## **Contents**

Preface to the First Edition XIII Preface to the Second Edition XVList of Contributors XVII

1	Properties and Use of Microreactors 1
	David Barrow, Shan Taylor, Alex Morgan, and Lily Giles
1.1	Introduction 1
1.1.1	A Brief History of Microreactors 1
1.1.2	Advantages of Microreactors 6
1.2	Physical Characteristics of Microreactors 7
1.2.1	Geometries 7
1.2.2	Constructional Materials and Their Properties 10
1.3	Fluid Flow and Delivery Regimes 16
1.3.1	Fluid Flow 16
1.3.2	Fluid Delivery 20
1.3.3	Mixing Mechanisms 21
1.4	Multifunctional Integration 23
1.5	Uses of Microreactors 23
1.5.1	Overview 23
1.5.1.1	Fast and Exothermic Reactions 24
1.5.2	Precision Particle Manufacture 25
1.5.3	Wider Industrial Context 27
1.5.3.1	Sustainability Agenda 27
1.5.3.2	Point-of-Demand Synthesis 27
	References 28
2	Fabrication of Microreactors Made from Metals and Ceramic 35
	Juergen J. Brandner
2.1	Manufacturing Techniques for Metals 35
2.2	Etching 36
2.3	Machining 38
2.4	Generative Method: Selective Laser Melting 41
2.5	Metal Forming Techniques 42



٧ı	Contents	•
	2.6	Assembling and Bonding of Metal Microstructures 43
	2.7	Ceramic Devices 46
	2.8	Joining and Sealing 48
		References 49
	3	Microreactors Made of Glass and Silicon 53 Thomas Frank
	3.1	How Microreactors Are Constructed 53
	3.1.1	Glass As Material 54
	3.1.2	Silicon As Material 57
	3.2	The Structuring of Glass and Silicon 58
	3.2.1	Structuring by Means of Masked Etching As in
		Microsystems Technology 58
	3.2.2	Etching Technologies 60
	3.2.2.1	Anisotropic (Crystallographic) Wet Chemical Etching of Silicon (KOH) 61
	3.3	Isotropic Wet Chemical Etching of Silicon 63
	3.3.1.1	Isotropic Wet Chemical Etching of Silicon 64
	3.3.1.2	Isotropic Wet Chemical Etching of Silicon Glass 65
	3.3.2	Other Processes 66
	3.3.2.1	Photostructuring of Special Glass 66
	3.3.3	Drilling, Diamond Lapping, Ultrasonic Lapping 68
	3.3.4	Micro Powder Blasting 69
	3.3.5	Summary 71
	3.4	Other Processes 72
	<b>3.4.1</b>	Sensor Integration 72
	3.5	Thin Films 72
	3.6	Bonding Methods 73
	3.6.1	Anodic Bonding of Glass and Silicon 73
	3.6.2	Glass Fusion Bonding 73
	3.6.3	Silicon Direct Bonding (Silicon Fusion Bonding) 74
	3.6.4	Establishing Fluid Contact 76
	3.7	Other Materials 78
		References 79
	4	Automation in Microreactor Systems 81
		Jason S. Moore and Klavs F. Jensen
	4.1	Introduction 81
	4.2	Automation System 84
	4.3	Automated Optimization with HPLC Sampling 86
	4.4	Automated Multi-Trajectory Optimization 89
	4.5	Kinetic Model Discrimination and Parameter Fitting 94
	4.6	Conclusions and Outlook 97
		References 99

5	Homogeneous Reactions 101
	Takahide Fukuyama, Md. Taifur Rahman, and Ilhyong Ryu
5.1	Acid-Promoted Reactions 101
5.2	Base-Promoted Reactions 106
5.3	Radical Reactions 108
5.4	Condensation Reactions 110
5.5	Metal-Catalyzed Reactions 117
5.6	High Temperature Reactions 122
5.7	Oxidation Reactions 124
5.8	Reaction with Organometallic Reagents 125 References 130
6	Homogeneous Reactions II: Photochemistry and Electrochemistry and
	Radiopharmaceutical Synthesis 133
	Paul Watts and Charlotte Wiles
6.1	Photochemistry in Flow Reactors 133
6.2	Electrochemistry in Microreactors 137
6.3	Radiopharmaceutical Synthesis in Microreactors 139
6.3.1	Fluorinations in Microreactors 141
6.3.2	Synthesis of 11C-Labeled PET Radiopharmaceuticals in
0.5.2	Microreactors 145
6.4	Conclusion and Outlook 147
0.1	References 147
7	Heterogeneous Reactions 151
•	Kiyosei Takasu
7.1	Arrangement of Reactors in Flow Synthesis 152
7.2	Immobilization of the Reagent/Catalyst 155
7. <b>2</b> .1	A Packed-Bed Reactor 155
7.2.2	Monolith Reactors 156
7.2.3	Miscellaneous 157
7.2.3	Flow Reactions with an Immobilized Stoichiometric Reagent 159
7.4	Flow Synthesis with Immobilized Catalysts: Solid Acid Catalysts 165
7. <del>4</del> 7.5	Flow Reaction with an Immobilized Catalysts: Transition Metal Catalysts
7.5	Dispersed on Polymer 166
7.5.1	•
7.5.1 7.5.2	Catalytic Hydrogenation 167 Catalytic Cross-Coupling Reactions and Carbonylation Reactions 171
	Miscellaneous 175
7.5.3	
7.6	Flow Reaction with an Immobilized Catalyst: Metal Catalysts
7.61	Coordinated by a Polymer-Supported Ligand 176
7.6.1	Flow Reactions Using Immobilized Ligands with a Transition
77	Metal Catalyst 179
7.7	Organocatalysis in Flow Reactions 183
7.8	Flow Biotransformation Reactions Catalyzed by Immobilized
	Enzymes 186

VIII	Contents	
	7.9	Multistep Synthesis 187
	7.10	Conclusion 191 References 191
	8	Liquid-Liquid Biphasic Reactions 197
	8.1	Matthew J. Hutchings, Batool Ahmed-Omer, and Thomas Wirth Introduction 197
	8.2	Background 198
	8.3	Kinetics of Biphasic Systems 199
	8.4	Biphasic Flow in Microchannels 200
	8.5	Surface and Liquid–Liquid Interaction 202
	8.6	Liquid–Liquid Microsystems in Organic Synthesis 207
	8.7	Micromixer 209
	8.8	Conclusions and Outlook 218
	6.0	References 218
	9	Gas–Liquid Reactions 221 Ivana Dencic and Volker Hessel
	9.1	Introduction 221
	9.2	Contacting Principles and Microreactors 222
	9.2.1	Contacting with Continuous Phases 222
	9.2.1.1	Falling Film Microreactor 222
	9.2.1.2	Continuous Contactor with Partly Overlapping Channels 226
	9.2.1.3	Mesh Microcontactor 227
	9.2.1.4	Annular-Flow Microreactors 229
	9.2.2	Contacting with Disperse Phases 231
	9.2.2.1	Taylor-Flow Microreactors 232

Micromixer-Capillary/Tube Reactors 237

Direct Fluorination of Aliphatics and Non-C-Moieties 249

Oxidations of Alcohols, Diols, and Ketones with Fluorine 253

Direct Fluorination of Heterocyclic Aromatics

Photochlorination of Aromatic Isocyanates 254

Photoradical Chlorination of Cycloalkenes

Reactive Carbon Dioxide Absorption 263

Mono-Chlorination of Acetic Acid 256

Sulfonation of Toluene 257

Photooxidation Reactions 259

Gas-Liquid-Solid Reactions 265

Micro-packed Bed Reactors 240

Membrane Microreactors 242

Tube in Tube Microreactor 243

Direct Fluorination of Aromatics 246
Direct Fluorination of Aromatics 246

Gas-Liquid Reactions 245

Scaling Up of Microreactor Devices

9.2.2.2

9.2.2.3

9.2.2.4

9.2.2.5

9.2.3

9.3.1

9.3.1.1

9.3.1.2 9.3.1.3

9.3.2

9.3.3

9.3.4

9.3.5

9.3.6 9.3.7

9.3.8

9.4

9.3

9.4.1	Hydrogenations 266
9.4.1.1	Cyclohexene Hydrogenation over Pt/Al <sub>2</sub> O <sub>3</sub> 266
9.4.1.2	Hydrogenation of p-Nitrotoluene and Nitrobenzene over
	Pd/C and Pd/Al <sub>2</sub> O <sub>3</sub> 267
9.4.1.3	Hydrogenation of Azide 270
9.4.1.4	Hydrogenation of Pharmaceutical Intermediates 270
9.4.1.5	Selective Hydrogenation of Acetylene Alcohols 271
9.4.1.6	Hydrogenation of α-Methylstyrene over Pd/C 272
9.4.2	Oxidations 273
9.4.2.1	Oxidation of Alcohols 275
9.4.2.2	Oxidation of Sugars 275
9.5	Homogeneously Catalyzed Gas-Liquid Reactions 276
9.5.1	Asymmetric Hydrogenation of Cinnamic Acid Derivatives 276
9.5.2	Asymmetric Hydrogenation of Methylacetamidocynamate 278
9.6	Other Applications 281
9.6.1	Segmented Gas-Liquid Flow for Particle Synthesis 281
9.6.2	Catalyst Screening 281
<b>)</b> .7	Conclusions and Outlook 282
	References 283
10	Bioorganic and Biocatalytic Reactions 289
	Masaya Miyazaki, Maria Portia Briones-Nagata, Takeshi Honda, and
	Hiroshi Yamaguchi
l0.1	General Introduction 289
L <b>0.2</b>	Bioorganic Syntheses Performed in Microreactors 292
l0.2.1	Biomolecular Syntheses in Microreactors: Peptide, Sugar and
	Oligosaccharide, and Oligonucleotide 292
10.2.1.1	Peptide Synthesis 292
10.2.1.2	Sugar and Oligosaccharide Synthesis 296
10.2.1.3	Oligonucleotide Synthesis 302
10.3	Biocatalysis by Enzymatic Microreactors 304
10.3.1	Classification of Enzymatic Microreactors Based on
	Application 304
10.3.1.1	Applications of Microreactors for Enzymatic Diagnostics
	and Genetic Analysis 304
10.3.1.2	Application of Microreactors for Enzyme-Linked
	Immunoassays 308
10.3.1.3	Applications of Microfluidic Enzymatic Microreactors
	in Proteomics 312
L0.3.2	Enzymatic Microreactors for Biocatalysis 347
10.3.3	Advantages of Microreactors in Biocatalysis 347
10.3.4	Biocatalytic Transformations in Microfluidic Systems 348
10.3.4.1	Solution-phase Enzymatic Reactions 348
10.3.4.2	Microfluidic Reactors with Immobilized Enzymes for
	Riocatalytic Transformations 357

Contents	
10.4	Multienzyme Catalysis in Microreactors 362
10.5	Conclusions 365
	References 366
11	Industrial Microreactor Process Development up to Production 373
	Ivana Dencic and Volker Hessel
11.1	Mission Statement from Industry on Impact and Hurdles 373
11.2	Screening Studies in Laboratory 375
11.2.1	Peptide Synthesis 375
11.2.2	Hantzsch Synthesis 378
11.2.3	Knorr Synthesis 379
11.2.4	Enamine Synthesis 381
11.2.5	Aldol Reaction 381
11.2.6	Wittig Reaction 382
11.2.7	Polyethylene Formation 382
11.2.8	Diastereoselective Alkylation 383
11.2.9	Multistep Synthesis of a Radiolabeled Imaging Probe 384
11.3	Process Development at Laboratory Scale 386
11.3.1	Nitration of:Substituted Benzene Derivatives 386
11.3.2	Microflow Azide Syntheses 387
11.3.3	Vitamin Precursor Synthesis 389
11.3.4	Ester Hydrolysis to Produce an Alcohol 391
11.3.5	Synthesis of Methylenecyclopentane 391
11.3.6	Condensation of 2-Trimethylsilylethanol 391
11.3.7	Staudinger Hydration 392
11.3.8	(S)-2-Acetyl Tetrahydrofuran Synthesis 392
11.3.9	Synthesis of Intermediate for Quinolone Antibiotic Drug 393
11.3.10	Domino Cycloadditions in Parallel Fashion 394
11.3.11	Phase-Transfer Catalysis-Mediated Knoevenagel Condensation 396
11.3.12	Ciprofloxazin <sup>®</sup> Multistep Synthesis 396
11.3.13	Methyl Carbamate Synthesis 397
11.3.14	Newman-Kuart Rearrangement 398
11.3.15	Ring-Expansion Reaction of N-Boc-4-Piperidone 399
11.3.16	Synthesis of Aldehydes 400
11.3.17	Grignard Reactions and Li-Organic Reactions 402
11.3.18	Continuous Synthesis of Disubstituted Triazoles 404
11.3.19	Production of 6-Hydroxybuspirone 405
11.3.20	Swern-Moffatt Oxidation 406
11.4	Pilot Plants and Production 408
11.4.1	Hydrogen Peroxide Synthesis 408
11.4.2	Phenylboronic Acid Synthesis 410
11.4.3	Diverse Case Studies at Lonza 411
11.4.4	Alkylation Reactions Based on Butyllithium 414
11.4.5	Microprocess Technology in Japan 416
11.4.6	Pilot Plant for Methyl Methacrylate Manufacture 417

11.4.7	Grignard Exchange Reaction 417
11.4.8	Halogen-Lithium Exchange Pilot Plant 419
11.4.9	Swern–Moffatt Oxidation Pilot Plant 420
11.4.10	Yellow Nano Pigment Plant 422
11.4.11	Polycondensation 423
11.4.12	H <sub>2</sub> O <sub>2</sub> -Based Oxidation to 2-Methyl-1,4-naphthoquinone 424
11.4.13	Friedel-Crafts Alkylation 425
11.4.14	Diverse Studies from Japanese Project Cluster 426
11.4.14.1	Synthesis of Photochromic Diarylethenes 426
11.4.14.2	Cross-Coupling in a Flow Microreactor 427
11.4.15	Direct Fluorination of Ethyl 3-Oxobutanoate 428
11.4.16	Deoxofluorination of a Steroid 429
11.4.17	Microprocess Technology in the United States 430
11.4.18	Propene Oxide Formation 432
11.4.19	Diverse Industrial Pilot-Oriented Involvements 433
11.4.20	Production of Polymer Intermediates 435
11.4.21	Synthesis of Diazo Pigments 436
11.4.22	Selective Nitration for Pharmaceutical Production 438
11.4.23	Nitroglycerine Production 439
11.4.24	Fine Chemical Production Process 440
11.4.25	Grignard-Based Enolate Formation 441
11.5	Challenges and Concerns 442
	References 444

Index 447