

## Contents

	<b>Foreword</b>	V
	<b>Preface</b>	XIX
	<b>Abbreviations</b>	XXIII
<b>Part I</b>	<b>Chemical Basics</b>	1
<b>1</b>	<b>Definition, Options, and Examples: What Actually Is Catalysis?</b>	3
1.1	Definition of Catalysis	3
1.2	The Different Varieties of Catalysis	5
1.3	The Directing Effect of the Catalyst	8
1.4	Catalysis as a Part of “Green Chemistry”	10
1.5	Sources of Information about Catalysis	10
	Literature	14
<b>2</b>	<b>A Brief History: Homogeneous Transition Metal Catalysis: A Young Science</b>	17
2.1	A Brief History	17
2.1.1	Phase I: Inorganic Basic Chemicals (1898–1918)	18
2.1.2	Phase II: Refinery Processes: Synthesis Gas and Acetylene Chemistry (1919–1945)	18
2.1.3	Phase III: Petrochemical Industrial Products (1946–1970)	19
2.1.4	Phase IV: Fine Chemicals and Specialty Products (1971 to date)	21
	Literature	25
<b>3</b>	<b>Industrial Homogeneous Catalysis: What is the Economic Importance?</b>	27
3.1	Application Areas of Catalysis	27
3.2	Important Homogeneous Catalyzed Processes	27
3.3	Synthesis of Fine Chemicals by Homogeneous Catalysis	28
	Literature	32
<b>4</b>	<b>Definitions of Important Terms: Selectivity, STY, TON, TOF, and More. . .</b>	35
4.1	Conversion	35
4.2	Yield	36

4.2.1	Plant Yield (Overall Yield)	37
4.3	Selectivity	37
4.3.1	Chemoselectivity	37
4.3.2	Regioselectivity	38
4.3.3	Diastereoselectivity	38
4.3.4	Enantioselectivity	39
4.4	Other Important Target Values	40
4.4.1	Space–Time Yield (STY)	40
4.4.2	Catalyst Lifetime	40
4.4.3	Turnover Number	41
4.4.4	Turnover Frequency	42
4.4.5	Productivity	42
4.5	The Choice is Yours!	43
	Literature	46
<b>5</b>	<b>Bonds, Elemental Steps, and Catalyst Cycles: Basics of Organometallic Chemistry</b>	<b>47</b>
5.1	Ligands	47
5.2	Change in Oxidation State	50
5.3	Changing of Coordination Number (CN) and Coordination Geometry	50
5.4	The Elementary Steps	51
5.4.1	Association/Dissociation	52
5.4.2	Oxidative Addition/Reductive Elimination	53
5.4.3	Insertion/Extrusion	53
5.4.4	Oxidative Coupling (Cycloaddition)/Reductive Cleavage (Retrocycloaddition)	55
5.4.5	Further Elementary Steps	56
5.4.6	A Review of the Elementary Steps	56
5.5	Catalytic Cycles	57
	Literature	60
<b>6</b>	<b>Transition Metal Complexes: The “Captains” of Homogeneous Catalysis</b>	<b>63</b>
6.1	Group IIIB Metals and Lanthanides	63
6.2	Metals of Group IVB	64
6.3	Metals of Groups VB to VIIB	64
6.4	The “Iron Metals” of Group VIII	65
6.5	The Noble Metals from Group VIII	65
6.5.1	Ruthenium	66
6.5.2	Osmium	67
6.5.3	Rhodium	67
6.5.4	Iridium	70
6.5.5	Palladium	70
6.5.6	Platinum	72
6.6	Gold: A Noble Metal from Group IB	72
6.7	The Cost of Catalyst Metals	72

6.8	The Availability of Transition Metal Catalysts	74
6.9	A Typical Experiment: Synthesis of Pd(acac) <sub>2</sub>	75
	Literature	76
<b>7</b>	<b>The Complex Ligands: The “Mates” of Homogeneous Catalysis</b>	<b>79</b>
7.1	Monodentate Ligand or Chelate?	79
7.2	Basicity of Ligands	82
7.3	Cone Angle (“Tolman Cone Angle”)	83
7.4	The Bite Angle	88
7.5	Costs and Accessibility of Ligands	91
7.6	A Typical Experiment: The Synthesis of Biphephos	93
7.7	Stability of Ligands	95
	Literature	98
<b>8</b>	<b>The Solvents: The Reaction Medium</b>	<b>101</b>
8.1	Criteria for Choosing Solvents	102
8.1.1	The Dielectric Constant (Permittivity)	102
8.1.2	Dipole Moment	104
8.2	Miscibility of Solvents	106
8.3	Solvents as Activators	107
8.4	Solvents as Deactivators	108
8.5	Availability and Purity of Solvents	109
8.5.1	Solvent Availability	109
8.5.2	Solvent Purity	110
8.6	Special Solvents	111
	Literature	112
<b>9</b>	<b>Asymmetric Catalysis: The “Special Case”</b>	<b>115</b>
9.1	A Glossary of Asymmetric Catalysis	115
9.1.1	Preliminary Information	115
9.2	A Quick Look Back	119
9.3	Mechanistic Considerations	121
9.4	Chiral Ligands	125
9.5	Overview on Homogeneous Catalyzed Asymmetric Syntheses	127
9.6	Industrial Applications	127
	Literature	131
<b>10</b>	<b>Thermodynamics of Homogeneous Catalysis: When Does a Chemical Reaction Run?</b>	<b>133</b>
10.1	Gibbs Energy and Energy Plot	133
10.2	Calculation or Assessment of the Free Reaction Enthalpy	135
10.3	Thermodynamic Analysis of Complex Reaction Systems	136
	Literature	139

<b>11</b>	<b>Kinetics of Homogeneous Catalysis: How Does the Reaction Proceed?</b>	<b>141</b>
11.1	Frequently Occurring Kinetics	141
11.2	The Energy Diagram for Explaining Regioselectivity	145
11.3	The Energy Diagram for Explaining Enantioselectivity	146
11.4	Execution of Kinetic Measurements	146
11.5	A Concrete Example: The (Isomerizing) Hydroformylation of Octenes	147
11.6	Possible Failures in Kinetic Measurements	149
	Literature	151
<b>12</b>	<b>Overview on Spectroscopic Methods: Can We See into Homogeneous Catalysis?</b>	<b>153</b>
12.1	UV/Visible Spectroscopy	153
12.2	IR Spectroscopy	155
12.3	NMR Spectroscopy	157
12.3.1	<sup>1</sup> H NMR Spectroscopy	157
12.3.2	NMR Spectroscopy with Para Hydrogen	158
12.3.3	<sup>31</sup> P NMR Spectroscopy	159
12.4	Mass Spectroscopy	162
12.5	Extended X-Ray Absorption Fine Structure Analysis	163
12.6	Inductively Coupled Plasma Optical Emission Spectroscopy (ICP-OES)	164
	Literature	166
<b>Part II</b>	<b>Process Engineering Fundamentals</b>	<b>169</b>
<b>13</b>	<b>Reactor Types: Where Does Catalysis Occur?</b>	<b>171</b>
13.1	Reactions in Homogeneous Liquid Phase	171
13.1.1	Stirred-Tank Reactor	171
13.1.2	Tubular Reactor	173
13.2	Fluid–Fluid Systems	174
13.2.1	Sparged Stirred-Tank Reactor	174
13.2.2	Bubble Column Reactor	175
13.2.3	Loop Reactors	175
13.2.4	Jet Tube Reactor	175
13.2.5	Reactors for Gaseous Product Streams	176
13.2.6	Falling Film Reactor	176
13.2.7	Jet Scrubber	177
13.2.8	Liquid Ring Pump and Sparged Tubular Reactor	177
13.3	The “Embarras de Richesses”	177
13.4	Pressure Reactors	180
13.5	New Trends	182
	Literature	185
<b>14</b>	<b>Overview on Catalyst Recycling Methods: Is My Catalyst Economical?</b>	<b>189</b>
14.1	The Principles of Separation	189
14.2	Precipitation	193

14.2.1	Chemical Precipitation	193
14.2.2	Addition of a Solvent	194
14.2.3	Removal of a Solvent	194
14.2.4	Addition of Specific Precipitants	194
14.2.5	Thermal Deposition of a Metal Catalyst	195
14.2.6	Tags	195
14.3	Crystallization	196
14.4	Adsorption	196
	Literature	199
<b>15</b>	<b>Thermal Separation: The Simplest Removal of Volatile Products</b>	<b>203</b>
15.1	The Basics	203
15.1.1	Separation by Distillation of the Product	203
15.1.2	Thermal Decomposition of the Catalyst	203
15.2	Example: Hydroformylation	204
15.2.1	The Triad Process	204
15.2.2	The Gas Recycle Process	205
15.2.3	The Liquid Recycle Process	206
15.3	Example: Oxidation of Ethene to Acetaldehyde	207
15.4	Example: Carbonylation of Methanol to Acetic Acid	209
	Literature	212
<b>16</b>	<b>Immobilization on Solid Supports: From Homogeneous to Heterogeneous</b>	<b>213</b>
16.1	The Basic Principle	213
16.2	Organic Supports	214
16.3	Inorganic Supports	215
	Literature	219
<b>17</b>	<b>Liquid–Liquid Multiphase Systems: The Smart Approach to Catalyst Separation</b>	<b>223</b>
17.1	Variants of Liquid–Liquid Biphasic (LLB) Systems	224
17.2	Reaction and Separation	225
17.2.1	Organic/Organic Biphasic Systems	226
17.2.2	Organic/Aqueous Biphasic Systems	227
17.2.3	Micellar Catalysis	232
17.3	Reactions with <i>In-Situ</i> Extraction	234
17.4	Reactions with Post Extraction	235
	Literature	238
<b>18</b>	<b>Thermomorphic Solvent Systems: Clever Enhancements</b>	<b>243</b>
18.1	Thermoregulated Phase-Transfer Catalysis	243
18.2	Thermoregulated Microemulsions	245
18.3	Thermoregulated Fluorous Solvent Systems	246
18.4	Thermoregulated Polymer-Bound Catalysts	248

- 18.5 Thermomorphic Multicomponent Solvent Systems 251
- 18.5.1 Finding a Suitable TMS System 252
- 18.6 A Retrospective Look at Catalyst Recycling Methods 253
  - Literature 256
  
- Part III Homogeneous Catalyzed Reaction Types 259**
  
- 19 An Overview of C–C-Bonding Reactions: A Guide Through the Jungle 263**
  - Literature 270
  
- 20 Hydroformylations: The Industrial Route to Aldehydes and Alcohols 273**
  - 20.1 Substrates 274
  - 20.2 Catalysts 275
  - 20.3 Mechanisms 277
  - 20.4 Industrial Processes 278
    - 20.4.1 First-Generation Catalysts (from ~1950) 279
    - 20.4.2 Second-Generation Catalysts (from ~1960) 279
    - 20.4.3 Third-Generation Catalysts (from ~1974) 280
    - 20.4.4 Fourth-Generation Catalysts (from ~1984) 281
  - 20.5 Asymmetric Hydroformylation 281
  - 20.6 A Typical Experiment: Hydroformylation of 1-Octene 282
    - Literature 284
  
- 21 Carbonylations: The Versatile Insertions of Carbon Monoxide 291**
  - 21.1 Reactions between CO and Hydrogen 291
  - 21.2 Reactions of CO with Alkenes and Vinyl Arenes 292
  - 21.3 Reactions of CO with Dienes 293
  - 21.4 Reactions of CO with Alkynes 295
  - 21.5 Reactions of CO with Alcohols 296
    - 21.5.1 Carbonylation Reactions 297
    - 21.5.2 Homologation Reactions 298
  - 21.6 A Typical Experiment 298
    - Literature 300
  
- 22 Oligomerization and Cyclooligomerization: The Conversion of Unsaturated Aliphatics into Short Chains or Medium-Sized Rings 303**
  - 22.1 Oligomerization of Alkenes 303
    - 22.1.1 Ethene 303
    - 22.1.2 Propene 308
    - 22.1.3 Other Monoenes 310
  - 22.2 Dienes 311
  - 22.3 Alkynes 313
  - 22.4 Cooligomerizations 314
    - 22.4.1 Ethene and Butadiene 314

- 22.4.2 Ethene and Styrene (Hydrovinylation) 315
- 22.4.3 Cooligomerizations with Alkynes 316
- 22.5 A Typical Experiment 316
  - Literature 318
  
- 23 Metathesis: A “Change-Your-Partners” Dance 323**
  - 23.1 Mechanism and Catalysts 325
  - 23.2 Industrial Applications 330
  - 23.3 A Typical Experiment: Self Metathesis of 1-Octene 332
    - Literature 334
  
- 24 Polymerizations: The Purposeful Assembly of Macromolecules 337**
  - 24.1 Polyethylene and Ziegler Catalysts 337
  - 24.2 Polypropylene and Metallocene Catalysis 341
  - 24.3 Further Polyolefins 346
  - 24.4 Polydienes 347
  - 24.5 Polyketones 348
  - 24.6 Polyalkynes 349
  - 24.7 Post-Metallocenes 350
  - 24.8 Current Topics in Polymer Research 351
  - 24.9 A Typical Experiment 352
    - Literature 354
  
- 25 Telomerizations: The Construction of C<sub>8</sub> and C<sub>10</sub> Chains 359**
  - 25.1 Reactions, Mechanisms, and Catalysts 359
  - 25.2 Butadiene Telomerizations 362
    - 25.2.1 Butadiene and Oxygen Nucleophiles 363
    - 25.2.2 Butadiene and Nitrogen Nucleophiles 367
    - 25.2.3 Butadiene and Carbon Nucleophiles 368
    - 25.2.4 Carboxy Telomerization 368
    - 25.2.5 Cyclic Telomeres 369
  - 25.3 Telomerizations with Isoprene 371
  - 25.4 Telomerizations in Liquid–Liquid Biphase Systems 372
  - 25.5 A Typical Experiment 374
    - Literature 376
  
- 26 Reactions with Carbon Dioxide: The Activation of an “Inactive” Molecule 381**
  - 26.1 Carbon Dioxide and Alkanes 382
  - 26.2 Carbon Dioxide and Alkenes 383
  - 26.3 Carbon Dioxide and Dienes 384
  - 26.4 Carbon Dioxide and Alkynes 387
  - 26.5 Carbon Dioxide and Aromatics 388
  - 26.6 Carbon Dioxide and Hydrogen 388
  - 26.7 Carbon Dioxide and Epoxides 392

- 26.8 Carbon Dioxide and Amines 393
- 26.9 Carbon Dioxide-Containing Polymers 394
  - 26.9.1 Aliphatic Polycarbonates Containing CO<sub>2</sub> and Epoxides 394
  - 26.9.2 Polypyrones from CO<sub>2</sub> and Diynes 394
  - 26.9.3 CO<sub>2</sub>-Containing Polyesters of Diynes and Dihalides 395
  - 26.9.4 Aromatic Polycarbonates Based on CO<sub>2</sub> 395
- 26.10 A Typical Experiment 396
  - Literature 398
  
- 27 Carbon–Carbon Coupling with Aromatics: New Name Reactions 403**
  - 27.1 Mizoroki–Heck Reactions 404
  - 27.2 Sonogashira–Hagihara Reactions 406
  - 27.3 Suzuki–Miyaura Reaction 407
  - 27.4 Cross-Couplings with Metal Organyles 409
  - 27.5 A Typical Experiment 411
    - Literature 413
  
- 28 Hydrogenations: C–H Bond Formation 419**
  - 28.1 Catalysts and Mechanisms 419
  - 28.2 Asymmetric Hydrogenation 420
  - 28.3 Hydrogenation of Various Functional Groups 422
    - 28.3.1 C–C Multiple Bonds 422
    - 28.3.2 C=O Double Bonds 424
    - 28.3.3 C=N Double Bonds 426
  - 28.4 Technical Applications 426
    - 28.4.1 (S)-Metolachlor 427
    - 28.4.2 *l*-DOPA 428
    - 28.4.3 Aspartame 428
    - 28.4.4 Naproxen 428
    - 28.4.5 Indinavir 429
    - 28.4.6 Carbapenem 429
    - 28.4.7 Biotin 429
  - 28.4.8 Production of Cyclohexane 429
  - 28.5 A Typical Experiment 431
    - Literature 432
  
- 29 Oxidations: Formation of C–O Bonds 437**
  - 29.1 Wacker Oxidations 437
  - 29.2 Epoxidations 440
  - 29.3 Asymmetric Dihydroxylations 444
  - 29.4 Oxidative Cleavage of C=C Double Bonds 444
  - 29.5 Oxidations of Alkyl Aromatics 446
  - 29.6 A Typical Experiment 448
    - Literature 449



<b>30</b>	<b>Aminations: Formation of C–N Bonds</b>	<b>455</b>
30.1	Amination of Aryl Halides	455
30.2	Hydroamination of Alkenes	458
30.3	Hydroaminations of Dienes	461
30.4	Hydroamination of Alkynes	462
30.5	Amination of Functional Groups	462
30.6	...Some More Aminations	463
30.7	A Typical Experiment	464
	Literature	466
<b>31</b>	<b>Isomerizations: Migration of Double Bonds and Rearrangement of the Carbon Backbone</b>	<b>473</b>
31.1	Isomerization of Alkenes	473
31.1.1	The Alkyl Mechanism	474
31.1.2	The Allylic Mechanism	474
31.2	Isomerization of Substituted Alkenes	475
31.3	Rearrangement of the Backbone	478
31.4	A Typical Experiment	479
	Literature	480
<b>Part IV</b>	<b>New Trends</b>	<b>485</b>
<b>32</b>	<b>Tandem Reactions: Multiple Synthesis Steps in One Pot</b>	<b>487</b>
32.1	Multicomponent Reactions	488
32.2	Multifunctional Catalysis	489
32.3	Tandem and Related Reactions	491
32.3.1	One-Pot Reactions	492
32.3.2	Domino Reactions	493
32.3.3	Cascade or Zip Reactions	493
32.3.4	Tandem Reactions	494
32.3.4.1	Orthogonal Tandem Catalysis	494
32.3.4.2	Auto-Tandem Reactions	495
32.3.4.3	Assisted Tandem Catalysis	496
32.4	A Typical Experiment	497
	Literature	500
<b>33</b>	<b>Combinatorial Chemistry and High-Throughput Catalyst Screening: The Fast Way to Optimum Results</b>	<b>507</b>
33.1	Basics and Definitions	507
33.2	Parallel Reactor Systems	509
33.3	Sequential Reactor Systems	514
	Literature	517
<b>34</b>	<b>Green Solvents: Working with Eco-Friendly Solvents</b>	<b>521</b>
34.1	Ionic Liquids	521
34.2	Supercritical Fluids	526

- 34.3 Fluorous Solvents 529
- 34.4 Polyethers 530
- 34.5 Conclusions 531
- Literature 533
  
- 35 Alkane Activations: Acquisitions of New Feedstocks 541**
- 35.1 Mechanistic Considerations 542
- 35.2 Alkane Oxidations 543
- 35.3 Alkane Carbonylations 545
- 35.4 Alkane Metathesis 545
- 35.5 Alkane Hydrogenolysis 546
- 35.6 Alkane Borylation 546
- 35.7 Alkane Sulfonation 547
- 35.8 A Look Back 547
- Literature 548
  
- 36 More Efficient Ligands: The Best is the Enemy of the Good 553**
- 36.1 Nitrogen-Containing Ligands 554
- 36.2 Unusual Phosphorus Ligands 556
- 36.3 Ligands Containing Elements from Group VIA 557
- 36.4 Ligands Containing Elements from Group IVA 559
- Literature 562
  
- 37 Nanocatalysis: Between Homogeneous and Heterogeneous Catalysis 569**
- 37.1 Synthesis and Properties of Nanocatalysts 569
- 37.2 Stabilization of Nanoparticles 571
- 37.3 Heterogenization of Nanoparticles on Solid Supports 574
- 37.4 Catalysis Involving Metal Nanoparticles 574
- Literature 576
  
- 38 Homogeneous Catalysis with Renewables: Using Nature's Treasures 583**
- 38.1 Catalytic Conversion of Fatty Compounds 585
- 38.1.1 Catalytic Functionalization of Unsaturated Fatty Compounds 586
- 38.1.1.1 Selective Hydrogenations 586
- 38.1.1.2 Hydroformylation 586
- 38.1.1.3 Hydroaminomethylation 587
- 38.1.2 Catalytic Oligomerization of Unsaturated Fats 587
- 38.1.3 Catalytic Oxidation of Unsaturated Fatty Compounds 588
- 38.1.4 Catalytic Metathesis of Unsaturated Fatty Compounds 589
- 38.1.5 Catalytic Derivatization of Glycerol 591
- 38.2 Catalytic Reactions of Carbohydrates 593
- 38.3 Catalytic Reactions of Terpenes 594
- Literature 597

<b>39</b>	<b>Electrocatalysis/Sonocatalysis/Photocatalysis/Microwave/Extreme Pressure: Alternative Methods of Activation</b>	<b>603</b>
39.1	Electrocatalysis	603
39.2	Photocatalysis	605
39.3	Sonocatalysis	606
39.4	Microwave Catalysis	608
39.5	Extreme High-Pressure Catalysis	611
	Literature	613
<b>40</b>	<b>Process Development in Miniplants: From Laboratory to Production</b>	<b>621</b>
40.1	Miniplant with Continuously Stirred-Tank Reactor (Miniplant I)	622
40.2	Miniplant with Loop Reactor and Phase Separator (Miniplant II)	623
40.3	Miniplant with Jetloop Reactor and Phase Separator (Miniplant III)	626
40.4	Miniplant with a Mixer–Settler Battery (Miniplant IV)	628
	Literature	631
<b>41</b>	<b>The Future of Homogeneous Catalysis: A Look Ahead</b>	<b>633</b>
41.1	New Resources	633
41.1.1	Carbon Dioxide	634
41.1.2	Renewable Resources	635
41.1.3	Fats and Oils	635
41.1.4	Carbohydrates	637
41.1.5	Biorefineries	637
41.2	New Reactions	638
41.2.1	Selective Oxidations	639
41.2.2	Asymmetric Reactions	639
41.2.3	Tandem Reactions	640
41.2.4	Polymerizations	640
41.2.5	New Catalytic Reactions	641
41.2.6	Environment-Friendly Processes	641
41.3	New Catalysts	641
41.4	New Methods	643
	Literature	644
	<b>Answers to the Quickies</b>	<b>645</b>
	<b>Index</b>	<b>669</b>

