially of contacting a particle comprising a non-amorphous, non-ceramic, crystalline, porous, calcined, aluminum oxide particle that was produced by calcining at a particle temperature of from 300° C to 700° C, with a dilute acid for a sufficient time to increase the adsorbent properties of the particle.
22. The method of Claim 22, wherein the particle temperature is from 400° to 700° C.
24. A process for producing an acid enhanced adsorbent particle comprising contacting a particle comprising a non-ceramic, porous, oxide adsorbent particle with a dilute acid for a sufficient time to increase the adsorbent properties of the particle, wherein the oxide adsorbent particle is not aluminum oxide and wherein the resultant acid treated oxide adsorbent particle is not subsequently calcined.
25. The process of Claim 24, wherein the resultant acid treated oxide is microporous.
26. The process of Claim 24, wherein the dilute acid strength is equivalent to an aqueous acetic acid solution at less than or equal to 0.09 N.
27. The process of Claim 24, wherein the dilute acid strength is equivalent to an aqueous acetic acid solution at less than or equal to 0.02 N.

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28. The process of Claim 24, wherein the dilute acid strength is equivalent to an aqueous acetic acid solution at less than or equal to 0.01 N.
29. The process of Claim 24, wherein the dilute acid strength is equivalent to an aqueous acetic acid solution at less than or equal to 0.005 N.
30. The process of Claim 24, wherein the dilute acid strength is equivalent to an aqueous acetic acid solution at less than or equal to 0.001 N.
31. The process of Claim 24, wherein the oxide prior to or after acid treatment is not sintered.
32. The process of Claim 24, wherein the oxide adsorbent particle is silicon dioxide, manganese oxide, copper oxide, vanadium pentoxide, zirconium oxide, iron oxide, or titanium dioxide.
33. The process of Claim 24, wherein the adsorbent particle is zeolite.
34. The process of Claim 24, wherein the acid contacting is more than a surface wash but less than an etching of the particle.
35. The particle made by the process of Claim 1.
36. The particle made by the process of Claim 5.
37. The particle made by the process of Claim 24.
38. The particle made by the process of Claim 32.

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39. The particle of Claim 35, wherein said particle passes the EPA TCLP test for a particular contaminant.
40. The particle of Claim 39, wherein said contaminant is lead.
41. A process for reducing or eliminating the amount of contaminants in a liquid or gas stream comprising contacting the particle of Claim 35 with the liquid or gas stream for a sufficient time to reduce the amount of or eliminate the contamination from the liquid or gas stream.
42. The process of Claim 41, wherein the stream is liquid.
43. The process of Claim 41, wherein the stream is gas.
44. The process of Claim 41, wherein the contaminant is lead, phosphate, selenium, or zinc.
45. A composition comprising the aluminum oxide particle made by the process of Claim 1.
46. The composition of Claim 45, further comprising a second oxide adsorbent particle.
47. The composition of Claim 46, further comprising a cross-linked colloidal aluminum oxide binder.
48. The composition of Claim 45, further comprising silicon dioxide, manganese oxide, copper oxide, vanadium pentoxide, zirconium oxide, iron oxide or titanium dioxide.

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49. The composition of Claim 45, further comprising a zeolite.
50. The composition of Claim 45, further comprising copper oxide and manganese oxide, wherein said copper oxide and said manganese oxide have not been acid enhanced.
51. The composition of Claim 50, wherein the composition comprises 50-98 parts by weight of said acid enhanced aluminum oxide, 1-49 parts by weight of said copper oxide, and 1-49 parts by weight of said manganese oxide.
52. The composition of Claim 51, wherein said copper oxide is CuO and said manganese oxide is MnO_2 .
53. The composition of Claim 50, wherein said composition passes the EPA TCLP test for trichloroethylene.
54. The composition of Claim 45, further comprising a noble metal.
55. The composition of Claim 45, further comprising a catalyst particle.
56. The composition of Claim 45, further comprising an adsorbent particle.
57. A process for reducing or eliminating the amount of an organic contaminant in a liquid or gas stream comprising contacting the composition of Claim 50 with the liquid or gas stream for a sufficient time to reduce the amount of or eliminate the organic contaminant from the liquid or gas stream.
58. The process of Claim 57, wherein the organic contaminant is a chlorinated organic.

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59. The process of Claim 57, wherein the organic contaminant is trichloroethylene.
60. The process of Claim 57, wherein said reduction or elimination is by a catalytic degradation process.
61. A composition comprising (1) a particle made by the process comprising contacting a particle comprising a non-amorphous, non-ceramic, crystalline, porous, calcined, aluminum oxide particle that was produced by calcining at a particle temperature of from 300° C to 700° C, with a dilute acid for a sufficient time to increase the adsorbent properties of the aluminum oxide particle and (2) copper oxide and (3) manganese oxide, wherein said copper oxide and said manganese oxide have not been acid enhanced.
62. The composition of Claim 61, wherein the particle temperature is from 400° to 700° C.
63. The method of Claim 1, wherein the particle, prior to contacting with the acid, further comprises a second type of adsorbent and/or catalytic particle and further comprises a binder comprising a colloidal metal oxide or colloidal metalloid oxide.
64. The method of Claim 63, wherein the binder is cross-linked to at least one of the particle types or to itself.
65. The method of Claim 1, further comprising,
- (1) mixing the resultant particle of Claim 1 with at least one other type of adsorbent and/or catalyst particle, a binder comprising colloidal metal oxide or colloidal metalloid oxide, and an acid; and
 - (2) heating the mixture to a sufficient temperature for a sufficient time to cross-link the binder to at least one type of particle or to itself.

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66. An adsorbent and/or catalyst and binder composition comprising the particle made by the process of Claim 1 and further comprising a second type of adsorbent and/or catalyst particle and a binder comprising colloidal metal oxide or colloidal metalloid oxide.
67. The composition of Claim 66, wherein the binder is cross-linked to at least one of the particle types or to itself.
68. The method of Claim 24, wherein the particle, prior to contacting with the acid, further comprises a second type of adsorbent and/or catalytic particle and further comprises a binder comprising colloidal metal oxide or colloidal metalloid oxide.
69. The method of Claim 68, wherein the binder is cross-linked to at least one of the particle types or to itself.
70. The method of Claim 24, further comprising,
(1) mixing the resultant particle of Claim 1 with at least one other type of adsorbent and/or catalyst particle, a binder comprising colloidal metal oxide or colloidal metalloid oxide, and an acid; and
(2) heating the mixture to a sufficient temperature for a sufficient time to cross-link the binder to at least one type of particle or to itself.
71. An adsorbent and/or catalyst and binder composition comprising the particle made by the process of Claim 24 and further comprising a second type of adsorbent and/or catalyst particle and a binder comprising colloidal metal oxide or colloidal metalloid oxide.
72. The composition of Claim 71, wherein the binder is cross-linked to at least one of the particle types or to itself.

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73. A method for producing an adsorbent and/or catalyst and binder system comprising
- (i) mixing components comprising
 - (a) a binder comprising a colloidal metal oxide or colloidal metalloid oxide,
 - (b) an oxide adsorbent and/or catalyst particle, and
 - (c) an acid,
 - (ii) removing a sufficient amount of water from the mixture to cross-link components a and b to form an adsorbent and/or catalyst and binder system.
74. The method of Claim 73, wherein the removing is by heating or by using a drying agent.
75. The method of Claim 73, wherein the removing is by heating.
76. The method of Claim 73, wherein the binder comprises colloidal alumina, colloidal silica, a colloidal metal oxide wherein the metal is iron, or a mixture thereof.
77. The method of Claim 73, wherein the binder is colloidal alumina.
78. The method of Claim 73, wherein the binder is from 1% to 99.9% by weight of the mixture.
79. The method of Claim 73, wherein the binder is colloidal alumina and is from 10% to 35% by weight of the mixture.
80. The method of Claim 73, wherein component b comprises at least two different types of oxide adsorbent and/or catalyst particles.

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81. The method of Claim 73, wherein component b comprises at least three different types of oxide adsorbent and/or catalyst particles.
82. The method of Claim 73, wherein component b comprises a metal oxide particle.
83. The method of Claim 73, wherein component b comprises a non-ceramic, porous metal oxide particle.
84. The method of Claim 73, wherein component b comprises a particle of an oxide of aluminum, titanium, copper, vanadium, silicon, manganese, iron, zinc, zirconium, magnesium, calcium, strontium, barium, boron, gallium, indium, thallium, germanium, tin, lead, arsenic, antimony, or bismuth or zeolite or a mixture thereof.
85. The method of Claim 73, wherein component b comprises a mixture of at least two metal oxide particles having the same metal with varying stoichiometry and oxidation states.
86. The method of Claim 73, wherein component b comprises aluminum oxide, titanium dioxide, copper oxide, vanadium pentoxide, silicon dioxide, manganese dioxide, iron oxide, zinc oxide, zirconium oxide or zeolite particle.
87. The method of Claim 86, wherein component b further comprises a second type of adsorbent and/or catalyst particle of aluminum oxide, titanium dioxide, copper oxide, vanadium pentoxide, silicon dioxide, manganese dioxide, iron oxide, zinc oxide, zeolite, activated carbon, peat, zinc or tin particle.
88. The method of Claim 73, wherein component b comprises a non-amorphous, non-ceramic, crystalline, porous, calcined aluminum oxide particle that was

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produced by calcining the precursor to the calcined aluminum oxide at a particle temperature of from 300°C to 700°C.

89. The method of Claim 88, wherein the calcined aluminum oxide particle is in the gamma, chi-rho, or eta form.
90. The method of Claim 89, wherein the calcined aluminum oxide particle was pretreated with an acid activation treatment.
91. The method of Claim 73, wherein the acid comprises an aliphatic or aryl carboxylic acid.
92. The method of Claim 73, wherein the acid comprises nitric acid, sulfuric acid, hydrochloric acid, boric acid, acetic acid, formic acid, phosphoric acid or mixtures thereof.
93. The method of Claim 73, wherein the acid is acetic acid or nitric acid.
94. The method of Claim 73, wherein the concentration of the acid is from 0.15 N to 8.5 N.
95. The method of Claim 73, wherein the removal is from 25°C to 400°C.
96. The method of Claim 75, wherein the heating is from 70°C to 150°C and the binder is colloidal alumina or colloidal silica.
97. The adsorbent and/or catalyst and binder system made by the process of Claim 73.

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98. An adsorbent and/or catalyst and binder system comprising a binder that has been cross-linked with at least one type of oxide adsorbent and/or catalyst particle.
99. The system of Claim 98, wherein the binder comprises a colloidal metal oxide or colloidal metalloid oxide.
100. The system of Claim 98, wherein the binder comprises colloidal alumina, colloidal silica, a colloidal metal oxide wherein the metal is iron, or a mixture thereof.
101. The system of Claim 98, wherein the binder comprises colloidal alumina, colloidal silica, or a mixture thereof.
102. The system of Claim 98, wherein the binder is colloidal alumina.
103. The system of Claim 99, wherein the binder is from 1% to 99.9% by weight of the mixture.
104. The system of Claim 99, wherein the binder is colloidal alumina and is from 10% to 35% by weight of the mixture.
105. The system of Claim 99, wherein the oxide adsorbent and/or catalyst particle comprises at least two different types of oxide adsorbent and/or catalyst particles.
106. The system of Claim 99, wherein the oxide adsorbent and/or catalyst particle comprises at least three different types of oxide adsorbent and/or catalyst particles.

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107. The system of Claim 99, wherein the oxide adsorbent and/or catalyst particle comprises a metal oxide particle.
108. The system of Claim 99, wherein the oxide adsorbent and/or catalyst particle comprises a non-ceramic, porous metal oxide particle.
109. The system of Claim 99, wherein the oxide adsorbent and/or catalyst particle comprises particles of an oxide of aluminum, titanium, copper, vanadium, silicon, manganese, iron, zinc, zirconium, magnesium, calcium, strontium, barium, boron, gallium, indium, thallium, germanium, tin, lead, arsenic, antimony, or bismuth, or zeolite, or a mixture thereof.
110. The system of Claim 99, wherein the oxide adsorbent and/or catalyst particle comprises a mixture of at least two metal oxide particles having the same metal with varying stoichiometry and oxidation states.
111. The system of Claim 99, wherein the oxide adsorbent and/or catalyst particle comprises aluminum oxide, titanium dioxide, copper oxide, vanadium pentoxide, silicon dioxide, manganese dioxide, iron oxide, zinc oxide, zirconium oxide or zeolite particle.
112. The system of Claim 99, wherein the oxide adsorbent and/or catalyst particle further comprises a second type of adsorbent and/or catalyst particles of aluminum oxide, titanium dioxide, copper oxide, vanadium pentoxide, silicon dioxide, manganese dioxide, iron oxide, zinc oxide, zeolite, activated carbon, peat, zinc or tin particle.
113. The system of Claim 99, wherein the oxide adsorbent and/or catalyst particle comprises a non-amorphous, non-ceramic, crystalline, porous, calcined

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aluminum oxide particle that was produced by calcining the precursor to the calcined aluminum oxide at a particle temperature of from 300°C to 700°C.

114. The system of Claim 113, wherein the calcined aluminum oxide particle is in the gamma, chi-rho, or eta form.
115. The system of Claim 114, wherein the calcined aluminum oxide particle was pretreated with an acid activation treatment.
116. The system of Claim 98, wherein the binder is colloidal alumina and the particle comprises aluminum oxide, copper oxide, and manganese dioxide.
117. The system of Claim 98, wherein the binder is colloidal alumina and the particle comprises aluminum oxide and carbon.
118. The system of Claim 98, wherein the binder is colloidal alumina and the particle comprises copper oxide and manganese dioxide.
119. The system of Claim 98, wherein the binder is colloidal alumina and the particle comprises aluminum oxide, copper oxide, manganese dioxide and carbon.
120. The system of Claim 98, wherein the binder is colloidal silica and the particle comprises aluminum oxide, copper oxide and manganese dioxide.
121. The system of Claim 98, wherein the binder is colloidal alumina and the particle comprises aluminum oxide, gallium oxide and copper oxide.
122. The system of Claim 121, wherein the colloidal alumina is from 1 to 97% by weight, the aluminum oxide is from 1 to 97% by weight, the gallium

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oxide is from 1 to 97% by weight, and the copper oxide is from 1 to 97% by weight.

123. The system of Claim 121, wherein the colloidal alumina is from 5 to 40% by weight, the aluminum oxide is from 40 to 97% by weight, the gallium oxide is from 1 to 10% by weight, and the copper oxide is from 1 to 10% by weight.
124. The system of Claim 98, wherein the binder is colloidal alumina and the particle comprises aluminum oxide, and a mixed oxide comprising manganese dioxide, aluminum oxide and copper oxide.
125. The system of Claim 124, wherein the colloidal alumina is from 1 to 98% by weight, the aluminum oxide is from 1 to 98% by weight, and the mixed oxide is from 1 to 98% by weight.
126. The system of Claim 124, wherein the colloidal alumina is from 10 to 40% by weight, the aluminum oxide is from 10 to 40% by weight, and the mixed oxide is from 20 to 70% by weight.
127. The system of Claim 98, wherein the binder is colloidal alumina and the particle comprises aluminum oxide and copper oxide.
128. The system of Claim 127, wherein the colloidal alumina is from 1 to 98% by weight, the aluminum oxide is from 1 to 98% by weight, and the copper oxide is from 1 to 98% by weight.
129. The system of Claim 127, wherein the colloidal alumina is from 10 to 40% by weight, the aluminum oxide is from 30 to 70% by weight, and the copper oxide is from 1 to 20% by weight.



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130. The system of Claim 98, wherein the binder is colloidal alumina and the particle comprises aluminum oxide, copper oxide and zirconium oxide.
131. The system of Claim 130, wherein the colloidal alumina is from 1 to 97% by weight, the aluminum oxide is from 1 to 97% by weight, and the copper oxide is from 1 to 97% by weight, and the zirconium oxide is from 1 to 97% by weight.
132. The system of Claim 130, wherein the colloidal alumina is from 10 to 40% by weight, the aluminum oxide is from 30 to 70% by weight, and the copper oxide is from 10 to 20% by weight, and the zirconium oxide is from 1 to 20% by weight.
133. The system of Claim 98, wherein the binder is colloidal alumina and the particle comprises aluminum oxide and silver nitrate.
134. The system of Claim 133, wherein the colloidal alumina is from 1 to 98% by weight, the aluminum oxide is from 1 to 98% by weight, and the silver nitrate is from 1 to 98% by weight.
135. The system of Claim 133, wherein the colloidal alumina is from 10 to 40% by weight, the aluminum oxide is from 30 to 70% by weight, and the silver nitrate is from 1 to 20% by weight.
136. The system of Claim 98, wherein the binder is colloidal alumina and the particle comprises aluminum oxide, magnesium oxide, manganese dioxide and copper oxide.
137. The system of Claim 136, wherein the colloidal alumina is from 1 to 96% by weight, the aluminum oxide is from 1 to 96% by weight, the



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magnesium oxide is from 1 to 96% by weight, the manganese dioxide is from 1 to 96% by weight, and the copper oxide is from 1 to 96% by weight.

138. The system of Claim 136, wherein the colloidal alumina is from 10 to 40% by weight, the aluminum oxide is from 30 to 70% by weight, the magnesium oxide is from 1 to 30% by weight, the manganese dioxide is from 1 to 20% by weight, and the copper oxide is from 1 to 20% by weight.
139. The system of Claim 98, wherein the binder is colloidal alumina and the particle comprises aluminum oxide, copper oxide, and a mixed oxide comprising copper oxide, manganese dioxide, and lithium hydroxide.
140. The system of Claim 139, wherein the colloidal alumina is from 1 to 97% by weight, the aluminum oxide is from 1 to 97% by weight, the copper oxide is from 1 to 97% by weight, and the mixed oxide is from 1 to 97% by weight.
141. The system of Claim 139, wherein the colloidal alumina is from 10 to 40% by weight, the aluminum oxide is from 30 to 70% by weight, the copper oxide is from 1 to 20% by weight, and the mixed oxide is from 1 to 20% by weight.
142. The system of Claim 98, wherein the catalyst and binder system comprises colloidal alumina, aluminum oxide, and one or more of the oxide particles of V_2O_5 , WO_2 , WO_3 , TiO_2 , Re_2O_7 , As_2O_3 , As_2O_5 , OsO_4 , Sb_2O_3 or mixtures thereof.
143. The system of Claim 98, wherein the catalyst and binder system comprises colloidal alumina, aluminum oxide, and one or more of the oxide particles of V_2O_5 , ZrO_2 , TiO_2 , MgO , ThO_2 , lanthanide oxides or mixtures thereof.



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144. The system of Claim 98, wherein the catalyst and binder system comprises colloidal alumina, aluminum oxide, and one or more of the oxide particles of CuO, ZnO, Ag₂O, AgO, CdO, SnO₂, PbO, V₂O₅, ZrO₂, MgO, ThO₂, lanthanide oxides, or mixtures thereof.
145. The system of Claim 98, wherein the catalyst and binder system comprises colloidal alumina, aluminum oxide, and one or more of the oxide particles of MnO₂, Fe₂O₃, Fe₃O₄, Ru₂O₃, OsO₄, CoO, Co₂O₃, RuO, NiO or mixtures thereof.
146. The system of Claim 98, wherein the catalyst and binder system comprises colloidal alumina, aluminum oxide, and one or more of the oxide particles of Fe₂O₃, Fe₃O₄, CoO, Co₂O₃ or mixtures thereof.
147. The system of Claim 98, wherein the catalyst and binder system comprises colloidal alumina, aluminum oxide, and one or more of the particles of zeolite, MgO, ThO₂ or mixtures thereof.
148. The system of Claim 98, wherein the catalyst and binder system comprises colloidal alumina, aluminum oxide, and one or more of the oxide particles of MgO, ThO₂ or mixtures thereof.
149. A method for reducing or eliminating the amount of a contaminant from a liquid or gas stream comprising contacting the system of Claim 98 with the contaminant in the stream for a sufficient time to reduce or eliminate the amount of contaminant from the stream.
150. A method for reducing or eliminating the amount of a contaminant from a liquid or gas stream comprising contacting the system of Claim 99 with the



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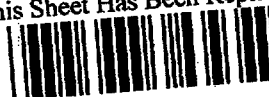
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contaminant in the stream for a sufficient time to reduce or eliminate the amount of contaminant from the stream.

151. The method of Claim 150, wherein the stream is a liquid.
152. The method of Claim 150, wherein the stream comprises water.
153. The method of Claim 150, wherein the stream is a gas.
154. The method of Claim 150, wherein the stream comprises air or natural gas.
155. The method of Claim 150, wherein the contaminant from the liquid or gas stream is reduced or eliminated by a catalytic reaction.
156. The method of Claim 150, wherein the contaminant from the liquid or gas stream is reduced or eliminated by an adsorption reaction.
157. The method of Claim 150, wherein the contaminant is acetone, ammonia, benzene, carbon monoxide, chlorine, hydrogen sulfide, trichloroethylene, 1,4-dioxane, ethanol, ethylene, formaldehyde, hydrogen cyanide, hydrogen sulfide, methanol, methyl ethyl ketone, methylene chloride, nitrogen oxide, propylene, styrene, sulfur dioxide, toluene, vinyl chloride, arsenic, cadmium, chlorine, 1,2-dibromochloropropane, iron, lead, phosphate, radon, selenium, or uranium.
158. The method of Claim 150, wherein the contaminant is hydrogen sulfide.
159. A method for catalyzing the decomposition of an organic compound comprising contacting the organic compound with the system of Claim 98 for a sufficient time to catalyze the degradation of the organic compound.



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160. The method of Claim 159, wherein the catalytic reaction is at room temperature.
161. The method of Claim 159, wherein the organic compound is a chlorinated hydrocarbon.
162. The method of Claim 159, wherein the organic compound is trichloroethylene.
163. A method for reducing or eliminating a contaminant from a gas stream by catalysis comprising contacting the system of Claim 99 with a gas stream containing a contaminant comprising an oxide of nitrogen, an oxide of sulfur, carbon monoxide, hydrogen sulfide, or mixtures thereof for a sufficient time to reduce or eliminate the contaminant amount.
164. The method of Claim 163, wherein the catalytic reaction is at room temperature.
165. A method for adsorbing an ion from a liquid or gas stream comprising contacting the system of Claim 99 with a liquid or gas stream containing the ion.
166. The method of Claim 165, wherein the ion comprises an anion, a cation, an oxo-anion, a poly-oxoanion or a mixture thereof.
167. A method for regenerating the system of Claim 99 that has adsorbed a contaminant, comprising thermally oxidizing said system or contacting said system with (1) a reagent wash comprising aqueous ammonia, a phosphine, a detergent or a mixture thereof; (2) an acid or base to cause a pH swing; (3) or a Lewis acid or base.



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168. A method for producing an adsorbent and/or catalyst and binder system comprising
- (i) mixing components comprising
 - (a) a binder comprising a colloidal metal oxide or colloidal metalloid oxide,
 - (b) a first adsorbent and/or catalyst particle that does not cross-link with the binder, and
 - (c) an acid,
 - (ii) removing a sufficient amount of water from the mixture to cross-link component a to itself, thereby entrapping and holding component b within the cross-linked binder, to form an adsorbent and/or catalyst and binder system.
169. The method of Claim 168, wherein the removing is by heating or by using a drying agent.
170. The method of Claim 168, wherein the removing is by heating.
171. The method of Claim 168, further comprising a second adsorbent and/or catalyst particle that cross-links with the binder, thereby cross-linking the binder and the second particle and thereby entrapping and holding the first particle within the cross-linked binder and/or within the cross-linked binder and second particle.
172. The method of Claim 168, wherein component b comprises an activated carbon particle.
173. The method of Claim 168, wherein component b does not contain an oxide particle.
174. The method of Claim 168, wherein the binder comprises colloidal alumina, colloidal silica, or a mixture thereof.



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175. The method of Claim 168, wherein the binder is colloidal alumina.
176. A composition for binding adsorbent and/or catalytic particles to produce an agglomerated particle comprising (a) a colloidal metal oxide or colloidal metalloid oxide and (b) an acid.
177. The composition of Claim 176, wherein the colloidal metal oxide or colloidal metalloid oxide comprises colloidal alumina or colloidal silica.
178. The composition of Claim 176, wherein the colloidal metal oxide or colloidal metalloid oxide is colloidal alumina.
179. The composition of Claim 176, wherein the acid is acetic acid or nitric acid.
180. The composition of Claim 176, wherein the acid is nitric acid.
181. A kit for binding adsorbent and/or catalytic particles to produce an agglomerated particle comprising (a) a colloidal metal oxide or colloidal metalloid oxide and (b) an acid.
182. A method for binding adsorbent and/or catalytic particles, comprising the steps of:
- (1) mixing colloidal alumina or colloidal silica with the particles and an acid;
 - (2) agitating the mixture to homogeneity; and
 - (3) heating the mixture for a sufficient time to cause cross-linking of the aluminum oxide in the mixture.
183. The method of Claim 182, wherein the colloidal alumina or colloidal silica is colloidal alumina.



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184. The method of Claim 183, wherein the colloidal alumina is from 20% to 99% by weight of the mixture.
185. The method of Claim 182, wherein the acid is nitric acid.
186. The system of Claim 99, wherein the particle comprises aluminum oxide, silicon dioxide and activated carbon.
187. The method of Claim 73, wherein during or after step (i), the mixture of step (i) is not heated above the cross-linking temperature of the colloidal metal oxide or colloidal metalloid oxide.
188. The method of Claim 73, wherein during or after step (i), the mixture of step (i) is not heated to or above the calcining temperature of the colloidal metal oxide or colloidal metalloid oxide.
189. The method of Claim 73, wherein during or after step (i), the mixture of step (i) is not heated to or above the calcining temperature of the particle.
190. The method of Claim 73, wherein during or after step (i), the mixture of step (i) is not heated above 400° C.
191. The adsorbent and/or binder system made by the process of Claim 168.
192. The adsorbent and/or binder system made by the process of Claim 171.
193. An adsorbent and/or catalyst and binder system, comprising:
- (a) a pendant ligand substituted or unsubstituted binder, and
 - (b) a pendant ligand substituted or unsubstituted oxide adsorbent and/or oxide catalyst particle,



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wherein at least one of components (a) and (b) is pendant ligand substituted, and wherein component (a) is cross-linked with component (b).

194. The system of Claim 193, wherein the binder comprises a colloidal metal oxide or a colloidal metalloid oxide.
195. The system of Claim 194, wherein the binder comprises colloidal alumina, colloidal silica, a colloidal metal oxide wherein the metal is iron, or a mixture thereof.
196. The system of Claim 194, wherein the binder comprises colloidal alumina, colloidal silica, or a mixture thereof.
197. The system of Claim 194, wherein the binder is colloidal alumina.
198. The system of Claim 194, wherein the oxide adsorbent and/or oxide catalyst particle is pendant ligand substituted.
199. The system of Claim 194, wherein the binder is pendant ligand substituted.
200. The system of Claim 194, wherein the oxide adsorbent and/or oxide catalyst particle and the binder are both pendant ligand substituted.
201. The system of Claim 194, wherein the pendant ligand substitution on the binder and oxide adsorbent and/or catalyst particle independently comprises at least one pendant ligand moiety having a complexing group end.
202. The system of Claim 201, wherein the pendant ligand moiety further comprises a tether end.



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203. The system of Claim 202, wherein the tether end comprises an aliphatic group, an aromatic group, a silyl group, a siloxy group or a combination thereof or an oligomer or polymer thereof.
204. The system of Claim 203, wherein the tether end comprises an aliphatic or aromatic group that is from 1 to 20 carbons, branched or unbranched, substituted or unsubstituted.
205. The system of Claim 201, wherein the complexing group comprises a group with a lone-pair of electrons.
206. The system of Claim 201, wherein the complexing group comprises a hydroxyl group, an ether, a thiol, a thioether, an amine, a mono- or disubstituted amine, a phosphine, a mono- or disubstituted phosphine or a mixture thereof.
207. The system of Claim 201, wherein the complexing group comprises an unsaturated organic moiety.
208. The system of Claim 207, wherein the unsaturated organic moiety is cyclic, acyclic, or aromatic.
209. The system of Claim 208, wherein the acyclic unsaturated organic moiety comprises an olefin, an allyl, a diene, a triene or a mixture thereof.
210. The system of Claim 208, wherein the cyclic unsaturated organic moiety comprises a cyclopentadiene, cycloheptatriene, cyclooctadiene, cyclooctatetraene or a mixture thereof.
211. The system of Claim 208, wherein the aromatic unsaturated organic moiety comprises benzene, naphthalene, anthracene or mixtures thereof.



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212. A method of using the system of Claim 194 as a catalyst support system comprising binding the system of Claim 194 with a second catalyst particle.
213. The method of Claim 212, wherein the second catalyst particle is a homogeneous catalyst.
214. An anchored adsorbent and/or catalyst and binder system, comprising:
- (a) a pendant ligand substituted or unsubstituted binder, and
 - (b) a pendant ligand substituted or unsubstituted oxide adsorbent and/or oxide catalyst particle, and
 - (c) a metal complex,
- wherein at least one of components (a) and (b) is pendant ligand substituted, wherein component (a) is cross-linked with component (b), and wherein the metal complex (c) is bound to component (a) and/or (b).
215. The system of Claim 214, wherein the binder comprises a colloidal metal oxide or a colloidal metalloid oxide.
216. The system of Claim 215, wherein the binder comprises colloidal alumina, colloidal silica, a colloidal metal oxide wherein the metal is iron, or a mixture thereof.
217. The system of Claim 215, wherein the binder comprises colloidal alumina, colloidal silica, or a mixture thereof.
218. The system of Claim 215, wherein the binder is colloidal alumina.
219. The system of Claim 215, wherein the oxide adsorbent and/or oxide catalyst particle is pendant ligand substituted.

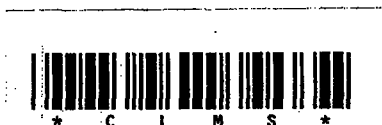


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220. The system of Claim 215, wherein the binder is pendant ligand substituted.
221. The system of Claim 215, wherein the oxide adsorbent and/or oxide catalyst particle and the binder are both pendant ligand substituted.
222. The system of Claim 214, wherein the metal complex comprises a metal salt, metal carbonyl complex, metal phosphine complex, metal amine complex, metal olefin complex, a metal acetylene complex, a metal polyene complex, a metal hydride complex, a metal halide complex or a mixture thereof.
223. The system of Claim 222, wherein the metal salt comprises a halide, a carbonate, an oxalate, a bicarbonate, or a carboxalate as the counterion of lithium, sodium, potassium, rubidium, cesium, francium, magnesium, calcium, strontium, barium, radon, the transition metals, the lanthanide metals or the actinide metals as the metal moiety.
224. The system of Claim 222, wherein the metal carbonyl comprises a mono-nuclear or poly-nuclear binary carbonyl of a transition metal.
225. The system of Claim 224, wherein the metal carbonyl comprises a mono-nuclear or poly-nuclear mixed carbonyl-phosphine, carbonyl-phosphite, carbonyl-olefin, carbonyl-acetylene, carbonyl-cyclopentadienyl complexes, carbonyl-hydride, or carbonyl-halide of a transition metal.
226. The system of Claim 222, wherein the metal complex comprises a hydrogenation catalyst, an oxidation catalyst, a hydroformylation catalyst, a reduction catalyst, an isomerization catalyst, a polymerization, a carbonylation catalyst, a reforming catalyst, an olefin metathesis catalyst, a Fischer-Tropsch catalyst, a gasification catalyst or a mixture thereof.



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227. A method for producing a pendant ligand substituted adsorbent and/or catalyst system, comprising:
- (i) mixing components, comprising:
 - (a) a pendant ligand substituted or unsubstituted binder comprising a colloidal metal oxide or a colloidal metalloid oxide,
 - (b) a pendant ligand substituted or unsubstituted oxide adsorbent and/or oxide catalyst particle, and
 - (c) an acid,wherein at least one of components (a) and (b) is pendant ligand substituted,
 - (ii) removing a sufficient amount of water from the mixture to cross-link components (a) and (b) to form a pendant ligand substituted adsorbent and/or catalyst and binder system, and
228. The method of Claim 227, further comprising (iii) binding a metal complex onto the resulting system of step (ii) to form the anchored catalyst system.
229. The method of Claim 228, wherein the binding step (iii) comprises vapor deposition, incipient wetness, aqueous impregnation or non-aqueous impregnation.
230. The method of Claim 228, further comprising prior to step (i), reacting an unsubstituted binder with a hydroxyl-reactive compound to produce a pendant ligand substituted binder.
231. The method of Claim 228, further comprising prior to step (i), reacting an unsubstituted oxide adsorbent and/or oxide catalyst particle with a hydroxyl-reactive compound to produce a pendant ligand substituted oxide adsorbent and/or oxide catalyst particle.



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232. The method of Claim 228, further comprising prior to step (i), reacting an unsubstituted binder and an unsubstituted oxide adsorbent and/or oxide catalyst particle with a hydroxyl-reactive compound to produce a pendant ligand substituted binder and a substituted oxide adsorbent and/or oxide catalyst particle.
233. The anchored adsorbent and/or catalyst and binder system made by the process of Claim 228.
234. The method of Claim 73, further comprising
iii) reacting the resultant oxide adsorbent and/or oxide catalyst particle and the binder system of step (ii) with a hydroxyl-reactive compound to form a pendant ligand substituted oxide adsorbent and/or oxide catalyst and binder system.
235. The method of Claim 234, further comprising (iv) after step (iii) binding a metal complex onto the resulting system of step (iii) to form an anchored catalyst system.
236. The method of Claim 235, wherein the binder is pendant ligand substituted.
237. The method of Claim 234, wherein the oxide adsorbent and/or catalyst particle is pendant ligand substituted.
238. The method of Claim 235, wherein the oxide adsorbent and/or oxide catalyst particle and the binder are both pendant ligand substituted.
239. The method of Claim 235, wherein the binding step (iv) comprises vapor deposition, incipient wetness, aqueous impregnation or non-aqueous impregnation.



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240. The pendant ligand substituted adsorbent and/or catalyst and binder system made by the process of Claim 234.
241. The anchored adsorbent and/or catalyst and binder system made by the process of Claim 235.
242. A method of encapsulating a contaminant within an adsorbent particle comprising heating the particle of Claim 35 that has adsorbed a contaminant to a temperature sufficient to close the pores of the particle to thereby encapsulate the contaminant within the particle.
243. A method of encapsulating a contaminant within an adsorbent particle comprising heating the system of Claim 99 that has adsorbed a contaminant to a temperature sufficient to close the pores of the system to thereby encapsulate the contaminant within the system.
244. The method of Claim 242, wherein the temperature is from 450°C to 2000°C.
245. The method of Claim 243, wherein the temperature is from 450°C to 2000°C.
246. The method of Claim 91, wherein the acid comprises acetic acid, benzoic acid, butyric acid, citric acid, fatty acids, lactic acid, maleic acid, malonic acid, oxalic acid, salicylic acid, stearic acid, succinic acid, tartaric acid, propionic acid, valeric acid, hexanoic acid, heptanoic acid, caprylic acid, pelargonic acid, capric acid, undecanoic acid, lauric acid, tridecanoic acid, myristic acid, pentadecanoic acid, palmitic acid, heptadecanoic acid, nonadecanoic acid, arachidic acid, heneicosanoic acid, behenic acid, triosanoic acid, lignoceric acid, pentacosanoic acid, cerotic acid, heptasanoic acid, montanic acid, nonacosanoic acid, melissic acid, phthalic acid, glutaric acid, adipic acid,



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azelaic acid, sebacic acid, cinnamic acid, acrylic acid, crotonic acid, linoleic acid or a mixture thereof.

247. A method for regenerating the system of Claim 35 that has adsorbed a contaminant, comprising thermally oxidizing said system or contacting said system with (1) a reagent wash comprising aqueous ammonia, a phosphine, a detergent or a mixture thereof; (2) an acid or base to cause a pH swing; (3) or a Lewis acid or base.
248. An anchored adsorbent and/or catalyst and binder system, comprising:
- (a) a binder, and
 - (b) an oxide adsorbent and/or oxide catalyst particle, and
 - (c) a metal complex,
- wherein component (a) is cross-linked with component (b), and wherein the metal complex (c) is bound directly to component (a) and/or (b).
249. The method of Claim 73, further comprising binding a metal complex directly onto the resulting system of step (ii) to form an anchored catalyst system.
250. The particle made by the process of Claim 249.
251. A method for regenerating the system of Claim 37 that has adsorbed a contaminant, comprising thermally oxidizing said system or contacting said system with (1) a reagent wash comprising aqueous ammonia, a phosphine, a detergent or a mixture thereof; (2) an acid or base to cause a pH swing; (3) or a Lewis acid or base.

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252. A method for modifying the physical property of the system of Claim 99, comprising heating the system of Claim 99 for a sufficient time to thereby modify the physical property.
253. The method of Claim 252, wherein the heating is performed to increase the surface area of the system.
254. The method of Claim 253, wherein the physical property comprises surface area, pore area, bulk density, skeletal density or porosity.
255. The system of Claim 215, wherein the pendant ligand substitution on the binder and oxide adsorbent and/or catalyst particle independently comprises at least one pendant ligand moiety having a complexing group end.
256. The system of Claim 255, wherein the pendant ligand moiety further comprises a tether end.
257. The system of Claim 255, wherein the tether end comprises an aliphatic group, an aromatic group, a silyl group, a siloxy group or a combination thereof or an oligomer or polymer thereof.
258. The system of Claim 257, wherein the tether end comprises an aliphatic or aromatic group that is from 1 to 20 carbons, branched or unbranched, substituted or unsubstituted.
259. The system of Claim 255, wherein the complexing group comprises a group with a lone-pair of electrons.



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260. The system of Claim 255, wherein the complexing group comprises a hydroxyl group, an ether, a thiol, a thioether, an amine, a mono- or disubstituted amine, a phosphine, a mono- or disubstituted phosphine or a mixture thereof.
261. The system of Claim 255, wherein the complexing group comprises an unsaturated organic moiety.
262. The system of Claim 261, wherein the unsaturated organic moiety is cyclic, acyclic, or aromatic.
263. The system of Claim 262, wherein the acyclic unsaturated organic moiety comprises an olefin, an allyl, a diene, a triene or a mixture thereof.
264. The system of Claim 262, wherein the cyclic unsaturated organic moiety comprises a cyclopentadiene, cycloheptatriene, cyclooctadiene, cyclooctetraene or a mixture thereof.
265. The system of Claim 262, wherein the aromatic unsaturated organic moiety comprises benzene, naphthalene, anthracene or mixtures thereof.
266. The method of Claim 227 wherein the removing is by heating or by using a drying agent.
267. The method of Claim 227, wherein the removing is by heating.
268. The method of Claim 227, wherein the binder comprises colloidal alumina, colloidal silica, a colloidal metal oxide wherein the metal is iron, or a mixture thereof.
269. The method of Claim 227, wherein the binder is colloidal alumina.

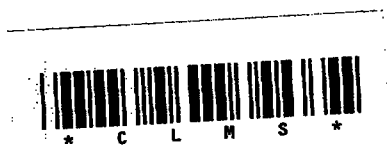


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270. The method of Claim 227, wherein the binder is from 1% to 99.9% by weight of the mixture.
271. The method of Claim 227, wherein the binder is colloidal alumina and is from 10% to 35% by weight of the mixture.
272. The method of Claim 227, wherein component b comprises at least two different types of oxide adsorbent and/or catalyst particles.
273. The method of Claim 227, wherein component b comprises at least three different types of oxide adsorbent and/or catalyst particles.
274. The method of Claim 227, wherein component b comprises a metal oxide particle.
275. The method of Claim 227, wherein component b comprises a non-ceramic, porous metal oxide particle.
276. The method of Claim 227, wherein component b comprises a particle of an oxide of aluminum, titanium, copper, vanadium, silicon, manganese, iron, zinc, zirconium, magnesium, calcium, strontium, barium, boron, gallium, indium, thallium, germanium, tin, lead, arsenic, antimony, or bismuth or zeolite or a mixture thereof.
277. The method of Claim 227, wherein component b comprises a mixture of at least two metal oxide particles having the same metal with varying stoichiometry and oxidation states.



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278. The method of Claim 227, wherein component b comprises aluminum oxide, titanium dioxide, copper oxide, vanadium pentoxide, silicon dioxide, manganese dioxide, iron oxide, zinc oxide, zirconium oxide or zeolite particle.
279. The method of Claim 278, wherein component b further comprises a second type of adsorbent and/or catalyst particle of aluminum oxide, titanium dioxide, copper oxide, vanadium pentoxide, silicon dioxide, manganese dioxide, iron oxide, zinc oxide, zeolite, activated carbon, peat, zinc or tin particle.
280. The method of Claim 227, wherein component b comprises a non-amorphous, non-ceramic, crystalline, porous, calcined aluminum oxide particle that was produced by calcining the precursor to the calcined aluminum oxide at a particle temperature of from 300°C to 700°C.
281. The method of Claim 280, wherein the calcined aluminum oxide particle is in the gamma, chi-rho, or eta form.
282. The method of Claim 281, wherein the calcined aluminum oxide particle was pretreated with an acid activation treatment.
283. The method of Claim 227, wherein the acid comprises an aliphatic or aryl carboxylic acid.
284. The method of Claim 227, wherein the acid comprises nitric acid, sulfuric acid, hydrochloric acid, boric acid, acetic acid, formic acid, phosphoric acid or mixtures thereof.
285. The method of Claim 227, wherein the acid is acetic acid or nitric acid.



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286. The method of Claim 227, wherein the concentration of the acid is from 0.15 N to 8.5 N.
287. The method of Claim 227, wherein the cross-linking temperature is from 25°C to 400°C.
288. The method of Claim 227, wherein the cross-linking temperature is from 70°C to 150°C and the binder is colloidal alumina or colloidal silica.
289. The method of Claim 234 wherein the removing is by heating or by using a drying agent.
290. The method of Claim 234, wherein the removing is by heating.
291. The method of Claim 234, wherein the binder comprises colloidal alumina, colloidal silica, a colloidal metal oxide wherein the metal is iron, or a mixture thereof.
292. The method of Claim 234, wherein the binder is colloidal alumina.
293. The method of Claim 234, wherein the binder is from 1% to 99.9% by weight of the mixture.
294. The method of Claim 234, wherein the binder is colloidal alumina and is from 10% to 35% by weight of the mixture.
295. The method of Claim 234, wherein component b comprises at least two different types of oxide adsorbent and/or catalyst particles.



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296. The method of Claim 234, wherein component b comprises ~~at least three~~ different types of oxide adsorbent and/or catalyst particles.
297. The method of Claim 234, wherein component b comprises a metal oxide particle.
298. The method of Claim 234, wherein component b comprises a non-ceramic, porous metal oxide particle.
299. The method of Claim 234, wherein component b comprises a particle of an oxide of aluminum, titanium, copper, vanadium, silicon, manganese, iron, zinc, zirconium, magnesium, calcium, strontium, barium, boron, gallium, indium, thallium, germanium, tin, lead, arsenic, antimony, or bismuth or zeolite or a mixture thereof.
300. The method of Claim 234, wherein component b comprises a mixture of at least two metal oxide particles having the same metal with varying stoichiometry and oxidation states.
301. The method of Claim 234, wherein component b comprises aluminum oxide, titanium dioxide, copper oxide, vanadium pentoxide, silicon dioxide, manganese dioxide, iron oxide, zinc oxide, zirconium oxide or zeolite particle.
302. The method of Claim 301, wherein component b further comprises a second type of adsorbent and/or catalyst particle of aluminum oxide, titanium dioxide, copper oxide, vanadium pentoxide, silicon dioxide, manganese dioxide, iron oxide, zinc oxide, zeolite, activated carbon, peat, zinc or tin particle.
303. The method of Claim 234, wherein component b comprises a non-amorphous, non-ceramic, crystalline, porous, calcined aluminum oxide particle that was



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produced by calcining the precursor to the calcined aluminum oxide at a particle temperature of from 300°C to 700°C.

304. The method of Claim 303, wherein the calcined aluminum oxide particle is in the gamma, chi-rho, or eta form.
305. The method of Claim 304, wherein the calcined aluminum oxide particle was pretreated with an acid activation treatment.
306. The method of Claim 234, wherein the acid comprises an aliphatic or aryl carboxylic acid.
307. The method of Claim 234, wherein the acid comprises nitric acid, sulfuric acid, hydrochloric acid, boric acid, acetic acid, formic acid, phosphoric acid or mixtures thereof.
308. The method of Claim 234, wherein the acid is acetic acid or nitric acid.
309. The method of Claim 234, wherein the concentration of the acid is from 0.15 N to 8.5 N.
310. The method of Claim 234, wherein the cross-linking temperature is from 25°C to 400°C.
311. The method of Claim 234, wherein the cross-linking temperature is from 70°C to 150°C and the binder is colloidal alumina or colloidal silica.
312. The system of Claim 99, wherein the binder is colloidal alumina, and the particle comprises aluminum oxide, mixed oxides of manganese, copper oxide, and carbon.

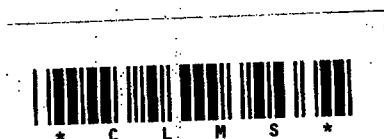


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313. The system of Claim 312, further comprising lithium hydroxide.
314. The process of claim 41, wherein the contaminant comprises an anion, an oxoanion, a cation, or a poly-oxoanion.
315. The method of claim 150, wherein the contaminant comprises an anion, an oxoanion, a cation, or a poly-oxoanion.
316. The method of Claim 65, wherein the heating step is from 25°C to 400°C.
317. The method of Claim 65, wherein the heating step is from 70°C to 150°C.
318. The method of Claim 96, wherein the binder is colloidal alumina.
319. The system of Claim 99, wherein the binder is not colloidal alumina or colloidal silica.
320. The system of Claim 99, wherein the oxide adsorbent and/or catalyst particle has not been acid enhanced treated.
321. The system of Claim 99, wherein the binder is colloidal alumina and the particle comprises aluminum oxide, zinc oxide and copper oxide.
322. The system of Claim 99, wherein the binder is colloidal alumina and the particle comprises aluminum oxide and copper oxide.
323. The system of Claim 99, wherein the system is not a catalyst support.
324. The system of Claim 113, wherein the particle temperature is from 400°C to 700°C.



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325. A method of encapsulating a contaminant within an adsorbent particle comprising heating the particle of Claim 37 that has adsorbed a contaminant to a temperature sufficient to close the pores of the particle to thereby encapsulate the contaminant within the particle.
326. The method of Claim 325, wherein the temperature is from 450°C to 2000°C.
327. The system of claim 99, wherein the particle (b) comprises Al_2O_3 , TiO_2 , CuO , Cu_2O , V_2O_5 , SiO_2 , MnO_2 , Mn_2O_3 , Mn_3O_4 , ZnO , WO_2 , WO_3 , Re_2O_7 , As_2O_3 , As_2O_5 , MgO , ThO_2 , Ag_2O , AgO , CdO , SnO_2 , PbO , FeO , Fe_2O_3 , Fe_3O_4 , Ru_2O_3 , RuO , OsO_4 , Sb_2O_3 , CoO , Co_2O_3 , NiO or zeolite.
328. The system of claim 327, wherein the particle (b) further comprises a second type of adsorbent and/or catalyst particles of an oxide of aluminum, titanium, copper, vanadium, silicon, manganese, iron, zinc, zirconium, tungsten, rhenium, arsenic, magnesium, thorium, silver, cadmium, tin, lead, antimony, ruthenium, osmium, cobalt or nickel or zeolite, activated carbon, including coal and coconut carbon, peat, zinc or tin.
329. The system of claim 99, wherein particle (b) comprises aluminum oxide, silicon dioxide and activated carbon.



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