

Contents

Preface XIII

1	Introduction	1
1.1	Green Chemistry and Sustainable Development	1
1.1.1	What is “Green Chemistry”?	2
1.1.2	Quantifying Environmental Impact: Efficiency, <i>E</i> -factors, and Atom Economy	4
1.1.3	Just How “Green” is this Process?	6
1.1.4	Product and Process Life-Cycle Assessment (LCA)	9
1.2	What is Catalysis and Why is it Important?	10
1.2.1	Homogeneous Catalysis, Heterogeneous Catalysis, and Biocatalysis	12
1.2.2	Replacing Stoichiometric Reactions with Catalytic Cycles	19
1.2.3	Industrial Example: The BHC Ibuprofen Process	22
1.3	Tools in Catalysis Research	23
1.3.1	Catalyst Synthesis and Testing Tools	24
1.3.2	Catalyst Characterization Tools	26
1.3.3	Tools for Modeling/Mechanistic Studies	28
1.4	Further Reading	29
1.5	Exercises	31
	References	35
2	The Basics of Catalysis	39
2.1	Catalysis is a Kinetic Phenomenon	39
2.1.1	Reaction Rates, Reaction Orders, Rate Equations, and Rate-Determining Steps	40
2.1.1.1	The Reaction Order	42
2.1.1.2	The Rate-Determining Step	43
2.1.2	The Reaction Profile and the Reaction Coordinate	44
2.1.3	Zero-Order, First-Order, and Second-Order Kinetics	46

2.1.3.1	Zero-Order Rate Equations	46
2.1.3.2	First-Order Rate Equations	47
2.1.3.3	Second-Order Rate Equations	48
2.1.4	Langmuir–Hinshelwood Kinetics	49
2.1.5	The Steady-State Approximation	52
2.1.6	Michaelis–Menten Kinetics	54
2.1.7	Consecutive and Parallel First-Order Reactions	56
2.1.8	Pre-Equilibrium, “Catalyst Reservoirs,” and Catalyst Precursors	58
2.2	Practical Approaches in Kinetic Studies	60
2.2.1	Initial Reaction Rates and Concentration Effects	61
2.2.1.1	Concentration Effects	62
2.2.2	Creating Pseudo Order Conditions	62
2.2.3	What You See versus What You Get	63
2.2.4	Learning from Stoichiometric Experiments	64
2.3	An Overview of Some Basic Concepts in Catalysis	64
2.3.1	Catalyst/Substrate Interactions and Sabatier’s Principle	65
2.3.2	Catalyst Deactivation, Sintering, and Thermal Degradation	66
2.3.2.1	Catalyst Deactivation	66
2.3.2.2	Catalyst Sintering and Thermal Degradation	66
2.3.3	Catalyst Inhibition	68
2.3.3.1	Catalyst Poisoning	69
2.4	Exercises	69
	References	73
3	Homogeneous Catalysis	77
3.1	Metal Complex Catalysis in the Liquid Phase	77
3.1.1	Elementary Steps in Homogeneous Catalysis	78
3.1.1.1	Ligand Exchange: Dissociation and Coordination	79
3.1.1.2	Oxidative Addition	81
3.1.1.3	Reductive Elimination	83
3.1.1.4	Insertion and Migration	84
3.1.1.5	De-insertion and β -Elimination	85
3.1.1.6	Nucleophilic Attack on a Coordinated Substrate	85
3.1.1.7	Other Reaction Types	86
3.1.2	Structure/Activity Relationships in Homogeneous Catalysis	88
3.1.2.1	Steric Effects: Ligand Size, Flexibility, and Symmetry	88
3.1.2.2	Electronic Effects of Ligands, Substrates, and Solvents	92
3.1.3	Asymmetric Homogeneous Catalysis	93
3.1.4	Industrial Examples	96
3.1.4.1	The Shell Higher Olefins Process (SHOP)	97
3.1.4.2	The Wacker Oxidation Process	99
3.1.4.3	The Du Pont Synthesis of Adiponitrile	100
3.1.4.4	The Ciba–Geigy Metolachlor Process	102
3.2	Homogeneous Catalysis without Metals	104

3.2.1	Classic Acid/Base Catalysis	104
3.2.2	Organocatalysis	105
3.3	Scaling up Homogeneous Reactions: Pros and Cons	108
3.3.1	Catalyst Recovery and Recycling	108
3.3.2	Hybrid Catalysts: Bridging the Homogeneous/Heterogeneous Gap	110
3.4	“Click Chemistry” and Homogeneous Catalysis	111
3.5	Exercises	113
	References	117
4	Heterogeneous Catalysis	127
4.1	Classic Gas/Solid Systems	129
4.1.1	The Concept of the Active Site	131
4.1.2	Model Catalyst Systems	132
4.1.3	Real Catalysts: Promoters, Modifiers, and Poisons	134
4.1.4	Preparation of Solid Catalysts: Black Magic Revealed	135
4.1.4.1	High-Temperature Fusion and Alloy Leaching	137
4.1.4.2	Slurry Precipitation and Co-precipitation	138
4.1.4.3	Impregnation of Porous Supports	139
4.1.4.4	Hydrothermal Synthesis	139
4.1.4.5	Drying, Calcination, Activation, and Forming	141
4.1.5	Selecting the Right Support	143
4.1.6	Catalyst Characterization	146
4.1.6.1	Traditional Surface Characterization Methods	146
4.1.6.2	Temperature-Programmed Techniques	149
4.1.6.3	Spectroscopy and Microscopy	149
4.1.7	The Catalytic Converter: an Example from Everyday Life	154
4.1.8	Surface Organometallic Chemistry	156
4.2	Liquid/Solid and Liquid/Liquid Catalytic Systems	158
4.2.1	Aqueous Biphasic Catalysis	159
4.2.2	Fluorous Biphasic Catalysis	161
4.2.3	Biphasic Catalysis Using Ionic Liquids	163
4.2.4	Phase-Transfer Catalysis	164
4.3	Advanced Process Solutions Using Heterogeneous Catalysis	165
4.3.1	The BP AVADA Ethyl Acetate Process	166
4.3.2	The ABB Lummus/Albemarle AlkyClean Process	168
4.3.3	The IFP and Yellowdiesel Processes for Biodiesel Production	168
4.3.4	The ABB Lummus/UOP SMART Process	172
4.4	Exercises	173
	References	177
5	Biocatalysis	189
5.1	The Basics of Enzymatic Catalysis	190
5.1.1	Terms and Definitions – The Bio Dialect	191
5.1.2	Active Sites and Substrate Binding Models	194

5.1.3	Intramolecular Reactions and Proximity Effects	195
5.1.4	Common Mechanisms in Enzymatic Catalysis	197
5.2	Applications of Enzyme Catalysis	199
5.2.1	Whole-Cell Systems versus Isolated Enzymes	200
5.2.2	Immobilized Enzymes: Bona Fide Heterogeneous Catalysis	202
5.2.2.1	Binding Enzymes to Solid Supports	202
5.2.2.2	Trapping Enzymes in Polymers or Sol/Gel Matrices	203
5.2.2.3	Cross-Linking of Enzymes	204
5.2.3	Replacing “Conventional Routes” with Biocatalysis	205
5.2.4	Combining “Bio” and “Conventional” Catalysis	207
5.3	Developing New Biocatalysts: Better than Nature’s Best	210
5.3.1	Prospecting Natural Diversity	210
5.3.2	Rational Design	211
5.3.3	Directed Evolution	211
5.4	Nonenzymatic Biocatalysts	213
5.4.1	Catalytic Antibodies (Abzymes)	213
5.4.2	Catalytic RNA (Ribozymes)	214
5.5	Industrial Examples	215
5.5.1	High-Fructose Corn Syrup: 11 Million Tons per Year	215
5.5.2	The Mitsubishi Rayon Acrylamide Process	217
5.5.3	The BMS Paclitaxel Process	218
5.5.4	The Tosoh/DSM Aspartame Process	220
5.6	Exercises	221
	References	224
6	Computer Applications in Catalysis Research	231
6.1	Computers as Research Tools in Catalysis	231
6.2	Modeling of Catalysts and Catalytic Cycles	233
6.2.1	A Short Overview of Modeling Methods	233
6.2.2	Simplified Model Systems versus Real Reactions	236
6.2.3	Modeling Large Catalyst Systems Using Classical Mechanics	236
6.2.4	In-Depth Reaction Modeling Using Quantum Mechanics	238
6.3	Predictive Modeling and Rational Catalyst Design	240
6.3.1	Catalysts, Descriptors, and Figures of Merit	241
6.3.2	Three-Dimensional (3D) Descriptors	242
6.3.2.1	Comparative Molecular Field Analysis (CoMFA)	243
6.3.2.2	The Ligand Repulsive Energy Method	244
6.3.3	Two-Dimensional (2D) Descriptors	245
6.3.4	Generating Virtual Catalyst Libraries in Space A	248
6.3.5	Understanding Catalyst Diversity	250
6.3.6	Virtual Catalyst Screening: Connecting Spaces A, B, and C	253
6.3.7	Predictive Modeling in Heterogeneous Catalysis	255
6.3.8	Predictive Modeling in Biocatalysis	256
6.4	An Overview of Data-Mining Methods in Catalysis	257
6.4.1	Principal Components Analysis (PCA)	259

6.4.2	Partial Least-Squares (PLS) Regression	260
6.4.3	Artificial Neural Networks (ANNs)	262
6.4.4	Classification Trees	264
6.4.5	Model Validation: Separating Knowledge from Garbage	264
6.4.5.1	Cross-Validation and Bootstrapping	265
6.4.5.2	Mixing the Dependent Variables (γ -Randomizing)	266
6.4.5.3	Defining the Model Domain	266
6.5	Exercises	266
	References	268