Contents

Preface to the Third Edition *XV*
Abbreviations *XVII*

1 Introduction *1*
1.1 The Phenomenon Catalysis *1*
1.2 Mode of Action of Catalysts *2*
1.2.1 Activity *4*
1.2.1.1 Turnover Frequency TOF *6*
1.2.1.2 Turnover Number TON *7*
1.2.2 Selectivity *7*
1.2.3 Stability *8*
1.2.4 Mole Balance and Conversion *8*
1.3 Classification of Catalysts *10*
1.4 Comparison of Homogeneous and Heterogeneous Catalysis *11*
Exercises *14*
References *15*

2 Homogeneous Catalysis with Transition Metal Catalysts *17*
2.1 Key Reactions in Homogeneous Catalysis *18*
2.1.1 Coordination and Exchange of Ligands *18*
2.1.2 Complex Formation *20*
2.1.3 Acid–Base Reactions *22*
2.1.4 Redox Reactions: Oxidative Addition and Reductive Elimination *23*
2.1.4.1 Oxidative Coupling and Reductive Cleavage *27*
2.1.5 Insertion and Elimination Reactions *28*
2.1.5.1 β-Elimination *30*
2.1.5.2 α-Elimination *30*
2.1.6 Reactions at Coordinated Ligands *31*
2.2 Catalyst Concepts in Homogeneous Catalysis *32*
2.2.1 The 16/18-Electron Rule *32*
2.2.2 Catalytic Cycles *34*
2.3 Characterization of Homogeneous Catalysts *35*
2.3.1 Infrared Spectroscopy *38*

2.3.2 NMR Spectroscopy *40*
Exercises *42*
References *45*

3 Homogeneously Catalyzed Industrial Processes *47*
3.1 Overview *47*
3.2 Examples of Industrial Processes *48*
3.2.1 Oxo Synthesis *50*
3.2.2 Production of Acetic Acid by Carbonylation of Methanol *52*
3.2.3 Selective Ethylene Oxidation by the Wacker Process *55*
3.2.4 Oxidation of Cyclohexane *57*
3.2.5 Suzuki Coupling *58*
3.2.6 Oligomerization of Ethylene (SHOP Process) *59*
3.2.7 Telomerization of Butadiene *61*
3.2.8 Adipodinitrile *63*
3.3 Asymmetric Catalysis *63*
3.3.1 Introduction *63*
3.3.2 Catalysts *64*
3.3.3 Commercial Applications *65*
3.3.3.1 Asymmetric Hydrogenation *65*
3.3.3.2 Enantioselective Isomerization: L-Menthol *67*
3.3.3.3 Asymmetric Epoxidation *68*
3.4 Alkene Metathesis *69*
3.4.1 Examples of Heterogeneous Catalysis *72*
3.5 Recycling of Homogeneous Catalysts *73*
3.5.1 Overview *73*
3.5.1.1 Precipitation of the Catalyst or of the Product(s) *73*
3.5.1.2 Thermal Separation *73*
3.5.1.3 Membrane Separation *73*
3.5.1.4 Adsorption *74*
3.5.1.5 Phase Separation/Extraction *74*
3.5.2 Reactions in Two-Phase Liquid–Liquid Systems *74*
Exercises *76*
References *78*

4 Biocatalysis *81*
4.1 Introduction *81*
4.1.1 Active Sites *83*
4.1.2 Coenzymes *84*
4.2 Kinetics of Enzyme-Catalyzed Reactions *84*
4.3 Industrial Processes with Biocatalysts *90*
4.3.1 Acrylamide from Acrylonitrile *90*
4.3.2 Aspartame Through Enzymatic Peptide Synthesis *91*
4.3.3 L-Amino Acids by Aminoacylase Process *92*
4.3.4 Pharmaceuticals *93*

4.3.5 Herbicides *95*
4.3.5.1 4-Hydroxyphenoxypropionic Acid as Herbicide Intermediate *96*
Exercises *97*
References *97*

5 Heterogeneous Catalysis: Fundamentals *99*
5.1 Individual Steps in Heterogeneous Catalysis *99*
5.2 Kinetics and Mechanisms of Heterogeneously Catalyzed Reactions *101*
5.2.1 The Importance of Adsorption in Heterogeneous Catalysis *102*
5.2.2 Kinetic Treatment *106*
5.2.3 Mechanisms of Heterogeneously Catalyzed Gas-Phase Reactions *108*
5.2.3.1 Langmuir–Hinshelwood Mechanism (1921) *109*
5.2.3.2 Eley–Rideal Mechanism (1943) *111*
5.3 Catalyst Concepts in Heterogeneous Catalysis *113*
5.3.1 Energetic Aspects of Catalytic Activity *113*
5.3.2 Steric Effects *124*
5.3.3 Electronic Factors *134*
5.3.3.1 Redox Catalysts *134*
5.3.3.2 Acid/Base Catalysts (Ionic Catalysts) *135*
5.3.3.3 Metals *136*
5.3.3.4 Bimetallic Catalysts *140*
5.3.3.5 Semiconductors *144*
5.3.3.6 Insulators: Acidic and Basic Catalysts *157*
5.4 Catalyst Performance *164*
5.4.1 Factors Which Affect the Catalyst Performance *164*
5.4.2 Supported Catalysts *166*
5.4.3 Promoters *172*
5.4.4 Inhibitors *176*
5.5 Catalyst Deactivation *177*
5.5.1 Catalyst Poisoning *179*
5.5.2 Poisoning of Metals *179*
5.5.3 Poisoning of Semiconductor Oxides *182*
5.5.4 Poisoning of Solid Acids *182*
5.5.5 Deposits on the Catalyst Surface *183*
5.5.6 Thermal Processes and Sintering *185*
5.5.7 Catalyst Losses via the Gas Phase *186*
5.6 Regeneration and Recycling of Heterogeneous Catalysts *186*
5.7 Characterization of Heterogeneous Catalysts *189*
5.7.1 Physical Characterization *190*
5.7.1.1 Temperature-Programmed Desorption *195*

5.7.2 Chemical Characterization and Surface Analysis *195*
5.7.2.1 Temperature-Programmed Reaction Methods *196*
5.7.2.2 Transmission Electron Microscopy *197*
5.7.2.3 Low-Energy Electron Diffraction (LEED) *198*
5.7.2.4 IR Spectroscopy *199*
5.7.2.5 Electron Spectroscopy for Chemical Analysis (ESCA) *199*
5.7.2.6 Auger Electron Spectroscopy (AES) *201*
5.7.2.7 Ion Scattering Spectroscopy (ISS) *201*
5.7.2.8 Secondary Ion Mass Spectrometry (SIMS) *202*
Exercises *203*
References *209*

6 Catalyst Shapes and Production of Heterogeneous Catalysts *211*
6.1 Introduction *211*
6.2 Bulk Catalysts *212*
6.2.1 Precipitation *212*
6.2.2 Fusion and Alloy Leaching *214*
6.2.3 Sol–Gel Synthesis *215*
6.2.4 Flame Hydrolysis *217*
6.2.5 Hydrothermal Synthesis *217*
6.2.6 Heteropolyacids *219*
6.3 Supported Catalysts *219*
6.3.1 Impregnation *220*
6.3.2 Coprecipitation *225*
6.3.3 Adsorption/Ion-Exchange *226*
6.3.3.1 Ion-Exchange Resins *227*
6.3.4 Anchoring/Grafting *228*
6.3.5 Monolithic Catalysts *229*
6.4 Shaping of Catalysts and Catalyst Supports *230*
6.5 Immobilization of Homogeneous Catalysts *232*
6.5.1 Supported Solid-Phase Catalysts (SSPC) *234*
6.5.2 Supported Liquid-Phase Catalysts (SLPC) *236*
6.5.3 Encapsulation *236*
Exercises *237*
References *238*

7 Shape-Selective Catalysis: Zeolites *239*
7.1 Composition and Structure of Zeolites *239*
7.2 Catalytic Properties of the Zeolites *242*
7.2.1 Shape Selectivity *243*
7.2.1.1 Reactant Selectivity *243*
7.2.1.2 Product Selectivity *246*
7.2.1.3 Restricted Transition State Selectivity *246*
7.2.2 Acidity of Zeolites *247*

7.3 Isomorphic Substitution of Zeolites *251*
7.4 Metal-Doped Zeolites *252*
7.5 Applications of Zeolites *255*
Exercises *258*
References *259*

8 Heterogeneously Catalyzed Processes in Industry *261*
8.1 Overview *261*
8.1.1 Production of Inorganic Chemicals *261*
8.1.2 Production of Organic Chemicals *261*
8.1.3 Refinery Processes *262*
8.1.4 Catalysts in Environmental Protection *264*
8.2 Examples of Industrial Processes – Bulk Chemicals *266*
8.2.1 Ammonia Synthesis *266*
8.2.2 Hydrogenation *268*
8.2.3 Methanol Synthesis *270*
8.2.4 Selective Oxidation of Propene *272*
8.2.4.1 Oxidation of Propene with H_2O_2 to Propylene Oxide *277*
8.2.5 Selective Oxidation of Hydrocarbons *277*
8.2.5.1 *n*-Butane to Maleic Anhydride *278*
8.2.5.2 *o*-Xylene to Phthalic Anhydride *280*
8.3 Fine Chemicals Manufacture *281*
8.3.1 Fine Chemicals and Their Synthesis *281*
8.3.2 Selected Examples of Industrial Processes *285*
8.3.2.1 Hydrogenation *286*
8.3.2.2 Oxidation *288*
8.3.2.3 Catalytic C–C Linkage *290*
8.3.2.4 Acid/Base Catalysis *292*
Exercises *294*
References *297*

9 Refinery Processes and Petrochemistry *299*
9.1 Hydrotreating *300*
9.2 Catalytic Cracking *302*
9.3 Hydrocracking *304*
9.4 Catalytic Reforming *306*
9.5 Alkylation *307*
9.6 Hydroisomerization *308*
9.7 Synthesis Gas and Hydrogen by Steam Reforming *310*
9.8 Natural Gas Conversion to Fuels and Chemicals *312*
9.9 Fischer–Tropsch Synthesis *313*
9.10 Etherification Reactions *315*
Exercises *316*
References *317*

10 Electrocatalytic Processes *319*
10.1 Comparison Between Electrocatalysis and Heterogeneous Catalysis *319*
10.2 Electroorganic Syntheses *319*
10.2.1 Electrocatalytic Hydrogenation *320*
10.2.2 Electrocatalytic Oxidation *322*
10.2.3 Electrochemical Addition *323*
10.3 Electrocatalysis in Fuel Cells *324*
10.3.1 Basic Principles *324*
10.3.2 Types of Fuel Cell and Catalyst *325*
10.3.3 Important Reactions in Fuel Cell Technology *328*
10.3.3.1 The Anodic Reaction *328*
10.3.3.2 The Cathodic Reaction *329*
10.3.3.3 Methanol Oxidation *331*
Exercises *332*
References *333*

11 Environmental Catalysis and Green Chemistry *335*
11.1 Automotive Exhaust Catalysis *335*
11.2 NO_x Removal Systems *338*
11.2.1 Selective Catalytic Reduction of Nitrogen Oxides *338*
11.2.2 NO_x Storage-Reduction Catalyst for Lean-Burning Engines *340*
11.3 Catalytic Afterburning *341*
11.4 Green Chemistry and Catalysis *344*
11.4.1 Examples of Catalytical Processes *345*
11.4.1.1 Aldol Condensation *345*
11.4.1.2 Diels–Alder Reaction *346*
11.4.1.3 Hydrogenation *347*
11.4.1.4 Cyclization in Water *347*
11.4.1.5 Use of Ionic Liquids *347*
11.4.1.6 Green Solvents *349*
Exercises *350*
References *351*

12 Phase-Transfer Catalysis *353*
12.1 Definition *353*
12.2 Catalysts for PTC *353*
12.3 Mechanism and Benefits of PTC *354*
12.4 PTC Reactions *355*
12.5 Selected Industrial Processes with PTC *356*
12.5.1 Continuous Dehydrohalogenation to Produce the Large-Scale Monomer Chloroprene *356*
12.5.2 Polycarbonate Manufacture with Phosgene *356*
12.5.3 Etherification (O-Alkylation) *357*
12.5.4 Aldehydes by Oxidation of Alcohols with Hypochlorite *357*

12.5.5 Carbonylation *357*
12.5.6 2-Phenylbutyronitrile by Alkylation *358*
Exercises *359*
References *359*

13 Catalytic Processes with Renewable Materials *361*
13.1 Biofuels *361*
13.2 Biorefinery *366*
13.2.1 Lignocellulose Feedstock Biorefinery *368*
13.3 Chemicals from Biomass *369*
13.3.1 Chemicals from Biomass via Platform Molecules *369*
13.3.1.1 Carbohydrates *369*
13.3.1.2 Fats and Oils *373*
13.3.1.3 Terpenes *375*
13.3.2 Direct Biomass Conversion to End-Products *376*
Exercises *378*
References *378*

14 Polymerization Catalysis *381*
14.1 Introduction *381*
14.2 Fundamentals of Catalytical Polymerization Processes *381*
14.3 Coordination Polymerization *383*
14.3.1 Ziegler–Natta Catalysts *383*
14.3.1.1 Heterogeneous Ziegler–Natta Catalysts *384*
14.3.1.2 Homogeneous Ziegler–Natta Catalysts *386*
14.3.1.3 Metallocenes *386*
14.3.1.4 Ring-Opening Metathetic Polymerization *388*
14.4 Examples of Catalytical Polymerization Processes *389*
14.4.1 Polyethylene Production *389*
14.4.2 Polypropylene Production *391*
Exercises *392*
References *393*

15 Planning, Development, and Testing of Catalysts *395*
15.1 Stages of Catalyst Development *395*
15.2 Development of a Catalytical Process: Hydrogenation of Benzene to Cyclohexane *398*
15.3 Selection and Testing of Catalysts in Practice *401*
15.3.1 Catalyst Screening *401*
15.3.2 Catalyst Test Reactors and Kinetic Modeling *405*
15.3.2.1 Differential Reactor *405*
15.3.2.2 Differential Circulating Reactor *407*
15.3.2.3 Integral reactor *411*
15.3.3 Kinetic Modeling and Simulation *416*
15.3.3.1 Hydrogenation of Benzaldehyde *416*

15.3.3.2 Modeling of a Trickle Bed Reactor *420*
15.3.4 Catalyst Discovery via High-Throughput Experimentation *427*
Exercises *430*
References *430*

16 Catalysis Reactors *433*
16.1 Plug Flow Reactor (PFR) *433*
16.2 Continuous Stirred-Tank Reactor (CSTR) *435*
16.3 Reactor Calculations *436*
16.4 Two-Phase Reactors *440*
16.4.1 Single-Bed Reactor *441*
16.4.2 Multibed Reactor *441*
16.4.3 Multitubular Reactors *442*
16.4.4 Shallow-Bed Reactors *442*
16.4.5 Fluidized-Bed Reactors *443*
16.5 Three-Phase Reactors *443*
16.5.1 Fixed-Bed Reactors *445*
16.5.2 Suspension Reactors *447*
16.6 Reactors for Homogeneously Catalyzed Reactions *451*
16.7 New Reactor Concepts *452*
16.7.1 Membrane Reactors *452*
16.7.2 Catalytic Reactive Distillation *453*
16.7.3 Catalytic Microreactors *454*
Exercises *455*
References *457*

17 Economic Importance of Catalysts *459*
References *462*

18 Future Development of Catalysis *463*
18.1 Homogeneous Catalysis *463*
18.2 Heterogeneous Catalysis *465*
18.2.1 Use of Other Cheaper Raw Materials *467*
18.2.2 Catalysts for Energy Generation *468*
18.2.3 Better Strategies for Catalyst Development *469*
References *472*

Solutions to the Exercises *473*

Index *513*