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| (51) International Patent Classification <sup>6</sup> :<br><b>C07F 9/38</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | <b>A1</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | (11) International Publication Number: <b>WO 97/05149</b><br>(43) International Publication Date: 13 February 1997 (13.02.97) |
| (21) International Application Number: <b>PCT/GB96/01548</b><br>(22) International Filing Date: <b>27 June 1996 (27.06.96)</b><br>(30) Priority Data: <b>9515265.8</b> <b>25 July 1995 (25.07.95)</b> <b>GB</b><br>(71) Applicant (for all designated States except US): <b>ZENBECA LIMITED [GB/GB]; 15 Stanhope Gate, London W1Y 6LN (GB).</b><br>(72) Inventor; and<br>(75) Inventor/Applicant (for US only): <b>HODGKINSON, Ian [GB/GB]; 1 Bankfield Drive, Holmbridge, Huddersfield, Yorkshire HD7 1PH (GB).</b><br>(74) Agents: <b>RICKS, Michael, James et al.; Zeneca Agrochemicals, Intellectual Property Dept., Jealotts Hill Research Station, P.O. Box 3538, Bracknell, Berkshire RG42 6YA (GB).</b> | (81) Designated States: <b>AL, AM, AT, AU, AZ, BB, BG, BR, BY, CA, CH, CN, CZ, DE, DK, EE, ES, FI, GB, GE, HU, IL, IS, JP, KE, KG, KP, KR, KZ, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, TJ, TM, TR, TT, UA, UG, US, UZ, VN, ARIPO patent (KE, LS, MW, SD, SZ, UG), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG).</b><br><br><b>Published</b><br><i>With international search report.</i> |                                                                                                                               |
| (54) Title: <b>PROCESS FOR THE PREPARATION OF N-PHOSPHONOMETHYGLYCINE</b><br>(57) Abstract<br><p><i>N</i>-(phosphonomethylglycine)(glyphosate) or a salt or ionic form thereof is removed from an aqueous mixture such as an effluent stream in which it is present by addition to the mixture of ions capable of forming an insoluble or partially soluble complex glyphosate salt, and removing the complex salt from the mixture. Iron (III) ions are particularly suitable. In a preferred integrated process, glyphosate is recovered from the complex glyphosate salt.</p>                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                               |