

Contents

Preface *XI*

Foreword *XIII*

1	Introduction: Green Chemistry and Catalysis	1
1.1	Introduction	1
1.2	E Factors and Atom Efficiency	2
1.3	The Role of Catalysis	5
1.4	The Development of Organic Synthesis	8
1.5	Catalysis by Solid Acids and Bases	10
1.6	Catalytic Reduction	14
1.7	Catalytic Oxidation	18
1.8	Catalytic C–C Bond Formation	23
1.9	The Question of Solvents: Alternative Reaction Media	27
1.10	Biocatalysis	29
1.11	Renewable Raw Materials and White Biotechnology	34
1.12	Enantioselective Catalysis	35
1.13	Risky Reagents	38
1.14	Process Integration and Catalytic Cascades	39
	References	43
2	Solid Acids and Bases as Catalysts	49
2.1	Introduction	49
2.2	Solid Acid Catalysis	50
2.2.1	Acidic Clays	50
2.2.2	Zeolites and Zeotypes: Synthesis and Structure	52
2.2.3	Zeolite-catalyzed Reactions in Organic Synthesis	59
2.2.3.1	Electrophilic Aromatic Substitutions	60
2.2.3.2	Additions and Eliminations	65
2.2.3.3	Rearrangements and Isomerizations	67
2.2.3.4	Cyclizations	70
2.2.4	Solid Acids Containing Surface SO ₃ H Functionality	71
2.2.5	Heteropoly Acids	75

2.3	Solid Base Catalysis	76
2.3.1	Anionic Clays: Hydrotalcites	76
2.3.2	Basic Zeolites	80
2.3.3	Organic Bases Attached to Mesoporous Silicas	82
2.4	Other Approaches	85
	References	87
3	Catalytic Reductions	91
3.1	Introduction	91
3.2	Heterogeneous Reduction Catalysts	92
3.2.1	General Properties	92
3.2.2	Transfer Hydrogenation Using Heterogeneous Catalysts	100
3.2.3	Chiral Heterogeneous Reduction Catalysts	101
3.3	Homogeneous Reduction Catalysts	104
3.3.1	Wilkinson Catalyst	104
3.3.2	Chiral Homogeneous Hydrogenation Catalysts and Reduction of the C=C Double Bond	106
3.3.3	Chiral Homogeneous Catalysts and Ketone Hydrogenation	111
3.3.4	Imine Hydrogenation	113
3.3.5	Transfer Hydrogenation using Homogeneous Catalysts	114
3.4	Biocatalytic Reductions	116
3.4.1	Introduction	116
3.4.2	Enzyme Technology in Biocatalytic Reduction	119
3.4.3	Whole Cell Technology for Biocatalytic Reduction	125
3.5	Conclusions	127
	References	127
4	Catalytic Oxidations	133
4.1	Introduction	133
4.2	Mechanisms of Metal-catalyzed Oxidations:	
	General Considerations	134
4.2.1	Homolytic Mechanisms	136
4.2.1.1	Direct Homolytic Oxidation of Organic Substrates	137
4.2.2	Heterolytic Mechanisms	138
4.2.2.1	Catalytic Oxygen Transfer	139
4.2.3	Ligand Design in Oxidation Catalysis	141
4.2.4	Enzyme Catalyzed Oxidations	142
4.3	Alkenes	147
4.3.1	Epoxidation	147
4.3.1.1	Tungsten Catalysts	149
4.3.1.2	Rhenium Catalysts	150
4.3.1.3	Ruthenium Catalysts	151
4.3.1.4	Manganese Catalysts	152
4.3.1.5	Iron Catalysts	153
4.3.1.6	Selenium and Organocatalysts	154

4.3.1.7	Hydrotalcite and Alumina Systems	156
4.3.1.8	Biocatalytic Systems	156
4.3.2	Vicinal Dihydroxylation	156
4.3.3	Oxidative Cleavage of Olefins	158
4.3.4	Oxidative Ketonization	159
4.3.5	Allylic Oxidations	161
4.4	Alkanes and Alkylaromatics	162
4.4.1	Oxidation of Alkanes	163
4.4.2	Oxidation of Aromatic Side Chains	165
4.4.3	Aromatic Ring Oxidation	168
4.5	Oxygen-containing Compounds	170
4.5.1	Oxidation of Alcohols	170
4.5.1.1	Ruthenium Catalysts	172
4.5.1.2	Palladium-catalyzed Oxidations with O ₂	176
4.5.1.3	Gold Catalysts	178
4.5.1.4	Copper Catalysts	179
4.5.1.5	Other Metals as Catalysts for Oxidation with O ₂	181
4.5.1.6	Catalytic Oxidation of Alcohols with Hydrogen Peroxide	182
4.5.1.7	Oxoammonium Ions in Alcohol Oxidation	183
4.5.1.8	Biocatalytic Oxidation of Alcohols	184
4.5.2	Oxidative Cleavage of 1,2-Diols	185
4.5.3	Carbohydrate Oxidation	185
4.5.4	Oxidation of Aldehydes and Ketones	186
4.5.4.1	Baeyer-Villiger Oxidation	187
4.5.5	Oxidation of Phenols	190
4.5.6	Oxidation of Ethers	191
4.6	Heteroatom Oxidation	192
4.6.1	Oxidation of Amines	192
4.6.1.1	Primary Amines	192
4.6.1.2	Secondary Amines	193
4.6.1.3	Tertiary Amines	193
4.6.1.4	Amides	194
4.6.2	Sulfoxidation	194
4.7	Asymmetric Oxidation	195
4.7.1	Asymmetric Epoxidation of Olefins	196
4.7.2	Asymmetric Dihydroxylation of Olefins	204
4.7.3	Asymmetric Sulfoxidation	207
4.7.4	Asymmetric Baeyer-Villiger Oxidation	208
4.5	Conclusion	211
	References	212
5	Catalytic Carbon–Carbon Bond Formation	223
5.1	Introduction	223
5.2	Enzymes for Carbon–Carbon Bond Formation	223
5.2.1	Enzymatic Synthesis of Cyanohydrins	224

5.2.1.1	Hydroxynitrile Lyases	225
5.2.1.2	Lipase-based Dynamic Kinetic Resolution	228
5.2.2	Enzymatic Synthesis of α -Hydroxyketones (Acyloins)	229
5.2.3	Enzymatic Synthesis of α -Hydroxy Acids	234
5.2.4	Enzymatic Synthesis of Aldols (β -Hydroxy Carbonyl Compounds)	235
5.2.4.1	DHAP-dependent Aldolases	236
5.2.4.2	PEP- and Pyruvate-dependent Aldolases	241
5.2.4.3	Glycine-dependent Aldolases	242
5.2.4.4	Acetaldehyde-dependent Aldolases	242
5.2.5	Enzymatic Synthesis of β -Hydroxynitriles	244
5.3	Transition Metal Catalysis	245
5.3.1	Carbon Monoxide as a Building Block	245
5.3.1.1	Carbonylation of R-X (CO "Insertion/R-migration")	245
5.3.1.2	Aminocarbonylation	249
5.3.1.3	Hydroformylation or "Oxo" Reaction	250
5.3.1.4	Hydroaminomethylation	251
5.3.1.5	Methyl Methacrylate via Carbonylation Reactions	253
5.3.2	Heck-type Reactions	254
5.3.2.1	Heck Reaction	256
5.3.2.2	Suzuki and Sonogashira Reaction	257
5.3.3	Metathesis	258
5.3.3.1	Metathesis involving Propylene	259
5.3.3.2	Ring-opening Metathesis Polymerization (ROMP)	259
5.3.3.3	Ring-closing Metathesis (RCM)	260
5.4	Conclusion and Outlook	261
	References	261
6	Hydrolysis	265
6.1	Introduction	265
6.1.1	Stereoselectivity of Hydrolases	266
6.1.2	Hydrolase-based Preparation of Enantiopure Compounds	268
6.1.2.1	Kinetic Resolutions	268
6.1.2.2	Dynamic Kinetic Resolutions	269
6.1.2.3	Kinetic Resolutions Combined with Inversions	270
6.1.2.4	Hydrolysis of Symmetric Molecules and the "meso-trick"	271
6.2	Hydrolysis of Esters	271
6.2.1	Kinetic Resolutions of Esters	272
6.2.2	Dynamic Kinetic Resolutions of Esters	274
6.2.3	Kinetic Resolutions of Esters Combined with Inversions	276
6.2.4	Hydrolysis of Symmetric Esters and the "meso-trick"	278
6.3	Hydrolysis of Amides	279
6.3.1	Production of Amino Acids by (Dynamic) Kinetic Resolution	280
6.3.1.1	The Acylase Process	280
6.3.1.2	The Amidase Process	281

6.3.1.3	The Hydantoinase Process	282
6.3.1.4	Cysteine	283
6.3.2	Enzyme-catalysed Hydrolysis of Amides	283
6.3.3	Enzyme-catalysed Deprotection of Amines	285
6.4	Hydrolysis of Nitriles	286
6.4.1	Nitrilases	286
6.4.2	Nitrile Hydratases	287
6.5	Conclusion and Outlook	290
	References	290
7	Catalysis in Novel Reaction Media	295
7.1	Introduction	295
7.1.1	Why use a solvent?	295
7.1.2	Choice of Solvent	296
7.1.3	Alternative Reaction Media and Multiphasic Systems	298
7.2	Two Immiscible Organic Solvents	299
7.3	Aqueous Biphasic Catalysis	300
7.3.1	Olefin Hydroformylation	302
7.3.2	Hydrogenation	304
7.3.3	Carbonylations	306
7.3.4	Other C–C Bond Forming Reactions	307
7.3.5	Oxidations	309
7.4	Fluorous Biphasic Catalysis	309
7.4.1	Olefin Hydroformylation	310
7.4.2	Other Reactions	311
7.5	Supercritical Carbon Dioxide	313
7.5.1	Supercritical Fluids	313
7.5.2	Supercritical Carbon Dioxide	314
7.5.3	Hydrogenation	314
7.5.4	Oxidation	316
7.5.5	Biocatalysis	317
7.6	Ionic Liquids	318
7.7	Biphasic Systems with Supercritical Carbon Dioxide	322
7.8	Thermoregulated Biphasic Catalysis	323
7.9	Conclusions and Prospects	323
	References	324
8	Chemicals from Renewable Raw Materials	329
8.1	Introduction	329
8.2	Carbohydrates	332
8.2.1	Chemicals from Glucose via Fermentation	333
8.2.2	Ethanol	335
8.2.2.1	Microbial Production of Ethanol	338
8.2.2.2	Green Aspects	339
8.2.3	Lactic Acid	340

8.2.4	1,3-Propanediol	342
8.2.5	3-Hydroxypropanoic Acid	346
8.2.6	Synthesizing Aromatics in Nature's Way	347
8.2.7	Aromatic α -Amino Acids	349
8.2.7	Indigo: the Natural Color	353
8.2.8	Pantothenic Acid	355
8.2.9	The β -Lactam Building Block 7-Aminodesacetoxycephalosporanic Acid	358
8.2.9	Riboflavin	361
8.3	Chemical and Chemoenzymatic Transformations of Carbohydrates into Fine Chemicals and Chiral Building Blocks	363
8.3.1	Ascorbic Acid	364
8.3.2	Carbohydrate-derived C ₃ and C ₄ Building Blocks	368
8.3.3	5-Hydroxymethylfurfural and Levulinic Acid	370
8.4	Fats and Oils	372
8.4.1	Biodiesel	373
8.4.2	Fatty Acid Esters	374
8.5	Terpenes	375
8.6	Renewable Raw Materials as Catalysts	378
8.7	Green Polymers from Renewable Raw Materials	379
8.8	Concluding Remarks	380
	References	380
9	Process Integration and Cascade Catalysis	389
9.1	Introduction	389
9.2	Dynamic Kinetic Resolutions by Enzymes Coupled with Metal Catalysts	390
9.3	Combination of Asymmetric Hydrogenation with Enzymatic Hydrolysis	401
9.4	Catalyst Recovery and Recycling	402
9.5	Immobilization of Enzymes: Cross-linked Enzyme Aggregates (CLEAs)	405
9.6	Conclusions and Prospects	406
	References	407
10	Epilogue: Future Outlook	409
10.1	Green Chemistry: The Road to Sustainability	409
10.2	Catalysis and Green Chemistry	410
10.3	The Medium is the Message	412
10.4	Metabolic Engineering and Cascade Catalysis	413
10.5	Concluding Remarks	413
	References	414