





Cite this: *Green Chem.*, 2024, **26**, 7456

Safe and sustainable chemicals and materials: a review of sustainability assessment frameworks†

Carla Caldeira,‡ Elisabetta Abbate, Christian Moretti,  Lucia Mancini and Serenella Sala  *

In the context of the EU Chemicals Strategy for Sustainability, a key action regards the development of a framework to identify criteria for safe and sustainable by design chemicals and materials. The integration of safety and sustainability considerations is challenging, and this systematic review investigates how aspects pertaining to sustainability have been implemented in 155 frameworks proposed by scholars, industry, governments and non-governmental organizations. In particular, this review scrutinizes methods, models and indicators for environmental, social and economic aspects in frameworks combining multiple sustainability dimensions. Furthermore, the application of such frameworks to an early stage of chemicals and materials development was also analysed. The review unveiled that the majority of the frameworks are purely conceptual/theoretical, while some attempts are made by others towards providing methods and indicators for the assessment as well as operational procedure of decision support. Life cycle considerations are often remarked as necessary for evaluating the environmental sustainability of chemicals, climate change being the environmental impact mentioned by the majority of frameworks. Social sustainability aspects with quantitative indicators have been proposed only in a few studies so far. Another aspect often disregarded is data uncertainty. Although the reviewed frameworks showed several similarities in structure and aspects covered, indicators often differ significantly. Hence, using one framework instead of another might lead to a different outcome.

Received 24th November 2023,
Accepted 11th March 2024

DOI: 10.1039/d3gc04598f

rsc.li/greenchem

1. Introduction

The chemicals sector contributes to 7% of the global climate change impact and 10% of the global energy demand.^{1,2} Given the growing consumption of chemicals, the concern about their environmental, health, and social impacts has significantly grown.^{2–4}

A key policy goal defined in the European Green Deal is a zero pollution/toxic-free environment, together with climate neutrality, biodiversity protection, and circular economy.⁵ To support such ambition, the EU Chemicals Strategy for Sustainability (CSS) – Towards a Toxic-Free Environment puts forward actions to reduce impacts on human health and the environment associated with chemicals, materials, products, and services.⁶ In particular, the EU CSS calls for the definition of criteria for Safe and Sustainable by Design (SSbD) chemicals

and materials by integrating safety, circularity and functionality, minimizing their life cycle environmental footprint.

The selection of safer alternatives has been the subject of several studies proposing frameworks for the assessment.^{7–9} Following these frameworks, viable or new alternatives are screened before commercialization to avoid regrettable substitutions. These frameworks include a hazard and risk assessment^{10–13} focusing mostly on the physicochemical properties (e.g. flammability), human toxicity (e.g. carcinogenicity) and ecotoxicity (e.g. bioaccumulation) of chemicals and materials. Within the European Union, environmental, health, and safety (EHS) legislation criteria are set by the REACH regulation.¹⁴

A seminal approach to considering sustainability aspects in chemical development was proposed in the field of green chemistry. The Green Chemistry concept was introduced in the environmental protection strategy of the U.S. (United States) Environmental Protection Agency (EPA) in the early 1990s.¹⁵ This concept then became well known with the publication of the 12 Green Chemistry principles by Anastas and Warner¹⁶ which consider efficient utilization of raw materials and elimination of waste and toxic and/or hazardous substances.¹⁷

European Commission, Joint Research Centre, Via Enrico Fermi 2749, Ispra, Italy.

E-mail: serenella.sala@ec.europa.eu

† Electronic supplementary information (ESI) available. See DOI: <https://doi.org/10.1039/d3gc04598f>

‡ Current affiliation: Syensqo Lyon Research and Innovation Center, 85 Avenue des Freres Perret 69190 Saint-Fons, France.



In the past decade, the integration of sustainability aspects in the selection of chemicals and materials has been gaining prominence with the ambition of moving towards safer and more sustainable chemicals and materials.^{9,18–22} Incorporating chemicals' sustainability aspects besides safety allows accounting for trade-offs between exposure of humans and ecosystems and environmental impacts (e.g. climate change) associated with chemical production and supply chains.

To gain insights into which safety and sustainability aspects would be relevant to be included in a framework for the development of SSbD criteria for chemicals and materials, the European Commission Joint Research Centre (EC-JRC) carried out an initial review on how sustainability aspects have been implemented in decision frameworks for safety, identifying which dimensions, aspects, methods and indicators have been proposed, as well as the decision approaches applied in the overall sustainability assessment framework.²³ This review informed the development of the SSbD framework by the EC-JRC²⁴ that underpins the EC Recommendation establishing a European assessment framework for safe and sustainable by design chemicals and materials.²⁵ The framework considers the Green Chemistry principles key to design SSbD chemicals but their performance should be assessed by means of comprehensive sustainability assessment that considers the entire life cycle. A testing period by stakeholders is taking place and the revision of the framework built based on the feedback obtained during this period is foreseen. To inform the further development of the EC framework, a more systematic analysis of the frameworks is needed, especially unveiling the key scientific underpinning of the proposed framework, their level of operationalization and the focus to design support *versus* a proper and comprehensive assessment of the alternatives. Hence, this study aims to investigate indicators with respective methods covering sustainability aspects in frameworks integrating multiple sustainability dimensions and discuss the level of integration reached so far, highlighting frameworks used for the design of chemicals and materials, including in the early stage of development.

2. Materials and methods

A systematic procedure to select frameworks to be included in the review (section 2.1) is illustrated and the aims and structure of the review (section 2.2) presented, including the classification of the different sustainability aspects analysed (section 2.3).

2.1 Selection of the frameworks to be reviewed

This review scrutinized frameworks from different sources and proposed by different types of stakeholders. Hence, the frameworks were identified from scientific articles, grey literature and regulations. In this context, the term “framework” refers to any decision structure made of aspects and indicators to

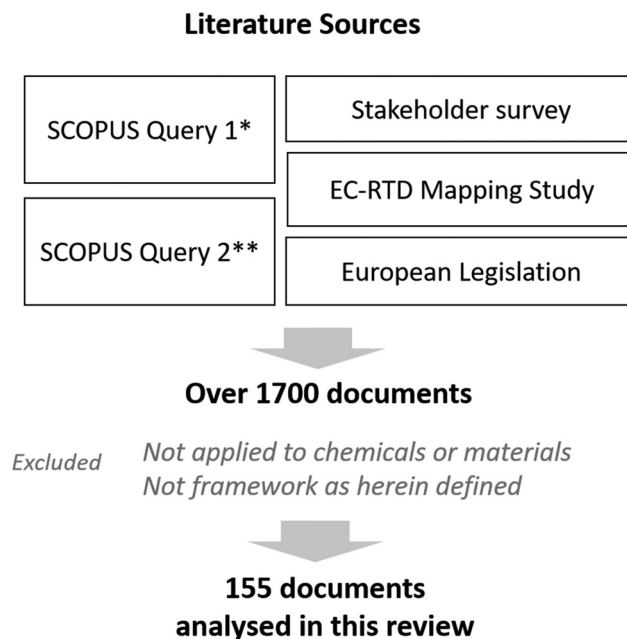


Fig. 1 Sources for the frameworks considered in this review. *as in Caldeira et al.²³ updated to May 2023. **new query considered for this review.

proceed from the relevant data to the outcome to inform future actions and support decision making. For example, a so-called framework can represent the decision structure implemented in chemical design tools.

An overview of sources used to perform this review is presented in Fig. 1. The review builds and expands on the review carried out by the EC-JRC,²³ the EC-RTD mapping study²⁶ and the results of a targeted stakeholders' survey.²⁷ The latter provided information mainly on grey literature and existing legislation that considers sustainability aspects.

Moreover, the scientific literature obtained from the Scopus database with query 1 characterized by terms linked to the concept of safe and sustainable chemicals§ was updated in May 2023 including 868 articles. The search string used in Scopus was characterised also by the terms “solvent”, “selection” and “guide” since solvent selection guides reporting alternative assessment frameworks for solvent selection have been used for more than 20 years in the pharmaceutical sector,²⁸ making this term well established. Moreover, since multi criteria decision analysis (MCDA) has been highlighted as a key instrument for sustainability assessment in general, as discussed in major works and reviews (e.g. ref. 29 and 30)

§TITLE-ABS-KEY ((“alternatives assessment” OR “chemicals alternative assessments” OR “alternatives analysis” OR “substitution assessment” OR “chemicals assessment” OR “solvent selection” OR “solvents selection” OR “solvent design” OR “safe and sustainable” OR “social LCA” OR “life cycle costing” OR “life cycle cost”) AND (“chemical” OR “chemicals” OR “solvent” OR “solvents”) AND (“framework” OR “frameworks” OR “guide” OR “guides” OR “methodology” OR “methodologies” OR “tool” OR “tools”)).



an additional search in the Scopus database with query 2¶ was done, returning over 1400 results.

Once duplicates (studies captured in both reviews) were eliminated, the abstracts were revised. Those dealing with topics not related to chemicals and materials *e.g.* in supply chain management (*e.g.*, supplier selection, transportation, location) and waste management (recycling, materials recovery, remediation) were excluded. The main text was considered in cases when reading the abstract and the title was not sufficient for such a screening. Additional frameworks not found directly by the Scopus search but cited by excluded case studies or reviews were also included in our analysis. In the end, 155 documents were considered in this review.

2.2 Aim and structure of the review

The main aim of this review is to update and extend the review carried out by Caldeira *et al.*²³ to inform the further development of the EC SSbD framework and to analyse to which extent the frameworks have been applied in the early stage of development of chemicals and materials. Therefore, frameworks introduced and adopted for chemicals and materials in the design phase were pinpointed to identify potential indicators used for sustainability assessment in the early stage of development. The following elements were collected and analysed in all the selected frameworks:

- i. Coverage of sustainability dimensions (*i.e.* safety, environmental, social, and economic) and aspects (*e.g.* climate change) as well as which indicators and respective methods are suggested.
- ii. Adoption of a life cycle approach and if so, what is the methodology and which are the environmental impacts considered. As mentioned in the Introduction, the EU CSS³¹ recalls the importance of a life cycle perspective in minimizing chemicals' potential impacts to detect shifts in burdens between impact categories, life cycle stages or geographic locations.
- iii. Decision support procedure implemented, including eventual scoring systems and the level of aggregation of the evaluation outcome as well as how data gaps and uncertainty were taken into account in the assessment.

2.3 Classification of the aspects considered in the reviewed frameworks

The aspects considered by the reviewed frameworks were classified into four categories as in Caldeira *et al.*²³

2.3.1. Resource, processing- and product-related aspects. Aspects related to the chemical/material production process *e.g.* efficiencies related to energy or chemical reactions, type of feedstock, *etc.* or products *e.g.* recycled content or durability; the aspects belonging to this level are often linked to pressures on multiple sustainability dimensions;

2.3.2. Pressure aspects. Aspects reflecting various pressures along the value chain such as emissions to water, soil or air, operational costs, working hours, *etc.*

2.3.3. Impact aspects. Aspects reflecting the effect *i.e.* the impacts (environmental, social, and economic) caused by resource and processing- and product-related aspects and by the pressure aspects. In the case of social and economic aspects, however, the assessment is usually limited to performance indicators, as clear impact pathways and impact assessment methods are not always available.³²

3. Frameworks for sustainability assessment of chemicals and materials

From the literature collected, 155 frameworks were selected to be analysed in detail as presented in the following sections. Section 3.1 provides an overview of the frameworks whilst section 3.2 provides detailed information on dimensions, aspects, and indicators. The consideration of life cycle approaches is discussed in section 3.3, the evaluation procedure adopted in section 3.4 and how data gaps and uncertainty were considered in section 3.5.

3.1 Overview of the frameworks analysed

Table 1 presents an overview of the frameworks regarding the field of application *i.e.* if it was applied to chemicals,|| materials,** or products,†† life cycle considerations, application in the early stage of development, decision procedure, uncertainty consideration and the stakeholder who developed the approaches (*e.g.* academia or industry). Most of the frameworks focused on chemicals⁸⁹ and materials,⁴³ and less on products.²⁰ 105 frameworks considered life cycle approaches, and 81 included the decision procedure in their analysis. Fewer frameworks included uncertainty.²⁵ Out of 155 frameworks, 102 were proposed by academia, 15 by certification schemes and 14 by industry. Eight frameworks for chemicals were proposed (or coordinated) by governmental agencies such as the European Environmental Agency³³ and the German Federal Environment Agency,³⁴ in Europe and the US National Research Council³⁵ and the USA-based Interstate Chemicals Clearinghouse³⁶ in USA. The 6 frameworks proposed by international organizations are designed for chemicals in general,^{37–40} plastics,⁴¹ nanomaterials⁴² and electronics.⁴³ The

|| Chemicals are substances and mixtures as defined in Registration, Evaluation, Authorization and Restriction of Chemicals (REACH) and Classification, Labelling and Packaging (CLP) legislations.

**Materials denote either substances or mixtures which may or may not yet fulfil the definition of an article under REACH and may be of natural or synthetic origin.²⁴

††Products are goods supplied for distribution, consumption or use on the Community market whether in return for payment or free of charge (EU Ecolabel). Materials denote either substances or mixtures which may or may not yet fulfil the definition of an article under REACH and may be of natural or synthetic origin.²⁴

¶TITLE-ABS-KEY (multicriteria OR multi-criteria OR "multiple criteria" OR mcdm OR mcdm OR multiattribute) AND (chemical OR material OR substance) AND (safe* OR sustainab*).



Table 1 Overview of the literature review regarding the consideration of the life cycle, application in the early stage of development, the decision procedure in place, the consideration of uncertainty and the type of document

Scope of the application	Total of frameworks	Life cycle consideration	Early stage application	Decision procedure	Uncertainty
Chemicals	89	59	35	48	12
Drug	1			★ 1	
Energy retardants	1			★ 1	★ 1
Flame retardants	3	★ 2	★ 2	★ 1	
Fluorinated greenhouse gases (F-gases)	1	■ 1			
Fragrance	2	★ ▲ 2	★ 1	★ 1	
Fuels	8	★ 3	★ 2	★ 8	★ 3
Metals	1	★ 1		★ 1	★ 1
Polymers	1	★ 1		★ 1	
Precursor	2	★ 2	★ 2	★ 2	
Solvents	33	★ 16	★ 16	★ 18	★ 5
Surfactant	1	★ 1		★ 1	
Not specified	35	● ★ 30	● ★ 12	★ 13	◆ 2
Materials	43	30	13	29	11
Additive manufacturing	1	★ 1		★ 1	
Bioplastics	1	★ 1	★ 1		
Building materials	18	▲ ★ 11	★ 7	★ 17	★ 8
Carbon fiber	1	★ 1			
Compositers	1	★ 1		1	
Nanomaterials	3	★ 5	★ 3	1	★ 1
Plastics	4	★ ▲ ● 5	★ 1	★ 1	
Protective membrane	1		★ 1	★ 1	★ 1
Textiles	4	▲ 1			
Vehicle (carrier)	2	★ 1		★ 2	
Not specified	6	★ 3		★ 5	★ 1
Products	20	14	1	4	1
Batteries	1	★ 1			
Chemical industry	1	★ 1		★ 1	
Cosmetics	1		★ 1	★ 1	
Electronics	2	▲ 2			
Energy	2	■ ★ 2			
Financial	1	■ 1			
IT	1				
Not specified	11	■ ◆ ▲ ● 7		● 2	● 1
Chemicals and materials	1	★ 1	★ 1		
Chemical and products	1				
Materials and products	1	▲ 1			
certification;		▲			
guidance;		●			
regulation;		■			
scientific paper; and		★			
tool.		◆			

4 frameworks from NGOs were developed for chemicals^{44–47} and electronics.⁴⁸

Fig. 2 depicts the dimensions covered *i.e.* safety, and environmental, economic, and social sustainability. Despite this division, the authors recognize that safety is integrated in sustainability: it is important to note that safety is a wide concept embedded in several Sustainable Developments Goals, and chemical safety is stated in several targets relating to human health, environmental quality, and access to services and resources. However, since the SSbD concept

distinguishes the two terms (safety and sustainability), the same was done in this work.

Most of the frameworks consider environmental and economic aspects⁴⁷ or only environmental.³⁷ A lower number of frameworks consider social aspects that are either combined with environmental aspects⁷ or with environmental and economic.²⁰ For the latter in which environmental, economic and social aspects are considered there are frameworks suggested for example in ref. 34, 36, 39 and 49–54.



Share (%) of frameworks covering sustainability dimensions



Fig. 2 Aspects covered by the literature for frameworks applied at low TRLs and developed products.

The work by Rossi *et al.*⁵³ is a seminal framework to guide alternative assessment of chemicals, materials, and products. The evaluation performed *via* this framework look at four major areas: (1) impacts on human health and the environment, (2) social justice impacts, (3) technical performance and (4) economic feasibility. The framework proposed by the German Environmental Agency (UBA) investigates potential impacts of chemicals on human health and the environment and on social responsibilities in supply chains,³⁴ while economic aspects are addressed to a minor extent only. The framework proposed by CEFIC (European Chemical Industry Council) is comprehensive in terms of covered dimensions but it is still at a conceptual level. The framework from the World Business Council on Sustainable Development (WBCSD) regards the Chemical Industry Methodology for Portfolio Sustainability Assessments (PSA).⁵⁵ This framework is built on two established guidance documents on assessing environmental and social impacts of chemical products based on a life cycle approach.^{56,57} This framework is a major reference for frameworks further developed by companies implementing in-house PSA methodologies.^{51,54,58} The framework proposed by the Interstate Chemicals Clearinghouse (IC2) includes considerations of the full life cycle of the product. Both environmental and social impacts are considered *via* a set of modules. A priority is given on the modules regarding hazard, cost, availability, performance evaluation, and exposure assessment – whilst others (Materials Management, Social Impact, and Life Cycle) should be considered if relevant to the particular chemical, product, or process under assessment. The Cradle to Cradle Certified® Product Standard presents a list of requirements that products should comply with, ranging from human health to product circularity, climate protection, and social fairness. It also includes water and soil stewardship, general requirements and recommendation for packaging.

A different distribution of the dimensions included has been observed for the frameworks that take the early stage of development into account. Fig. 2 clearly shows the low percentage of frameworks applied in the early stage of development analysing social aspects. Conversely, the economic aspect is covered by 53% of these frameworks, a percentage that drops to 32% for frameworks that do not focus on the design phase. This suggests the central role of economic aspects when dealing with new chemicals or materials in order to assess

further efforts in the development of the chemical/material under consideration. A similar trend can be observed for frameworks dealing with the environmental aspect, which is included in the majority of frameworks (around 80%), both those considering the early stage of development and those not. Frameworks focusing on single sustainability dimensions were rarely identified, suggesting that frameworks covering more than one aspect are preferred as they provide a broader analysis.

3.2 Dimensions, aspects and indicators

Section 3.2.1 provides an overview of resource and processing- and product-related aspects. These aspects are not considered under any dimension in particular and they refer to the characteristics of the process or the final product that directly affect the amount and type of pressure and related impacts in multiple dimensions. Then, aspects related to environmental, social, and economic dimensions are presented in sections 3.2.2, 3.2.3, and 3.2.4, respectively. Detailed information collected for each framework is presented in the excel file provided in the ESI.†

3.2.1 Aspects related to resource use, and processing- and product-related aspects. Resources and processing- and product-related aspects were further classified into four different groups:

- energy, including energy consumption/efficiency of a process or over the life cycle;
- circularity, considering features linked to reducing, reusing, repairing, refurbishing, remanufacturing, and recycling options;
- biodegradability, referring to the capacity for biological degradation of organic materials by living organisms down to the base substances such as water, carbon dioxide, methane, basic elements and biomass; and
- aspects related to the type and quantity of resources used and efficiency of the production process.

The indicators suggested in the frameworks associated with each aspect are summarized in Table 2, highlighting indicators used in frameworks in the early stage of development. Definitions and assessment methods are reported in the ESI.† Most of the frameworks include indicators related to the type and quantity of resources used. Indicators on biodegradability are seldom used, however with a slightly higher percentage in the case of frameworks considering the design phase. In contrast, circularity is highly analysed.

Energy. The amount of energy consumed^{‡‡} by a process, product or system was one of the most proposed indicators (46 frameworks). Energy efficiency and cumulative energy demand were also frequently used (32 frameworks). Cumulative energy demand is a sum of both the direct and indirect energy used

‡‡Annex 10 of the guide proposed by the German Environment Agency³⁴ provides a comprehensive overview of the energy consumption of chemicals and materials. In this guide, “green chemicals” are chemicals consuming less than 10 MJ kg⁻¹ during production, “yellow chemicals” between 10 and 100 MJ kg⁻¹ and “red chemicals” more than 100 MJ kg⁻¹.





Table 2 Indicators for resource, and processing- and product-related aspects

Aspect Indicator	Number of frameworks adopted	Early stage application	Aspect Indicator	Number of frameworks adopted	Early stage application
Resource, and processing- and product-related					
Energy	375	149	Marine biodegradability [–]	2	
	87	38	Octanol–water distribution coefficient [Kow]	2	2
Cumulative energy demand [MJ]	17	12	Soil biodegradability [–]	1	
Energy conservation [–]	2		Resources: types, quantity, and efficiency considerations		
			Amount of (solid/water) waste [kg or %]	17	68
Energy consumption [kW h or MJ]	39	14			
Energy efficiency [%]	17	4	Atom economy [%]	5	6
Energy intensity [kW h kg ^{–1} or MJ kg ^{–1}]	2	1	Biomass consumption [kg]	1	
Non-renewable resources with energy content [MJ]	1		Carbon economy [–]	1	1
Number of (process) steps [–]	1	1	E-factor [%]	6	4
Primary energy demand [MJ]	1	1	Fossil fuel consumption [kg]	1	1
Process carbon footprint	1	1	Global material economy [%]	1	1
Process efficiency [%]	1	1	Hazard Waste [kg]	2	1
Reaction efficiency [%]	2	2	Imported resources [E]	1	
Recycling energy [E]	1		Mass yield [%]	2	2
Renewable resources with energy content [MJ]	1		Material conservation [E]	2	
Stoichiometric factor	1	1	Material intensity index [%]	4	1
			Net mass of materials consumed [kg]	6	4
Circularity	112	36			
			Non-renewable resource amount [kg]	4	2
Aqueous waste valorisation [E]	1	1			
			Non-hazardous waste [kg]	2	1
Boiling temperature [°C]	10	5	Number of solvents [E]	1	1
Disassembly/repairability design [E]	10		Raw material consumption [kg per ton]	2	2
Durability [years]	13	4			
			Raw material origin [E]	2	2
Durability of the building [years]	1		Reaction efficiency [%]	10	5
Energy requirement for recycling [MJ kg ^{–1}]	2	1	Recycled input materials [%]	1	
Heat of vaporisation [MJ kg ^{–1}]	2	1	Relative process greenness [–]	1	1
Number of carbon atoms [E]	1		Renewability of resources [%]	5	5
Percentage of reclaimed products and their packaging materials [%]	1				
Purity of recovered solvent [%]	2	1	Renewable or fossil? [–]	18	6
Recyclable? [–]	12	3	Renewable resource amount [kg]	4	2
Recyclability/circularity [–]	21	8	Resource consumption [kg]	4	2
Recycled content [%]	12	1	Resource efficiency	1	1
Recycling efficiency/recovery rate [%]	9	4	Resource valorisation [–]	2	2
Reuse rate/reusability [–]	4	2	Solid waste [kg per ton]	2	1
Solvent selectivity [–]	2		Solid waste generation [kg]	5	2
Used organic solvent valorisation [–]	1	1	Solvent selectivity [–]	1	1
Waste reduction [–]	1	13	Use of critical raw materials? [–]	5	1
Waste utilization [–]	5	3	Waste characterisation potential [kg]	1	
			Waste cleaning [–]	2	
Yield of extraction (%)	2	7	Waste reduction algorithm [–]	1	1
Biodegradability	19				
Biodegradability [–]	4	1	Water consumption [m3]	32	7
Biodegradability requirement [–]	6		Water efficiency [m3]	1	
Biodegradability [–]	4	4			

throughout the life cycle. This indicator was often considered as a proxy for the increase or decrease of other environmental impacts that directly correlate with energy consumption such as climate change.^{3,59–62} However, the correlation between these two indicators are expected to become lower in future scenarios, considering the ambition of achieving an energy mix relying less on fossil fuels.

Circularity. Circularity related indicators have been proposed in 58 of the reviewed frameworks, of which 24 were focused on the design phase. The indicators mostly refer to the recyclability for chemicals and durability and reparability for products, with a high variability on how the recyclability of a chemical or product is defined. Some conceptually report information on its recyclability,³⁰ while others²¹ evaluate the recycled content or the recycling efficiency.

Various indicators measure the performance during distillation processes mostly found in frameworks applied to solvents as distillation is the major technique used by the chemical industries for recycling solvents.⁶³ These indicators were proposed in terms of amounts (e.g. the energy requirement for recycling), efficiencies (e.g. yield of extraction) or physical properties (e.g. boiling temperature). However, environmental trade-offs of recycling chemicals are overlooked using these indicators. For example, the energy needed for distillation to recover a solvent might be higher than producing it.⁶³

To minimize undesirable trade-offs of circularity, two innovative approaches were proposed in ref. 2 and 64. Chavarrio *et al.*⁶⁴ proposed a quantitative multi-criteria decision method based on both the solvent and extraction processes under consideration. This method relies on criteria such as the cost of the solvent, yield of extraction, purity of recovered solvent, heat of vaporization, boiling temperature, solvent selectivity, *etc.* Wang and Hellweg² proposed a two-step circularity assessment to evaluate approaches to reduce the major causes of chemical losses and qualitatively catalogue chemicals into six major categories leading to different management practices for recovering the embedded raw materials. As pointed out by Wang and Hellweg,² most of the indicators used for assessing circularity are mass-based and can be misleading in guiding environmental sustainability. The authors give the example of lithium-ion batteries for which higher energy consumption and air pollution arises from current recycling technologies than from primary production. It is therefore essential to couple mass-based circularity indicators with methods that assess the environmental impacts of the 'circular' system.

Biodegradability. Non-biodegradable chemicals can persist in the environment for a long time, and they may become a hazard. For this reason, biodegradability was often considered as an aspect belonging to the safety dimension instead of the environmental dimension. Biodegradability as a hazard (persistence and bioaccumulation) is considered in legislation, guidelines and standards as well as in ecolabel criteria,⁶⁵ e.g. for lubricants⁶⁶ or cosmetics.⁶⁷

As an environmental aspect, it was mostly qualitatively addressed. So, most frameworks mention biodegradability as

an aspect causing environmental issues but not providing information on a specific indicator or method to be used. Indicators regarding biodegradability were often discussed with respect to the biodegradability of plastics based on specific standards e.g. ASTM D-6400⁶⁸ or the standard EN13432.⁶⁹ In particular, no life cycle-based indicator regarding plastic littering was found. In fact, modelling littering requires a wide range of data regarding fate, exposure and effect modelling, which are mostly unavailable e.g. data regarding degradation rates of additives, effects from ingestion of plastic particles, *etc.*⁷⁰ However, the LCA community is developing research in this field on the development of harmonized pathways to account for impacts of plastic litter, specifically to the marine environment.⁷¹

Type and quantity of resources and efficiency of the production process. Regarding the type of resource, the distinction between fossil and renewable feedstock is frequently proposed. Chemical production heavily relies on non-renewable resources as the input,⁷² so the use of renewable resources instead of fossil ones to produce new chemicals is regarded as a possible way to improve chemicals' environmental sustainability (26 frameworks). A couple of frameworks developed by the pharmaceutical industry conceptualized this indicator in terms of the percentage of fossil feedstock over the total feedstock.^{73,74} A more articulated indicator *via* multiple scores for the use of resources considering the availability of both renewable and non-renewable raw materials is proposed by the German Environment Agency.³⁴ However, similar to the mass-based indicators for circularity, the use of renewable feedstocks, such as biomass feedstock, can be misleading regarding environmental sustainability.

Water is the resource that most of the frameworks pointed out as a key aspect to consider, water consumption (m3) being the most recommended indicator at the pressure level (32 frameworks).

The amount of waste generated and the net mass of materials consumed were also recommended by 24 and 6 frameworks, respectively. The argument in favour of easy-to-calculate mass-based metrics measuring waste generation is often a proxy for the trends of most environmental impacts.^{4,17} Indicators typically used in Green Chemistry such as atom economy and *E*-factor and similar mass-based metrics that can be expressed in terms of *E*-factors (e.g. mass intensity = *E*-factor + 1)¹⁷ were also often proposed.

The idea behind mass-based metrics used in green chemistry is that the amount of waste generated is often a good proxy for all other environmental impacts.⁴ However, this assumption would lead to misleading outcomes in other cases, such as environmental comparisons between fossil and bio-based alternatives.^{17,22}

3.2.2 Environmental dimension. This section presents the aspects related to the environmental dimension considered in the frameworks either at the pressure or impact level (Table 3). Environmental impacts caused by pressures can be quantified at two levels: at the midpoint level *i.e.* the direct consequence of the pressure and the endpoint level *i.e.* damage caused to



Table 3 Aspects under the environmental dimension at pressure and impact levels, including those used in the early stage of development

Aspect	Indicator	Number of frameworks adopted	Early stage application	Aspect	Indicator	Number of frameworks adopted	Early stage application
Environmental Pressure		459	181	Photochemical Ozone Formation		29	15
Air emission		25	12	Photochemical oxidant formation and ecosystems [kg NO _x -eq to air]		1	1
Air emissions		3	3	Photochemical oxidant formation and human health [kg NO _x -eq to air]		1	1
Atmospheric CO ₂ emissions [g]		3	1	Photochemical oxidation potential [PCO]		2	2
Atmospheric NO _x emissions [g]		5	2	POCP [kg of ethene-eq or kg NMVOC or kg O ₃]		25	11
Atmospheric SO ₂ emissions [g]		3	1	Acidification		35	12
Atmospheric VOC emissions [g]		2	1	Acidification potential [mole H + eq]		20	3
Critical air mass [%]		2	2	Aquatic acidification [kg H + ions]		1	1
Dimethylformamide [g]		3	2	Atmospheric acidification [kg SO ₂ -eq]		2	2
Fine particulate matter (mg PM 2.5)		4	1	Terrestrial acidification [kg SO ₂ -eq]		12	6
Water emission		18	13	Eutrophication		36	14
Biological oxygen demand 5 [g]		3	2	Eutrophication potential [kg of phosphate]		19	5
Chemical oxygen demand [g]		3	2	Freshwater eutrophication potential [kg P eq]		10	5
Contaminant emission [g]		1	1	Marine eutrophication potential [mol N eq]		6	4
Critical water mass [%]		2	2	Terrestrial eutrophication potential [kg of N equivalents]		1	1
Total organic carbon [kg]		4	4	Resources		62	22
Water Discharge quality		2	3	Damage to Resources [-]		4	3
Water emissions [kg m ⁻³]		1	1	Eco-indicator 99 depletion of resources [-]		1	1
Soil emission		1	1	Fossil resource scarcity [kg oil eq.]		2	1
Soil emissions		61	25	Land occupation [m ² a crop eq.]		8	3
Toxicity		1	1	Land requirements		1	1
Bioconcentration factor		3	1	Land Use [M ha]		1	1
Ecotoxicity [CTU]		5	1	Land use [kg C deficit]		2	1
Ecotoxicity [-]		1	1	Land use [-]		5	2
Ecotoxicity damage [PDF m3d]		4	3	Limiting depletion of fossil/mineral resources [-]		4	2
Freshwater [eco]toxicity [CTUe]		5	2	Mineral resource scarcity [kg Cu eq.]		1	1
Freshwater ecotoxicity [g C ₆ H ₄ Cl ₂ -eq]		4	2	Resource depletion potential [kg Sb eq.]		7	1
Human toxicity - cancer potential [CTUh]		3	1	Resource use/depletion - fossil [MJ]		14	7
Human toxicity - no cancer potential [CTUh]		7	1	Water consumption potential [m ³ eq]		1	1
Human toxicity [-]		9	5	Water depletion potential [m ³ eq]		10	2
Indoor air quality [-]		3	1	water footprints [m ³ eq]		1	1
LCT human toxicity [mg intake]		3	1	Endpoint			
Marine ecotoxicity [g C ₆ H ₄ Cl ₂ -eq]		1	1	Air pollution - air pollution and acidification [DALY]		1	1
Respiratory inorganics		1	1	Biodiversity protection (conceptual)		10	1
Smog potential [kg NO _x eq.]		10	5	Chemicals safety		2	1
Terrestrial ecotoxicity [g C ₆ H ₄ Cl ₂ -eq]		95	33	Climate change damage [DALY]		2	2
Climate Change		1	3	Air and water pollution [DALY]		1	1
C factor		4	3	Eco-indicator 99 total [-]		8	2
Climate change [-]		1	1	Eco-indicator 99 ecosystem quality [-]		2	1
CO ₂ balance		89	12	Eco-Indicator 99 human health [DALY]		2	1
GWP 100 [kg CO ₂ -eq]		26	11	Ecosystem quality (recipe)		3	2
Stratospheric ozone depletion		1	5	Ecosystems (species year)		5	1
Ozone depletion [-]		25	1	Ecosystem damage (conceptual)		2	1
Ozone depletion potential [kg CFC-11]		10	2	Embodied biodiversity footprints		1	1
Particulate Matter		2	2	Human health (DALY)		8	2
Particulate matter [PM2.5eq]		2	2	Human health (recipe)		3	2
Ionizing radiation		2	2	Inherent safety indicator		1	1
Ionizing radiation [kBq U235 eq.]		2	2	Ionizing radiation-human health [DALY]		1	1
				Oral toxicity [-log LD50]		1	1
				Resource depletion [\$]		3	3



the ecosystem and human health. The latter is presented in Table 3 under “Integrated assessment”.

Regarding indicators at the pressure level, NO_x , SO_2 , CO_2 and fine particulate matter released into the air have been proposed as indicators in 3–4 frameworks. The indicator named the “critical air mass” index is an old environmental indicator proposed already in the nineties in chemicals’ selection tools and early studies on green chemistry.^{75,76} This indicator represents the mass of a specific type of air emissions (e.g. SO_2) emitted by a process over a standard value typically representing the maximum acceptable amount of that pollutant e.g. based on legislation requirements.

Critical water mass is analogous to the critical air mass indicator but for the water compartment.^{75,76} Another indicator related to water emissions reported in the reviewed frameworks was the total organic carbon proposed to measure water pollution, especially by guides from the pharmaceutical industry.^{73,74,77} This indicator refers to the total soluble and insoluble organic matter entering water bodies. Biological oxygen demand and chemical oxygen have been proposed by three frameworks each. These indicators are common indicators to measure water quality.⁷⁸ Finally, one indicator regarding soil emission was found at the pressure level mentioned by one framework.⁷⁹ Still, the indicator was just mentioned without providing further information. Besides “soil biodegradability” in the resource dimension, no other indicators to evaluate impacts on soil were found. Indicators linked to the soil impacts are “Terrestrial eutrophication potential”, “Terrestrial ecotoxicity”, and “Terrestrial acidification”. This emphasizes the lack of interest in monitoring and assessing the impact on soils, focusing more attention on water and air emissions. In light also with the recent Proposal for a Directive on Soil Monitoring and Resilience,⁸⁰ there is a need to develop and include indicators representative of the soil compartments both at the pressure and impact levels in the future.

A particular indicator with a single occurrence⁸¹ is a pressure-based indicator used as a proxy for toxicity in the EPA’s GREENSCOPE (Gauging Reaction Effectiveness for the Environmental Sustainability of Chemistries with a multi-Objective Process Evaluator) tool. The definition of this indicator is detailed in Ruiz-Mercado *et al.*⁸² Essentially, this indicator represents the ratio between the total mass of toxins released over the total mass of products.

Regarding the environmental impacts, there were numerous (slightly) different versions of mid-point level indicators covering the same aspect in the reviewed framework. Therefore, indicators were grouped with the closest indicator in the counting when reasonably connected to another one in the list. For example, if the acidification potential was reported with a missing unit or a slightly different name, it was counted as the same indicator.

As presented in Table 3, environmental impacts at the mid-point level in the reviewed frameworks relate to climate change, toxicity, pollution such as acidification, eutrophication, ozone depletion, photochemical ozone formation, particulate matter and ionizing radiation, and resources and e.g. land use or water depletion.

The most suggested indicator in the frameworks is by far the global warming potential.⁸⁹ This indicator represents the sum of Greenhouse Gas (GHG) emissions multiplied by the specific characterization factor. The calculation of this indicator depends on the time-scale, which was always 100 years in the reviewed frameworks reporting this indicator. The high occurrence of this indicator is due to both a broad acknowledgment of the priority of dealing with climate change and the scientific consensus on the model underpinning this indicator.⁸³ This indicator is also adopted in various EU policies, especially for energy and alternative fuels.^{84,85}

Stratospheric ozone depletion potential is suggested in 25 frameworks. The calculation of this indicator is based on a steady-state ozone depletion potential model.⁸⁶ The indicator obtained from this characterization model represents the relative measure of the expected impact on ozone per unit mass emission of a gas compared to that expected from the same mass emission of CFC-11. The broad suggestion for this indicator reflects both consensuses on the methodology for its calculation and a broad scientific acknowledgment of the impact caused by the depletion of the ozone layer on humans (e.g. increased skin cancer cases) and plants. Substances causing ozone depletion have been listed in the Montreal Protocol on Substances that Deplete the Ozone Layer, which entered into force already on January 1, 1989.⁸⁷

The photochemical oxidant formation potential, ozone depletion potential, eutrophication potential, and acidification potential were often suggested in the reviewed frameworks. Photochemical ozone formation directly or indirectly impacts human health *via* the generation of ozone at the ground level. To measure photochemical ozone formation impacts, photochemical ozone creation potential was suggested by two frameworks in the early stage of development. The LOTOS-EUROS⁸⁸ model is the most common method behind this indicator. Using this model, the photochemical ozone creation potential is determined by comparing the rate at which a unit mass of chemical reacts with a hydroxyl radical (OH^\bullet) to the rate at which a unit mass of ethylene reacts with OH^\bullet .

The reviewed frameworks have frequently reported indicators for eutrophication and acidification impacts. These indicators are often considered when comparing bio-based and petrochemical alternatives.^{70,89–93} In fact, eutrophication and acidification impacts are usually higher for bio-based alternatives than petrochemical ones. Eutrophication is due to the release of nutrients to soil or freshwater due to fuel combustion and fertilizers in agriculture. In aquatic compartments, such nutrient excess causes the growth of algae or other plants, limiting the development of the original ecosystem. Models for the calculation of eutrophication indicators can provide a single value with no distinction per compartment⁹⁴ or a separate result for freshwater and marine compartments⁹⁵ and terrestrial compartment.⁹⁶

Available models for calculating acidification potentials usually refer to terrestrial acidification due to atmospheric deposition of acidifying compounds.⁹⁶ Terrestrial acidification is a global threat to plant diversity.⁹⁷ The most significant source of



acidification is fuel combustion processes, especially for fuels with a high sulphur content as those used *e.g.* in tractors.

Regarding resources, the reviewed frameworks have often considered resource use/depletion – fossil (MJ), water depletion potential and land use indicators. For the depletion of fossil resources, the scarcity/resource depletion model in ref. 98 is implemented in most LCA midpoint methods. The same model can also provide an indicator for the depletion of metal and mineral resources suggested in 14 of the reviewed frameworks.

The method underpinning the water depletion potential indicator suggested by most frameworks is the Swiss Ecological Scarcity Method.⁹⁹ However, the AWARE model¹⁰⁰ has emerged more recently and it is currently recommended by the European Commission.¹⁰¹ This model provides an indicator with the same unit as the Swiss Ecological Scarcity Method but with significantly different modelling of the characterization factors.

The indicators related to land use mentioned by the reviewed frameworks are based on various methods and models such as the Swiss Ecological Scarcity Method,⁹⁹ Ecoindicator 99,¹⁰² the Soil Organic Matter model¹⁰³ and the LANCA model.¹⁰⁴ Also for land indicators, different models are not directly comparable even if the indicator might have the same unit since the characterization modelling often focuses on a different land-use aspect and covers different land types.

As also remarked as relevant by the EU CSS, various frameworks propose life cycle midpoint indicators for aspects typically considered in safety/risk assessments like ecotoxicity and human toxicity. The suggested indicators are based on various methods and models: the ReCiPe 2016 impact method,⁹⁵ the USEtox model,¹⁰⁵ the CML 2001 method⁹⁴ and EDIP97.¹⁰⁶ Indicators for toxicity aspects based on a different method/model provide significantly different results even when expressed for the same unit *e.g.* some do not consider certain compartments or do not consider acute (*i.e.* short-term) toxic effects in the ecotoxicity category.

Despite some LCA indicators for toxicity aspects being suggested by various frameworks, this should not lead to the thinking that LCA can replace risk assessments to evaluate whether a process is safe.³⁵ In fact, there is no direct equivalency between LCA toxicity-related midpoint impacts and outcomes from risk assessments. For example, LCA does not generally consider the direct exposure pathways from a product but through exposure in environmental media.⁶² However, there are some attempts to bridge the gap between LCA and risk assessment.^{107–110}

Another indicator proposed by various frameworks is particulate matter expressed in relative human health damage compared to fine particulate matter (PM 2.5 eq.) based on the model described by Rabl *et al.*¹¹¹

Some of the frameworks suggest impacts at the endpoint level, based on damage-oriented modelling regarding three protection areas *i.e.*, human health, ecosystems and resources, *via* integrated assessments (Table 3). These indicators are mainly based on two impact assessment methods *i.e.*, ReCiPe

2016 (or earlier 2008 version) and Ecoindicator 99 (considered a precursor of the current ReCiPe 2016). The ReCiPe 2016 human health endpoint indicator (as well as Ecoindicator 99) addresses the damage to human health caused by respiratory and carcinogenic effects from organic and inorganic substances, human health issues caused by ionizing radiation, and climate change and ozone depletion. The ReCiPe 2016 ecosystem quality endpoint indicator (as well as Ecoindicator 99) addresses the damage to the ecosystem quality caused by ecotoxicological effects, land-use-related impacts, acidification and eutrophication.

Two frameworks also mentioned indicators at the endpoint level for climate change.^{18,112} However, endpoint indicators for individual environmental aspects are much less commonly used in LCAs than midpoint indicators.

Some aspects are suggested at the conceptual level without suggesting a specific indicator and method in the reviewed frameworks. Ten frameworks remarked the importance of protecting biodiversity. In particular, the guides by BASF⁵⁴ and the US National Research Council³⁵ consider biodiversity conservation as one of the leading sustainability criteria. However, there is a lack of data or shared consensus on monitoring biodiversity losses *via* current LCA indicators.³⁵ Nonetheless, impacts on biodiversity are quantitatively strictly related to LCA endpoint indicators for damage to the ecosystem quality mentioned in the previous section.¹¹³ Various (purely) conceptual frameworks have remarked the relevance of accounting for climate change issues, eco-toxicity, human toxicity, land use, and fossil/mineral resources.

The frameworks in the early stage of development showed a similar trend to the overall indicators adopted for the evaluation of the environmental dimension. This could be due to the fact that most of the indicators refer to midpoint impact categories of LCA. LCA can be performed also in the early stage as well as the estimation of the impact categories, being aware of higher uncertainty linked to the data availability and quality (see section 3.5 for further details). The slightly higher use of indicators on pressure was observed highlighting the higher availability of water and air emission information.

3.2.3 Social dimension. Table 4 shows the aspects and indicators mentioned by the reviewed frameworks under the social dimension. Aspects and indicators are clustered based on the potentially affected stakeholders, using the categories recommended in the UNEP.³²

The 31 frameworks including the social dimension have often flagged aspects to be considered without proposing an indicator quantifying them based on a specific method. One of the reviewed studies remarked the lack of quantitative social assessments in common alternative assessment frameworks.¹¹⁴

As shown in Fig. 3, social impacts related to workers have the highest coverage in the revised framework, as 59% of total mentions of social aspects in the reviewed frameworks concerns the category “workers”. The other stakeholder categories (local communities, value chain actors and society) have a lower coverage and the stakeholder category “children” (included in the last update of the UNEP Guidelines in 2020)



Table 4 Aspects and indicators related to stakeholders' categories with respective occurrence in the reviewed frameworks. Conceptual = just mentioned without recommending quantification based on a specific method or indicator

Stakeholder category	Number of frameworks adopted	Early stage application	Stakeholder category	Number of frameworks adopted	Early stage application
Aspect/indicator			Aspect/indicator		
Social	189	20	Risk of conflicts	1	
Consumer	8	3	Value added	1	
Brand communication	1	1	Youth illiteracy	1	
Consumer acceptance	1	1	Value chain actors	13	4
Consumer health & safety	1		Fair competition	1	
Content of natural substances	2	1	Promoting social responsibility	2	1
(%)			Regional materials	2	1
Ethics in marketing communication	2		Supply chain responsibility score	3	1
Impact on basic needs of customers	1		Tracking capacity	5	1
Local community	41	5	Workers	110	8
Access to basic needs	2		Accident rates at the workplace	1	
Certified environmental management system	1		Age	2	
Community acceptance	2		Annual job training	2	
Drinking water coverage	1		Association and bargaining rights	1	
Embodied forest area footprints	1		Child labour	12	2
Embodied agricultural area footprints	1		Disability	2	
Extraction of material resources	1		Equal opportunities and discrimination	9	
Human rights (conceptual)	5	1	Evidence of violations of laws and employment regulations	1	
Human rights (LCA impact category)	2		Fair salary	9	
Human satisfaction (appropriateness for culture and level of noise and vibration)	2	1	Forced labour	11	1
Impact on the local economy	1		Freedom of association and collective bargaining	7	1
International migrant stock	1		Gender wage gap	1	
International migrant workers in the sector	1		Labour influence	1	
Level of industrial water use	1		Men in the sectoral labour force	1	
Local employment	11	2	Noise reduction	4	
Net migration rate	1		Part-time work	4	
Pollution level of the country	1		Presence of sufficient safety measures	1	
Public welfare and safety	2		Rate of injuries	3	
Respect to indigenous rights	1		Respect to the national standards for security and social responsibility	6	1
Respect to the living conditions	1	1	Sexual harassment	4	
Sanitation coverage	1		Social security and expenditure	1	
Unemployment rate	1		Time of exposure	1	
Society	17		Trade unionism	1	
Active involvement of enterprises in corruption and bribery	1		Trafficking in person	1	
Contribution to economic development	1		Weekly hours of work per employee	1	
Corruption prevention initiatives	4		Women in the sectoral labour force	1	
Health expenditure	1		Workers affected by natural disasters	1	
Illiteracy rate	1		Workers' health & safety	11	3
Life expectancy at birth	3		Working conditions (LCA impact category)	1	
Poverty alleviation	1		Working hours (e.g. maximum)/work-life balance	9	
Public expenditure on education	1				
Public sector corruption	1				





Fig. 3 Comparison of the coverage of social aspects in the reviewed frameworks and in the UNEP Guidelines on S-LCA³², considering the various stakeholders' categories. In the case of S-LCA, shares refer to the total number of impact subcategories recommended in the UNEP Guidelines. For the reviewed frameworks, shares refer to the mentions of social aspects concerning the six stakeholder categories. A detailed list of aspects is available in the ESI.[†]

is not represented at all. The higher coverage of aspects related to workers can be explained by the higher data availability for work-related aspects, which usually are also easier to measure through quantitative indicators. Impacts on local communities, while being very relevant when assessing sustainability of product alternatives, are usually more difficult to assess due to the need for site-specific data. Impacts on society and value chain actors can also be challenging to assess given that in some cases the impact pathway is less defined. For what concerns impacts on consumers, they are to a large extent covered under the safety assessment.

Fig. 3 also lists additional social aspects found in the literature review that are not explicitly or completely addressed in the UNEP Guidelines.

The social aspects that are included in the highest number of frameworks are child labour,¹² forced labour,¹¹ workers health and safety¹¹ (in the stakeholder category "workers") and local employment¹¹ (under the stakeholder category "local community"). For the stakeholder category "value chain actors" the tracking capacity is included in 5 frameworks, while under the category "society" the aspect included the most is corruption prevention initiatives (4 frameworks), while the other two frameworks include other corruption-related aspects. For the "consumers" category the aspects ethics in marketing communication and content of natural substances are both included in two frameworks.

For what concerns positive impacts, which should capture the potential value for society or other stakeholders arising from a production and/or consumption activity, only the aspects local employment and contribution to economic development are included in the reviewed frameworks. While positive impact assessment is poorly implemented in practice (also due to the multiple conceptual definitions that can be adopted), there is clear interest in including this perspective in the sustainability assessment.¹¹⁵

Table 4 also shows that social dimension is seldom included in the sustainability assessment in the early stage of development. Among the indicators adopted in the early stage, worker-related aspects are the most assessed by few authors either from academia^{53,116–118} and international organization.¹¹⁹

3.3.4 Economic dimension. Table 5 shows the indicators under the economic dimension mentioned by the reviewed frameworks.

As shown in Table 5 indicators under the economic dimension are related to external cost, internal costs, profitability, value chain actors and others. The indicators related to internal costs are included in the highest number of frameworks⁵⁹ and in particular the total production cost is mentioned in 26 frameworks.

Profitability was remarked as a relevant concept in various frameworks. Four frameworks include financial profit as a quantitative indicator to measure it, while four frameworks proposed the indicator net present value. In 8 frameworks profitability was included without specifying a quantitative indicator to measure it.

The life cycle cost was recommended in 17 reviewed frameworks. In most of these frameworks, the life cycle cost calculation was combined with environmental LCA. Several frameworks, especially from scientific articles, mentioned accounting for the externality cost and the cost of waste generated. Potentially, methods for calculating life cycle costs could include externality costs caused by life cycle environmental impacts and land eco-remediation. Analogously, social LCA impacts such as worker safety and health protection could be included in life cycle cost methods.

As observed in a critical evaluation of economic approaches performed in the EU project Orienting,^{§§120} a variety of Life Cycle Costing (LCC) methods have been proposed in the literature. The three main types of LCC include: conventional LCC, environmental LCC, and social LCC. This methodology, however, still lacks a general standard that provides guidelines for its use/application.¹²¹

Table 6 shows the economic indicators that have been detected in the frameworks revised in this study and their comparison with those reported in two reviews of sustainability assessment methodologies.^{122,123}

The comparison shows that a variety of indicators can be applied, depending on the scope and the perspective of the economic analysis. The assessment of externalities is still poorly implemented, while profitability indicators are included in the three reviews under considerations, showing that, at this point, the methodology is mainly applied to assess company-related financial performance, rather than actual sustainability impacts.

The economic dimension is also addressed in frameworks regarding the early stage of development. In total, 34 frameworks include aspects, mostly on profitability and internal

§§Operational Life Cycle Sustainability Assessment Methodology Supporting Decisions Towards a Circular Economy, grant agreement no 958231.



Table 5 Indicators related to economic aspects with respective occurrence in the reviewed frameworks. Conceptual = just mentioned without recommending quantification based on a specific method or indicator

Aspect	Number of frameworks adopted	Early stage application
Economic	143	63
External cost	24	4
Externality cost [€]	3	
Life cycle cost [€]	17	3
Waste (incl. emissions)/recycling treatment cost	4	1
Internal cost	59	27
(Total) production cost [€]	26	15
Cost of maintenance/repairs	3	1
Product cost	6	1
Purchase cost	20	7
SSbD implementation costs	1	1
Total Annual Cost (TAC)	3	2
Profitability	25	14
Added value [€]	1	
Financial profit [€]	4	2
Minimum selling price [€]	4	2
Net present value [€]	4	4
Normalised added value [-]	1	
Payback period [years]	1	1
Profitability (conceptual)	8	3
Total capital investment	1	1
Yield	1	1
Value chain actors	5	
Product performance	1	
Stakeholder requirements	1	
Transparency and information	1	
Value chain collaboration	1	
Willingness to pay	1	
Other	38	23
Additional income (incentives, flexibility, and additional area)	1	
Affordability	1	
Breakeven point	1	1
Comfort of occupants	1	
Customer acceptance and satisfaction	1	
Discounted cash flow rate of return	1	1
Feedstock price	2	2
Flash point	1	1
Initial and maintenance budget	1	
Innovation potential (by number of publications)	1	1
Market acceptance	2	
Non-construction cost (tax, financial cost)	4	1
Performance uncertainty (material never used in a context)	1	1
Point of explosion	1	1
Predictability	1	
Process cost	2	2
Projected price	1	1
Reaction and resistance to fire	1	1
Scalability	1	
Waste management cost	7	6
Total Capital Cost (TCC)	3	2
Total Production Cost (TPC)	3	2

costs, mostly by academia. Smith *et al.* are the only ones from an international agency introducing the GREENSCOPE indicators for the design including also indicators for the economic dimension.⁸¹

3.3 Life cycle thinking considerations

About 60% of the selected frameworks consider LCA a key method to assess sustainability aspects. The idea to integrate the life cycle environmental impacts with risk assessment has a long history in solvent selection frameworks which started in the early nineties.^{75,76,124} For example, compared to the risk assessment used to cover safety aspects, the LCA methodology can broaden the scope to include climate change impacts.¹²⁵ The two methods could potentially be used either combined or in parallel.^{126,127}

The frameworks reviewed often pointed out that a cradle-to-grave comparison of the final application (product or service) is necessary to evaluate chemicals' safety and sustainability compared to the alternatives. However, the reviewed frameworks rarely provided clear recommendations on when a cradle-to-gate comparison of chemicals is considered enough and when a cradle-to-grave LCA evaluation becomes necessary.

To optimize the time needed to conduct an LCA, several scientific articles^{77,126,128,129} presented various easy-to-use LCA-based tools allowing preliminary environmental profiling, especially for the early stage of development. Examples of them include: (i) the FLASC tool calculates preliminary cradle-to-gate impacts for eight impact categories for a wide range of materials commonly used in drug manufacture;⁷⁷ (ii) the Q-SA√ESS (Quick Sustainability Assessment *via* Experimental Solvent Selection) methodology calculates six cradle-to-grave sustainability metrics for the three "most sustainable solvents" for a specific process;¹³⁰ and, (iii) the US EPA (United States Environmental Protection Agency) created a method rapidly generating life cycle inventories from publicly available databases by allocating the emissions from facilities related to the production of the chemical of interest.¹³¹

Other leading streamlined LCA tools are the ecosolvent tool¹³² for solvents, the LICARA NanoSCAN tool¹³³ for nanomaterials and other models proposed by recent literature for application to a broad range of chemicals (*e.g.* ref. 126). Tools for streamlined LCAs can provide valuable decision support for chemicals in their early stage of development when data availability is very limited. However, the results generated using such tools have high uncertainty especially due to low technological, geographical and temporal representativeness. Hence, robust evaluations can be generated only *via* full LCAs.

Alternatively, previous studies^{128,134} proposed the use of physicochemical properties to predict the life cycle environmental impact in the early stage of development. Their approach assumes that there is a link between those properties and the environmental performance of the chemical production process being developed and assessed. Finally, Pizzol *et al.*¹³⁵ recently proposed and tested a tiered approach with qualitative assessment for safety, environmental, and social dimensions in the early stage of development.

While several environmental LCAs of nanotechnologies have already been published,^{136,137} various studies acknowledged the challenges of conducting LCAs of nanomaterials due to their complexity and dynamic behavior during the life



Table 6 Comparison between the economic indicators reported in the revised frameworks for SSbD chemicals and the literature reviews published in Alejandrino *et al.* (2021)¹²² and Visentin *et al.* (2020)¹²³

	Economic indicator	Alejandrino <i>et al.</i> 2021 ¹²²	Visentin <i>et al.</i> 2020 ¹²³	Revised frameworks
External cost	Externality cost		✓	✓
	Life cycle cost		✓	✓
	Waste (incl. emissions)/recycling treatment cost			✓
Internal cost	(Total) production cost	✓	✓	✓
	Cost of maintenance/repairs		✓	✓
	Product cost			✓
	Purchase cost			✓
	SSbD implementation costs			✓
	Total Annual Cost (TAC)			✓
	Electricity cost		✓	
	Cost of capital		✓	
	Raw material cost			
	Labour cost		✓	
Profitability	Added value	✓		✓
	Financial profit	✓		✓
	Minimum selling price			✓
	Net present value	✓	✓	✓
	Normalised added value			✓
	Payback period	✓		✓
	Profitability		✓	✓
	Total capital investment	✓		✓
	Yield			✓
	Internal rate return	✓		
Value chain actors	Revenues			
	Product performance			✓
	Stakeholder requirements			✓
	Transparency and information			✓
	Value chain collaboration			✓
Other	Willingness to pay			✓
	Additional income (incentives, flexibility, and additional area)		✓	
	Affordability			✓
	Breakeven point			✓
	Comfort of occupants			✓
	Customer acceptance and satisfaction			✓
	Discounted cash flow rate of return			✓
	Feedstock price			✓
	Flash point			✓
	Initial and maintenance budget			✓
	Innovation potential (by number of publications)			✓
	Market acceptance			✓
	Non-construction cost (tax, financial cost)			✓
	Performance uncertainty (material never used in a context)		✓	
	Point of explosion			✓
	Predictability			✓
	Price	✓		
	Process cost			✓
	Projected price			✓
	Reaction and resistance to fire			✓
	Scalability			✓
	Waste management cost			✓
	Total Capital Cost (TCC)			✓
	Total Production Cost (TPC)			✓
	Economic impact score	✓		
	Financial incentives	✓		
	Risk	✓		
	GDP/contribution to GDP	✓		
	Investment	✓		

cycle.^{138–140} However, an effort is currently ongoing to fill this gap. Such an effort is ongoing also for LCAs covering social and economic aspects.¹⁴¹ In particular, LCA guidelines for manufactured nanomaterials were released in 2018.¹⁴²

The environmental assessment of chemicals has been evolving and moving from typical green chemistry mass-based metrics to a life-cycle perspective, as this was identified as indispensable to verify actual environmental benefits.^{17,130,143}



3.4 Decision-making support: evaluation and trade-offs

Rarely, a certain chemical is optimal for all safety and sustainability aspects *e.g.* it might not present hazard concerns but require a high amount of energy for its production, resulting, for example, in high climate change impacts. Therefore, the assessment of safety and sustainability of chemicals should include a procedure to support decision making considering as well existing trade-offs.¹⁴⁴

The preliminary step in frameworks assessing safety and sustainability of alternative chemicals is the identification of alternatives and its technical performance. The technical performance in fulfilling the function of the candidate alternative and of the alternatives in providing such functions is established *via* techno-feasibility assessments.^{18,35,144,145} New or alternative chemicals should be compared based on equal functional performances using “substitution factors” and for LCA using a “functional unit”. Nevertheless, a calculation procedure for substitution factors for a specific function and/or a structured method to detect respective alternatives was rarely reported.

Then, the safety performance of the alternatives scrutinizing physicochemical properties and applying risk assessment is evaluated. If safety is part of the framework, the evaluation of environmental, social, and economic aspects is conducted only for chemicals passing the safety assessment.

In the case of social impact assessment, compensation between positive and negative impacts should be avoided. Moreover, when assessing positive impacts, great caution must be taken with the inclusion of product utilities and when comparing the positives for one stakeholder group with the negatives for another. Indeed, as observed by Croes *et al.*¹⁴⁶ an imprudent inclusion of positive impacts might lead to white-washing practices and loss of credibility of the assessment.

The vast majority of frameworks provide a separate outcome for each aspect considered or at least per dimension (safety, environmental, social, and economic). For example, a chemical can have the outcome “recommended” in the environmental dimension but “problematic” in the safety dimension or *vice versa*.⁶² The decision is then left to the user of the outcome, leaving an appropriate degree of freedom on the final decision. In particular, if safety is part of the assessment, an aggregated score over multiple sustainability dimensions is not recommended to avoid compensation between different impacts. To facilitate decision making, the impact profiles of the alternatives can also be presented at the highest aggregated level with single scores per dimension.^{18,62}

The score is often translated in colour coding based on a percentage performance indicator, *e.g.* 0% representing the no sustainability (the alternative performs the worst in that aspect) and 100% representing the highest sustainability (the alternative performs the best in that aspect), and this is particularly the case of frameworks developed for the early stage.⁸¹ Pfizer was one of the first companies to use color-coding to categorize solvents (green = preferred, amber = usable and red = undesirable).¹⁴⁷ A similar coding system has

also been proposed by other companies *e.g.* Sanofi, Astra Zeneca and GSK^{77,148,149} and environmental agencies *e.g.* the German Environment Agency.¹⁵⁰

In most cases, color-coding is applied to the outcome of each criterion to evaluate safety, health, and environmental aspects.^{73,148,150} For example, each chemical can get a score between 1 and 10 for each criterion, which is then translated into the 3-color code (*e.g.* green, yellow, and red).^{62,73,130,148,149,151} Except for green, the meaning of the other colours can be slightly different, *e.g.* red can mean undesirable¹⁴⁷ or substitution requested.^{148,150} Some guides use brown to catalogue banned chemicals (*e.g.* ref. 148). White colour is often used for data unavailability that does not allow the assessment for a certain criterion.^{148–150} Sometimes also orange is included as a colour to indicate a chemical that should be substituted but does not have to if it is still compliant with current regulation.⁷³

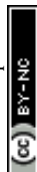
Other approaches to support decision making suggested in the literature include the use of Multi-Objective Optimization (MOO) techniques or Multi-Criteria Decision Analysis (MCDA). MOO frameworks for alternative assessment are normally implemented in computer-aided molecular design tools using for example a Fuzzy Analytic Hierarchy Process (FAHP) weighting approach.^{63,152} This means that the decision-making is structured as a hierarchy where the primary goal of the design *e.g.* safety comes before other criteria and sub-criteria, giving priority to the objects of the decision problem that must be fulfilled.^{63,152} Regarding the design, simple hotspot analysis is also conducted to guide further development of the design of the new chemical or material.¹⁵³

MCDA, which allows simultaneous comparison of multiple and often conflicting aspects, has also been highlighted as a key instrument for sustainability assessment, as discussed in major works and reviews.^{29,30,154} Two commonly used MCDA methods are the multi-attribute utility theory and outranking.⁶¹ Although MCDA methods may be useful in providing decision makers with a common baseline to understand the performance of alternatives and the trade-offs they present, they may be significantly resource intensive. MCDA in the early stage of development have been found to be recently explored by few authors. Garas *et al.*¹¹⁷ adopted a Sustainable Decision Support System (SDSS) scoring system that integrates LCA and MCDA; García-Velásquez C.¹⁵⁵ used the Pareto frontiers to guide decision in the plastic sector. Finally, Manjunatheshwara and Vinodh adopted a grey method for the decision specifically for materials selection at the design phase with uncertain conditions.¹⁵⁶

3.5 Data availability and uncertainty

A key issue in sustainability assessment of chemicals and, in particular, of new ones, is the lack of data and data uncertainty.

Some of the frameworks propose ways to deal with data gaps, reflecting this in the evaluation. Malloy *et al.*⁶¹ applied an MCDA framework to assess the impact of data gaps on alternative assessment using multi-attribute utility theory and



outranking other tools, penalising aspects with missing data by applying a lower score (GreenScreen full assessment, SciVera, GreenSuite); other tools, usually list-based tools, consider missing data as undetermined (GreenScreen List Translator) or indifferent on the final score (GreenWERCs).¹⁵⁷

GreenSuite's procedure uses five criteria to differentiate the cause of the missing data to score the aspect as more hazardous.¹⁵⁸

The GreenScreen® tool (and by extension, the IC2¹⁵⁹ and Rossi⁴⁴ frameworks) propose a system based on the preliminary score to assess the level of the material analysed, in which data gap analysis is applied to determine if the data requirements are met. If the analysis fails, the final score is lowered by one unit, otherwise the score is confirmed.⁴⁵

OECD¹⁶⁰ addresses data gaps by using two different approaches, depending on whether the data quality is limited (tier 1) or whether high quality data are used (tier 2), stating the quality of the assessment to the audience.

Regarding uncertainty assessment, a limited number of frameworks have suggested ways to perform it. NRC¹⁵⁷ suggests a list of good practices to deal with uncertainties that include the selection of alternatives with only known aspects and conducting a quantitative analysis, pointing out that when uncertainty is large enough to overwhelm any relative differences between alternatives, it becomes impossible to determine any better alternative. Safe Consumer Products¹⁶¹ provide a stepwise approach to carry-out uncertainty assessment and data gaps.

Although the assessment of chemicals or materials in the early stage of development is quite uncertain due to the lack or quality of data, only 9 authors focused on sensitivity analyses or uncertainty, most of them regarding construction and solvent sectors. Among available options, Posada *et al.* performed a Monte Carlo simulation to identify the variability on the input data, and similarly, Zapata Boada *et al.* analysed the influence of parameters affecting economic and environmental performances by sensitivity analysis. In addition, the Triangular Fuzzy Number and Fuzzy Topsis,^{152,162} the VEGA toolbox¹⁶³ and the IDEMAT 2001 database¹⁶⁴ have been used to evaluate variability and uncertainty. Uncertainty assessment is key for early stage assessments as it provides the decision maker the spectrum of possibilities enabling a more informed decision making. At a minimum, sensitivity analysis should be conducted on key parameters in the system to study the robustness of results and their sensitivity to uncertainty factors. This will determine whether data collection and quality need to be improved and enhance the interpretation of results.

4. Conclusion

This review focused on how sustainability has been implemented in frameworks used to assess the safety and sustainability of chemicals and materials. In particular, frameworks integrating more than one sustainability dimension

among safety, environmental, social, and economic were analysed and to which extent they were applied in the early stages of development of chemicals and materials.

While some of the reviewed frameworks are conceptual, other frameworks provide a detailed guideline to support the selection of safer and more sustainable chemicals. Most reviewed frameworks pointed out that the criteria regarding safety and sustainability of alternatives should be based on equal functional performance. However, they lack providing a calculation procedure of substitution factors for a specific function and a structured method to detect respective alternatives.

A major focus was on scrutinizing sustainability aspects and indicators and respective calculation methods as well as the decision procedures proposed by the frameworks. The intent was to understand the current state of art and gaps to reach a better-informed decision-making process for designing or selecting safe and sustainable chemicals. This review highlighted that there is no uniform and comprehensive set of indicators for examining the sustainability of a chemical within proposals of frameworks from academia, governments, NGOs, or industry, especially for what concerns socio-economic aspects. This fact could negatively impact the roadmaps of chemicals since they might be sustainable according to one framework but not another.

In this sense, LCA can be of use as it covers multiple environmental impacts. In fact, there was a broad consensus on the need to account for the life cycle of chemicals and on the need to use indicators based on the life cycle assessment methodology. In fact, LCA can overcome the limitation of simple mass- and energy-based metrics that do not capture actual shifts in environmental burdens by selecting an alternative instead of another. LCA has been gaining prominence in sustainability assessment nonetheless there are limitations that need to be addressed to ensure robust assessments. In particular, guidance is needed for LCA modelling of technologies at a low technology readiness level and for which the data gaps and uncertainty are even more predominant. While the S-LCA does not have the same level of maturity as the environmental LCA, this methodology underpins internationally agreed guidelines that can be taken as a reference, especially for what concerns the list of social aspects to be selected for the assessment, and as general guidance for the social assessment. The LCC methodology is the most heterogeneous for what concerns the methodological approach but also from a conceptual point of view (which kind of impacts should be assessed, area to be protected, *etc.*).

Increasing chemicals' circularity is also acknowledged by the EU CSS as a way to contribute to reducing chemical pollution in wastewaters. However, mass-based/circularity metrics in the reviewed frameworks do not account for the effect of multiple cycles in environmental assessment as well as hazard and risk assessments. Therefore, as also remarked by the EU CSS, there is a need to develop methodologies for chemical risk assessment that take into account the whole life cycle and the effect of increased circularity.



To have the “paradigm shift” towards safe and sustainable chemicals, the industry and sustainability/LCA community need to respond to the challenges resulting from this review. Numerous organizations already have many initiatives, but these are carried out mainly independently. With a lack of coordination, it is difficult to guarantee a harmonized selection of suitable sustainability indicators to be integrated into future frameworks. This review shows that there is no uniform set of indicators within proposals of frameworks from academia, governments, NGOs, or industry for evaluating the sustainability of chemicals. If different indicators are implemented in the various frameworks developed in parallel for the same context, they can negatively impact the product roadmaps that often take years for development.

Author contributions

Carla Caldeira: conceptualization, methodology, investigation, visualization, and writing – original draft; Elisabetta Abbate: investigation, visualization, and writing – review & editing; Christian Moretti: investigation, methodology, and writing – original draft; Lucia Mancini: investigation, methodology, and writing – review & editing; Serenella Sala: conceptualization, writing – review & editing, and supervision.

Conflicts of interest

There are no conflicts to declare.

Acknowledgements

The work presented in this paper was developed in the context of the Administrative Arrangement “Support Criteria for Safe and Sustainable-by-Design advanced materials and chemicals (SSBDCHEM)”, JRC 36058/DG RTD LC-01671974, between the European Commission’s Directorate General for Research and Innovation (DG RTD) and the Joint Research Centre (JRC).

References

- 1 IEA, *The Future of Petrochemicals: Towards more sustainable plastics and fertilisers*, International Energy Agency. 2018.
- 2 Z. Wang and S. Hellweg, First Steps Toward Sustainable Circular Uses of Chemicals: Advancing the Assessment and Management Paradigm, *ACS Sustainable Chem. Eng.*, 2021, **9**(20), 6939–6951.
- 3 J. F. Martínez-Gallegos, A. Burgos-Cara, F. Caparrós-Salvador, G. Luzón-González and M. Fernández-Serrano, Dihydroxyacetone crystallization: Process, environmental, health and safety criteria application for solvent selection, *Chem. Eng. Sci.*, 2015, **134**, 36–43.
- 4 A. E. Cervera-Padrell, T. Skovby, S. Kiil, R. Gani and K. V. Gernaey, Active pharmaceutical ingredient (API) production involving continuous processes - A process system engineering (PSE)-assisted design framework, *Eur. J. Pharm. Biopharm.*, 2012, **82**(2), 437–456.
- 5 European Commission, *Communication from the Commission: The European Green Deal*, COM(2019) 640 Final. 2019, p. 24.
- 6 European Commission, *Chemicals Strategy for Sustainability Towards a Toxic-Free Environment*, 2020.
- 7 L. Heine and A. Nestler, Promising Practices for Alternatives Assessment: Lessons from a Case Study of Copper-Free Antifouling Coatings, *Integr. Environ. Assess. Manage.*, 2019, **15**(6), 867–879.
- 8 M. H. Whittaker, *Chemicals Alternatives Assessments*, *Encycl Toxicol*, 3rd edn, 2014, pp. 782–786.
- 9 J. A. Tickner, R.V. Simon, M. Jacobs, L. D. Pollard and S. K. van Bergen, The nexus between alternatives assessment and green chemistry: supporting the development and adoption of safer chemicals, *Green Chem. Lett. Rev.*, 2021, **14**(1), 21–42.
- 10 E. Giubilato, L. Pizzol, P. Scanferla, V. Faggian, A. Critto, E. Semenzin, *et al.*, Comparative occupational risk assessment to support the substitution of Substances of Very High Concern: Alternatives assessment for diarsenic trioxide in Murano artistic glass production, *J. Cleaner Prod.*, 2016, **139**, 384–395.
- 11 K. Geiser, J. Tickner, S. Edwards and M. Rossi, The Architecture of Chemical Alternatives Assessment, *Risk Anal.*, 2015, **35**(12), 2152–2161.
- 12 P. Lek-utaiwan, B. Suphanit, P. L. Douglas and N. Mongkolsiri, Design of extractive distillation for the separation of close-boiling mixtures: Solvent selection and column optimization, *Comput. Chem. Eng.*, 2011, **35**(6), 1088–1100.
- 13 M. Sparrevik, T. Saloranta, G. Cornelissen, E. Eek, A. M. Fet, G. D. Breedveld, *et al.*, Use of life cycle assessments to evaluate the environmental footprint of contaminated sediment remediation, *Environ. Sci. Technol.*, 2011, **45**(10), 4235–4241.
- 14 European Commission, *Regulation (EC) No 1907/2006 of the European Parliament and of the Council of 18 December 2006 concerning the Registration, Evaluation, Authorisation and Restriction of Chemicals (REACH), establishing a European Chemicals Agency, amending Directive 1999/4. Vol. 10, Ec 2074/2005*, 2006.
- 15 I. Amato, The Slow Birth of Green Chemistry, *Science*, 1993, **259**(5101), 1538–1541. Available from: <https://www.science.org/doi/abs/10.1126/science.259.5101.1538.a>.
- 16 P. T. Anastas and J. C. Warner, (It ‘s Not Easy Being Green) The Pollution Prevention Act (PPA) states: Principles of Green Chemistry, in *Green Chem theory Pract*, 1998.
- 17 R. A. Sheldon, Metrics of Green Chemistry and Sustainability: Past, Present, and Future, *ACS Sustainable Chem. Eng.*, 2018, **6**(1), 32–48.
- 18 P. Fantke, L. Huang, M. Overcash, E. Griffing and O. Jolliet, Life cycle based alternatives assessment (LCAA)



- for chemical substitution, *Green Chem.*, 2020, **22**(18), 6008–6024.
- 19 S. Saroj, P. Shah, V. Jairaj and R. Rathod, Green Analytical Chemistry and Quality by Design: A Combined approach towards Robust and Sustainable Modern Analysis, *Curr. Anal. Chem.*, 2018, **14**(4), 367–381.
 - 20 J. Ooi, M. A. B. Promentilla, R. R. Tan, D. K. S. Ng and N. G. Chemmangattuvalappil, A systematic methodology for multi-objective molecular design via Analytic Hierarchy Process, *Process Saf. Environ. Prot.*, 2017, **111**, 663–677.
 - 21 J. Tickner, M. M. Jacobs and N. B. Mack, Alternatives assessment and informed substitution: A global landscape assessment of drivers, methods, policies and needs, *Sustainable Chem. Pharm.*, 2019, **13**, 100161.
 - 22 F. Pena-Pereira, A. Kloskowski and J. Namieśnik, Perspectives on the replacement of harmful organic solvents in analytical methodologies: A framework toward the implementation of a generation of eco-friendly alternatives, *Green Chem.*, 2015, **17**(7), 3687–3705.
 - 23 C. Caldeira, R. Farcal, C. Moretti, L. Mancini, H. Rauscher and K. Rasmussen, *et al.*, *Safe and Sustainable chemicals by design chemicals and materials: Review of safety and sustainability dimensions, aspects, methods, indicators, and tools*, 2022, p. 1–185.
 - 24 C. Caldeira, R. Farcal, I. Garmendia Aguirre, L. Mancini, D. Tosches and A. Amelio, *et al.*, *Safe and Sustainable chemicals and materials by Design: Framework for the definition of criteria and evaluation procedure for chemicals and materials*, 2022.
 - 25 European Commission, COMMISSION RECOMMENDATION (EU) 2022/2510 of 8 December 2022 establishing a European assessment framework for “safe and sustainable by design” chemicals and materials, Off J Eur Union. 2022, vol. 2531.
 - 26 EC, Mapping, study for the development of sustainable-by-design criteria, 2021.
 - 27 EC, Survey, in support of the Commission services’ work on the definition of Safe and Sustainable by Design criteria for chemicals and materials, 2021.
 - 28 A. D. Curzons, D. C. Constable and V. L. Cunningham, Solvent selection guide: a guide to the integration of environmental, health and safety criteria into the selection of solvents, *Clean Technol. Environ. Policy*, 1999, **1**(2), 82–90.
 - 29 L. Diaz-Balteiro, J. González-Pachón and C. Romero, Measuring systems sustainability with multi-criteria methods: A critical review, *Eur. J. Oper. Res.*, 2017, **258**(2), 607–616.
 - 30 A. Lindfors, Assessing sustainability with multi-criteria methods: A methodologically focused literature review, *Environ. Sustain. Ind.*, 2021, **12**, 100149.
 - 31 EC, Communication, from the Commission to the European Parliament, the Council, the European Economic and Social Committee and the Committee of the Regions. Chemicals Strategy for Sustainability Towards a Toxic-Free Environment COM (2020) 667, 2020.
 - 32 United Nations Environment Programme, *Guidelines for Social Life Cycle Assessment of Products and Organizations*. United Nations Environment Programme. United Nations Environ Program, 2020, (2)), pp. 1–140. Available from: <https://www.lifecycleinitiative.org/library/pilot-projects-on-guidelines-for-social-life-cycle-assessment-of-products-and-organizations-2022/%0A>, <https://www.lifecycleinitiative.org/wp-content/uploads/2021/01/Guidelines-for-Social-Life-Cycle-Assessment-of-P>.
 - 33 EEA, *Designing safe and sustainable products requires a new approach for chemicals Key messages*, 2020, pp. 1–10.
 - 34 UBA, *Guide on sustainable chemicals - A decision tool for substance manufacturers, formulators and end users of chemicals*, 2016.
 - 35 NRC, *A framework to guide selection of chemical alternatives*, 2014.
 - 36 IC2, *Alternatives Assessment Guide Version 1.1*, 2017.
 - 37 UN, *Globally Harmonized System of Classification and Labelling of Chemicals (GHS Rev. 9)*, 2021.
 - 38 OECD, *Revised Guidance Document 150 on Standardised Test Guidelines for Evaluating Chemicals for Endocrine Disruption*, OECD; 2018.
 - 39 WBCSD, *Chemical Industry Methodology for Portfolio Sustainability Assessments (PSA)*, 2018.
 - 40 OECD, *Guidance on Key Considerations for the Identification and Selection of Safer Chemical Alternatives*, 2021.
 - 41 OECD, *Considerations and Criteria for Sustainable Plastics from a Chemicals Perspective BACKGROUND PAPER 1*, 2018, p. 40.
 - 42 OECD, *Moving Towards a Safe(r) Innovation Approach (SIA) for More Sustainable Nanomaterials and Nano-enabled Products. Series on the Safety of Manufactured Nanomaterials*, 2020;(96):No. 96. Available from: ENV/JM/MONO(2020)36/REV1.
 - 43 IEEE, *IEEE Standard for Environmental and Social Responsibility Assessment of Computers and Displays. Vol. 2018, IEEE Std 1680.1–2018 (Revision of IEEE Std 1680.1–2009)*, 2018, pp. 1–121.
 - 44 M. Rossi, C. Peele and B. Thorpe, *BizNGO Chemical alternatives Assessment Protocol*, 2012, pp. 1–12.
 - 45 GreenScreen, *GreenScreen method for Safer Chemicals*, 2018.
 - 46 ChemSec, *Chemical groups on the SIN (Substitute It Now) List*, 2019.
 - 47 ChemSec, *ChemSec position paper on Safe and Sustainable by Design*, 2021.
 - 48 GEC, *Sustainable Marketplace: Greener Products and Services*, 2021.
 - 49 C2C, *What is Cradle to Cradle Certified®?* 2021.
 - 50 A. Belhadi, S. S. Kamble, S. A. R. Khan, F. E. Touriki and M. D. Kumar, Infectious Waste Management Strategy during COVID-19 Pandemic in Africa: an Integrated Decision-Making Framework for Selecting Sustainable Technologies, *Environ. Manage.*, 2020, **66**(6), 1085–1104.



- 51 EVONIK, *Sustainability Report*, 2020.
- 52 CEFIC, *Safe and Sustainable-by-Design: Boosting innovation and growth within the European chemical industry*, 2021.
- 53 M. Rossi, J. Tickner and K. Geiser, *Alternatives Assessment Framework of the Lowell Center for Sustainable Production*, 2006, p. 24. Available from: <https://papers2://publication/uuid/E70800E7-DFE2-4B5A-96DC-D0873D278F24>.
- 54 BASF, *Sustainable Solution Steering*, 2018, pp. 1–32.
- 55 World Business Council for Sustainable Development, *Chemical Industry Methodology for Portfolio Sustainability Assessments (PSA)*, 2018, p. 1–46. Available from: <https://www.wbcsd.org/Programs/Energy-Circular-Economy/Factor-10/Sector-Deep-Dives/Resources/Chemical-Industry-Methodology-for-Portfolio-Sustainability-Assessments>.
- 56 World Business Council for Sustainable Development, *Social Life Cycle Metrics for Chemical Products*, 2016, pp. 1–99. Available from: <https://www.wbcsd.org/Projects/Chemicals/Resources/Social-Life-Cycle-Metrics-for-Chemical-Products>.
- 57 World Business Council for Sustainable Development, *Life Cycle Metrics for Chemical Products*, 2014; vol. 120.
- 58 Solvay, *Solvay launches Solvay One Planet*, 2020; vol. 6–8. Available from: <https://www.solvay.com>.
- 59 C. Capello, U. Fischer and K. Hungerbühler, What is a green solvent? A comprehensive framework for the environmental assessment of solvents, *Green Chem.*, 2007, **9**(9), 927–993.
- 60 D. Reinhardt, F. Ilgen, D. Kralisch, B. König and G. Kreisel, Evaluating the greenness of alternative reaction media, *Green Chem.*, 2008, **10**(11), 1170–1181.
- 61 T. F. Malloy, P. J. Sinsheimer, A. Blake and I. Linkov, Use of multi-criteria decision analysis in regulatory alternatives analysis: a case study of lead free solder, *Integr. Environ. Assess. Manage.*, 2013, **9**(4), 652–664.
- 62 D. Prat, A. Wells, J. Hayler, H. Sneddon, C. R. McElroy, S. Abou-Shehadeh, *et al.*, CHEM21 selection guide of classical- and less classical-solvents, *Green Chem.*, 2015, **18**(1), 288–296.
- 63 J. Ooi, D. K. S. Ng and N. G. Chemmangattuvalappil, A Systematic Molecular Design Framework with the Consideration of Competing Solvent Recovery Processes, *Ind. Eng. Chem. Res.*, 2019, **58**(29), 13210–13226.
- 64 J. E. Chavarrio, M. F. Gutiérrez and Á. Orjuela, A Quantitative Multi-Criteria Solvent Selection Method for Extraction Processes: Case Study—Downstream Purification of Sucrose-Based Surfactants, *J. Surfactants Deterg.*, 2020, **23**(3), 513–526.
- 65 European Commission, *EU Ecolabel for Consumers*, 2021.
- 66 Condat, *Biodegradable and ECOLABEL lubricants*, 2021.
- 67 European Commission, *EU Ecolabel Rinse-off Cosmetic User Manual*, 2016, pp. 1–77.
- 68 ASTM, *ASTM D6400 - 19: Standard Specification for Labeling of Plastics Designed to be Aerobically Composted in Municipal or Industrial Facilities. Annual Book of ASTM Standards*, 2019, p. 1–3.
- 69 CEN, *Requirements for Packaging Recoverable Through Composting and Biodegradation - Test Scheme and Evaluation Criteria for the Final Acceptance of Packaging*, 2000.
- 70 EC, *Environmental, impact assessments of innovative bio-based product. Task 1 of “Study on Support to R&I Policy in the Area of Bio-based Products and Services” - Study*, 2019.
- 71 J. S. Woods, F. Veronesi, O. Joliet, I. Vázquez-Rowe and A. M. Boulay, A framework for the assessment of marine litter impacts in life cycle impact assessment, *Ecol. Indic.*, 2021, **129**, 107918.
- 72 P. G. Levi and J. M. Cullen, Mapping Global Flows of Chemicals: From Fossil Fuel Feedstocks to Chemical Products, *Environ. Sci. Technol.*, 2018, **52**(4), 1725–1734.
- 73 R. K. Henderson, C. Jiménez-González, D. J. C. Constable, S. R. Alston, G. G. A. Inglis, G. Fisher, *et al.*, Expanding GSK’s solvent selection guide – embedding sustainability into solvent selection starting at medicinal chemistry, *Green Chem.*, 2011, **13**(4), 854–862.
- 74 C. Jiménez-Gonzalez, A. D. Curzons, D. J. C. Constable and V. L. Cunningham, Expanding GSK’s Solvent Selection Guide - Application of life cycle assessment to enhance solvent selections, *Clean Technol. Environ. Policy*, 2004, **7**(1), 42–50.
- 75 S. K. Stefanis, A. Buxton, A. G. Livingston and E. N. Pistikopoulos, A methodology for environmental impact minimization: Solvent design and reaction path synthesis issues, *Comput. Chem. Eng.*, 1996, **20**(SUPPL.2), 1419–1424.
- 76 S. K. Stefanis, A. G. Livingston and E. N. Pistikopoulos, Minimizing the environmental impact of process Plants: A process systems methodology, *Comput. Chem. Eng.*, 1995, **19**(SUPPL. 1), 39–44.
- 77 A. D. Curzons, C. Jiménez-González, A. L. Duncan, D. J. C. Constable and V. L. Cunningham, Fast life cycle assessment of synthetic chemistry (FLASCTM) tool, *Int. J. Life Cycle Assess.*, 2007, **12**(4), 272–280.
- 78 C. N. Sawyer, *Chemistry for environmental engineering and science*, McGraw-Hill, New York, 5th edn, 2003.
- 79 OECD, *Sustainability and Safe and Sustainable by Design: Working Descriptions for the Safer Innovation Approach [Internet]*, 2022. Available from: <https://www.oecd.org/chemicalsafety/>.
- 80 European Commission, *Proposal for a directive of the European Parliament and of the Council on Soil Monitoring and Resilience (soil Monitoring Law)*, 2023, pp. 172–180.
- 81 R. L. Smith, G. J. Ruiz-Mercado and M. A. Gonzalez, Using GREENSCOPE indicators for sustainable computer-aided process evaluation and design, *Comput. Chem. Eng.*, 2015, **81**, 272–277, DOI: [10.1016/j.compchemeng.2015.04.020](https://doi.org/10.1016/j.compchemeng.2015.04.020).
- 82 G. J. Ruiz-Mercado, R. L. Smith and M. A. Gonzalez, Sustainability indicators for chemical processes: I. Taxonomy, *Ind. Eng. Chem. Res.*, 2012, **51**(5), 2309–2328.
- 83 D. L. Hartmann, A. M. G. K. Tank and M. Rusticucci, *IPCC Fifth Assessment Report, Climate Change 2013: The Physical Science Basis*, IPCC AR5, 2013.
- 84 EC, *Proposal, for a Directive of the European Parliament and of the Council on the promotion of the use of energy from renewable sources*, Off J Eur Union. 2016.



- 85 EU, Directive, 2015/652/EC of the European Parliament and of the Council of 20 April 2015 laying down calculation methods and reporting requirements pursuant to Directive 98/70/EC of relating to the quality of petrol and diesel fuels, 2015.
- 86 V. Ramanathan and Y. Feng, Air pollution, greenhouse gases and climate change: Global and regional perspectives, *Atmos. Environ.*, 2009, **43**(1), 37–50.
- 87 UN, Montreal, Protocol on Substances that Deplete the Ozone Layer, 1989.
- 88 R. van Zelm, M. A. J. Huijbregts, H. A. den Hollander, H. A. van Jaarsveld, F. J. Sauter, J. Struijs, *et al.*, European characterization factors for human health damage of PM10 and ozone in life cycle impact assessment, *Atmos. Environ.*, 2008, 441–453.
- 89 M. L. M. Broeren, M. C. Zijp, S. L. Waaijers-van der Loop, E. H. W. Heugens, L. Posthuma, E. Worrell, *et al.*, Environmental assessment of bio-based chemicals in early-stage development: a review of methods and indicators, *Biofuels, Bioprod. Biorefin.*, 2017, **11**(4), 701–718.
- 90 E. Stokstad, Nitrogen crisis from jam-packed livestock operations has ‘paralyzed’ Dutch economy, *Science*, 2019, 4.
- 91 L. M. Tufvesson, P. Tufvesson, J. M. Woodley and P. Börjesson, Life cycle assessment in green chemistry: Overview of key parameters and methodological concerns, *Int. J. Life Cycle Assess.*, 2013, **18**(2), 431–444.
- 92 I. Vural Gursel, C. Moretti, L. Hamelin, L. G. Jakobsen, M. M. Steingrimsdottir, M. Junginger, *et al.*, Comparative cradle-to-grave life cycle assessment of bio-based and petrochemical PET bottles, *Sci. Total Environ.*, 2021, **793**, 148642.
- 93 C. Moretti, L. Hamelin, L. G. Jakobsen, M. H. Junginger, M. M. Steingrimsdottir, L. Høiby, *et al.*, Cradle-to-grave life cycle assessment of single-use cups made from PLA, PP and PET, *Resour., Conserv. Recycl.*, 2021, **169**, 105508.
- 94 J. Guinée, *Handbook on life cycle assessment - Operational guide to the ISO standards*. Centre of Environmental Science The Netherlands LU, editor. Vol. 6, *International Journal of Life Cycle Assessment*, Kluwer Academic Publishers, Dordrecht, Netherlands, 2001, pp. 255.
- 95 M. Huijbregts, Z. J. N. Steinmann, P. M. F. M. Elshout, G. Stam, F. Verones, M. D. M. Vieira, *et al.*, ReCiPe 2016 - A harmonized life cycle impact assessment method at midpoint and endpoint level. Report I: Characterization, *Natl. Inst. Public Heal. Environ.*, 2016, **194**.
- 96 M. Posch, J. Seppälä, J. P. Hettelingh, M. Johansson, M. Margni and O. Jolliet, The role of atmospheric dispersion models and ecosystem sensitivity in the determination of characterisation factors for acidifying and eutrophying emissions in LCIA, *Int. J. Life Cycle Assess.*, 2008, **13**, 477–486.
- 97 L. B. Azevedo, R. Van Zelm, A. J. Hendriks, R. Bobbink and M. A. J. Huijbregts, Global assessment of the effects of terrestrial acidification on plant species richness, *Environ. Pollut.*, 2013, **174**, 10–15.
- 98 L. van Oers, A. de Koning, J. B. Guinée and G. Huppes, *Abiotic Resource Depletion in LCA*, Public Works and Water Management, 2002.
- 99 R. Frischknecht, R. Steiner, B. Arthur, E. Norbert and H. Gabi, *Swiss Ecological Scarcity Method: The New Version 2006*. Cycle, 2006.
- 100 A. M. Boulay, J. Bare, C. De Camillis, P. Döll, F. Gassert, D. Gerten, *et al.*, Consensus building on the development of a stress-based indicator for LCA-based impact assessment of water consumption: outcome of the expert workshops, *Int. J. Life Cycle Assess.*, 2015, **20**(5), 577–583.
- 101 EC, Commission, recommendation of 16.12.2021 on the use of the Environmental Footprint methods to measure and communicate the life cycle environmental performance of products and organisations. (2021) 9332 final, 2021.
- 102 M. Goedkoop, R. Heijungs, M. Huijbregts, A. De Schryver, J. Struijs and R. Van Zelm, *ReCiPe 2008*, Ministerie van Volkshuisvesting, Ruimtelijke ordening en Milieubeheer, 2009.
- 103 L. Milà i Canals, C. Bauer, J. Depestele, A. Dubreuil, R. Freiermuth Knuchel, G. Gaillard, *et al.*, Key Elements in a Framework for Land Use Impact Assessment Within LCA (11 pp), *Int. J. Life Cycle Assess.*, 2007, **12**(1), 5–15.
- 104 T. Beck, U. Bos, B. Wittstock, M. Baitz, M. Fischer and K. Selbauer, *Land Use Indicator Value Calculation in Life Cycle Assessment - Method Report*. Vol. 9, Cycle, 2010. 67p.
- 105 R. K. Rosenbaum, T. M. Bachmann, L. S. Gold, M. A. J. Huijbregts, O. Jolliet, R. Juraske, *et al.*, USEtox - The UNEP-SETAC toxicity model: Recommended characterisation factors for human toxicity and freshwater ecotoxicity in life cycle impact assessment, *Int. J. Life Cycle Assess.*, 2008, **13**, 532–546.
- 106 H. Wenzel, M. Hauschild, L. Alting and M. Overcash, Environmental assessment of products volume 1: Methodology, tools, and case studies in product, *Int. J. Life Cycle Assess.*, 1999, **4**(1), 6–6.
- 107 M. J. Eckelman, Life cycle inherent toxicity: A novel LCA-based algorithm for evaluating chemical synthesis pathways, *Green Chem.*, 2016, **18**(11), 3257–3264.
- 108 K. A. Scanlon, S. M. Lloyd, G. M. Gray, R. A. Francis and P. Lapuma, An Approach to Integrating Occupational Safety and Health into Life Cycle Assessment: Development and Application of Work Environment Characterization Factors, *J. Ind. Ecol.*, 2015, **19**(1), 27–37.
- 109 L. Aissani, F. Jabouille, J. Bourgois and P. Rousseaux, A new methodology for risk evaluation taking into account the whole life cycle (LCRA): Validation with case study, *Process Saf. Environ. Prot.*, 2012, **90**(4), 295–303.
- 110 T. M. Martin, A framework for an alternatives assessment dashboard for evaluating chemical alternatives applied to flame retardants for electronic applications, *Clean Technol. Environ. Policy*, 2017, **19**(4), 1067–1086.
- 111 A. Rabl, J. V. Spadaro and M. Holland, Description of the RiskPoll software, in *How Much Is Clean Air Worth?*, 2014.
- 112 S. Tian, H. Tang, Q. Wang, X. Yuan, Q. Ma and M. Wang, Evaluation and optimization of blanket production from



- recycled polyethylene terephthalate based on the coordination of environment, economy, and society, *Sci. Total Environ.*, 2021, **772**, 145049.
- 113 L. Scherer, S. A. Van Baren and P. M. Van Bodegom, Characterizing Land Use Impacts on Functional Plant Diversity for Life Cycle Assessments, *Environ. Sci. Technol.*, 2020, **54**(11), 6486–6495.
 - 114 N. G. Chemmangattuvalappil, Development of solvent design methodologies using computer-aided molecular design tools, *Curr. Opin. Chem. Eng.*, 2020, **27**, 51–59, DOI: [10.1016/j.coche.2019.11.005](https://doi.org/10.1016/j.coche.2019.11.005).
 - 115 K. Subramanian, C. K. Chau and W. K. C. Yung, Relevance and feasibility of the existing social LCA methods and case studies from a decision-making perspective, *J. Cleaner Prod.*, 2018, **171**, 690–703, DOI: [10.1016/j.jclepro.2017.10.006](https://doi.org/10.1016/j.jclepro.2017.10.006).
 - 116 P. Saavalainen, S. Kabra, E. Turpeinen, K. Oravisjärvi, G. D. Yadav, R. L. Keiski and E. Pongrácz, Sustainability assessment of chemical processes: Evaluation of three synthesis routes of DMC, *J. Chem.*, 2015, **2015**, 402315, DOI: [10.1155/2015/402315](https://doi.org/10.1155/2015/402315).
 - 117 G. Garas, A. M. Sayed and E. S. H. Bakhoun, Application of nano waste particles in concrete for sustainable construction: a comparative study, *Int. J. Sustain. Eng.*, 2021, **14**(6), 2041–2047, DOI: [10.1080/19397038.2021.1963004](https://doi.org/10.1080/19397038.2021.1963004).
 - 118 A. Arias, G. Feijoo and M. T. Moreira, Establishing the multi-criteria roadmap and metrics for the evaluation of active films for food packaging, *Curr. Res. Green Sustainable Chem.*, 2021, **4**, 100160, DOI: [10.1016/j.crgsc.2021.100160](https://doi.org/10.1016/j.crgsc.2021.100160).
 - 119 UN Environment Programme (UNEP), GREEN AND SUSTAINABLE CHEMISTRY: FRAMEWORK MANUAL Executive Summary. Available from: <https://www.unenvironment.org/explore-topics/chemicals-waste>.
 - 120 M. Bianchi, T. M. Bachmann, J. van der Kamp, M. Riemer, F. Riva and N. Pr  at, *et al.*, *Critical evaluation of economic approaches*, 2021.
 - 121 W. T. Fran  a, M. V. Barros, R. Salvador, A. C. de Francisco, M. T. Moreira and C. M. Piekarski, Integrating life cycle assessment and life cycle cost: a review of environmental-economic studies, *Int. J. Life Cycle Assess.*, 2021, **26**(2), 244–274, DOI: [10.1007/s11367-020-01857-y](https://doi.org/10.1007/s11367-020-01857-y).
 - 122 C. Alejandrino, I. Mercante and M. D. Bovea, Life cycle sustainability assessment: Lessons learned from case studies, *Environ. Impact Assess. Rev.*, 2021, **87**, 106517, DOI: [10.1016/j.eiar.2020.106517](https://doi.org/10.1016/j.eiar.2020.106517).
 - 123 C. Visentin, A. W. da S. Trentin, A. B. Braun and A. Thom  , Life cycle sustainability assessment: A systematic literature review through the application perspective, indicators, and methodologies, *J. Cleaner Prod.*, 2020, **270**, 122509.
 - 124 E. N. Pistikopoulos and S. K. Stefanis, Optimal solvent design for environmental impact minimization, *Comput. Chem. Eng.*, 1998, **22**(6), 717–733.
 - 125 I. Linkov, B. D. Trump, B. A. Wender, T. P. Seager, A. J. Kennedy and J. M. Keisler, Integrate life-cycle assessment and risk analysis results, not methods, *Nat. Nanotechnol.*, 2017, **12**(8), 740–743, DOI: [10.1038/nnano.2017.152](https://doi.org/10.1038/nnano.2017.152).
 - 126 S. Oguzcan, J. Dvarioniene, A. Tugnoli and J. Kruopiene, Environmental impact assessment model for substitution of hazardous substances by using life cycle approach *, *Environ. Pollut.*, 2019, **254**, 112945, DOI: [10.1016/j.envpol.2019.07.113](https://doi.org/10.1016/j.envpol.2019.07.113).
 - 127 M. M. Jacobs, T. F. Malloy, J. A. Tickner and S. Edwards, Alternatives assessment frameworks: Research needs for the informed substitution of hazardous chemicals, *Environ. Health Perspect.*, 2016, **124**(3), 265–280.
 - 128 R. Calvo-Serrano, M. Gonz  lez-Miquel and G. Guill  n-Gos  lbez, Integrating COSMO-Based σ -Profiles with Molecular and Thermodynamic Attributes to Predict the Life Cycle Environmental Impact of Chemicals, *ACS Sustainable Chem. Eng.*, 2019, **7**(3), 3575–3583.
 - 129 J. Tickner, M. Jacobs, T. Malloy, T. Buck, A. Stone, A. Blake, *et al.*, Advancing alternatives assessment for safer chemical substitution: A research and practice agenda, *Integr. Environ. Assess. Manage.*, 2019, **15**(6), 855–866.
 - 130 V. Isoni, L. L. Wong, H. H. Khoo, I. Halim and P. Sharratt, Q-SA/ESS: A methodology to help solvent selection for pharmaceutical manufacture at the early process development stage, *Green Chem.*, 2016, **18**(24), 6564–6572.
 - 131 S. A. Cashman, D. E. Meyer, A. N. Edelen, W. W. Ingwersen, J. P. Abraham, W. M. Barrett, *et al.*, Mining available data from the United States environmental protection agency to support rapid life cycle inventory modeling of chemical manufacturing, *Environ. Sci. Technol.*, 2016, **50**(17), 9013–9025.
 - 132 ETH, *Ecosolvent*. 2021.
 - 133 T. van Harmelen, E. K. Zondervan-van den Beuken, D. H. Brouwer, E. Kuijpers, W. Fransman, H. B. Buist, *et al.*, LICARA nanoSCAN - A tool for the self-assessment of benefits and risks of nanoproducts, *Environ. Int.*, 2016, **91**, 150–160, DOI: [10.1016/j.envint.2016.02.021](https://doi.org/10.1016/j.envint.2016.02.021).
 - 134 G. Wernet, S. Hellweg, U. Fischer, S. Papadokonstantakis and K. Hungerb  hler, Molecular-structure-based models of chemical inventories using neural networks, *Environ. Sci. Technol.*, 2008, **42**(17), 6717–6722.
 - 135 L. Pizzol, A. Livieri, B. Salieri, L. Farcas, L. G. Soeteman-Hern  ndez, H. Rauscher, *et al.*, Screening level approach to support companies in making safe and sustainable by design decisions at the early stages of innovation, *Clean. Environ. Syst.*, 2023, **10**, 100132.
 - 136 B. Salieri, D. A. Turner, B. Nowack and R. Hirsch, Life cycle assessment of manufactured nanomaterials: Where are we?, *NanoImpact*, 2018, **10**, 108–120.
 - 137 G. Upreti, R. Dhingra, S. Naidu, I. Atuahene and R. Sawhney, Life cycle assessment of nanomaterials, in *Green Process Nanotechnol From Inorg to Bioinspired Nanomater*, 2015, pp. 393–408.
 - 138 A. Kraegeloh, B. Suarez-Merino, T. Sluijters and C. Micheletti, Implementation of safe-by-design for nanomaterial development and safe innovation: Why we need



- a comprehensive approach, *Nanomaterials*, 2018, **8**(4), 239.
- 139 C. Som, M. Berges, Q. Chaudhry, M. Dusinska, T. F. Fernandes, S. I. Olsen, *et al.*, The importance of life cycle concepts for the development of safe nanoproducts, *Toxicology*, 2010, **269**(2–3), 160–169.
 - 140 S. Gottardo, A. Mech, J. Drbohlavov, J. R. Sintes and H. Rauscher, NanoImpact Towards safe and sustainable innovation in nanotechnology: State-of-play for smart nanomaterials, *NanoImpact*, 2021, **21**, 100297.
 - 141 D. E. Meyer and V. K. K. Upadhyayula, The use of life cycle tools to support decision making for sustainable nanotechnologies, *Clean Technol. Environ. Policy*, 2014, **16**(4), 757–772.
 - 142 CEN, *CEN/TS 17276:2018. Nanotechnologies - Guidelines for Life Cycle Assessment - Application of EN ISO 14044:2006 to Manufactured Nanomaterials*, 2018.
 - 143 J. R. Silverman, C. Bode and B. Subramaniam, Open-Access Chemical Assessments for Students and Educators: A Case Study for Evaluating Aspirin Synthesis, *ACS Symp. Ser.*, 2019, **1318**, 119–127.
 - 144 T. F. Malloy, V. M. Zaunbrecher, C. M. Batteate, A. Blake, W. F. Carroll, C. J. Corbett, *et al.*, Advancing alternative analysis: Integration of decision science, *Environ. Health Perspect.*, 2017, **125**(6), 652–664.
 - 145 H. Fu, S. Tisdale and M. Schaffer, Framework for implementing material alternatives assessment. 2016 Int Conf Electron Packag ICEP 2016. 2016, pp. 99–104.
 - 146 P. R. Croes and W. J. V. Vermeulen, Quantification of corruption in preventative cost-based S-LCA: a contribution to the Oiconomy project, *Int. J. Life Cycle Assess.*, 2019, **24**(1), 142–159.
 - 147 K. Alfonsi, J. Colberg, P. J. Dunn, T. Fevig, S. Jennings, T. A. Johnson, *et al.*, Green chemistry tools to influence a medicinal chemistry and research chemistry based organisation, *Green Chem.*, 2008, **10**(1), 31–36.
 - 148 D. Prat, O. Pardigon, H. W. Flemming, S. Letestu, V. Ducandas, P. Isnard, *et al.*, Sanofi's Solvent Selection Guide: A Step Toward More Sustainable Processes, *Org. Process Res. Dev.*, 2013, **17**(12), 1517–1525.
 - 149 L. J. Diorazio, D. R. J. Hose and N. K. Adlington, Toward a More Holistic Framework for Solvent Selection, *Org. Process Res. Dev.*, 2016, **20**(4), 760–773.
 - 150 German Environment Agency, *Guide on sustainable chemicals: A decision tool for substance manufacturers, formula-tors and end users of chemicals*, 2016.
 - 151 C. T. Pinheiro, M. J. Quina and L. M. Gando-Ferreira, New Methodology of Solvent Selection for the Regeneration of Waste Lubricant Oil Using Greenness Criteria, *ACS Sustainable Chem. Eng.*, 2018, **6**(5), 6820–6828.
 - 152 J. Ooi, D. K. S. Ng and N. G. Chemmangattuvalappil, Optimal molecular design towards an environmental friendly solvent recovery process, *Comput. Chem. Eng.*, 2018, **117**, 391–409.
 - 153 S. Zapata-Boada, M. Gonzalez-Miquel, M. Jobson and R. M. Cuéllar-Franca, A Methodology to Evaluate Solvent Extraction-Based Processes Considering Techno-Economic and Environmental Sustainability Criteria for Biorefinery Applications, *Ind. Eng. Chem. Res.*, 2021, **60**(45), 16394–16416.
 - 154 V. Ibáñez-Forés, M. D. Bovea and V. Pérez-Belis, A holistic review of applied methodologies for assessing and selecting the optimal technological alternative from a sustainability perspective, *J. Cleaner Prod.*, 2014, **70**, 259–281.
 - 155 C. García-Velásquez, C. Defryn and Y. Van Der. Meer, Life cycle optimization of the supply chain for biobased chemicals with local biomass resources, *Sustainable Production and Consumption*, 2023, **36**, 540–551.
 - 156 K. J. Manjunatheshwara and S. Vinodh, Application of TISM and MICMAC for analysis of influential factors of sustainable development of tablet devices: a case study, *Int. J. Sustain. Eng.*, 2018, **11**(5), 353–364, DOI: [10.1080/19397038.2017.1387186](https://doi.org/10.1080/19397038.2017.1387186).
 - 157 National Research Council, *A Framework to Guide Selection of Chemical Alternatives. A Framework to Guide Selection of Chemical Alternatives*, 2014.
 - 158 J. M. Panko, K. Hitchcock, M. Fung, P. J. Spencer, T. Kingsbury and A. M. Mason, A comparative evaluation of five hazard screening tools, *Integr. Environ. Assess. Manage.*, 2017, **13**(1), 139–154.
 - 159 Interstate Chemicals Clearinghouse, *Alternatives Assessment Guide Version 1.1*, 2017; Available from: https://theic2.org/article/download-pdf/file_name/IC2_AA_Guide_Version_1.1.pdf.
 - 160 OECD, *Test Guidelines for chemicals [Internet]*, 2024. Available from: <https://www.oecd.org/chemicalsafety/testing/oecdguidelinesforthetestingofchemicals.htm>.
 - 161 Safer Consumer Products, *Alternative Analysis guide*, 2020, (32999), pp. 1–302. Available from: https://dtsc.ca.gov/wp-content/uploads/sites/31/2016/01/AA-Guide-Version-1-0_June-2017.pdf.
 - 162 M. Saeli, R. Micale, M. P. Seabra, J. A. Labrincha and G. La Scalia, Selection of novel geopolymeric mortars for sustainable construction applications using fuzzy topsis approach, *Sustainability*, 2020, **12**(15), 5987.
 - 163 S. Linke, K. McBride and K. Sundmacher, Systematic Green Solvent Selection for the Hydroformylation of Long-Chain Alkenes, *ACS Sustainable Chem. Eng.*, 2020, **8**(29), 10795–10811.
 - 164 P. Samani, A. Mendes, V. Leal, J. M. Guedes and N. Correia, A sustainability assessment of advanced materials for novel housing solutions, *Build. Environ.*, 2015, **92**, 182–191.

