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TITLE: PROCESS FOR PURIFYING HYDROXIDE COMPOUNDS**Technical Field**

This invention relates to a method of purifying hydroxide compounds. In particular, the invention relates to a method of recycling or purifying organic and inorganic hydroxide compounds using an electrochemical cell.

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Background of the Invention

Quaternary ammonium hydroxides such as tetramethylammonium hydroxide (TMAH) and tetraethyl ammonium hydroxide (TEAH) are strong organic bases that have been known for many years. Such quaternary ammonium hydroxides have found a variety of uses including use as a titrant for acids in organic solvents and as a supporting electrolyte in polarography. Aqueous solutions of quaternary ammonium hydroxides, particularly TMAH solutions, have been used extensively as a developer for photoresists in printed circuit board and microelectronic chip fabrication. Use of quaternary

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ammonium hydroxides in the electronics area requires that there be no residue following the normal post-bake period. In electronic applications, it is desirable that the aqueous solutions of quaternary ammonium hydroxides should be essentially free from metal ions such as sodium, potassium, zinc and calcium; anions such as halides, nitrates, nitrites, carbonates, carboxylates, sulfates and neutral organic species such as methanol, amines, etc. Particularly in recent years, there has been an increasing demand for quaternary ammonium hydroxides having a high purity.

U.S. Patent 4,714,530 (Hale et al) describes an electrolytic process for preparing high purity quaternary ammonium hydroxides which utilizes a cell containing a catholyte compartment and an anolyte compartment separated by a cation-exchange membrane. The process comprises charging an aqueous solution of a quaternary ammonium hydroxide to the anolyte compartment, adding water to the catholyte compartment, and passing a direct current through the electrolysis cell to produce a higher purity quaternary ammonium hydroxide in the catholyte compartment which is subsequently recovered. The '530 patent also describes an improvement which comprises heating the quaternary ammonium hydroxide at an elevated temperature prior to charging the hydroxide to the anolyte compartment of the electrolytic cell.

U.S. Patent 4,938,854 (Sharifian et al) also describes an electrolytic process for purifying quaternary ammonium hydroxides by lowering the latent halide content. The electrolytic cell may be divided into an anolyte compartment and a catholyte compartment by a divider which may be an anion or cation selective membrane. The cathode in the catholyte

compartment comprises zinc, cadmium, tin, lead, copper or titanium, or alloys thereof, mercury or mercury amalgam.

Japanese Kokai Patent No. 60-131985 (1985) (Takahashi et al) describes a method of manufacturing a high purity quaternary ammonium hydroxide in an electrolysis cell which is divided into an anode chamber and a cathode chamber by a cation exchange membrane. A quaternary ammonium hydroxide solution containing impurities is charged to the anode chamber and a direct current is supplied between two electrodes after water has been charged to the cathode chamber. Purified quaternary ammonium hydroxide is obtained from the cathode chamber. The purified quaternary ammonium hydroxide contains reduced amounts of alkali metals, alkaline earth metals, anions, etc.

SUMMARY OF THE INVENTION

In one embodiment, the present invention relates to a process for purifying or recycling solutions containing a hydroxide compound, including the steps of:

(A) providing an electrochemical cell containing an anode, a cathode, a cation selective membrane and a bipolar membrane, the bipolar membrane having an anion selective side facing the anode and a cation selective side facing the cathode, wherein the cation selective membrane is positioned between the anode and the bipolar membrane, and the bipolar membrane is positioned between the cation selective membrane and the cathode, thereby defining a feed compartment between the cation selective membrane and the anode, a recovery compartment between the bipolar

membrane and the cation selective membrane, and a water compartment between the bipolar membrane and the cathode;

(B) charging a solution of an ionic compound at a first concentration to the water compartment, and water to the recovery compartment;

(C) charging a solution containing the hydroxide compound at a second concentration to the feed compartment;

(D) passing a current through the electrochemical cell to produce the hydroxide compound at a third concentration in the recovery compartment; and

(E) recovering the hydroxide compound from the recovery compartment.

In another embodiment, the present invention relates to a process for purifying or recycling solutions containing quaternary ammonium hydroxide, including the steps of:

(A) providing an electrochemical cell containing an anode, a cathode and one or more unit cells assembled for operational positioning between the anode and the cathode, each unit cell comprising; (A-1) three compartments defined by, in sequence beginning at the anode, a cation selective membrane and a bipolar membrane, the bipolar membrane having an anion selective side facing the anode and a cation selective side facing the cathode; (A-2) six compartments defined by, in sequence beginning at the anode, a first cation selective membrane, a first bipolar membrane, an anion selective membrane, a second cation selective membrane and a second bipolar membrane, the first and second bipolar membranes each having an anion selective side facing the anode and a cation selective side

facing the cathode; (A-3) six compartments defined by, in sequence beginning at the anode, a first anion selective membrane, a first cation selective membrane, a bipolar membrane, a second anion selective membrane and a second cation selective membrane, the bipolar membrane having an anion selective side facing the anode and a cation selective side facing the cathode; or (A-4) four compartments defined by, in sequence beginning at the anode, an anion selective membrane, a cation selective membrane and a bipolar membrane, the bipolar membrane having an anion selective side facing the anode and a cation selective side facing the cathode;

(B) charging a solution of an ionic compound at a first concentration to the compartment in each unit cell formed by the anion selective membrane and anode, the anion selective membrane and bipolar membrane, and the cathode and bipolar membrane, and charging water to the compartment in each unit cell formed by the cathode and cation selective membrane, and the bipolar membrane and cation selective membrane;

(C) charging a solution of the quaternary ammonium hydroxide at a second concentration to the compartment in each unit cell formed by the cation selective membrane and anion selective membrane, and the cation selective membrane and anode;

(D) passing a current through the cell to produce quaternary ammonium hydroxide at a third concentration in the compartment in each unit cell formed by the cathode and cation selective membrane, and the bipolar membrane and cation selective membrane; and

(E) recovering quaternary ammonium hydroxide from the compartments in each unit cell formed by the cathode and cation selective membrane, and the bipolar membrane and cation selective membrane.

As a result of the methods of the claimed invention, recycled solutions of hydroxide compounds can be obtained in which the concentration and purity is increased. Recycling spent solutions of hydroxide compounds provides not only cost savings, but also environmental benefits by eliminating the need for synthesizing new hydroxide compound solutions and associated expensive purification processes. The relatively high concentration and purity of hydroxide compound solutions can effectively be used in numerous applications where hydroxide solutions are required.

Description of the Drawings

Figure 1A is a schematic representation of a three-compartment cell containing one unit cell useful for recycling solutions containing a hydroxide compound in accordance with the invention;

Figure 1B is a schematic representation of an electrochemical cell containing a stack of two units of the unit cell of Figure 1A in a monopolar configuration; and

Figure 1C is a schematic representation of an electrochemical cell containing a stack of two units of the unit cell of Figure 1A in a bipolar configuration.

Figure 2 is a schematic representation of a six-compartment electrochemical cell in accordance with the invention.

Figure 3 is a schematic representation of another six-compartment electrochemical cell in accordance with the invention.

Figure 4 is a schematic representation of an electrochemical cell containing a stack of two units in accordance with the invention.

Figure 5 is a schematic representation of a five-compartment electrochemical cell in accordance with the invention.

5 Figure 6A is a schematic representation of a four-compartment electrochemical cell containing one unit cell in accordance with the invention; and

Figure 6B is a schematic representation of an electrochemical cell containing two unit cells of Figure 6A in accordance with the invention.

10 Figure 7 is a schematic representation of a seven-compartment electrochemical cell in accordance with the invention.

Figure 8 is a schematic representation of another five-compartment electrochemical cell in accordance with the invention.

15 Description of the Preferred Embodiments

The hydroxide compounds may generally be characterized by the formula



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wherein A is an organic or inorganic group and x is an integer equal to the valence of A. In one embodiment, the hydroxide compound should be sufficiently soluble in a solution such as water, alcohol or organic liquid, or mixtures thereof to allow a useful conversion rate.

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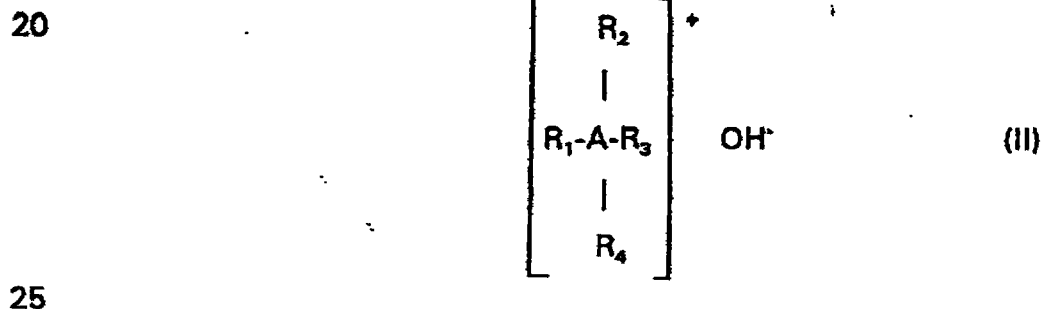
Examples of inorganic hydroxide compounds, which can be purified in accordance with the present invention, include metal hydroxides, for

instance the hydroxides of alkali metals such as sodium and potassium; alkaline earth metals such as magnesium and calcium; transition metals such as titanium, zirconium, chromium, manganese, iron, cobalt, nickel, copper, platinum; rare earth metals such as cerium, neodymium, samarium; etc.

5 Specific examples of inorganic hydroxide compounds which can be purified in accordance with the process of the present invention include potassium hydroxide, magnesium hydroxide, ferrous hydroxide, ferric hydroxide, cuprous hydroxide, cupric hydroxide, cobaltous hydroxide, cobaltic hydroxide, etc.

10 In another embodiment the process of the present invention is useful in preparing purified organic hydroxide compounds such as quaternary ammonium hydroxides, quaternary phosphonium hydroxides and tertiary sulfonium hydroxides. These organic hydroxides may collectively be referred to as onium hydroxides. In this and other embodiments, A in Formula (I)
15 above is an onium compound, and Formula (I) represents an onium hydroxide.

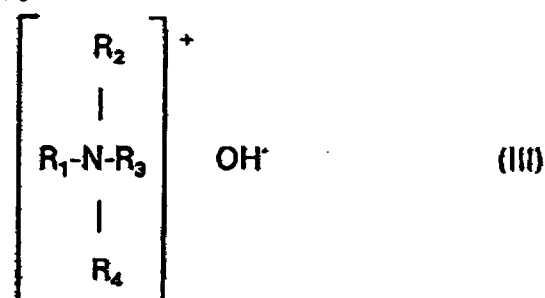
The quaternary ammonium and quaternary phosphonium hydroxides and may be characterized by the formula



wherein A is a nitrogen or phosphorus atom, R₁, R₂, R₃ and R₄ are each independently alkyl groups containing from 1 to about 20 carbon atoms, hydroxy alkyl or alkoxy alkyl groups containing from 2 to about 20 carbon atoms, aryl groups, or hydroxy aryl groups, or R₁ and R₂ together with A
5 may form a heterocyclic group provided that if the heterocyclic group contains a C=A group, R₃ is the second bond.

The alkyl groups R₁ to R₄ may be linear or branched, and specific examples of alkyl groups containing from 1 to 20 carbon atoms include methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, isooctyl, nonyl,
10 octyl, decyl, isodecyl, dodecyl, tridecyl, isotridecyl, hexadecyl and octadecyl groups. R₁, R₂, R₃ and R₄ also may be hydroxyalkyl groups such as hydroxyethyl and the various isomers of hydroxypropyl, hydroxybutyl, hydroxypentyl, etc. In one preferred embodiment, R₁-R₄ are independently alkyl groups containing one to ten carbon atoms and hydroxyalkyl groups
15 containing from two to three carbon atoms. Specific examples of alkoxyalkyl groups include ethoxyethyl, butoxymethyl, butoxybutyl, etc. Examples of various aryl and hydroxyaryl groups include phenyl, benzyl, and equivalent groups wherein benzene rings have been substituted with one or more hydroxy groups.

20 The quaternary ammonium hydroxides which can be purified in accordance with the process of the present invention may be represented by Formula III:



wherein R_1 - R_4 are as defined in Formula II. In one preferred embodiment, R_1 - R_4 are alkyl groups containing from 1 to about 3 carbon atoms and hydroxyalkyl groups containing 2 or 3 carbon atoms. Most often the quaternary ammonium hydroxides purified in accordance with the process of the invention will be tetramethylammonium hydroxide (TMAH) or tetraethylammonium hydroxide (TEAH). Specific examples of other such hydroxides include tetramethylammonium hydroxide, tetraethylammonium hydroxide, tetrapropylammonium hydroxide, tetrabutylammonium hydroxide, tetra-n-octylammonium hydroxide, trimethylhydroxyethylammonium hydroxide, trimethylmethoxyethylammonium hydroxide, dimethyldihydroxyethylammonium hydroxide, methyltrihydroxyethylammonium hydroxide, phenyltrimethylammonium hydroxide, phenyltriethylammonium hydroxide, benzyltrimethylammonium hydroxide, benzyltriethylammonium hydroxide, dimethylpyrrolidinium hydroxide, dimethylpiperidinium hydroxide, diisopropylimidazolinium hydroxide, N-alkylpyridinium hydroxide, etc.

Examples of quaternary phosphonium hydroxides representative of Formula II wherein $A=P$ which can be purified in accordance with the process of the present invention include tetramethylphosphonium hydroxide, tetraethylphosphonium hydroxide, tetrapropylphosphonium hydroxide,

tetrabutylphosphonium hydroxide, trimethylhydroxyethylphosphonium hydroxide, dimethyldihydroxyethylphosphonium hydroxide, methyltri-
hydroxyethylphosphonium hydroxide, phenyltrimethylphosphonium hydroxide,
phenyltriethylphosphonium hydroxide and benzyltrimethylphosphonium
hydroxide, etc.

In another embodiment, the tertiary sulfonium hydroxides which can be purified in accordance with this invention may be represented by the formula



wherein R_1 , R_2 and R_3 are each independently alkyl groups containing from 1 to about 20 carbon atoms, hydroxy alkyl or alkoxy alkyl groups containing from 2 to about 20 carbon atoms, aryl groups, or hydroxy aryl groups, or R_1 and R_2 together with S may form a heterocyclic group provided that if the heterocyclic group contains a C=S group, R_3 is the second bond.

Examples of the hydroxide compounds represented by Formula IV include trimethylsulfonium hydroxide, triethylsulfonium hydroxide, tripropylsulfonium hydroxide, etc.

The hydroxide compounds which are purified or recycled in accordance with the process of the present invention are mixtures, preferably solutions, containing an oxidizable liquid and from about 3% to

about 55% by weight of the hydroxide and generally will contain varying amounts of one or more undesirable anions such as halide, carbonate, formate, nitrite, nitrate, sulfate, etc., some cations such as metals including zinc and calcium, sodium, potassium and some neutral species such as methanol, amines, etc. For example, solutions of quaternary ammonium hydroxides prepared by the electrolysis of quaternary ammonium halides typically may contain, at 25% by weight of quaternary ammonium hydroxide, from about 15 to about 500 ppm of halide and up to about 10,000 ppm of nitrate. Unless otherwise specifically indicated in this application all references to ppm of halide, metals, or carbonates, etc., are for solutions containing 25% by weight of the hydroxide compound.

In one embodiment, the process of the present invention is effective in reducing the amount of either nitrate or halide present in solutions of hydroxide compounds such as quaternary ammonium hydroxides. In a further embodiment, the process of the present invention results in a reduction of halide as well as nitrate in a solution of a hydroxide compound such as quaternary ammonium hydroxide.

Hydroxide compounds are commercially available. Hydroxide compounds can be prepared from the corresponding salts such as halides, sulfates and the like. Various methods of preparation are described in U.S. Patents 4,917,781 (Sharifian et al) and 5,286,354 (Bard et al) which are hereby incorporated by reference. There is no particular limit as to how the hydroxide compound is obtained.

In accordance with the process of the present invention, the hydroxide compound such as those described above are purified or recycled in an electrochemical cell. The purification or recycлизация may be by electrolysis

in an electrolytic cell or by electrodialysis in an electrodialytic cell. The electrochemical cells generally contain an anode, a cathode, and one or more unit cells assembled for operational positioning between the anode and the cathode. A number of electrolytic and electrodialytic cells containing various unit cells and multiple unit cells are described herein which are useful in the process of the present invention. Multiple unit cells may be defined by a number of compartments between an anode and a cathode (see, for example, Figure 4), or multiple unit cells may be defined by a number of compartments including an anode and cathode (see, for example, Figures 1B and 1C). Multiple unit cells including an anode and cathode may take a monopolar configuration (see, for example, Figure 1B), or a bipolar configuration (see, for example, Figure 1C). There is no particular limit to the number of unit cells which can be used. Nevertheless, in one embodiment, electrochemical cells which are used according to the present invention contain from 1 to about 25 unit cells, and preferably from 1 to about 10 unit cells.

The unit cells may contain three or more compartments defined by the anode, cathode, one or more bipolar membranes and one or more dividers or separators which may be (1) nonionic microporous diffusion barriers such as screens, filters, diaphragms, etc., of controlled pore size or pore size distribution allowing certain ions to pass through the divider or separator, or (2) ionic dividers or separators such as anion selective membranes and cation selective membranes which are preferred since their use generally results in the production of hydroxide compounds of higher purity and in higher yield. The various dividers useful in the electrochemical cells used in the invention are described more fully below.

Electrochemical cells according to the invention contain at least three compartments; namely, a feed compartment, a water compartment and a recovery compartment. Optionally, electrochemical cells according to the invention may contain at least one pass compartment. In certain

5 embodiments, an electrochemical cell according to the invention may have two or more of each of the compartments described above. In other embodiments, the electrochemical cell may have two or more of one or more of the compartments listed above. For example, in one embodiment, an electrochemical cell may have a feed compartment, two water compartments
10 and a recovery compartment.

A solution is charged to each compartment. The solution may be aqueous based, alcohol based, an organic solution or combinations thereof. In a preferred embodiment, the solution charged into each compartment is an aqueous solution. The solution charged into the feed compartment contains
15 the hydroxide compound to be recycled or purified at a certain concentration. The concentration of the hydroxide compound initially charged into the feed compartment is in the range from about 0.01M to about 1M. In another embodiment, the concentration of the hydroxide compound in the solution charged to into the feed compartment is from
20 about 0.1M to about 0.5M. In electrochemical cells containing two or more feed compartments, the concentrations of the hydroxide compound in the solutions charged into the feed compartments may be the same or different for each feed compartment. The concentration of the hydroxide compound in the solution charged to the cell is from about 0.5% to about 50% by
25 weight and more often between 2% and 5% by weight. The feed

compartment, as the term implies, holds the solution containing a hydroxide compound which is to be recycled and processed by the electrochemical cell.

The water compartment contains a solution of an ionic compound at a certain concentration. The water compartment containing an ionic

5 compound serves to maintain conductivity and enable lower operating cell voltages. An ionic compound is a chemical compound that ionizes in solution, such as an electrolyte. Examples of ionic compounds include salts, metal salts and acids or any compound which forms an anion and cation when dissolved in water. In a preferred embodiment, the ionic compound is

10 the same as the hydroxide compound charged into the feed compartment. In another embodiment, the ionic compound is different from the hydroxide compound charged into the feed compartment. The concentration of the ionic compound in the water compartment is in the range from about 0.01M to about 2M. In a preferred embodiment, the concentration is from about

15 0.05M to about 1M. And in a most preferred embodiment, the concentration is from about 0.1M to about 0.5M. In electrochemical cells containing two or more water compartments, the concentrations of the ionic compound in the solutions charged into the water compartments may be the same or different for each water compartment.

20 The recovery compartment initially is charged with a solution and preferably an aqueous solution. The solution charged to the recovery compartment may or may not contain an ionic compound. After passing a current through the electrochemical cell, the hydroxide compound may be recovered or otherwise obtained from the recovery compartment at a certain

25 concentration. After passing a current through the electrochemical cell, the concentration of the hydroxide compound in the recovery compartment is

generally higher than the concentration of the hydroxide compound initially charged into the feed compartment. In one embodiment, the concentration of the hydroxide compound in the recovery compartment is above about 1M. In another embodiment, the concentration of the hydroxide compound in the recovery compartment is above about 1.5M. In a preferred embodiment, the concentration of the hydroxide compound in the recovery compartment is above about 2M. In electrochemical cells containing two or more recovery compartments, the concentrations of the hydroxide compound in the solutions recovered from the recovery compartments may be the same or different for each recovery compartment.

The pass compartment initially is charged with a solution and preferably an aqueous solution. The solution charged to the pass compartment may or may not contain an ionic compound. After passing a current through the electrochemical cell, the hydroxide compound passes through the pass compartment in embodiments where a pass compartment is used. Since most undesirable compounds do not pass through the pass compartment, the pass compartment serves to further purify the hydroxide compound.

Several embodiments of electrochemical cells which may be used in the invention will be described with reference to the figures. Although numerous embodiments of various electrochemical cells are described in the figures, it will be readily apparent to those skilled in the art that numerous embodiments not specifically described in the figures exist within the scope of the invention.

An embodiment of an electrochemical cell is illustrated in Figure 1A, which is a schematic representation of an electrochemical cell 2 containing a

cathode 3, an anode 4 and a unit cell containing in sequence beginning at the anode 4, a cation selective membrane 6, and a bipolar membrane 5. The bipolar membrane 5 has an anion selective side (not shown) facing the anode and a cation selective side (not shown) facing the cathode. The electrochemical cell 2 contains three compartments; namely, a feed compartment 9, a recovery compartment 8 and a water compartment 7.

In operation of the electrochemical cell illustrated in Figure 1A, a solution containing an ionic compound at a first concentration, such as a hydroxide compound, is charged to the water compartment 7. Water is charged to the recovery compartment 8. A solution containing a hydroxide compound such as tetramethylammonium hydroxide at a second concentration is fed to the feed compartment 9. An electrical potential is established and maintained between the anode and the cathode to produce a flow of current across the cell whereupon the quaternary ammonium cation is attracted toward the cathode and passes through the cation selective membrane 6 into the recovery compartment 8. The quaternary ammonium cation combines with hydroxide ions formed at the anion selective side of the bipolar membrane to produce the desired tetramethylammonium hydroxide. Impurities such as chloride ion are attracted to the anode and thus remain in the feed compartment 9. Purified tetramethylammonium hydroxide is formed and recovered from the recovery compartment 8.

In another embodiment, an electrochemical cell similar to that of Figure 1A, except that a polyunit cell of two unit cells utilized in a monopolar configuration, is illustrated in Figure 1B, which is a schematic representation of an electrochemical cell 10B containing a first cathode 11B, a second cathode 12B, an anode 13B and two unit cells containing in sequence,

beginning at the first cathode 11B, a first bipolar membrane 14B, a first cation selective membrane 15B, the anode 13B, a second cation selective membrane 16B, and a second bipolar membrane 17B. The bipolar membranes 14B and 17B have their anion selective sides (not shown) facing the anode 13B, and the cation selective side (not shown) of bipolar membrane 14B facing the first cathode 11B while the cation selective side (not shown) of bipolar membrane 17B facing the second cathode 12B. The electrochemical cell 10B illustrated in Figure 1B contains six compartments; namely, a first water compartment 18B, a first recovery compartment 19B, a first feed compartment 20B, a second feed compartment 21B, a second recovery compartment 22B and a second water compartment 23B.

In operation of the electrochemical cell illustrated in Figure 1B, a solution containing an ionic compound at a first concentration is charged to water compartments 18B and 23B. Water is charged to recovery compartments 19B and 22B. A solution containing a hydroxide compound at a second concentration is charged to feed compartments 20B and 21B. An electrical potential is established and maintained between the anode and the cathodes to produce a flow of current across the cell where upon the cation of the hydroxide compound is attracted to the respective cathodes thereby passing through either the first or the second cation selective membranes 15B and 16B into the recovery compartments 19B and 22B. The cation combines with hydroxide ions formed at the anion selective side of bipolar membranes 14B and 17B to produce the desired hydroxide compound at a third concentration at the recovery compartments 19B and 22B. The hydroxide compound is produced at a concentration higher than the concentration of the hydroxide compound charged to the feed

compartments. The hydroxide compound at a third concentration is then recovered from the recovery compartments 19B and 22B.

In another embodiment, an electrochemical cell similar to that of Figure 1A, except that a polyunit cell of two unit cells utilized in a bipolar configuration, is illustrated in Figure 1C, which is a schematic representation of an electrochemical cell 10C containing a first cathode 11C, a first anode 12C and in sequence beginning at the first cathode 11C, a first bipolar membrane 14C, a first cation selective membrane 15C, a second anode 24C, a second cathode 25C, a second bipolar membrane 17C, and a second cation selective membrane 16C. The bipolar membranes 14C and 17C have their anion selective sides (not shown) facing the anodes 24C and 12C, respectively, and the cation selective sides (not shown) of bipolar membranes 14C and 17C facing the cathodes 11C and 25C, respectively. The electrochemical cell 10C illustrated in Figure 1C contains six compartment; namely, a first water compartment 18C, a first recovery compartment 19C, a first feed compartment 20C, a second feed compartment 21C, a second recovery compartment 22C and a second water compartment 23C.

In operation of the electrochemical cell illustrated in Figure 1C, a solution containing an ionic compound at a first concentration is charged to water compartments 18C and 23C. Water is charged to recovery compartments 19C and 22C. A solution containing a hydroxide compound at a second concentration is charged to feed compartments 20C and 21C. An electrical potential is established and maintained between the anode and the cathodes to produce a flow of current across the cell where upon the cation of the hydroxide compound is attracted to the respective cathodes

thereby passing through either the first or the second cation selective membranes 15C and 16C into the recovery compartments 19C and 22C. The cation combines with hydroxide ions formed at the anion selective side of bipolar membranes 14C and 17C to produce the desired hydroxide compound at a third concentration at the recovery compartments 19C and 22C. The hydroxide compound is produced at a concentration higher than the concentration of the hydroxide compound charged to the feed compartments. The hydroxide compound at a third concentration is then recovered from the recovery compartments 19C and 22C.

In another embodiment, an electrochemical cell is illustrated in Figure 2, which is a schematic representation of an electrochemical cell 30 containing a cathode 31, an anode 32, and in sequence beginning at the anode 32, a first anion selective membrane 33, a first cation selective membrane 34, a bipolar membrane 36, a second anion selective membrane 35 and a second cation selective membrane 37. The bipolar membrane 36 has an anion selective side (not shown) facing the anode and a cation selective side (not shown) facing the cathode. The electrochemical cell 30 illustrated in Figure 2 contains six compartments; namely, a first water compartment 38, a first feed compartment 39, a first recovery compartment 40, a second water compartment 41, a second feed compartment 42, and a recovery compartment 43.

In operation of the electrochemical cell illustrated in Figure 2, a solution of an ionic compound at a first concentration is charged to the water compartments 38 and 41. Water is charged to the recovery compartments 40 and 43. A solution containing a hydroxide compound at a second concentration is charged to feed compartments 39 and 42. An

electrical potential is established and maintained between the anode and the cathode to produce a flow of current across the cell whereupon the cation of the hydroxide compound is attracted to the cathode and passes through either the first cation selective membrane 34 or the second cation selective membrane 37 into either the recovery compartment 40 or the recovery compartment 43. In recovery compartments 40 and 43, the cation combines with hydroxide ions formed at either the cathode 31 or the anion selective side of bipolar membrane 36 to produce the desired hydroxide compound at a third concentration. The hydroxide compound at a third concentration is then removed from the recovery compartments 40 and 43.

In another embodiment, an electrochemical cell is illustrated in Figure 3, which is a schematic representation of an electrochemical cell 50 containing a cathode 51, an anode 52 and in sequence beginning at the anode 52, a first cation selective membrane 53, a first bipolar membrane 54, an anion selective membrane 55, a second cation selective membrane 56, and a second bipolar membrane 57. The bipolar membranes 54 and 57 have an anion selective side (not shown) facing the anode and a cation selective side (not shown) facing the cathode. The cell 50 illustrated in Figure 3 contains six compartments; namely, a first feed compartment 58, a first recovery compartment 59, a first water compartment 60, a second feed compartment 61, a second recovery compartment 62, and a second water compartment 63.

In operation of the electrochemical cell illustrated in Figure 3, a solution containing an ionic compound at a first concentration is charged to the water compartments 60 and 63. Water is charged to the recovery compartments 59 and 62. A solution containing a hydroxide compound at a

second concentration is charged to feed compartments 58 and 61. An electrochemical potential is established and maintained between the anode and the cathode to produce a flow of current across the cell whereupon the cation of the hydroxide compound is attracted toward the cathode and
5 passes through either the first cation selective membrane 53 or the second cation selective membrane 56 into either the recovery compartment 59 or the recovery compartment 62. The cation combines with hydroxide ions formed either at the anion selective side of bipolar membrane 54 or the anion selective side of bipolar membrane 57 to produce the hydroxide compound
10 at a third concentration in the recovery compartments 59 and 62. The hydroxide compound at a third concentration is then recovered from recovery compartments 59 and 62.

In another embodiment, an electrochemical cell is illustrated in Figure 4, which is a schematic representation of an electrochemical cell 70
15 containing a cathode 71, an anode 72 and in sequence beginning at the anode 72, a first bipolar membrane 73, a first anion selective membrane 74, a first cation selective membrane 75, a second bipolar membrane 76, a second anion selective membrane 77, and a second cation selective membrane 78. The bipolar membranes 73 and 76 have an anion selective
20 side (not shown) facing the anode and a cation selective side (not shown) facing the cathode. The electrochemical cell 70 illustrated in Figure 4 contains seven compartments; namely, a first water compartment 79, a second water compartment 80, a first feed compartment 81, a first recovery compartment 82, a third water compartment 83, a second feed compartment
25 84, and a second recovery compartment 85.

In operation of the electrochemical cell illustrated in Figure 4, a solution of an ionic compound at a first concentration is charged to the water compartments. Water is charged to the recovery compartments. A solution containing a hydroxide compound at a second concentration is charged to the feed compartment. An electrical potential is established and maintained between the anode and the cathode to produce a flow or current across the cell whereupon the cation of the hydroxide compound is attracted towards the cathode and passes through either the first cation selective membrane 75 or the second cation selective membrane 78 and into either the recovery compartment 82 or the recovery compartment 85. The cation combines with hydroxide ions formed at either the anion selective side of the second bipolar membrane 76 or the cathode 71 to produce the hydroxide compound at a third concentration. The hydroxide compound at a third concentration is recovered from the recovery compartments 82 and 85.

In another embodiment, an electrochemical cell is illustrated in Figure 5, which is a schematic representation of an electrochemical cell 90 containing a cathode 91, an anode 92 and in sequence beginning at the anode 92, a first cation selective membrane 93, a first bipolar membrane 94, a second cation selective membrane 95, and a second bipolar membrane 96. The bipolar membranes 94 and 96 have an anion selective side (not shown) facing the anode and a cation selective side (not shown) facing the cathode. The electrochemical cell 90 illustrated in Figure 5 contains five compartments; namely, a first feed compartment 97, a first recovery compartment 98, a second feed compartment 99, a second recovery compartment 100, and a water compartment 101.

In operation of the electrochemical cell illustrated in Figure 5, a solution of an ionic compound at a first concentration is charged to the water compartment. Water is charged to the recovery compartments. A solution containing a hydroxide compound at a second concentration is charged to the feed compartment. An electrical potential is established and maintained between the anode and the cathode to produce a flow of current across the cell whereupon the cation of the hydroxide compound is attracted towards the cathode and passes through either the first cation selective membrane 93 or the second cation selective membrane 95 into either the recovery compartment 98 or the recovery compartment 100. The cation combines with hydroxide ions formed at either the anion selective side of the first bipolar membrane 94 or the anion selective side of the second bipolar membrane 96 to form the hydroxide compound at a third concentration in the recovery compartments 98 and 100. The hydroxide compound at a third concentration is recovered from the recovery compartments 98 and 100.

In another embodiment, an electrochemical cell is illustrated in Figures 6A and 6B. Figure 6A describes a single unit cell while Figure 6B describes a multiunit cell. Figure 6A is a schematic representation of an electrochemical cell 110 containing a cathode 111, an anode 112, and in sequence beginning at the anode 112, an anion selective membrane 113, a cation selective membrane 114, and a bipolar membrane 115. The bipolar membrane 115 has an anion selective side (not shown) facing the anode and a cation selective side (not shown) facing the cathode. The electrochemical cell 110 illustrated in Figure 6A contains four compartments; namely, a first water compartment 116, a feed compartment 117, a recovery compartment 118, and a second water compartment 119.

In operation of the electrochemical cell illustrated in Figure 6A, a solution containing an ionic compound at a first concentration is charged to the water compartments. Water is charged to the recovery compartment. A solution containing a hydroxide compound at a second concentration is charged to the feed compartment. An electrical potential is established and maintained between the anode and the cathode to produce a flow of current across the cell where upon the cation of the hydroxide compound is attracted towards the cathode and passes through the cation selective membrane 114 into the recovery compartment 118. The cations combines with hydroxide ions formed at the anion selective side of the bipolar membrane 115 to form the hydroxide compound at a third concentration in the recovery compartment 118. The hydroxide compound at a third concentration is removed from the recovery compartment 118.

Figure 6B is a schematic representation of an electrochemical cell 110B having two unit cells in a monopolar configuration containing a first cathode 111A, a second cathode 111B, an anode 112B, and in sequence beginning at the second cathode 111B, a first bipolar membrane 115B, a first cation selective membrane 114B, a first anion selective membrane 113B, a second anion selective membrane 113A, a second cation selective membrane 114A, and a second bipolar membrane 115A. The bipolar membranes 115A and 115B have an anion selective side (not shown) facing the anode, and bipolar membrane 115A has a cation selective side facing cathode 111A while bipolar membrane 115B has a cation selective side facing cathode 111B. The electrochemical cell 110B illustrated in Figure 6B contains eight compartments; namely, a first water compartment 119B, a first feed compartment 117B, a first recovery compartment 118B, a second

water compartment 116B, a third water compartment 116A, a second feed compartment 117A, a second recovery compartment 118A, and a fourth water compartment 119A.

5 In operation of the electrochemical cell illustrated in Figure 6B, the solution of an ionic compound at a first concentration is charged to the water compartments. Water is charged to the recovery compartments. A solution containing a hydroxide compound at a second concentration is charged to the feed compartments. An electrical potential is established and maintained between the anode and the cathode to produce a flow of current
10 across the cell whereupon the cation of the hydroxide compound in feed compartment 117A is attracted towards the first cathode 111A and the cation of the hydroxide compound in the feed compartment 117B is attracted towards the second cathode 111B thereby respectively passing through cation selective membrane 114A into recovery compartment 118A
15 or cation selective membrane 114B into recovery compartment 118B. The cation combines with hydroxide ions formed at the anion selective side of bipolar membranes 115B and 115A to produce the hydroxide compound at a third concentration in recovery compartments 118A and 118B. The hydroxide compound at a third concentration may be recovered from the
20 recovery compartments 118A and 118B.

In another embodiment, an electrochemical cell is illustrated in Figure 7, which is a schematic representation of an electrochemical cell 120 containing a cathode 121, and anode 122, and in sequence beginning at the anode 122, a first anion selective membrane 123, a first cation selective
25 membrane 124, a first bipolar membrane 125, a second anion selective membrane 126, a second cation selective membrane 127, and a second

bipolar membrane 128. The bipolar membranes 125 and 128 have an anion selective side (not shown) facing the anode and a cation selective side (not shown) facing the cathode. The electrolysis cell 120 illustrated in Figure 7 contains seven compartments; namely, a first water compartment 129, a
5 first feed compartment 130, a first recovery compartment 131, a second water compartment 132, a second feed compartment 133, a second recovery compartment 134, and a third water compartment 135.

In operation of the electrochemical cell illustrated in Figure 7, a solution containing an ionic compound at a first concentration is charged to
10 the water compartments. Water is charged to the recovery compartments. A solution containing a hydroxide compound at a second concentration is charged to the feed compartments. An electrical potential is established and maintained between the anode and the cathode to produce a flow of current
15 towards the cathode and passes through either the first cation selective membrane 124 or the second cation selective membrane 127 into either the first recovery compartment 131 or the second recovery compartment 134. The cation combines with hydroxide ions formed at either the anion selective
20 side of the bipolar membrane 125 or 128 to produce the desired hydroxide compound at the third concentration in the recovery compartments 131 and 134.

In another embodiment, an electrochemical cell is illustrated in Figure 8, which is a schematic representation of an electrochemical cell 140 containing a cathode 141, an anode 142, and in sequence beginning at the
25 anode 142, a first bipolar membrane 143, an anion selective membrane 144, a cation selective membrane 145, and a second bipolar membrane 146. The

bipolar membranes 143 and 146 have an anion selective side (not shown) facing the anode and a cation selective side (not shown) facing the cathode. The electrochemical cell 140 illustrated in Figure 8 contains five compartments; namely, a first water compartment 147, a second water
5 compartment 148, a feed compartment 149, a recovery compartment 150, and a third water compartment 151.

In operation of the electrochemical cell illustrated in Figure 8, a solution containing an ionic compound at a first concentration is charged to the water compartments. Water is charged to the recovery compartment. A
10 solution containing a hydroxide compound at a second concentration is charged to the feed compartment. An electrical potential is established and maintained between the anode and the cathode to produce a flow of current across the cell whereupon the cation of the hydroxide compound is attracted towards the cathode and passes through the cation selective membrane 145
15 into the recovery compartment 150. The cation combines with hydroxide ions formed at the anion selective side of the bipolar membrane 146 to produce the desired hydroxide compound at a third concentration in the recovery compartment 150. The hydroxide compound at a third concentration is recovered from the recovery compartment 150.

20 Since the desired product is the hydroxide compound, the recovery compartment contains a solution of water, alcohol, an organic liquid or a mixture of water and alcohol and/or an organic solvent provided that the recovery compartment contains sufficient water so that the desired hydroxide compound may form. The other compartments may contain
25 water, alcohol, or an organic liquid as described above, or a mixture of water, alcohol and/or an organic liquid.

Operation of the process of the present invention utilizing the electrochemical cells illustrated in Figures 1-8 generally is continuous and all of the liquids are continuously recirculated. Circulation is effected by pumping and/or by gas evolution. However, such electrochemical cells can be operated batchwise or in a continuous operation.

Various materials can be used as anodes in the electrochemical cells. For example, the anode may be made of metals such as titanium-coated electrodes, tantalum, zirconium, hafnium or alloys of the same. Generally, the anodes will have a non-passivable and catalytic film which may comprise metallic noble metals such as platinum, iridium, rhodium or alloys thereof, or a mixture of electroconductive oxides containing at least one oxide or mixed oxides of a noble metal such as platinum, iridium, ruthenium, palladium or rhodium. In one embodiment, the anode is a dimensionally stable anode such as an anode having a titanium base with ruthenium and/or iridium oxides thereon.

Various materials which have been used as cathodes in electrochemical cells can be included in the cells used in the above and other embodiments of the present invention. Cathode materials include nickel, iron, stainless steel, nickel plated titanium, graphite, carbon steel (iron) or alloys thereof etc. The term "alloy" is used in a broad sense and includes intimate mixtures of two or more metals as well as one metal coated onto another metal.

The electrochemical cell utilized in the process of the present invention contains at least one divider or separator, such as an ionic selective membrane, and at least one bipolar membrane. Compartments are defined as the area between two of: dividers and/or bipolar membranes and/or the

anode and/or cathode. The dividers and/or bipolar membranes function as diffusion barriers and/or gas separators.

The dividers or separators which can be utilized in the present invention can be selected from a wide variety of microporous diffusion barriers, screens, filters, diaphragms, etc., which contain pores of the
5 desired size allow cations of the hydroxide compound, such as onium cations, to migrate toward the cathode. The microporous dividers can be prepared from various materials including plastics such as polyethylene, polypropylene and Teflon, ceramics, etc. Microporous dividers such as
10 nonionic dividers can be used, for example, in addition to the dividers listed in the Figures. Specific examples of commercially available microporous separators include: Celanese Celgard and Norton Zitex. Microporous separators are particularly useful when the process of the present invention is utilized to purify the higher molecular weight hydroxides such as tetra n-
15 butyl phosphonium hydroxide and tetra n-butyl ammonium hydroxide.

The cation selective membranes used in the cells and the process of the invention may be any of those which have been used in the electrochemical purification or recycling of hydroxide compounds. Preferably, the cation-exchange membranes should contain a highly durable
20 material such as the membranes based on the fluorocarbon series, or from less expensive materials of the polystyrene or polypropylene series. Preferably, however, the cation selective membranes useful in the present invention include fluorinated membranes containing cation selective groups such as perfluorosulfonic acid and perfluorosulfonic and/perfluorocarboxylic
25 acid, perfluorocarbon polymer membranes such as sold by the E.I. duPont Nemours & Co. under the general trade designation "Nafion" such as

DuPont's Cationic Nafion 902 membrane. Other suitable cation selective membranes include styrenedivinyl benzene copolymer membranes containing cation selective groups such as sulfonate groups, carboxylate groups, etc.

Raipore Cationic R1010, (from Pall RAI), and NEOSEPTA CMH and

5 NEOSEPTA CM1 membranes from Tokuyama Soda are useful particularly with the higher molecular quaternary compounds. The preparation and structure of cation selective membranes are described in the chapter entitled "Membrane Technology" in *Encyclopedia of Chemical Technology*, Kirk-Othmer, Third Ed., Vol. 15, pp. 92-131, Wiley & Sons, New York, 1985.

10 These pages are hereby incorporated by reference for their disclosure of various cation selective membranes which can be useful in the process of the present invention.

Any anion selective membrane may be utilized including membranes used in processes for the desalination of brackish water. Preferably,
15 membranes should be selective with respect to the particular anions present in the cell (e.g., halide ions). The preparation and structure of anionic membranes are described in the chapter entitled "Membrane Technology" in *Encyclopedia of Chemical Technology*, Kirk-Othmer, Third Ed., Vol. 15, pp. 92-131, Wiley & Sons, New York, 1985. These pages are hereby

20 incorporated by reference for their disclosure of various anionic membranes which may be useful in the process of the present invention.

Among the anion selective membranes which may be utilized and which are commercially available are the following: AMFLON, Series 310, based on fluorinated polymer substituted with quaternary ammonium groups
25 produced by American Machine and Foundry Company; IONAC MA 3148, MA 3236 and MA 3475, based on polymer substituted with quaternary

ammonium derived from heterogenous polyvinylchloride produced by Ritter-Pfaulder Corp., Permutit Division; Tosflex IE-SF 34 or IE-SA 48 made by Tosoh Corp. which is a membrane designed to be stable in alkaline media; NEOSEPTA AMH, NEOSEPTA ACM, NEOSEPTA AFN or NEOSEPTA ACLE-SP from Tokuyama Soda Co.; and Selemion AMV and Selemion AAV from Asahi Glass. In one embodiment, the Tosflex IE-SF 34 and NEOSEPTA AMH anion exchange membranes are preferred because of their stability in alkaline solutions, such as the hydroxide containing solutions which are involved in the process of the invention.

The bipolar membranes used in the electrochemical cells are composite membranes containing three parts: a cation selective side or region, an anion selective side or region, and an interface between the two regions. When a direct current passes across a bipolar membrane, with the cation selective side toward or facing the cathode, electrical conduction is achieved by the transport of H^+ and OH^- ions which are produced by the dissociation of water which occurs at the interface under the influence of an electrical field. Bipolar membranes are described, for example, in U.S. Patents 2,829,095, 4,024,043 (single film bipolar membranes) and in 4,116,889 (cast bipolar membranes). The bipolar membranes useful in the process of the present invention include NEOSEPTA BIPOLAR 1 by Tokuyama Soda, WSI BIPOLAR, and Aqualytics Bipolar membranes.

Electrochemical purifying or recycling of the mixture containing the hydroxide compound contained in the feed compartment is effected by applying a current (generally direct current) between the anode and the cathode. The current which is passed through the electrochemical cell generally is a direct current dictated by the design and performance

characteristics of the cell which are readily apparent to those skilled in the art and/or can be determined by routine experimentation. Current densities between about 0.01 and about 4 amps per square inch are generally used, and current densities between about 0.3 and about 0.7 amps per square inch are preferred. Higher or lower current densities can be used for certain specific applications. The current density is applied to the cell for a period of time which is sufficient to result in the formation of the desired amount or concentration of the hydroxide compound in the recovery compartment.

During the electrochemical process, it is generally desirable that the temperature of the liquids within the cell be maintained within the range of from about 10°C to about 80°C, preferably from about 30°C to about 50°C, and particularly the temperature is maintained at about 40°C during the electrochemical process. Also during the electrochemical process, it is generally desirable that the pH of the liquids within the cell is highly alkaline. In one embodiment, the pH is about 13, and even above about 14. Since the claimed process is a purification process involving hydroxide, the pH changes as the process is practiced, and in particular, the pH generally increases as the process is practiced.

Although not wishing to be bound by any theory, operation of the electrochemical cells according to the invention is believed to be based, in part, on the migration of the cation of the hydroxide compound from the feed compartment to the recovery compartment as a result of the current applied.

The following examples illustrate the processes of the present invention. Unless otherwise indicated in the following examples and elsewhere in the specification and claims, all parts and percentages are by

weight, all temperatures are in degrees Centigrade, and pressure is at or near atmospheric pressure.

Example 1

5 An electrochemical cell according to Figure 1A is assembled. The anode is made of titanium coated with ruthenium oxide and the cathode is made of nickel. An aqueous solution of tetramethylammonium hydroxide is charged into the water compartment where the concentration is maintained between 0.1M to 0.5M. Water is charged into the recovery compartment.

10 A solution containing tetramethylammonium hydroxide at a concentration of about 0.2M, about 1,000 ppm nitrate and about 100 ppm chloride is charged to the feed compartment. An electrical potential is applied thereby causing tetramethylammonium cations to migrate towards the cathode thereby producing tetramethylammonium hydroxide in the recovery

15 compartment. The concentration of tetramethylammonium hydroxide in the recovery compartment is between 2M and 2.5M. The recovery compartment contains less than 10 ppm nitrate and less than 1 ppm chloride.

20 Example 2

 An electrochemical cell according to Figure 1A is assembled. The anode is made of titanium coated with iridium oxide and the cathode is made of stainless steel. An aqueous solution of tetramethylammonium hydroxide is charged into the water compartment where the concentration is

25 maintained between 0.1M to 0.5M. Water is charged into the recovery compartment. A solution containing tetramethylammonium hydroxide at a

concentration of about 0.2M and about 50 ppm chloride is charged to the feed compartment. An electrical potential is applied thereby causing tetramethylammonium cations to migrate towards the cathode thereby producing tetramethylammonium hydroxide in the recovery compartment.

5 The concentration of tetramethylammonium hydroxide in the recovery compartment is between 2M and 2.5M. The recovery compartment contains less than 1 ppm chloride.

Example 3

10 An electrochemical cell according to Figure 2 is assembled. The anode is made of titanium coated with ruthenium oxide and the cathode is made of nickel. An aqueous solution of tetramethylammonium hydroxide is charged into the water compartments where the concentration is maintained between 0.1M to 0.5M. Water is charged into the recovery compartments.

15 A solution containing spent tetramethylammonium hydroxide at a concentration of about 0.2M, about 1,000 ppm nitrate and about 100 ppm chloride is charged to the feed compartment. An electrical potential is applied thereby causing tetramethylammonium cations to migrate towards the cathode thereby producing clean tetramethylammonium hydroxide in the

20 recovery compartments. The concentration of tetramethylammonium hydroxide in the recovery compartments is between 2M and 2.5M. The recovery compartments contain less than 10 ppm nitrate and less than 1 ppm chloride.

Example 4

An electrochemical cell according to Figure 2 is assembled. The anode is made of titanium coated with iridium oxide and the cathode is made of stainless steel. An aqueous solution of tetramethylammonium hydroxide is charged into the water compartments where the concentration is maintained between 0.1M to 0.5M. Water is charged into the recovery compartments. A solution containing spent tetramethylammonium hydroxide at a concentration of about 0.2M and about 50 ppm ionic chloride is charged to the feed compartment. An electrical potential is applied thereby causing tetramethylammonium cations to migrate towards the cathode thereby producing clean tetramethylammonium hydroxide in the recovery compartments. The concentration of tetramethylammonium hydroxide in the recovery compartments is between 2M and 2.5M. The recovery compartments contain less than 1 ppm ionic chloride.

Example 5

An electrochemical cell according to Figure 1A is assembled. The anode is made of titanium coated with ruthenium oxide and the cathode is made of nickel. An aqueous solution of tetramethylammonium hydroxide is charged into the water compartment where the concentration is maintained between 0.2M to 0.5M. Water is charged into the recovery compartment. A solution containing tetramethylammonium hydroxide at a concentration of about 0.2M, about 2,000 ppm carbonate and about 200 ppm chloride is charged to the feed compartment. An electrical potential is applied thereby causing tetramethylammonium cations to migrate towards the cathode thereby producing tetramethylammonium hydroxide in the recovery

compartment. The concentration of tetramethylammonium hydroxide in the recovery compartment is between 2M and 2.5M. The recovery compartment contains less than 10 ppm carbonate and less than 1 ppm chloride.

5

Example 6

An electrochemical cell according to Figure 1A is assembled. The anode is made of titanium coated with iridium oxide and the cathode is made of stainless steel. An aqueous solution of tetramethylammonium hydroxide is charged into the water compartment where the concentration is maintained between 0.2M to 0.5M. Water is charged into the recovery compartment. A solution containing tetramethylammonium hydroxide at a concentration of about 0.2M, about 4,000 ppm nitrate and about 60 ppm chloride is charged to the feed compartment. An electrical potential is applied thereby causing tetramethylammonium cations to migrate towards the cathode thereby producing tetramethylammonium hydroxide in the recovery compartment. The concentration of tetramethylammonium hydroxide in the recovery compartment is between 2M and 2.5M. The recovery compartment contains less than 10 ppm nitrate and less than 1 ppm chloride.

10

15

20

Example 7

An electrochemical cell according to Figure 3 is assembled. The anode is made of titanium coated with ruthenium oxide and the cathode is made of nickel. An aqueous solution of tetramethylammonium hydroxide is charged into the water compartments where the concentration is maintained

25

between 0.2M to 0.5M. Water is charged into the recovery compartments. A solution containing tetramethylammonium hydroxide at a concentration of about 0.2M, about 3,000 ppm carbonate and about 400 ppm chloride is charged to the feed compartment. An electrical potential is applied thereby causing tetramethylammonium cations to migrate towards the cathode thereby producing tetramethylammonium hydroxide in the recovery compartments. The concentration of tetramethylammonium hydroxide in the recovery compartments is between 2M and 2.5M. The recovery compartments contain less than 10 ppm carbonate and less than 1 ppm chloride.

Example 8

An electrochemical cell according to Figure 3 is assembled. The anode is made of titanium coated with iridium oxide and the cathode is made of stainless steel. An aqueous solution of tetramethylammonium hydroxide is charged into the water compartments where the concentration is maintained between 0.2M to 0.5M. Water is charged into the recovery compartments. A solution containing tetramethylammonium hydroxide at a concentration of about 0.2M, about 5,000 ppm nitrate and about 500 ppm chloride is charged to the feed compartment. An electrical potential is applied thereby causing tetramethylammonium cations to migrate towards the cathode thereby producing tetramethylammonium hydroxide in the recovery compartments. The concentration of tetramethylammonium hydroxide in the recovery compartments is between 2M and 2.5M. The recovery compartments contain less than 10 ppm nitrate and less than 1 ppm chloride.

Example 9

An electrochemical cell according to Figure 1A is assembled. The anode is made of titanium coated with ruthenium oxide and the cathode is made of nickel. An aqueous solution of tetraethylammonium hydroxide is charged into the water compartment where the concentration is maintained between 0.1M to 0.5M. Water is charged into the recovery compartment. A solution containing tetraethylammonium hydroxide at a concentration of about 0.2M, about 500 ppm nitrate and about 100 ppm chloride is charged to the feed compartment. An electrical potential is applied thereby causing tetraethylammonium cations to migrate towards the cathode thereby producing tetraethylammonium hydroxide in the recovery compartment. The concentration of tetraethylammonium hydroxide in the recovery compartment is between 2M and 2.5M. The recovery compartment contains less than 10 ppm nitrate and less than 1 ppm chloride.

Example 10

An electrochemical cell according to Figure 2 is assembled. The anode is made of titanium coated with ruthenium oxide and the cathode is made of nickel. An aqueous solution of tetrabutylphosphonium hydroxide is charged into the water compartments where the concentration is maintained between 0.1M to 0.5M. Water is charged into the recovery compartments. A solution containing impure tetrabutylphosphonium hydroxide at a concentration of about 0.2M, about 100 ppm chloride, and potassium and magnesium impurities is charged to the feed compartment. An electrical potential is applied thereby causing tetrabutylphosphonium cations to migrate towards the cathode thereby producing tetrabutylphosphonium

hydroxide having reduced metallic impurities in the recovery compartments. The concentration of tetrabutylphosphonium hydroxide in the recovery compartments is between 2M and 2.5M. The recovery compartments contain less than 1 ppm chloride.

5 While the invention has been explained in relation to its preferred embodiments, it is to be understood that various modifications thereof will become apparent to those skilled in the art upon reading the specification. Therefore, it is to be understood that the invention disclosed herein is
10 intended to cover such modifications as fall within the scope of the appended claims.

What is claimed is:

1. A process for purifying solutions containing a hydroxide compound, comprising the steps of:

(A) providing an electrochemical cell comprising an anode, a cathode, a cation selective membrane and a bipolar membrane, the bipolar membrane having an anion selective side facing the anode and a cation selective side facing the cathode, wherein the cation selective membrane is positioned between the anode and the bipolar membrane, and the bipolar membrane is positioned between the cation selective membrane and the cathode, thereby defining a feed compartment between the cation selective membrane and the anode, a recovery compartment between the bipolar membrane and the cation selective membrane, and a water compartment between the bipolar membrane and the cathode;

(B) charging a solution of an ionic compound at a first concentration to the water compartment, and water to the recovery compartment;

(C) charging a solution containing the hydroxide compound at a second concentration to the feed compartment;

(D) passing a current through the electrochemical cell to produce the hydroxide compound at a third concentration in the recovery compartment; and

(E) recovering the hydroxide compound from the recovery compartment.

2. The process of claim 1, wherein the electrochemical cell further comprises a first anion selective membrane positioned between the cation selective membrane and the anode, a second anion selective membrane



positioned between the bipolar membrane and the cathode, and a second
5 cation selective membrane positioned between the second anion selective
membrane and the cathode, thereby defining a first water compartment
between the anode and the first anion selective membrane, a first feed
compartment between the first anion selective membrane and the cation
10 selective membrane, a first recovery compartment between the cation
selective membrane and the bipolar membrane, a second water compartment
between the bipolar membrane and the second anion selective membrane, a
second feed compartment between the second anion selective membrane
and the second cation selective membrane, and a second recovery
15 compartment between the second cation selective membrane and the
cathode, wherein the solution of the ionic compound is charged to each
water compartment, water is charged to each recovery compartment and the
solution of the hydroxide compound at a second concentration is charged to
each feed compartment.

3. The process of claim 1, wherein the electrochemical cell further
comprises an anion selective membrane positioned between the bipolar
membrane and the cathode, a second cation selective membrane positioned
between the anion selective membrane and the cathode, and second bipolar
5 membrane positioned between the second cation selective membrane and
the cathode, thereby defining a first feed compartment between the cation
selective membrane and the anode, a first recovery compartment between
the bipolar membrane and the cation selective membrane, a first water
compartment between the anion selective membrane and the bipolar
10 membrane, a second feed compartment between the second cation selective
membrane and the anion selective membrane, a second recovery



compartment between the second bipolar membrane and the second cation selective membrane, and a second water compartment between the cathode and the second bipolar membrane, wherein the solution of the ionic
15 compound is charged to each water compartment, water is charged to each recovery compartment and the solution of the hydroxide compound at a second concentration is charged to each feed compartment.

4. The process of claim 1, wherein the electrochemical cell further comprises a first anion selective membrane positioned between the cation selective membrane and the anode, a second bipolar membrane positioned between the first anion selective membrane and the anode, a second anion
5 selective membrane positioned between the bipolar membrane and the cathode, a second cation selective membrane positioned between the second anion selective membrane and the cathode, thereby defining a first water compartment between the second bipolar membrane and the anode, a second water compartment between the first anion selective membrane and the second bipolar membrane, a first feed compartment between the cation
10 selective membrane and the first anion selective membrane, a first recovery compartment between the bipolar membrane and the cation selective membrane, a third water compartment between second anion selective membrane and the bipolar membrane, a second feed compartment between the second cation selective membrane and the second anion selective
15 membrane, and a second recovery compartment between the cathode and the second cation selective membrane, wherein the solution of the ionic compound is charged to each water compartment; water is charged to each recovery compartment and the solution of the hydroxide compound at a
20 second concentration is charged to each feed compartment.



5. The process of claim 1, wherein the electrochemical cell further comprises a second cation selective membrane positioned between the bipolar membrane and the cathode, and a second bipolar membrane positioned between the second cation selective membrane and the cathode, thereby defining a water compartment between the second bipolar membrane and the cathode, a first recovery compartment between the second cation selective membrane and the second bipolar membrane, a first feed compartment between the bipolar membrane and the second cation selective membrane, a second recovery compartment between the cation selective membrane and the bipolar membrane, and a second feed compartment between the anode and the cation selective membrane, wherein water is charged to each recovery compartment and the solution of the hydroxide compound at a second concentration is charged to each feed compartment.

6. The process of claim 1, wherein the electrochemical cell further comprises an anion selective membrane positioned between the cation selective membrane and the anode, thereby defining a first water compartment between the bipolar membrane and the cathode, a recovery compartment between the cation selective membrane and the bipolar membrane, a feed compartment between the anion selective membrane and the cation selective membrane, and a second water compartment between the anode and the anion selective membrane, wherein the solution of the ionic compound is charged to each water compartment.

7. The process of claim 1, wherein the electrochemical cell further comprises a first anion selective membrane positioned between the cation selective membrane and the anode, a second anion selective membrane



5 positioned between the bipolar membrane and the cathode, a second cation
selective membrane positioned between the second anion selective
membrane and the cathode, and a second bipolar membrane positioned
between the second cation selective membrane and the cathode, thereby
defining a first water compartment between the first anion selective
membrane and the anode, a first feed compartment between the cation
10 selective membrane and the first anion selective membrane, a first recovery
compartment between the bipolar membrane and the cation selective
membrane, a second water compartment between the second anion
selective membrane and the bipolar membrane, a second feed compartment
between the second cation selective membrane and the second anion
15 selective membrane, a second recovery compartment between the second
bipolar membrane and the second cation selective membrane, and a third
water compartment between the cathode and the second bipolar membrane,
wherein the solution of the ionic compound is charged to each water
compartment, water is charged to each recovery compartment and the
20 solution of the hydroxide compound at a second concentration is charged to
each feed compartment.

8. The process of claim 1, wherein the electrochemical cell further
comprises an anion selective membrane positioned between the cation
selective membrane and the anode, and a second bipolar membrane
positioned between the anion selective membrane and the anode, thereby
5 defining a first water compartment between the bipolar membrane and the
cathode, a recovery compartment between the cation selective membrane
and the bipolar membrane, a feed compartment between the anion selective
membrane and the cation selective membrane, a second water compartment



10 between the second bipolar membrane and the anion selective membrane, a third water compartment between the anode and the second bipolar membrane, wherein the solution of the ionic compound is charged to each water compartment.

9. The process of claim 1, wherein the first concentration is between about 0.1 M to about 0.5 M.

10. The process of claim 1, wherein the third concentration is higher than the second concentration.

11. The process of claim 1, wherein the third concentration is above about 2 M.

12. The process of claim 1, wherein the ionic compound is same as the hydroxide compound.

13. The process of claim 1, wherein the hydroxide compound is a quaternary ammonium hydroxide, a quaternary phosphonium hydroxide or a tertiary sulfonium hydroxide.

14. The process of claim 1, wherein the hydroxide compound is a quaternary alkyl ammonium hydroxide.

15. The process of claim 1; wherein the hydroxide compound is tetramethyl ammonium hydroxide.

16. A process for purifying solutions containing quaternary ammonium hydroxide, comprising the steps of:

5 (A) providing an electrochemical cell comprising an anode, a cathode and one or more unit cells assembled for operational positioning between the anode and the cathode, each unit cell comprising;

(A-1) three compartments defined by, in sequence beginning at the anode, a cation selective membrane and a bipolar membrane, the bipolar



membrane having an anion selective side facing the anode and a cation selective side facing the cathode;

10 (A-2) six compartments defined by, in sequence beginning at the anode, a first cation selective membrane, a first bipolar membrane, an anion selective membrane, a second cation selective membrane and a second bipolar membrane, the first and second bipolar membranes each having an anion selective side facing the anode and a cation selective side facing the cathode;

15 (A-3) six compartments defined by, in sequence beginning at the anode, a first anion selective membrane, a first cation selective membrane, a bipolar membrane, a second anion selective membrane and a second cation selective membrane, the bipolar membrane having an anion selective side facing the anode and a cation selective side facing the cathode; or

20 (A-4) four compartments defined by, in sequence beginning at the anode, an anion selective membrane, a cation selective membrane and a bipolar membrane, the bipolar membrane having an anion selective side facing the anode and a cation selective side facing the cathode;

25 (B) charging a solution of an ionic compound at a first concentration to the compartment in each unit cell formed by the anion selective membrane and anode, the anion selective membrane and bipolar membrane, and the cathode and bipolar membrane, and charging water to the compartment in each unit cell formed by the cathode and cation selective membrane, and the bipolar membrane and cation selective membrane;

30 (C) charging a solution of the quaternary ammonium hydroxide at a second concentration to the compartment in each unit cell formed by the



35 cation selective membrane and anion selective membrane, and the cation selective membrane and anode;

(D) passing a current through the cell to produce quaternary ammonium hydroxide at a third concentration in the compartment in each unit cell formed by the cathode and cation selective membrane, and the bipolar membrane and cation selective membrane; and

40 (E) recovering quaternary ammonium hydroxide from the compartments in each unit cell formed by the cathode and cation selective membrane, and the bipolar membrane and cation selective membrane.

17. The process of claim 16, wherein the first concentration is between about 0.1 M to about 0.5 M.

18. The process of claim 16, wherein the third concentration is higher than the second concentration.

19. The process of claim 16, wherein the third concentration is above about 2 M.

20. The process of claim 16, wherein the electrochemical cell comprises at least one unit cell defined by (A-1).

21. The process of claim 16, wherein the electrochemical cell comprises at least one unit cell defined by (A-2).

22. The process of claim 16, wherein the electrochemical cell comprises at least one unit cell defined by (A-3).

23. The process of claim 16, wherein the electrochemical cell comprises at least one unit cell defined by (A-4).

24. The process of claim 16, wherein the quaternary ammonium hydroxide is tetramethyl ammonium hydroxide.

