Table 4 (continuation): Experimental data relating to the experiments carried out in Examples 1-10 (Examples 6-10 were carried out with acetone removal; Example 11 shows a comparative experiment)

Example/ sequence/ comments	Parameter	1st Extraction step				2nd Extraction step				3rd Extraction step				Overall process			
		Feed materials		Phases obtained		Feed materials		Phases obtained		Feed material		Phases obtained		TAA yield [based on product from A1]	NaOH feed [g]	NaOH feed [mol/mol NH_4NO_3-cat.]	NaOH feed [g/kg TAA]
		Organic phase	Extract-ant	Organic phase	Aqueous phase	Organic phase	Extract-ant	Organic phase	Aqueous phase	Organic phase	Extract-ant	Organic phase	Aqueous phase				
6/ A1-B-C1-D1/ 3 x crossflow; use of an NaOH solution; acetone content 16%	Phase/ Substance	from C1		OP1	WP1		NaOH (50%)	OP2	WP2		NaOH (50%)	OP3	WP3				
	Mass [g]	578	none, only phase separation	545	30.9		20	501	57.9		20	475	39.7				
	Content of TAA [g]	240		240	-	OP1	-	237	-	OP2	-	237	-	98.8%	30	3.61	127
	Content of $NaNO_3$ [3)]	3.1%		1.5%	26.3%		-	0.33%	16.2%		-	500 ppm	3.2%				
7/ A1-B-C1-D1/ 3 x crossflow; use of an NaOH solution; acetone content 3.6%	Phase/ Substance	from C1		OP1	WP1		NaOH (50%)	OP2	WP2		NaOH (50%)	OP3	WP3				
	Mass [g]	528	none, only phase separation	444	80.4		20	417	42.3		20	399	31.5				
	Content of TAA [g]	235		233	-	OP1	-	232	-	OP2	-	228	-	97.0%	30	3.61	132
	Content of $NaNO_3$ [3)]	3.35%		0.30%	21.4%		-	300 ppm	3.3%		-	<25 ppm [1)]	0.3%				
8/ A1-B-C1-D1/ 2 x crossflow; use of an NaOH solution; acetone content 3.6%	Phase/ Substance	from C1		OP1	WP1		NaOH (50%)	OP2	WP2								
	Mass [g]	528	none, only phase separation	441	81		40	405	69.4								
	Content of TAA [g]	235		234	-	OP1	-	231	-	Only two-stage extraction				98.3%	30	3.61	130
	Content of $NaNO_3$ [3)]	3.35%		0.27%	21.7%		-	110 ppm	1.92%								