

Contents

Preface — v

About the editors — xiii

Contributing authors — xv

Abbreviations — xvii

Part I Catalysis and activation

Clemens Brechtelsbauer and King Kuok (Mimi) Hii

1 Catalysis in flow — 3

1.1 Introduction — 3

1.1.1 Flow versus batch chemistry — 3

1.1.2 Development of catalytic reactions and flow for organic synthesis — 3

1.2 Reactor types, catalytic reactions and productivity — 5

1.2.1 Solid-liquid reactors — 6

1.2.2 Solid-liquid-gas systems — 18

1.3 Conclusion — 25

Claude de Bellefon

2 Catalytic engineering aspects of flow chemistry — 31

2.1 Introduction — 31

2.2 Basis of (catalytic) reactor engineering — 33

2.2.1 Flow motion in reactors — 33

2.2.2 Relevant physics — 36

2.2.3 Characteristic times — 36

2.2.4 Characteristic lengths — 38

2.2.5 Surface area — 40

2.2.6 Mixing — 41

2.2.7 Heat issues — 42

2.3 Describing the chemistry — 43

2.3.1 Kinetic rate laws — 43

2.3.2 Rate measurement and reaction time — 45

2.3.3 Catalyst deactivation — 47

2.4 Methodology for Flow reactor dimensioning — 51

2.4.1 Batch versus Flow reactor comparison — 51

2.4.2 Checking for mass and heat transfer limitations — 54

2.4.3 Basis for reactor scale-up — 59

2.5 Conclusion — 61

Thomas H. Rehm

3	Continuous-flow photochemistry in microstructured environment — 63
3.1	Environmental impact in view of <i>Green Chemistry</i> — 63
3.2	Physical considerations – reasons why microstructured equipment is preferred for flow photochemistry — 64
3.2.1	Absorption of light by molecules in solution — 64
3.2.2	Role of solvent — 66
3.2.3	Micrometer-sized structures as key elements of reactor equipment for flow photochemistry — 66
3.3	Technological considerations for flow photochemistry — 68
3.3.1	Light sources — 68
3.3.2	Reactor concepts for flow photochemistry — 73
3.4	Chemical considerations for flow photochemistry — 78
3.4.1	Photochemical reactions without catalyst material — 78
3.4.2	Heterogeneous flow photocatalysis — 80
3.4.3	Flow photocatalysis with organic dyes or noble metal complexes — 84
3.5	Summary and outlook — 91

Julian Schuelein and Holger Loewe

4	Electrochemistry in flow — 99
4.1	Introduction — 99
4.2	Electrochemistry in flow — 100
4.3	Microreactor design — 103
4.3.1	Thin gap cells — 104
4.3.2	ELMI – microstructured high pressure single pass thin gap flow cell — 111
4.3.3	Segmented thin gap flow cells — 114
4.4	Electrochemistry in microreactors — 116
4.4.1	Direct product synthesis — 116
4.4.2	Electrolyte free synthesis — 117
4.4.3	Activation of chemicals — 119
4.5	Ionic liquids in electrochemistry — 122

Part II Cutting-edge applications in advanced and functional materials

L. Zane Miller, Jeremy L. Steinbacher, and D. Tyler McQuade

5	Synthesis of materials in flow – principles and practice — 133
5.1	Introduction — 133
5.2	Unique properties of microreactors — 133
5.2.1	Mixing — 133
5.2.2	Thermal and pressure control — 134
5.2.3	Fluid behavior — 134

5.3	Synthesis of materials in flow —	140
5.3.1	Linear polymers —	140
5.3.2	Beads, disks, and other solid polymeric materials —	144
5.3.3	Janus materials —	149
5.3.4	Capsules —	150
5.3.5	Membranes and fibers —	152
5.3.6	Nanoparticles and inorganic nonpolymeric materials —	154
5.4	Conclusions —	156

Genoveva Filipcsei, Zsolt Otvos, Reka Angi, and Ferenc Darvas

6	Flow chemistry for nanotechnology —	161
6.1	Introduction to nanotechnology and graphene technology —	161
6.1.1	Introduction —	161
6.1.2	Definition and concepts —	161
6.1.3	Brief history of nanotechnology —	162
6.1.4	Why nanotechnology? —	163
6.1.5	Batch and flow-chemistry based nanonization technologies —	164
6.1.6	Overview and principles of microfluidic reactors —	165
6.2	Nanomaterials —	166
6.2.1	Structure and properties: is the smaller better? —	166
6.2.2	Organic nanoparticles: biologically active small molecules —	169
6.2.3	Inorganic nanoparticles: metallic, bimetallic and semiconductor particles —	171
6.2.4	Hybrid nanoparticles —	172
6.3	Theoretical background of nanoparticle synthesis using flow-chemistry based approaches —	173
6.3.1	Principles of nanoparticle stabilization —	173
6.3.2	Classical nucleation theory —	174
6.4	Application of flow technology in nanoparticle synthesis —	176
6.4.1	Synthesis of metal nanoparticles —	176
6.4.2	Synthesis of semiconductor nanoparticles —	177
6.4.3	Synthesis of biologically active organic nanoparticles —	178
6.5	Impact of nanotechnology: an outlook —	182

Samar Haroun, Paul C. H. Li

7	Continuous-flow synthesis of carbon-11 radiotracers on a microfluidic chip —	189
7.1	Introduction to continuous-flow microreactors and carbon-11 radiolabeling —	189
7.2	Microfluidic synthesis of raclopride —	192
7.2.1	Microfluidic nonradioactive synthesis of raclopride —	194
7.2.2	Microchip radioactive synthesis of [^{11}C]raclopride —	196

7.3	Computational fluid dynamics (CFD) — 200
7.3.1	Reaction engineering lab@REL module – “ideal” flow-reactor model — 201
7.3.2	Microelectromechanical system (MEMS) module – “geometry-dependent” flow study — 203
7.4	Conclusion — 207

Part III Additional features of the Flow Process: In-line analytics, safety and green principles

Ferenc Darvas, György Dormán, and Melinda Fekete

8	Lab environment: In-line separation, analytics, automation & self optimization — 213
8.1	The role of analytics in flow applications — 213
8.1.1	Applications of mass spectroscopy — 214
8.1.2	ReactIR flow cell — 218
8.1.3	Nuclear magnetic resonance (NMR) — 224
8.2	Automation and self optimization — 228
8.2.1	General description of the self-optimization methods — 228
8.2.2	Automation and feedback control systems — 230
8.2.3	Nelder–Mead Simplex method — 234
8.2.4	Multidimensional optimization — 235
8.2.5	Optimization and scale-up — 236
8.2.6	Flow reactors with built-in optimization — 238
8.3	In-line separation — 239
8.3.1	Liquid-liquid separators — 239
8.3.2	Scavenger and chromatography columns — 241
8.3.3	Simulated moving Bed Chromatography — 243

Jean-Christophe Monbaliu, Ana Cukalovic, and Christian V. Stevens

9	Safety aspects related to microreactor technology — 253
9.1	Introduction — 253
9.1.1	Chemical processes — 253
9.1.2	Safety in chemical processes — 254
9.2	Inherently safer processes using microreaction technology — 254
9.2.1	Advantages of microreaction technology to safety — 254
9.2.2	Recent examples of processes involving dangerous reagents/reactions under MRT conditions — 258
9.2.3	MRT processes involving harsh conditions (elevated temperatures and pressures) — 274
9.3	Conclusions — 275

Volker Hessel, Qi Wang, and Dana Kralisch

10	From green chemistry principles in flow chemistry towards green flow process design in the holistic viewpoint — 283
10.1	Introduction of Green Chemistry principles — 283
10.1.1	Green principles — 283
10.1.2	Green flow chemistry — 285
10.2	Flow process design and relation to green chemistry/engineering — 285
10.2.1	Flow processing – major means in process intensification — 285
10.2.2	Transport intensification – the flow-scale — 286
10.2.3	Chemical intensification – the reactor scale — 286
10.2.4	Process-design intensification – the full-process scale — 287
10.2.5	Elemental green criteria with proven impact of flow process design — 287
10.2.6	Elemental green criteria with suspected impact of flow process design — 288
10.2.7	Elemental green criteria with uncertainty over impact of flow process design — 288
10.3	Holistic methodology introduction for systematic green flow process design — 289
10.4	Green flow process design for fine chemicals/pharmaceuticals — 293
10.4.1	Technology comparison for green pharmaceutical process design — 293
10.4.2	Flow process design of a green biphasic fine chemical synthesis — 295
10.4.3	Exergetic LCA for improvement of an existing pharmaceutical production process — 297
10.5	Green flow process design for bulk chemicals and benchmark to conventional process — 298
10.5.1	Process simulation — 299
10.5.2	LCA for continuous flow synthesis of ADA — 302
10.5.3	LCA for two-step conventional synthesis of ADA — 303
10.5.4	Complete LCA picture — 303
10.5.5	Enlightenment — 305
10.6	Outlook for green flow process design — 306

Answers to the study questions — 313

Index — 327