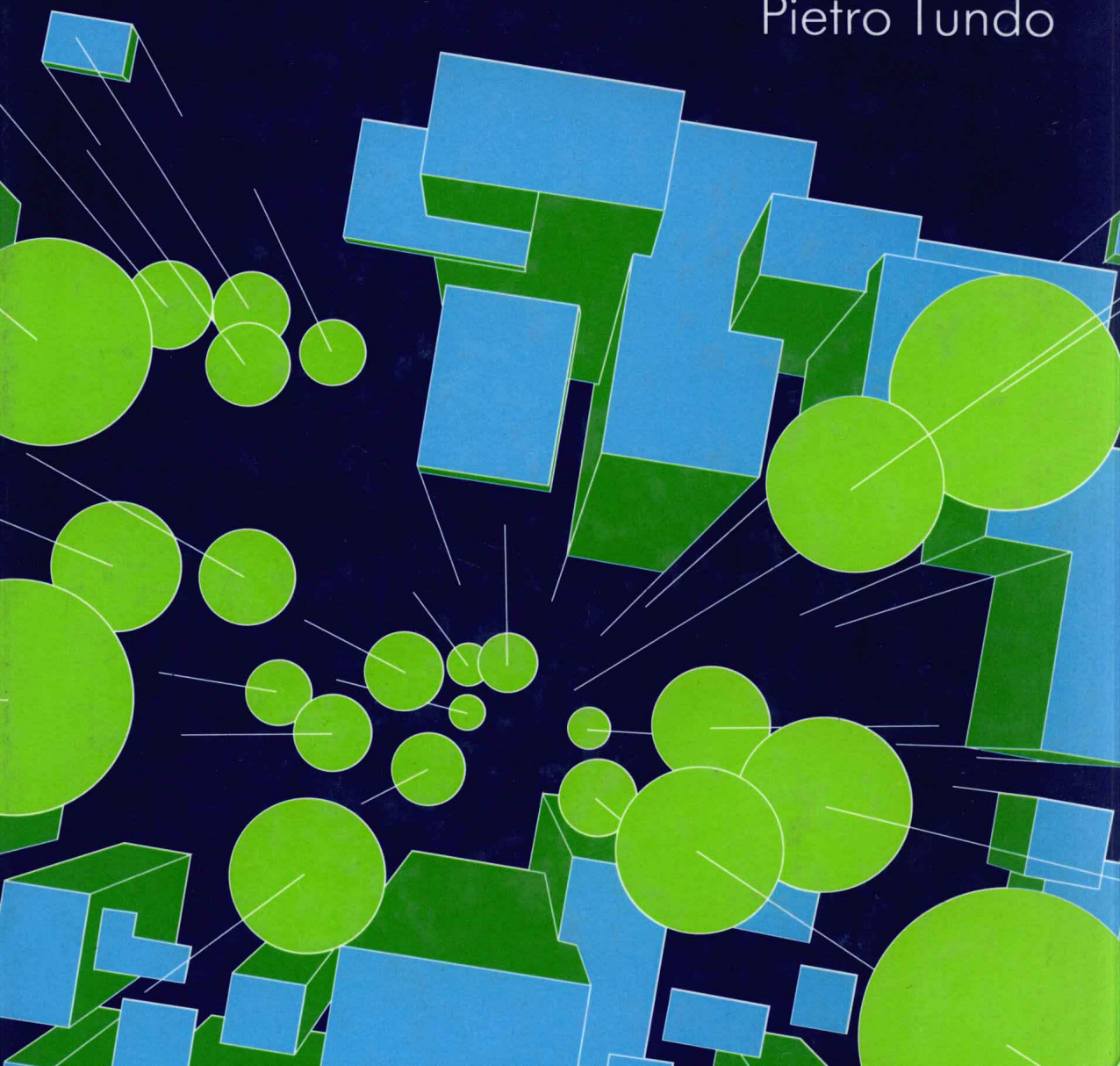


ELLIS HORWOOD SERIES IN ORGANIC CHEMISTRY

CONTINUOUS FLOW METHODS IN ORGANIC SYNTHESIS

Pietro Tundo



**ELLIS HORWOOD SERIES IN
ORGANIC CHEMISTRY**

Series Editor: Dr JOHN MELLOR, Department of
Chemistry, University of Southampton

**CONTINUOUS FLOW METHODS IN ORGANIC
SYNTHESIS**

PIETRO TUNDO, Professor of Organic Chemistry,
Faculty of Sciences, University of Venice, Italy
With a foreword by Professor P. HODGE, Department of
Chemistry, University of Lancaster

Organic syntheses carried out under continuous-flow conditions have been widely employed in industry because they can economically supply large quantities of a wide variety of chemicals.

The world output of fine chemicals has continued, and will continue to increase significantly. The book shows how improved new processes under flow conditions can be achieved as a result of new organic reaction methods and by the introduction of new resistant supports. Incorporating the knowledge we have of macromolecular chemistry, it addresses industrial problems via modern organic chemical methods. The author also shows that flow processes have the advantage that operational difficulties can be easily controlled, demonstrating how chemical research can take care of both environmental protection and work safety.

Continuous flow methods have been divided into:

- (i) Reactions carried out in gas-phase, by means of solid catalysts.
- (ii) Reactions carried out in gas-phase by means of liquid catalysts supported on solid matrices.
- (iii) Reactions carried out in liquid phase by means of catalysts supported on solid matrices.

There is discussion on numerous differing varieties of support catalysts, and how they can be combined in manufacture, introduced according to the classifications i, ii, and iii listed above. The applications include:

- gas-liquid phase-transfer analysis
- solid-phase peptide synthesis
- hydroformylation and other reactions under supported liquid-phase catalysis conditions
- recent synthetic applications of zeolites in fine chemistry
- reactions of Nafion-catalysts and other acidic exchange resins
- decontamination of mineral oils containing polychlorinated biphenyls
- immobilized enzymes in organic synthesis
- continuous-flow synthesis in phase-transfer catalysis.

An appendix provides more hints on reactors and included are lengthy accounts of recent supports for catalysts such as membranes and monoliths. There are 3000 references to the literature which should pave the way for further investigative research.

Readership: Researchers and graduate students of organic chemistry and industrial chemistry. Also of interest to researchers and graduate students of macromolecular and polymer chemistry. Plastics, pharmaceutical, and fine chemical industries will also find the book valuable.

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IN ORGANIC SYNTHESIS**

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Table of contents

FORWORD	11
PREFACE	13
ABBREVIATIONS	14
ACKNOWLEDGEMENTS	16
INTRODUCTION	17
1 PREPARATION AND PROPERTIES OF HETEROGENEOUS AND HETEROGENIZED CATALYSTS	21
1.1 Introduction	21
1.2 Catalysts for gas–solid syntheses	22
1.2.1 Metal oxides	22
1.2.1.1 Alumina	23
1.2.1.2 Silica gel	27
1.2.1.3 Silica–alumina	32
1.2.1.4 Zeolites	34
1.2.1.5 Other metal oxides	40
1.2.1.6 Other supports	42
1.2.2 Metals and supported metals	43
1.2.2.1 Preparation	45
1.2.2.2 Superbasic heterogeneous catalysts	49
1.3 Catalysts for gas–liquid syntheses	50
1.3.1 Supported liquid–phase catalysis (SL-PC)	51
1.3.2 Reaction 3 carried out with supported liquid–phase catalysis	54
1.4 Catalysts for liquid–solid syntheses	59
1.4.1 Inorganic supports	63
1.4.1.1 Introduction	63
1.4.1.2 Reagents on inorganic supports	64
1.4.1.3 Functionalization of inorganic supports	65
1.4.1.4 Catalytic systems on inorganic supports	72

1.4.2	Organic polymers	77
1.4.2.1	Synthesis of functional polymers.	77
1.4.2.2	Derivatizing functional polymers	80
1.4.2.3	Utilization of functional polymers.	85
1.4.2.4	Immobilized inorganic catalysts and reagents	86
1.4.2.5	Immobilized organic catalysts and reagents	87
	References.	99
2	CHARACTERIZATION OF SUPPORTED CATALYSTS	111
2.1	Porous solids	111
2.1.1	Surface area.	112
2.1.2	Pore volume and pore-size distribution	114
2.1.3	Chemisorption	118
2.2	Characterization of metal phase.	118
2.2.1	Electron scattering	119
2.2.2	Photon spectroscopy	119
2.3	Characterization of polymers	121
2.3.1	Chemical methods.	122
2.3.2	Physical methods	122
2.4	Characterization of catalysts under SL-PC conditions	127
2.4.1	Comparing catalytic activity	128
	References.	135
3	REACTIONS CARRIED OUT IN GAS PHASE	139
3.1	Basic industrial processes	139
3.1.1	Introduction	139
3.1.2	Aniline	140
3.1.3	Ethylene oxide	141
3.1.4	Styrene.	141
3.1.5	Amoxidation reactions.	142
3.1.6	Hydrogenation reactions.	142
3.2	Nafion catalysed reactions	144
3.2.1	Nafion properties	144
3.2.2	Nafion catalysed reactions.	145
3.2.3	Nafion supported catalysts	150
3.3	Zeolites	150
3.3.1	Introduction	150
3.3.2	Hydration and dehydration reactions.	153
3.3.3	Aldol condensation	153
3.3.4	Hydroformylation	154
3.3.5	Ethers and esters	154
3.3.6	Amines.	155
3.3.7	Nitration and halogenation of aromatics.	155
3.3.8	The Beckmann rearrangement	156
3.3.9	Acetylation of aromatics.	157

3.3.10	Selective oxidations with titanium silicalite	157
3.3.11	Conclusions	160
3.4	Supported basic catalysts	160
3.4.1	Introduction	160
3.4.2	Supported alkali metals and other superbasic catalysts.	161
	References	164

4 REACTIONS CARRIED OUT IN GAS PHASE OVER A LIQUID FILM OF CATALYST

		170
4.1	Introduction	170
4.2	Basic industrial processes	170
4.2.1	Supported phosphoric acid	170
4.2.2	Deacon catalyst: oxychlorination of ethylene.	172
4.2.3	Vanadia melt	175
4.3	Noble metal complexes	177
4.3.1	CF hydroformylation under gas and liquid phase	177
4.3.2	CF hydroformylation with supported liquid-phase catalysis	180
4.3.2.1	Introduction	180
4.3.2.2	Influence of the support	181
4.3.2.3	Nature of the liquid phase	183
4.3.2.4	Reaction mechanism	184
4.3.2.5	Applications	187
4.3.3	Other noble metals promoting reactions under SL-PC conditions	189
4.4	Gas-liquid phase-transfer catalysis (GL-PTC).	190
4.4.1	Introduction	190
4.4.2	Methods in GL-PTC	193
4.4.3	Reactions carried out in GL-PTC: reactive beds.	194
4.4.4	Reactions carried out in GL-PTC: catalytic beds	202
4.4.5	Base-mediated reactions in GL-PTC: mechanistic aspects	214
4.4.6	Pilot plant	215
	References	219

5 CONTINUOUS-FLOW SYNTHESSES IN THE LIQUID PHASE

5.1	Introduction	224
5.2	Basic industrial processes	225
5.2.1	Introduction	225
5.2.2	Linear α -olefins	226
5.2.3	Linear alkylbenzenes	226
5.2.4	Sulfonation	226
5.2.5	Ethyl acrylate and methyl methacrylate	227
5.2.6	Acrylic acid	227
5.2.7	Methacrylic acid	227
5.2.8	Vinyl acetate	227
5.2.9	<i>n</i> -Butyraldehyde	228
5.2.10	CF polymerization: styrene-acrylonitrile copolymer	228

5.3	Polymeric reagents	228
5.4	Solid-phase synthesis	229
5.4.1	Introduction	229
5.4.2	Solid-phase peptide synthesis (SPPS)	230
5.4.2.1	Protecting group strategies	233
5.4.2.2	Solid supports for SPPS	236
5.4.2.3	Linkers to the support	239
5.4.2.4	Methods of activation	241
5.4.2.5	Continuous-flow procedures	242
5.4.2.6	Instrumentation	244
5.4.2.7	Other SPPS strategies	246
5.4.2.8	Other polymeric reagents	249
5.4.2.9	New supports for solid-phase synthesis	252
5.5	Reactions with reagents and catalysts not chemically immobilized	261
5.5.1	Introduction	261
5.5.2	Removal and decontamination of polychlorinated biphenyls	262
5.5.3	Supported aqueous-phase catalysis	265
5.6	Strongly acidic ion exchange resins	267
5.6.1	Introduction	267
5.6.2	Industrial catalytic processes	269
5.6.3	Sulfonic acid-functionalized silica gel	272
5.7	Phase-transfer catalysis	276
5.7.1	Introduction	276
5.7.2	CF processes in PTC	282
5.8	Immobilized enzymes	287
5.8.1	Introduction	287
5.8.2	Supports for enzyme immobilization	288
5.8.3	Enzyme immobilization	289
5.8.4	Enzyme reactors for CF synthesis	291
5.8.5	Synthetic applications	292
5.9	CF asymmetric induction	296
	References	299
APPENDIX 1 MEMBRANES		311
A1.1	Introduction	311
A1.1.1	How the membrane works	313
A1.2	Membrane materials	318
A1.2.1	Organic membranes	318
A1.2.2	Inorganic membranes	318
A1.2.3	Other inorganic materials	319
A1.3	Membrane fabrication	321
A1.3.1	Organic membranes	321
A1.3.2	Inorganic membranes	322
A1.4	Membrane modules and catalytic reactor configurations	325
A1.4.1	Catalyst confinement	325
A1.4.2	Flow-through catalyst supports	327

A1.4.3	Membranes as mediator of catalyst contact	328
A1.4.4	Assembling unit operations	328
A1.5	Catalytic processes	329
A1.5.1	Composite/multistep membrane reactors.	330
A1.5.2	Multiphase enzyme membrane reactors.	331
A1.5.3	Extractive enzyme membrane reactors	333
A1.5.4	Phase-transfer catalysis with membranes	333
A1.5.5	Inorganic membranes in catalysis.	335
A1.6	Conclusions	336
	References.	340
APPENDIX 2 MONOLITHS		344
A2.1	Introduction	344
A2.2	Applications	349
	References.	351
APPENDIX 3 REACTORS		353
A3.1	Introduction	353
A3.2	Reactor classification	356
A3.3	Continuous reactors	360
A3.3.1	Reactors with plug flow with packed bed	360
A3.3.2	Reactors with perfect mixing.	361
A3.3.3	Kinetics	362
A3.4	Reactor description	364
A3.4.1	Stirred-tank reactors	364
A3.4.2	Fixed-bed reactors	364
A3.4.3	Bubble-column reactors	366
A3.4.4	Fluidized-bed reactors	368
A3.4.5	Trickle-bed reactors	369
A3.4.6	Particular type of reactors.	370
	References.	371
INDEX		374

*to my much loved parents
and my brother Paolo*

Foreword

Students of organic chemistry will be well aware that when a compound needs to be synthesized there are often two ways in which it can be achieved: the laboratory way and the industrial way. Usually the former involves batch processes whereas the latter involves continuous flow processes. Continuous flow methods have the advantages that the reaction conditions are normally easily controlled and reproduced and that a relatively small reactor can be used to produce large amounts of product. It is perhaps inevitable that with the passage of time the differences between the two approaches would decrease and, indeed, this is now the case. Thus, whilst many industrial continuous flow reactions involve gases, continuous flow liquid phase reactions are also common and the latter are beginning to appear in the research laboratory. For example, Merrifield's original method of solid phase peptide synthesis has been developed into a laboratory flow process. Immobilized enzymes can also be used in flow reactors. I believe the method can be applied with benefit to many other areas of organic synthesis and that one day small computer-controlled bench-top flow reactors will be a common feature of many research laboratories. Studies involving flow reactors are, however, interdisciplinary and there is little doubt that this has hampered developments. Accordingly, when the opportunity arose I encouraged Pietro Tundo, an organic chemist who has pioneered novel developments in laboratory flow reactors, to make available to others the benefits of his experience and to draw together into a book the various interdisciplinary aspects. The result is the present book. Whilst it considers industrial continuous flow processes, the emphasis is on principles and innovative developments, especially in small-scale and laboratory-scale processes. I am confident the book will become a reference point for future work and am proud to have been involved in the project. I look forward to future developments in the field.

Philip Hodge
Manchester

Preface

The future of industrial chemistry is bound up with how closely both environmental needs and increasing automation are coupled with the development of new ideas in basic research. In this respect, the optimization of the raw materials used, of energy consumption, of product yields and of the efficiency of reactors, together with the reduction of waste, are a constant challenge. Improvements in the individual steps of a production process may often be more important than the development of a new process.

The successful solution of the problems thus raised will require a team of experts drawn from a variety of disciplines who will be able to combine new materials and new catalysts with new reaction conditions. Particularly significant will be the design and preparation of selective catalysts for new processes in which continuous-flow conditions are of primary importance. It is the continuous-flow process, moreover, that utilizes such innovative supports as membranes and monoliths.

The aim of this book is to link the different pursuits of pure research and industrial development. While I cannot hope to do full justice to such an enormously wide field, I do hope that I succeed in making a contribution in the problem area that is at the heart of the evolution of the chemical industry.

P. Tundo

Abbreviations

CF	Continuous-flow
GL-PTC	Gas-liquid phase-transfer catalysis
PTC	Phase-transfer catalysis
SA-PC	Supported aqueous-phase catalysis
SL-PC	Supported liquid-phase catalysis
PFR	Plug-flow reactor
CSTR	Continuously stirred tank reactor
SPPS	Solid-phase peptide synthesis
SPS	Solid-phase synthesis

AIBN	Azobisisobutyronitrile
Py	Pyridine
DMF	<i>N,N'</i> -Dimethylformamide
THF	Tetrahydrofuran
HMPA	Hexamethylphosphoramide
DDC	<i>N,N'</i> -Dicyclohexylcarbodiimide
DVB	Divinylbenzene
PEGs	Polyethylene glycols
PCBs	Polychlobiphenyls
Boc	<i>t</i> -butoxycarbonyl
Fmoc	9-Fluorenylmethoxycarbonyl
DMC	Dimethyl carbonate
PTFE	Polytrifluoroethylene
DMTr	4,4'-Dimethoxytrityl
TFA	Trifluoroacetic acid
Ts	Tosyl
Ms	Mesyl

mEq	10 ⁻³ equivalents
mmol	10 ⁻³ moles
μmol	10 ⁻⁶ moles

molEq	Molar equivalents
MPa	10^6 pascals
ee	Enantiomeric excess
τ	Contact time, space time
GHSV	Gas hourly space velocity
LHSV	Liquid hourly space velocity
WHSV	Weight hourly space velocity
i.r.	Infrared spectroscopy
n.m.r.	Nuclear magnetic resonance
u.v.	Ultraviolet spectroscopy
TGA	Thermal gravimetric analysis
BET	Brunauer–Emmett–Teller's method for surface area determination