

Contents

List of Contributors *XI*

Preface *XIII*

1	Green Chemistry Metrics	1
	<i>David J.C. Constable</i>	
1.1	Introduction and General Considerations	1
1.2	Feedstocks	5
1.3	Chemicals	6
1.3.1	Hazard and Risk	6
1.4	General Chemistry Considerations and Chemistry Metrics	10
1.5	Evolution of Green Chemistry Metrics	11
1.6	Andraos: Tree Analysis	14
1.7	Process Metrics	15
1.8	Product Metrics	16
1.9	Sustainability and Green Chemistry	17
1.10	Making Decisions	18
	References	19
2	Expanding Rational Molecular Design beyond Pharma: Metrics to Guide Safer Chemical Design	29
	<i>Nicholas D. Anastas, John Leazer, Michael A. Gonzalez, and Stephen C. DeVito</i>	
2.1	Introduction to Safer Chemical Design	29
2.2	Life Cycle Thinking	30
2.2.1	Sustainability, Green Chemistry, and Green Engineering	30
2.2.2	Life Cycle Considerations	31
2.2.3	Life Cycle Assessment	32
2.2.4	Chemical Process Sustainability Evaluation – Metrics	34
2.3	Attributes of Chemicals of Good Character	36
2.4	Tools for Characterizing the Attributes of Chemicals of Good Character	37
2.4.1	Strive to Reduce or Eliminate the Use of Chemicals	40
2.4.2	Maximize Biological and Use Potency and Efficacy	40

2.4.3	Strive for Economic Efficiency	40
2.4.4	Limited Bioavailability	41
2.4.5	Limited Environmental Mobility	41
2.4.6	Design for Selective Reactivity: Toxicity	41
2.4.7	Minimize the Incorporation of Known Hazardous Functional Groups: Toxicophores and Isosteres	42
2.4.8	Minimize the Use of Toxic Solvents	42
2.4.9	Limited Persistence and Bioaccumulation	43
2.4.10	Quick Transformation to Innocuous Products	44
2.4.11	Avoid Extremes of pH	44
2.5	A Decision Framework	44
2.5.1	A Suggested Protocol for Approaching Safer Chemical Design	45
2.5.2	Alternatives and Chemical Risk Assessment	45
2.6	The Road Ahead: Training of a Twenty-First Century Chemist	46
	References	46

3 Key Metrics to Inform Chemical Synthesis Route Design 49

John Andraos and Andrei Hent

3.1	Introduction	49
3.2	Material Efficiency Analysis for Synthesis Plans	50
3.3	Case Study I: Bortezomib	56
3.3.1	Millennium Pharmaceuticals' Process	59
3.3.2	Pharma-Sintez Process	62
3.3.3	Material Efficiency – Local and Express	64
3.3.4	Synthesis Strategy for Future Optimization	72
3.3.5	Summary	73
3.4	Case Study II: Aspirin	74
3.4.1	Reaction Network	74
3.4.2	Material Efficiency	76
3.4.3	Environmental and Safety–Hazard Impact	78
3.4.4	Input Energy	84
3.4.5	Case I	84
3.4.6	Case II	85
3.4.7	Case III	85
3.4.8	Case IV	85
3.4.9	Case V	86
3.4.10	Case VI	86
3.4.11	Concluding Remarks and Outlook for Improvements	88
	References	91

4 Life Cycle Assessment 95

Concepción Jiménez-González

4.1	Introduction	95
4.2	The Evolution of Life Cycle Assessment	96
4.3	LCA Methodology at a Glance	97

4.3.1	Goal and Scope	98
4.3.2	Inventory Analysis	98
4.3.3	Impact Assessment	99
4.3.4	Interpretation	99
4.3.5	LCI/A Limitations	100
4.3.6	Critical Review	101
4.3.7	Streamlined Life Cycle Assessment	102
4.4	Measuring Greenness with LCI/A – Applications	103
4.4.1	Probing Case Studies	103
4.4.2	Chemical Route Comparison	106
4.4.3	Material Assessment	109
4.4.4	Product LCAs	112
4.4.5	Footprinting	115
4.5	Final Remarks	117
	References	118
5	Sustainable Design of Batch Processes	125
	<i>Tânia Pinto-Varela and Ana Isabel Carvalho</i>	
5.1	Introduction	125
5.2	State of the Art	126
5.2.1	Design and Retrofit of Batch Processes	127
5.2.2	Sustainability Assessment	131
5.3	Framework for Design and Retrofitting in Batch Processes	136
5.3.1	Economic Assessment	138
5.3.2	Environmental Assessment	139
5.3.3	Social Assessment	140
5.3.4	Methodologies	141
5.4	Case Studies	142
5.4.1	Retrofit Sustainable Batch Design	142
5.4.2	Design of Batch Process	147
5.5	Conclusions	150
	References	152
6	Green Chemistry Metrics and Life Cycle Assessment for Microflow Continuous Processing	157
	<i>Lihua Zhang, Qi Wang, and Volker Hessel</i>	
6.1	Introduction	157
6.1.1	Green Chemistry and Green Engineering in the Pharmaceutical Industry	157
6.1.2	Green Metrics and Life Cycle Assessment	158
6.1.3	Continuous Processing at Small Scale	159
6.2	Environmental Analysis through Green Chemistry Metrics and Life Cycle Assessment	162
6.2.1	Green Chemistry Metrics	162
6.2.2	Life Cycle Assessment (LCA)	163

6.3	Application of Green Chemistry Metrics and Life Cycle Assessment to Assess Microflow Processing	163
6.3.1	Use as Benchmarking Tool for Continuous versus Batch; at Lab and Production Scale	164
6.3.2	Use as Decision Support Tool for Single Innovation Drivers – Choice of Type of Microreactor and Type of a Catalyst (Including Use/Not Use)	167
6.3.2.1	Reaction Conditions of Batch Process and Continuous Microflow Process	167
6.3.2.2	SLCA Results	168
6.3.2.3	Economic Evaluation	170
6.3.2.4	Conclusions	171
6.3.3	Use as Decision Support Tool for Single Innovation Drivers – Solvent Choice and Role of Recycling	171
6.3.4	Use as Decision Support Tool for Bundled Innovation Drivers Such as Multifaceted Process Optimization versus Process Intensification	174
6.3.4.1	API Production Process at Sanofi	174
6.3.4.2	Process Alternatives for Optimization and Intensification	174
6.3.4.3	Ecological Profile Comparison of Crude Batch and Continuous Operation	175
6.3.4.4	Cost Analysis of Batch and Continuous Operation	178
6.3.4.5	Conclusions	179
6.3.5	Cascading Reactions Into a Microreactor Flow Network – Greenness of Multistep Reaction/Separation Integration	179
6.3.5.1	LCA Study for Single-Step Analyses in Batch and Flow	181
6.3.5.2	LCA Study for “Two-Reactor Network” Process Designs	184
6.3.5.3	LCA Study for “Three-Reaction Network” Process Designs	184
6.3.6	Use as Process-Design Guidance and Benchmarking Tool Against Conventional Processes	186
6.3.6.1	Process Simulation and CAPEX Cost Study	188
6.3.6.2	LCA for Continuous Flow Synthesis of ADA	190
6.3.6.3	LCA for Two-Step Conventional Synthesis of ADA	191
6.3.6.4	Complete LCA Picture	191
6.3.6.5	Green Metrics Compared for the Direct Microflow Route and Conventional Two-Step Route	192
6.3.6.6	Conclusions	194
6.4	Economic Analysis and Snapshot on Applications with Continuous Microflow Processing	195
6.4.1	Life Cycle Costing (LCC)	195
6.4.2	Snapshot on LCC Applications with Continuous Microflow Processing	196
6.5	Conclusions and Outlook	199
	References	201

7	Benchmarking the Sustainability of Biocatalytic Processes	207
	<i>John M. Woodley</i>	
7.1	Introduction	207
7.2	Biocatalytic Processes	207
7.3	Biocatalytic Process Design and Development	210
7.4	Sustainability of Biocatalytic Processes	210
7.5	Quantitative Measuring of the Sustainability of Biocatalytic Processes	212
7.6	Early Stage Sustainability Assessment	213
7.6.1	Evaluation of Route Feasibility	214
7.6.1.1	Atom Economy	214
7.6.1.2	Carbon Mass Efficiency	214
7.6.2	Evaluation of Biocatalyst and Reaction Development	215
7.6.2.1	Process Mass Intensity	215
7.6.2.2	Solvent Intensity	215
7.6.2.3	Water Intensity	216
7.6.2.4	E-factor	216
7.7	Benchmarking	216
7.7.1	Route Selection	216
7.7.2	Biocatalyst and Reaction Development	217
7.8	Examples	217
7.8.1	Biocatalytic Route to Atorvastatin	218
7.8.2	Biocatalytic Route to Sitagliptin	219
7.9	Future Perspectives	221
7.9.1	Process Development	221
7.9.2	Methodology	223
7.10	Concluding Remarks	224
	References	225
 8	 How Chemical Hazard Assessment in Consumer Products Drives Green Chemistry	 231
	<i>Lauren Heine and Margaret H. Whittaker</i>	
8.1	Introduction	231
8.2	What Drives Consumer Product Companies to Look for Less Hazardous Chemical Ingredients	232
8.2.1	Chemical Substitution and Regrettable Substitution	233
8.2.2	Nonprofit Organization (NPO) Campaigns	235
8.2.3	Retailer Initiatives	237
8.2.4	State Initiatives	240
8.2.5	Consumer Product Sector Leaders: Setting the Example for Others	242
8.3	What is Chemical Hazard Assessment?	243
8.3.1	Globally Harmonized System of Classification and Labelling of Chemicals (GHS)	244
8.3.2	Comprehensive and Abbreviated Forms of CHA	247

8.3.2.1	GreenScreen for Safer Chemicals	248
8.3.2.2	Quick Chemical Assessment Tool (QCAT)	252
8.3.2.3	GreenScreen List Translator (GS LT)	253
8.4	How Chemical Hazard Assessment is Used	255
8.4.1	Chemical Footprint Project	255
8.4.2	Health Product Declaration Version 2.0 (HPD)	259
8.4.3	Red List – Declare Label	259
8.4.4	United States Environmental Protection Agency: Safer Choice Program	260
8.4.5	International Living Future Institute’s Living Product Challenges	262
8.4.6	Cradle to Cradle Certified Product Program	262
8.4.7	Chemical Alternatives Assessment	263
8.5	Case Studies Showing How CHA Leads to Safer Consumer Products	264
8.5.1	Case Study 1. US EPA Safer Choice Product Certification	264
8.5.2	Case Study 2. Levi Strauss & Co. Screened Chemistry	267
8.5.3	Case Study 3. Development of an Alternative Food Can Liner	269
8.6	Challenges: Beyond Chemical Hazard Assessment	271
8.6.1	Transparency	271
8.6.2	Filling Data Gaps for Existing and Emerging Hazards: Predictive Toxicology and Tox21	272
8.6.3	Integrating CHA into Green Product Design	272
8.7	Conclusion	274
	References	275
9	Tying it all together to drive Sustainability in the Chemistry Enterprise	281
	<i>David J.C. Constable and Concepción Jiménez-González</i>	
9.1	New Areas of Sustainable and Green Chemistry Metrics Research	286
	References	290
	Index	291