

Index

Page references to figures are in italics, to tables in bold

- acceleration of reactions 163–9
 high temperatures 163–5
 peptide synthesis 163–5, *164*
 acrylates 212
 activated complex 11, *11*
 and transition state theory 12
 activation energy 11–12, 14
 and exothermicity 88–9, 88
 reactions in solution 16–17
 unimolecular reactions 14
 activation of molecules *see* molecular activation
N-acyliminium ions 46–50, 154–5,
 182, 183–4, *184*
 characterization 48–9, 48
 electrochemical reduction 61
 radical trapping 61
 generation
 by C–H bond dissociation
 46–50
 from pyrrolidine
 carbamate 47–8
 transient intermediaries 46–7
 by C–Si bond dissociation
 50
 in polymerization 182, 183–4,
184
 reaction
 with aromatic compounds 155,
156
 with benzene 91
 with carbon nucleophiles 49
 cycloaddition 160–2
 disguised chemical
 selectivity 81, 83, 156–7
 energy considerations 80, 80
 with heteroaromatic
 compounds 155–6, **156**
 microflow system 81–2, 82, **82**
 monoalkylation product 79–80
 product protonation 79–80
 product selectivity 155, **156**
 rates 83, 83
 sequential alkylation
 reactions 157
 with styrene and
 derivatives 160–2, **161**
 three-component coupling
 49–50
 with trimethoxybenzene 154–5
 using macrobatch
 reactor 80–1
 using micromixer 81–2
 with trimethylbenzene 79–80,
 91
 alcohols 147–50
 alkene oxidation 145–6
 alkoxy-carbenium ions
 generation
 under acidic conditions 51

- alkoxycarbenium ions (*Continued*)
 by C—C bond dissociation
 53–5
 dication generation 53–4
 by C—H bond dissociation 51
 by C—S bond cleavage 52–3
 by C—Si bond dissociation
 50–2
 use of silyl groups 51
 nomenclature 50–1
 react with carbon nucleophiles 52
 stability 51–2
allylic alcohol dehydration 153–4
amide bond formation 163–5, 164
amine addition reactions 143, **144**
aromatic compounds
 and *N*-acyliminium ions 155, **156**
 iodination 157–8, 159
 substitution 90, 91
Arrhenius formula 11
aryl halide reactions 37, **38**
aryllithium compounds 151–2, 201
azadiene synthesis 36
azo pigments 219
azobisisobutyronitrile (AIBN) 96,
 96

Bell—Evans—Polanyi principle 88
benzene and *N*-acyliminium ions 91
benzene ring, electrophile
 introduction 151–3, 152
benzocyclobutenone 35, 35
benzyl methacrylate (BMA),
 polymerization 195
benzyne 98–9
bi-phasic azo-coupling
 reactions 162–3
bimolecular reactions 14
 gas phase 15–16
 potential energy surface 16, 16
 precomplexes 16
 solution phase 16–17
block copolymers 174, 185, 187–8,
 188, 188

boronic acid esters
 react with Grignard
 reagents 158–60
 multisubstitution 158–9
 product selectivity 159, **160**
bromination 141
bromine—lithium exchange
 reaction 99–101, 100,
 151–3, 151
 microflow system 151–3, 152
 residence time 101, 101
 yield 100–1, 101
bromobenzenes 151–3, 152
o-bromophenyllithium 98, 98, 99–101
Brownian motion 7
 theory 72–3
Brundtland Commission 219
butyl acrylate (BA),
 polymerization 193–5,
 212–13, 215–16
by-products 154–63
 N-acyliminium ion reactions 160
 aromatic iodination 157–8, 159
 bi-phasic azo-coupling
 reactions 162–3
 in Friedel—Crafts reaction 154–7
 phenylmagnesium bromide
 reactions 158–60
 polymeric 162

*C*₆₀ synthesis 36
carbamate oxidation 46
carbanions 40, 43
carbocations 40, 41
 cation-pool generation 44–56
 nucleophile trapping 43–4
carbon radicals
 cation pool reduction 61–2
 generation 59, 62
 cation pool precursors 60
 imminium salts reduction 60
 one-electron reduction 59–60
 radical chain process 59
 redox-mediated method 59

- catalyst-containing microflow
 - reactor 129–31, 130, 131
 - membranous 131
 - organic catalysts 130–1
 - Pd catalyst 129, 130, 166, 166
 - solid (supported) catalyst 130
- cation-flow method 57–9, 58
 - monitoring device 58
 - paired electrolysis 58, 59
 - reactor construction 57, 57
- cation-pool initiated
 - polymerization 182–4
 - N*-acyliminium ions 182, 183–4, 184
 - microsystem 182–3, 183
 - molecular weight increase 183, 183
- cation-pool method 44–56
 - cell structure 44, 45
 - electrochemical oxidation
 - system 44, 46
 - generation methods 46–56
 - C–C bond dissociation 53–5
 - C–H bond dissociation 46–50
 - C–S bond cleavage 52–3
 - C–Si bond dissociation 50–2
 - chemical generation (indirect method) 55–6
 - advantages 56
 - steps 55–6
 - time scale 56
 - nucleophile addition 45–6
 - in polymerization 182–4
 - supporting liquids 45
- cation-pool reduction 61–2
- cationic polymerization 176–88, 197
- cation-pool initiation 182–4
- conventional 176–8
 - chain transfer reaction 178
 - propagation step 177
 - termination 177
- ideal living 180–1
- living 178–80
- livingness 184–5
- microflow-system
 - controlled 184–5
 - block copolymers 185, 187–8, 188, 188
 - CF₃SO₃H initiation 187
 - chain-transfer 185
 - compared with
 - conventional 185–6, 186
 - initiation 184
 - requirements 184–5
 - restarting 185
 - termination 185
- chemical activation 41–3
- chemical libraries 24–7
 - and click chemistry 25–7
 - construction 24–5
 - and reaction speeds 25, 27
- chemical reactions
 - classification 8
 - macroscopic view 7, 8
 - molecular level 7
 - time–space relationship 4
- chemoselectivity
 - (regioselectivity) 87
- chlorination 139–41, 142
- click chemistry 25–7, 27
- combinatorial chemistry 24–5
 - parallel 24–5, 26
- combustion 9, 10
- competitive reactions 73–6
 - consecutive 74, 78–85, 160
 - N*-acyliminium ion pool
 - reactions 79–85
 - fluid dynamics simulation 83–5
 - Friedel–Crafts alkylation 78–85
 - relative rates estimation 82–3
- disguised chemical selectivity 75, 76
- kinetics 74–5
- mixing v. reaction speeds 74–5
- parallel 74, 85–7
 - Dushman reaction 86–7
 - stereoselectivity 87

- compound libraries *see* chemical libraries
- conduction 93–4, 93
- control of reactions 1, 69–104, 137, 223
- controlled mass transfer 166–7
- convection 94
- copolymers 173–4
- cycloaddition reactions 160–2
- cyclohexane oxidation 146
- cyclohexanol 149, 150
- diarylcarbenium ions
- generation
 - by C–H bond dissociation 54–5
 - by electrochemical oxidation 54
 - NMR confirmation 54–5
 - reactions 55
 - uses 54
- diarylethenes
- photochromism 201
 - synthesis 201–5
 - from aryllithium compounds 201
 - halogen–lithium exchange 201, 202–3, 203
 - microflow system 202–5, 204, 205
 - side reactions 202, 203
 - temperature 201, 202, 203, 204–5, 204
 - unsymmetrical 205, 205
- o-dibromobenzene 99, 100
- bromine–lithium exchange reaction 99–101, 100
- diffusion *see* molecular diffusion
- dimethyl sulfoxide (DMSO) 147–50
- disguised chemical selectivity 75, 76, 81, 83
- and alkylation products 81, 83
 - boronic acid esters and Grignard reagents 159
 - in competitive parallel reactions 85–7
 - in Friedel–Crafts reaction 181
 - in macrobatch reactions 155–6
 - and micromixing 85
 - and nucleophilicity parameters 156–7
 - in polymerization 181–2
 - downsizing 94–5, 94
 - drugs 30
 - Dushman reaction 86–7, 124–5
- electroauxiliaries 50, 51
- electrochemical activation 39–41
- carbanion generation 40
 - reactive reagent generation 40
- electrochemical microflow reactor 128–9, 129
- advantages 128
- electrophilic aromatic substitution 90–2, 91
- endothermic reactions 89, 90
- energy barriers 8–9, 89
- energy changes 8–9, 89
- energy levels
- and reaction rates 89–90
 - of transition states 89–90
- exothermicity 87–9, 88, 91, 102, 144
- activation energy 88–9, 88
 - control of reactions 138–46
 - halogen–magnesium exchange reactions 144
 - and reaction speed 89
 - and selectivity 88
- ¹⁸F-fluorodeoxyglucose (FDG) 27–30
- synthesis 27–30, 29
- fast reactions, exothermicity 87–9
- femtosecond chemistry 12–13, 14, 15
- and synthesis reactions 17, 18
- flash chemistry
- advantages 3–4

- defined 18, 19–21
- and green chemistry 220
- necessity 2, 23–32
- outlook 223–4
 - medicine 31
 - pharmacy 31
- schematic diagram 3, 20
- flash chromatography 3
- flash laser photolysis 3, 12
- flash vacuum pyrolysis (FVP) 3,
35–6, 35
 - benzocyclobutanone synthesis 35,
35
- flask sizes 1, 2–3
- flow switching 27, 28–9
- fluid dynamics simulation 83–5,
84, **85**
 - assumptions 84
 - lamination width 84–5
 - selectivity 84–5
- fluorination 138–9, 138, **140**, 141
 - microflow systems 138–9
 - of organosulfur compounds 139
 - of toluene 139
- free-radical polymerization
189–97
 - conventional 189–90
 - initiation 189
 - polymer chain length 190
 - temperature control 190
 - termination 189
 - viscosity 190
 - emulsion polymerization 191,
192, 192
 - industrial applications 212–18
 - continuous operation 216–17,
217
 - flow uniformity 213–15, 214
 - heat transfer 218
 - microtube reactors 213–18,
214
 - molecular weight
 - distribution 215, 218
 - numbering up 212–13
 - shell and tube
 - microreactor 212, 213
 - temperature control 212, 218
 - living polymerization 190–1
 - active/dormant species
 - equilibrium 190–1
 - molecular weight
 - distribution 191
 - time 191
 - microflow systems 191, 192–6
 - simulation 196–7
 - suspension polymerization
191–2, 192
 - see also* polymerization
- Friedel—Crafts reaction 78–85,
90–2, 92, 154–7
 - disguised chemical selectivity 181
 - heteroaromatic compounds
155–6
 - macrobatch reactor 155–6
 - microflow system 155
 - product selectivity 155
- green chemistry 219–20
 - flash chemistry contribution 220
- Grignard exchange process 208–11
 - flow rate 209, 210
 - heat exchanger 209, 209, 210–11
 - microflow system 210–11, 210,
211
 - micromixer 209–10
 - pressure drop 209–10, 210
 - time scale 209
- Grignard reagents 42, 143–5, 146,
208
 - react with boronic acid
esters 158–60
- halogen—lithium exchange
 - reactions 201, 202–3, 203
- halogen—magnesium exchange
 - reactions 143–5, 208–9
 - in microflow systems 144–5, 145,
146

- o-halophenyllithium 98–9
- Hammond's postulate 89–92
 - electrophilic aromatic substitution 90–2, 91
- heat removal 16, 102
 - in emulsion and suspension polymerization 192
 - in free radical polymerization 190
 - in synthesis reactions 17–18
- heat transfer 93–5, 93, 102
 - conduction 93–4, 93
 - convection 94
 - in microtube reactors 112–13
 - in polymerization reactions 194, 196, 197
 - radiation 94
 - rate 93
 - through reactor wall 93, 94–5
- heating of reactants
 - conventional methods 36–7, 37
 - microwave methods 37, 37
- heteroaromatic compounds, and
 - N*-acyliminium ions 155–6, **156**
- high temperature reactions 33–4
 - aminocarbonylation of
 - halobenzene 33–4, 34
 - at high pressures 33–4
 - microflow systems 33–4
- homogeneous solutions 70, 102
- homopolymers 173
- hydrocarbons, react with oxygen 9
- hydrogen—lithium exchange 206
- I⁺ ion 157–8
- ideal living cationic
 - polymerization 180–1
 - initiation 181, 182
 - mixing 181, 182
 - molecular weight control 182
 - speed 180
- imminium salts 60
- industrial applications 199–222
 - chemicals and drugs
 - production 30, 199
- diarylethene synthesis 201–5
- Grignard exchange process 208–11
- Kolbe—Schmitt synthesis 218
- phenylboronic acid process 218–19
- radical polymerization 212–18
- spiro lactone fragments 206–8
- interdigital multilamination
 - micromixer 115–17
 - flow rate 116–17
 - IMM single mixer 115–17, 116
 - LIGA technology 117
 - principle 115, 116–17, 117
- intermediates
 - decomposition 147–53
 - organolithium reactions 150–3
 - Swern—Moffatt oxidation 147–50
 - instability 102
- iodination
 - of aromatic compounds 157–8, 159
 - diiodination 158
 - microflow system 158
- kinetic stability 9–10
- kinetics 10–12, 69
- Kolbe electrolysis 39
- Kolbe-Schmitt synthesis 218
- lab-on-a-chip 106–7, 107
- living anionic polymerization 180
- living cationic polymerization 178–80
 - chain transfer suppression 178, 180
 - control 178–9
 - equilibrium active/dormant species 178, 179
 - essential requirements 180–1
 - initiation 178–9

- manifold split-and-recombination
 - micromixer 118–20
 - principle 118, 119
 - Toray Hi-mixer 119, 120
 - Yamatate YM-1
 - micromixer 119, 120
- medical treatment 27–30, 31
- methyl methacrylate (MMA)
 - polymerization 96, 195, 212–13
 - pilot plant 216, 216, 217
- microcapillary flow disk (MFD)
 - reactors 113
- microchip reactors 110–12, 111, 112
 - applications 111–12
 - connectors 110–11
 - construction 110
 - mixer 111
- microflow systems 23, 24, 102, 105–35, 223
 - cationic polymerization 184–5, 197
 - block copolymerization 185, 187–8, 188, **188**
 - CF₃SO₃H initiated 187
 - compared with
 - conventional 185–6, 186
 - characteristics 108–10, **109**
 - diarylethene synthesis 202–5, 204, 205
 - Friedel—Crafts alkylation 81–2, 82, **82**
 - Grignard exchange process 210–11, 210, 211
 - at high temperatures 33–4
 - historical aspects 105–8
 - chemical analysis 106–7
 - chemical synthesis 107–8
 - advantages 107, 108
 - approaches 108
 - large scale production 199, 202–5, 207–8
 - microwave reactions 37
 - phase boundary reactions 109
 - polymerization 191, 192–7
 - apparatus 192–3, 193
 - benzyl methacrylate (BMA) 195
 - butyl acrylate (BA) 193–5
 - heat transfer 194, 196, 197
 - methyl methacrylate (MMA) 195
 - molecular weight
 - distribution 193–5, **194**, 196
 - rate 193–4, 194
 - simulation 196–7
 - styrene (St) 195, 196
 - vinyl benzoate (VBz) 195
 - reaction acceleration
 - by controlled mass transfer 166–7, 166, 167
 - high pressure—high temperature 167–9, 168
 - high temperatures 163–5, 164
 - by microwaves 167, 167, 168
 - and radical initiators 165, 165
 - reactive species generation 57–8, 59
 - residence times 109–10
 - spiro lactone fragment 207–8
 - temperature
 - control 95–6, 95, 102
 - high 165
 - timescales 18
 - and unstable intermediates 102, 137, 223
- microfluidic devices 105–35
 - applications **106**
 - interdisciplinary approach 106
 - see also* microreactors
- microheat exchangers 125–6
 - Cross flow 126, 126
 - shell and tube 126, 127
- micromixers 113–25
 - active 114
 - flow rate 116–17, 124, 125
 - mixing efficiency 124–5, 125
 - passive 114–25, **118**

- micromixers (*Continued*)
 - anti-fouling micromixer 122–4
 - chaotic micromixers 121–2, 122
 - concentric multi-layered
 - cylindrical micromixer 123–4, 123
 - interdigital multilamination micromixer 115–17
 - jet micromixer 122–3, 123
 - manifold split-and-recombination micromixer 118–20
 - microsegment-collision micromixer 121, 122
 - SuperFocus micromixer 118
 - T-shaped 115, 120–1, 121
 - triangular micromixer 117–18, 118
 - Y-shaped 115, 115
 - types **114**
- micromixing 78, 85
 - and disguised chemical selectivity 85
 - Friedel—Crafts alkylation 78–85
 - and polymerization 85
- microreactors 1, 110–33
 - amine addition reactions 143
 - for bromination 141
 - catalyst-containing microflow reactor 129–31, 130, 131
 - for chlorination 139–41, 142
 - defined 110
 - electrochemical microflow reactor 128–9, 129
 - falling-film gas/liquid reactors 139, 141
 - for fluorination 138–9, **140**, 141
 - for free-radical polymerization 213–15, 214
 - high-pressure/high temperature 131–3, 132
 - microcapillary flow disk (MFD) 113
 - microchip 110–12
 - microheat exchangers 125–6
 - micromixers 113–25
 - microtube reactors 112–13, 113
 - for nitration 142–3
 - photochemical microflow reactor 126–7, 128
 - microstructured fluidic device *see* microreactors
 - micrototal analysis system (μ TAS) 106–7, 107
 - microtube reactors 112–13, 113
 - construction 112
 - for free-radical polymerization 213–18, 214
 - heat transfer 112–13
 - microwave irradiation 167, 167, 168
 - microwave reactions 36–8
 - mixing 69–87, 102
 - eddies 71
 - fluid dynamics simulation 83–5, **84**, **85**
 - high-dilution method 77, 77
 - and homogeneity 102
 - micromixing 78
 - molecular diffusion 71–3, 102
 - processes 70–1, 70, 71
 - and product selectivity 73–6, 102
 - and reaction temperature 76–7
 - speeds 70, 109
 - molecular activation 33–67
 - chemical activation 41–3
 - electrochemical activation 39–41
 - photochemical activation 38–9
 - thermal activation 33–8
 - flash vacuum pyrolysis 35–6
 - high temperature reactions 33–4
 - microwave reactions 36–8
 - in supercritical and subcritical fluids 34
 - molecular behaviour 223–4

- molecular diffusion 71–3, 102
 - and reaction rate 76, 76
 - size 72, 72
 - and temperature 76–7
 - theory 73
 - time 72, 72, 73, 109
- molecular size 4
- molecular weight distribution
 - in free-radical polymerization 215
 - in polymers 176, 177, 186, 187
- multi-step synthesis 19–20, 20
- neuropeptide Y 206
- nitration 142–3, 153
 - of phenol 143
 - of toluene 142, 142
- nucleophilicity parameters 156–7
- numbering-up 199–200
 - advantages 199–200
 - limitations 200
- obesity 206
- on-demand synthesis 30
- organic cations *see* carbocations
- organic synthesis 137–72
- organolithium compounds 42
 - instability 150
 - reactions 150–3
 - of bromobenzene derivatives 151
 - and temperature 150, 151
- organomagnesium halides *see* Grignard reagents
- organometallic compounds 42–3, 97
- pentafluorobenzene (PFB) 144–5
- peptide synthesis 163–5, 164
- phase boundary reactions 109
- phase-tag approach 25
- phenylboronic acid process 218–19
- photochemical activation 38–9
- photochemical microflow
 - reactor 126–7, 128
 - principles 127
- photochromism 201
- polydispersity index (PDI) 176, 215
- polymer synthesis 173–98
- polymeric by-products 162
- polymerization 173–98
 - addition polymerization 175
 - cation-pool initiated 182–4
 - cationic 176–88, 197
 - chain growth 174–5
 - defined 173
 - free-radical 189–97
 - heat generated 96
 - industrial applications 212–18
 - living cationic 178–80
 - microflow systems 182–8, 192–7
 - compared with conventional 185–6
 - initiated by $\text{CF}_3\text{SO}_3\text{H}$ 187
 - molecular weight distribution 176
 - polycondensation 176
 - step-growth 175–6
- positron emission tomography (PET) 27–30
 - probes 27–30
- potential energy surface 16, 16
- precomplexes 16
- product instability 153–4
 - allylic alcohol dehydration 153–4
 - nitration reactions 153
- product selectivity 73–6, 137, 154
- production volume increase
 - numbering-up 199–200
 - reactor size increase 199
- productivity 20
- quasi-living cationic
 - polymerization 180, 182
- radical cations *see* carbocations
- radical polymerization *see* free-radical polymerization
- radical reactions 165, 165
- reaction control 1, 69–104, 137, 223
- reaction rates 10–12
 - defined 10
 - and energy levels 89–90, 90
 - rate constant (k) 11
 - and temperature 76–7

- reaction times 1, 2, 23
control of reactions 1
mixing of components 70
and molecular size 4
multi-step synthesis 19–20
range 2, 23–4
for single molecules 14
slow 15
- reactive species
accumulation 43–56
cation-pool method 44–56
continuous generation 57–8, 59
- reactor-size increase 199, 200
- residence time
control 97–101, 102
defined 97–8, 97
in microflow systems 109–10
- scaling-up 199, 200
- silyl groups 50, 51
- solid-phase synthesis 25
- solution-phase synthesis 25
- solvation 16
- solvent
as energy sink 16–17, 92–3
as stabilizer 16
- Sonogashira coupling reactions 167–9
- spiro lactone fragments
synthesis 206–8
cis/trans mixtures 207
microflow process 206–8, 207,
208, 208
temperature 206, 207
- stereoselectivity 87
- stopped-flow method 40–1, 41
- styrene (St)
polymerization 195, 196
reacts with *N*-acyliminium
ions 160–2, 161
microflow systems 162
polymeric by-products 160
- supercritical fluids 131–3, 132
- sustainable chemical synthesis 219–20
- Suzuki—Miyaura coupling 37, 38,
166, 167
- Swern—Moffatt oxidation 147–50, 150
intermediates 148
mechanism 148
microflow system 149–50, 149
reaction time 148
temperature 147, 148, 149–50
yields 149
- synthesis reactions 17–18, 20, 24
close to customers 30
heat removal 17–18
molecular scale 17
on-demand 30
unimolecular v. bimolecular 17
- temperature control 87–96
exothermicity 87–9
free-radical polymerization 190,
212, 218
Friedel—Crafts reaction 90–2
Hammond's postulate 89–90
heat transfer 93–5, 93
microflow systems 95–6, 95, 109
measurement 95–6
and polymerization 96
radical initiators
decomposition 95–6, 96
and reaction rate 76–7
and selectivity 88
and solvent 92–3
- thermodynamic equilibria 8–9
- transition state 12, 12, 13
- trifluoroacetic anhydride
(TFAA) 147, 148, 149
- trimethoxybenzene 80–2, 154–5
- truly living cationic polymerization
see ideal living cationic
polymerization
- unimolecular reactions 14
- vinyl benzoate (VBz),
polymerization 195