

Contents

Foreword	V
List of Contributors	XV

1	Introduction to Green Chemistry, Organic Synthesis and Pharmaceuticals	1
	<i>Roger Sheldon</i>	
1.1	The Development of Organic Synthesis	1
1.2	The Environmental Factor	4
1.3	The Role of Catalysis	7
1.4	Green Chemistry: Benign by Design	10
1.5	Ibuprofen Manufacture	11
1.6	The Question of Solvents: Alternative Reaction Media	11
1.7	Biocatalysis: Green Chemistry Meets White Biotechnology	15
1.8	Conclusions and Prospects	18
	References	18
2	Green Chemistry Metrics	21
	<i>Richard K. Henderson, David J.C. Constable, and Concepción Jiménez-González</i>	
2.1	Introduction	21
2.2	Measuring Resource Usage	24
2.2.1	Focus on Solvents	26
2.2.2	Focus on Renewables	28
2.2.3	Cleaning and Maintenance	30
2.3	Life Cycle Assessment (LCA)	30
2.4	Measuring Chemistry and Process Efficiency	34
2.5	Measuring Process Parameters and Emissions	35
2.6	Real Time Analysis	36
2.6.1	Scalability	36
2.6.2	Controllability	37
2.6.3	Robustness	38

2.7	Operational Efficiency	38
2.8	Measuring Energy	39
2.9	Measuring the Toxicity of All the Substrates	40
2.9.1	Occupational Exposure Hazard and Risk	40
2.10	Measuring Degradation Potential	43
2.11	Measuring the Inherent Safety or Lack of Inherent Safety	45
2.12	Conclusions	45
	References	46
3	Solvent Use and Waste Issues	49
	<i>C. Stewart Slater, Mariano J. Savelski, William A. Carole, and David J.C. Constable</i>	
3.1	Introduction to Solvent Use and Waste Issues	49
3.1.1	Introduction	49
3.1.2	Process Efficiency Metrics	50
3.1.3	Impact Beyond the Plant – Solvent Life Cycle	51
3.1.4	Solvent Utilization	52
3.1.5	Solvents Used in the Pharmaceutical Industry	54
3.1.6	Solvent Use in Process Development	57
3.1.7	Consequences of Excessive Solvent Use	59
3.1.8	Waste Management Practices in the United States	61
3.2	Solvent and Process Greenness Scoring and Selection Tools	64
3.2.1	Review of Solvent and Process Scoring Methods	64
3.2.1.1	Greenness Assessment of Pharmaceutical Processes and Technology	64
3.2.1.2	Greenness Scoring Methods for Solvents	66
3.2.1.3	The GSK Solvent Selection Guide	68
3.2.1.4	The Rowan Solvent Greenness Index Method	70
3.3	Waste Minimization and Solvent Recovery	73
3.3.1	Minimizing Solvent Use	73
3.3.1.1	Batch versus Continuous Reactors	74
3.3.1.2	Biosynthetic Processes	74
3.3.1.3	Solid-State Chemistry	75
3.3.1.4	Telescoping	75
3.3.2	Recycling Solvents	76
3.3.2.1	Methods to Recover and Reuse Solvents	76
3.3.2.2	Issues with Solvent Recovery and Reuse	79
	Acknowledgments	80
	References	81
4	Environmental and Regulatory Aspects	83
	<i>David Taylor and Vyvyan T. Coombe</i>	
4.1	Historical Perspective	83
4.2	Pharmaceuticals in the Environment	84
4.2.1	Presence	84
4.2.2	Persistence	86
4.2.3	Bioaccumulation	86

4.2.4	Ecotoxicology	87
4.2.5	The Current State of the Science	90
4.3	Environmental Regulations	90
4.3.1	Product Regulations	91
4.3.2	Process Regulations	93
4.3.2.1	Chemicals Control	93
4.3.2.2	Integrated Pollution Control	95
4.3.3	Environmental Quality Regulations	97
4.4	A Look to the Future	98
	References	99
5	Synthesis of Sitagliptin, the Active Ingredient in Januvia® and Janumet®	101
	<i>Jaume Balsells, Yi Hsiao, Karl B. Hansen, Feng Xu, Norihiro Ikemoto, Andrew Clausen, and Joseph D. Armstrong III</i>	
5.1	Introduction	101
5.2	First-Generation Route	102
5.3	Sitagliptin through Diastereoselective Hydrogenation of an Enamine. The PGA Enamine-Ester Route	105
5.4	The Triazole Fragment	109
5.5	Direct Preparation of β -Keto Amides	112
5.6	Second-Generation Chiral Auxiliary Route. The PGA Enamine-amide Route	115
5.7	The Asymmetric Hydrogenation Route	116
5.8	Purification and Isolation of Sitagliptin (Pharmaceutical Form)	122
5.9	The Final Manufacturing Route	123
	Acknowledgments	125
	References	125
6	The Development of Short, Efficient, Economic, and Sustainable Chemoenzymatic Processes for Statin Side Chains	127
	<i>Martin Schürmann, Michael Wolberg, Sven Panke, and Hans Kierkels</i>	
6.1	Introduction: Biocatalysis	127
6.2	The Relevance of Statins	128
6.3	Biocatalytic Routes to Statin Side Chains	129
6.4	2-Deoxy-D-Ribose 5-Phosphate Aldolase (DERA)-Based Routes to Statin Intermediates	131
6.4.1	Chemical Transformations of the DERA Product Toward Statins	131
6.4.2	Optimization and Scale-Up of the DERA Reaction	133
6.4.2.1	Deactivation of DERA	136
6.4.2.2	Enzyme Kinetics	136
6.4.2.3	Conclusions and Outlook	138
6.4.3	Improvement of DERA by Directed Evolution	139
6.5	Conclusions	142
	Acknowledgments	143
	References	143

7	The Taxol® Story—Development of a Green Synthesis via Plant Cell Fermentation	145
	<i>Pia G. Mountford</i>	
7.1	Introduction	145
7.2	Discovery and Early Development	146
7.3	From Extraction of Taxol® from Pacific Yew Tree Bark to Semi-Synthetic Taxol®	147
7.4	Taxol® from Plant Cell Fermentation	150
7.5	Comparison of Semi-Synthetic versus PCF Taxol® Processes: The Environmental Impact	154
7.5.1	Semi-Synthetic Process	154
7.5.1.1	<i>Taxus Baccata</i> Plantations	154
7.5.1.2	Biomass Waste from Isolating 10-DAB	154
7.5.1.3	Chemical Synthesis	154
7.5.2	Plant Cell Fermentation Process	155
7.5.2.1	Plant Cell Fermentation	155
7.5.2.2	Crude Paclitaxel Isolation	155
7.5.2.3	Chromatographic Purification of Crude Paclitaxel	155
7.6	Comparison of Semi-Synthetic versus PCF Taxol®: Green Chemistry Principles	156
7.6.1	Reagent Use	156
7.6.2	Solvent Use	156
7.6.3	Energy and Handling Implications	157
7.7	Final Words	158
	Acknowledgments	158
	References	159
 8	 The Development of a Green, Energy Efficient, Chemoenzymatic Manufacturing Process for Pregabalin	 161
	<i>Peter J. Dunn, Kevin Hettenbach, Patrick Kelleher, and Carlos A. Martinez</i>	
8.1	Introduction	161
8.2	Process Routes to Pregabalin	161
8.2.1	Classical Resolution Route	162
8.2.2	Asymmetric Hydrogenation Route to Pregabalin	163
8.2.3	Non-Pfizer/Parke-Davis Routes to Pregabalin	165
8.3	Biocatalytic Route to Pregabalin	165
8.3.1	Enzyme Screening, Optimization, and Recycling of Undesired Enantiomer	166
8.3.2	Subsequent Chemical Steps to Pregabalin	170
8.4	Green Chemistry Considerations	171
8.4.1	Material Usage	172
8.4.2	Energy Usage	173
8.5	Conclusions	176
	Acknowledgments	176
	References	176

9	Green Processes for Peptide Mimetic Diabetic Drugs	179
	<i>Yasuhiro Sawai and Mitsuhsa Yamano</i>	
9.1	Introduction	179
9.2	Green Chemistry Considerations in Peptide-like API Manufacture	179
9.3	Purification Process to Manufacture Amorphous API	182
9.3.1	Cation Exchange Chromatography	184
9.3.2	Extraction	186
9.4	Preparation of Unnatural Amino Acids	187
9.4.1	Crystallization-Induced Diastereomer Transformation	188
9.4.2	Optical Resolution via Diastereomeric Salt Formation	191
9.5	Summary	193
	Acknowledgments	193
	References	193
10	The Development of an Environmentally Sustainable Process for Radafaxine	197
	<i>Trevor Grinter</i>	
10.1	Introduction	197
10.1.1	Background	198
10.2	Chemistry Process and the Dynamic Kinetic Resolution (DKR)	199
10.2.1	General Description of the Chemistry	201
10.2.2	Route 2	202
10.2.3	Route 3	202
10.3	Multicolumn Chromatography—Development of Route 4	206
10.4	Environmental Assessment	212
10.4.1	Life Cycle Metrics	214
10.4.2	Eco-Efficiency Benefits	216
10.5	Summary	217
	Acknowledgments	218
	References	218
11	Continuous Processing in the Pharmaceutical Industry	221
	<i>Lee Proctor, Peter J. Dunn, Joel M. Hawkins, Andrew S. Wells, and Michael T. Williams</i>	
11.1	Introduction	221
11.2	Continuous Production of a Key Intermediate for Atorvastatin	223
11.2.1	Laboratory Screening	223
11.2.2	Reaction Scale-up	225
11.2.3	Product Isolation and Waste Treatment	226
11.3	Continuous Process to Prepare Celecoxib	228
11.4	Continuous Oxidation of Alcohols to Aldehydes	232
11.5	Continuous Production of Bromonitromethane	234
11.6	Continuous Production and Use of Diazomethane	235
11.7	A Snapshot of Some Further Continuous Processes Used in the Preparation of Pharmaceutical Agents	238

11.8	Conclusions	241
	Acknowledgments	241
	References	241
12	Preparative and Industrial Scale Chromatography: Green and Integrated Processes	243
	<i>Eric Lang, Eric Valéry, Olivier Ludemann-Hombourger, Wieslaw Majewski, and Jean Bléhaut</i>	
12.1	Introduction	243
12.2	Basic Principles of Chromatography	244
12.3	Process Optimization to Reduce Eluent Consumption	246
12.3.1	Batch Processes	247
12.3.1.1	Increasing Injected Amount	247
12.3.1.2	Reducing Cycle Time with Stacked Injections (Case of Isocratic Eluents)	247
12.3.1.3	Reducing Cycle Time Using Gradients	248
12.3.2	Continuous Processes	249
12.4	Use of a Green Solvent: Supercritical Carbon Dioxide	252
12.5	Solvent Recycling Technologies	255
12.5.1	Recycling Devices for Isocratic Chromatography	256
12.5.2	Recycling Devices for Gradient Chromatography	257
12.5.3	Recycling Devices for Supercritical Carbon Dioxide	258
12.6	Application Examples	259
12.6.1	Optimization of a Batch Process	259
12.6.2	Selection of the Chromatographic Conditions	259
12.6.3	Scale-up on a Pilot SFC Unit	261
12.6.4	Optimization of an MCC Process	264
12.7	Conclusion: An Environmentally Friendly Solution for Each Separation	264
	Acknowledgment	266
	References	266
13	Dynamic Resolution of Chiral Amine Pharmaceuticals: Turning Waste Isomers into Useful Product	269
	<i>John Blacker and Catherine E. Headley</i>	
13.1	Background	269
13.1.1	Chiral Amine Resolution Processes	269
13.1.2	Homochiral Amine Racemization Processes	272
13.2	Integration of Chiral Amine Resolution and Racemization	276
13.2.1	Dynamic Resolution Processes	276
13.3	Case Studies	279
13.3.1	Asymmetric Transformation of (S)-7-Methoxy-1,2,3,4-tetrahydronaphthalen-2-amine	279
13.3.2	Asymmetric Transformation of (R)-1-tert-butyloxycarbonyl-3-aminopyrrolidine	281

13.3.3	Sertraline	282
13.4	Conclusions	286
	Acknowledgments	287
	References	287
14	Green Technologies in the Generic Pharmaceutical Industry	289
	<i>Apurba Bhattacharya and Rakeshwar Bandichhor</i>	
14.1	Introduction	289
14.2	'Waste': Definition and Remedy	292
14.3	Amidation	293
14.3.1	Carbodiimide and Acid Chloride Mediated Transformation	293
14.3.2	Metal-Catalyzed Oxidative Amide Synthesis	294
14.3.2.1	Copper-Catalyzed Amide Synthesis	294
14.3.2.2	Palladium-Catalyzed Amide Synthesis	294
14.3.2.3	Ruthenium-Catalyzed Amide Synthesis	295
14.3.3	N-Heterocyclic Carbene (NHC-Catalyzed Amidation)	296
14.3.4	Amidation Catalyzed by Boric Acid Derivatives	297
14.4	Synthesis of Galanthamine	298
14.5	Synthesis of Sofosbuvir	298
14.5.1	Precedented Approach	298
14.5.2	A Greener Approach	299
14.6	Synthesis of Levetiracetam	300
14.6.1	Established Approach	300
14.6.2	A More Eco-Friendly Synthesis	301
14.7	Synthesis of a Finasteride Intermediate	301
14.7.1	The Classical Approach	301
14.7.2	Problems with the Existing Synthesis	302
14.7.3	A Catalytic Approach	302
14.8	Bromination	304
14.8.1	Current Zafirlukast Bromination Method	304
14.8.2	Environmental Burden	305
14.8.3	Waste-Minimized Bromination	305
14.9	Sulfoxidation in the Synthesis of Rabeprazole	306
14.9.1	The Traditional Approach	306
14.9.2	A Greener Approach	307
14.10	Conclusions	307
	Acknowledgments	308
	References	308
15	Environmental Considerations in Biologics Manufacture	311
	<i>Sa V. Ho</i>	
15.1	Introduction	311
15.2	Therapeutic Biologics	312
15.2.1	Types of Therapeutic Biologics	312
15.2.2	General Features of Therapeutic Protein Manufacture	314

15.3	Environmental Impact Considerations	317
15.3.1	Microbially Produced Proteins	317
15.3.1.1	Insulin Production Process	317
15.3.1.2	Production of a Typical Medium-Sized Protein	318
15.3.1.3	Highly Efficient Protein Manufacturing Process	319
15.3.2	Monoclonal Antibodies and Mammalian Cell Culture Processes	321
15.3.2.1	Typical-to-Optimized Manufacturing Process for mAbs	322
15.3.2.2	Projected 'Intensified' Large-Scale Monoclonal Antibody Manufacturing Process	322
15.4	Overall Comparison	324
15.5	Environmental Indices for Therapeutic Protein Manufacture	325
15.6	Technologies with Potential Environmental Impact	327
15.7	Single-Use Biologics Manufacture	328
15.8	Summary	329
	Acknowledgments	330
	References	330
16	Future Trends for Green Chemistry in the Pharmaceutical Industry	333
	<i>Peter J. Dunn, Andrew S. Wells, and Michael T. Williams</i>	
16.1	Introduction	333
16.2	Waste Minimization in Drug Discovery	334
16.3	Greener Synthetic Methods in Primary Manufacturing	338
16.3.1	Synthesis Design and Execution	338
16.3.2	Reduction and Oxidation	339
16.3.3	C–C Bond Formation	340
16.3.4	Heteroatom Alkylation and Acylation	341
16.3.5	Biocatalysis Now and Into the Future	341
16.3.6	Application of Technology	343
16.4	Alternative Solvents in the Pharmaceutical Industry	344
16.4.1	Water	345
16.4.2	Ionic Liquids (ILs)	345
16.4.3	Fluorous Solvents	346
16.4.4	Supercritical CO ₂ (SC-CO ₂) and Gas-Expanded Liquids (GXL)	346
16.4.5	Molecular Solvents from Renewable Sources	347
16.4.6	Solid-Phase Reactions	348
16.4.7	The Work-Up	348
16.4.8	Obstacles to Change	349
16.5	Green Chemistry in Secondary Pharmaceutical Operations	349
16.6	Global Cooperation in Green Chemistry	351
16.6.1	The Pharmaceutical Roundtable	351
16.6.2	Recognition	352
16.6.3	The Global Impact	352
16.7	Conclusions	353
	References	353