

Table 1

Solvent*	GlaxoSmithKline Score						δ_d (MPa ^{0.5})	δ_p (MPa ^{0.5})	δ_h (MPa ^{0.5})	Hansen radius (-)	P(3HB) solubility (g/L)
	Waste	Environmental impact	Health	Flammability & Explosion	Reactivity/ Stability	Life Cycle Score					
Homo-polymer P(3HB)							19.3	5.3	6.3		
Chloroform	3	6	3	6	9	6	17.8	3.1	5.7	3.77	11.23
Water	4	10	10	10	10	10	15.5	16	42.3	38.32	0.00
Isoamyl alcohol	6	6	7	9	10	6	15.8	5.2	13.3	9.90	0.16
Glycerol	6	7	8	10	9	8	17.4	12.1	29.3	24.28	0.00
Cyclohexanone	6	8	6	8	9	6	17.8	6.3	5.1	3.38	14.66
Ethylacetate	4	8	8	4	8	6	15.8	5.3	7.2	7.06	1.15
Butylacetate	6	9	8	6	10	8	15.8	3.7	6.3	7.18	1.05
Ethyl lactate	7	5	4	8	10	-	16	7.6	12.5	9.34	0.24
Propylene carbonate	6	7	5	8	9	-	20.0	18.0	4.1	12.97	0.02
Phenetole	8	4	7	10	10	-	18.4	4.5	4.0	3.03	18.73
Anisole	6	6	7	7	6	5	17.8	4.1	6.7	3.26	16.00
Trichloroacetonitrile	5	6	6	7	10	-	16.4	7.4	6.1	6.17	2.13

* In bold the solvents with the best solubility, which were further analyzed.