

Contents

Preface *XI*

List of Contributors *XIII*

1	Principles of Microprocess Technology	1
	<i>Wladimir Reschetilowski</i>	
1.1	Introduction	1
1.2	History	2
1.3	Basic Characteristics	3
1.3.1	Microfluidics and Micromixing	4
1.3.2	Temperature and Pressure Control	5
1.3.3	Safety and Ecological Impact	7
1.4	Industrial Applications	8
1.5	Concluding Remarks	9
	References	10
2	Effects of Microfluidics on Preparative Chemistry Processes	13
	<i>Madhvanand Kashid, Albert Renken, and Liubov Kiwi-Minsker</i>	
2.1	Introduction	13
2.2	Mixing	15
2.3	Heat Management	18
2.3.1	Heat Transfer in Continuous-Flow Devices	19
2.3.2	Heat Control of Microchannel Reactors	22
2.4	Mass Transfer and Chemical Reactions	26
2.4.1	Fluid–Solid Catalytic Systems	26
2.4.2	Fluid–Fluid Systems	31
2.4.2.1	Flow Regimes	32
2.4.2.2	Mass Transfer	34
2.4.3	Three-Phase Systems	36
2.4.3.1	Gas–Liquid–Solid Systems	36
2.4.3.2	Gas–Liquid–Liquid Systems	40
2.5	Flow Separation	40
2.5.1	Geometrical Modifications	41
2.5.2	Wettability-Based Flow Splitters	42

2.5.3	Conventional Separator Adapted for Microstructured Reactors	44
2.6	Numbering-Up Strategy	45
2.7	Practical Exercise: Experimental Characterization of Mixing in Microstructured Reactors	46
	References	50
3	Modular Micro- and Millireactor Systems for Preparative Chemical Synthesis and Bioprocesses	55
	<i>Frank Schael, Marc-Oliver Piepenbrock, Jörn Emmerich, and Joachim Heck</i>	
3.1	Introduction	55
3.2	Modular Microreaction System	57
3.3	Examples for Microreactor Applications	60
3.3.1	Synthesis of Vitamin A Acetate	60
3.3.2	Screening of Process Parameters for a Suzuki–Miyaura Reaction	62
3.3.3	Scale-Up of Thermal Rearrangement of Furfuryl Alcohol	64
3.3.4	Online Reaction Monitoring and Automation of Chemical Synthesis and Bioprocesses	66
3.4	Laboratory Exercise: Suzuki Reaction in a Modular Microreactor Setup	70
	References	73
4	Potential of Lab-on-a-Chip: Synthesis, Separation, and Analysis of Biomolecules	77
	<i>Martin Bertau</i>	
4.1	Introduction	77
4.2	Learning from Nature: Analogies to Living Cells	77
4.3	Microenzyme Reactors	79
4.3.1	Enzyme Immobilization on the Microchannel Surface	80
4.3.2	Enzyme Immobilization on Supports	81
4.3.3	Modes of Operation	81
4.3.4	Enzymatic Conversions	81
4.3.5	Enzymatic Cleavage of Peptides	84
4.3.6	Determination of Inhibitor Properties	84
4.3.7	Cytotoxicity Assessment	87
4.4	Microchip Electrophoresis	87
4.4.1	Peptide Analysis	88
4.4.2	Chiral Separation	88
4.4.3	Coupling Biocatalysis and Analysis	88
4.4.4	Determination of Amino Acids in Goods and Foods	89
4.5	Microenzyme Membrane Reactor/Micromembrane Chromatography	89
4.6	Nucleic Acid Analysis in Microchannels	91
4.7	Saccharide Analyses in Microdevices	94
4.8	Practical Exercise: Lipase-Catalyzed Esterification Reaction	96
	References	97

5	Bioprocessing in Microreactors	101
	<i>Fridolin Okkels and Dorota Kwasny</i>	
5.1	Introduction	101
5.2	Background	101
5.2.1	Basic Elements of a Biosensor	101
5.2.2	Different Sensing Methods	103
5.2.3	The Effect of Reducing Dimensionality and Length Scales of Biosensors	103
5.2.4	Biosensors Based on Field-Effect Transistors	104
5.2.4.1	The Main Working Principle of FET Sensors	105
5.2.4.2	Fabrication of SiNW FET Sensors	106
5.2.4.3	Functionalization of SiNW FET Sensors Using APTES	107
5.2.5	Shielding by the Buffer: Combined Influence from Ions and Charge Carriers	107
5.3	Practical Exercise: Functionalization of Silicon Surface	108
	References	113
 6	 Synthesis of Fine Chemicals	 115
	<i>Sandra Hübner, Norbert Steinfeldt, and Klaus Jähnisch</i>	
6.1	Introduction	115
6.2	Organic Synthesis in Liquid and Liquid–Liquid Phases	116
6.2.1	Fluorination Reactions	116
6.2.2	Reactions with Diazomethane	127
6.2.3	Ultrasound-Assisted Liquid–Liquid Biphasic and Liquid Reactions	134
6.3	Gas–Liquid Biphasic Organic Synthesis	141
6.3.1	Ozonolysis Reactions	141
6.3.2	Photooxygenation Reactions	151
6.4	Practical Exercise: Photochemical Generation of Singlet Oxygen and Its [4 + 2] Cycloaddition to Cyclopentadiene	159
	References	161
 7	 Synthesis of Nanomaterials Using Continuous-Flow Microreactors	 165
	<i>Chih-Hung Chang</i>	
7.1	Introduction	165
7.2	Microfluidic Devices	165
7.3	Synthesis of Nanomaterials Using Microreactors	166
7.4	Kinetic Studies	180
7.5	Process Optimization	183
7.6	Point-of-Use Synthesis and Deposition	185
7.6.1	Deposition of Nanomaterials	185
7.7	Practical Exercises: Synthesis of Nanocrystals	187
7.7.1	Synthesis of ZnO Nanocrystals	187
7.7.2	Synthesis of CdS Nanoparticles	190
	References	192

8	Polymerization in Microfluidic Reactors	197
	<i>Jesse Greener and Eugenia Kumacheva</i>	
8.1	Introduction	197
8.2	Practical Considerations	198
8.2.1	Control Over Reaction Conditions	198
8.2.1.1	Batch Reactors	198
8.2.1.2	Microreactors	199
8.2.2	Control of Mixing	199
8.2.3	Control of Reagent Concentrations	200
8.2.4	Distance-to-Time Transformation	200
8.2.5	Potential Negative Impacts of Polymerization Reactions on Reactor Operation	201
8.2.5.1	Buildup in Solution Viscosity	201
8.2.5.2	Precipitation	202
8.2.5.3	Adsorption	202
8.2.6	Selection of Materials for Fabrication of MF Reactors	203
8.2.6.1	Polymer Materials	203
8.2.6.2	Metals	205
8.2.6.3	Glass	205
8.3	Single-Phase Polymerization	205
8.4	Multiphase Polymerization	208
8.4.1	Formation of Polymer Particles	209
8.4.1.1	Formation of Precursor Droplets	209
8.4.1.2	Transformation of Precursor Droplets into Polymer Particles	213
8.4.2	Review of Demonstrated Applications	214
8.4.2.1	Controlled Encapsulation	214
8.4.2.2	Encapsulation and Delivery	215
8.4.2.3	Cell Encapsulation	217
8.4.2.4	Microgels as Model Cells	219
8.5	Beyond Synthesis: New Developments for Next-Generation MF Polymerization	220
8.5.1	Scaled-Up MF Synthesis of Polymer Particles	220
8.5.2	<i>In Situ</i> Characterization of Polymerization in MF Reactors	223
8.5.3	Automated Systems for Polymerization Microreactors	223
8.6	Practical Exercise: MF Polymerization Reactor Kinetics Studies Using <i>In Situ</i> Characterization	224
	References	227
9	Electrochemical Reactions in Microreactors	231
	<i>Jun-ichi Yoshida and Aiichiro Nagaki</i>	
9.1	Introduction	231
9.2	Electrode Configuration	232
9.2.1	Serial Electrode Configuration	232
9.2.2	Interdigitated Electrode Configuration	233

9.2.3	Parallel Electrode Configuration	233
9.3	Electrolysis without Supporting Electrolytes	234
9.4	Generation and Reactions with Unstable Intermediates	235
9.5	Practical Exercise: Electrochemical Reactions in Flow Microreactors	239
	References	241
10	Heterogeneous Catalysis in Microreactors	243
	<i>Evgeny V. Rebrov</i>	
10.1	Introduction	243
10.2	Bulk Catalysts	244
10.3	Supported Catalysts	246
10.3.1	Macroporous Supports	247
10.3.1.1	ZnO Support	247
10.3.1.2	γ -Al ₂ O ₃ Support	247
10.3.1.3	Catalysts Immobilized onto Polymeric Particles	249
10.3.1.4	Silica-Supported Catalysts	251
10.3.1.5	Carbon-Supported Catalysts	253
10.4	Mesoporous Supports	256
10.4.1	Mesoporous Titania	258
10.4.2	Mesoporous Silica	260
10.4.3	Mesoporous Alumina	261
10.5	Microporous Supports	261
10.6	Practical Exercise: PdZn/TiO ₂ -Catalyzed Selective Hydrogenation of Acetylene Alcohols in a Capillary Microreactor	263
	References	265
11	Chemical Intensification in Flow Chemistry through Harsh Reaction Conditions and New Reaction Design	273
	<i>Timothy Noël and Volker Hessel</i>	
11.1	Introduction	273
11.2	High-Temperature Processing in Microflow	273
11.3	High-Pressure Processing in Microflow	278
11.4	Solvent Effects in Microflow	280
11.5	Ex-Regime Processing and Handling of Hazardous Compounds in Microflow	283
11.6	New Chemical Transformations in Microflow	284
11.7	Process Integration in Microflow	286
11.8	Practical Exercises	288
11.8.1	Claisen Rearrangement at Elevated Temperatures	288
11.8.2	Copper(I)-Catalyzed Azide-Alkyne Cycloaddition with Integrated Copper Scavenging Unit	290
	References	292

12	Modeling in Microreactors	297
	<i>Ekaterina S. Borovinskaya</i>	
12.1	Introduction	297
12.2	Processes in Microreactors and the Role of Mixing	298
12.3	Modeling of Processes in Microreactors Based on General Balance Equation	300
12.3.1	Plug Flow Tube Reactor Model	300
12.3.2	Laminar Flow Model	302
12.4	Computation of Reaction Flows in Microreactors	308
12.4.1	Computational Fluid Dynamics	308
12.4.2	Single-Phase Modeling	309
12.4.3	Two-Phase Modeling	310
12.4.3.1	Liquid–Liquid Flow with Chemical Reaction	310
12.4.3.2	Liquid–Gas Flow with Chemical Reaction	312
12.4.4	Three-Phase Modeling	315
12.5	Practical Exercise: Alkylation of Phenylacetonitrile	320
	References	323
	Index	327