
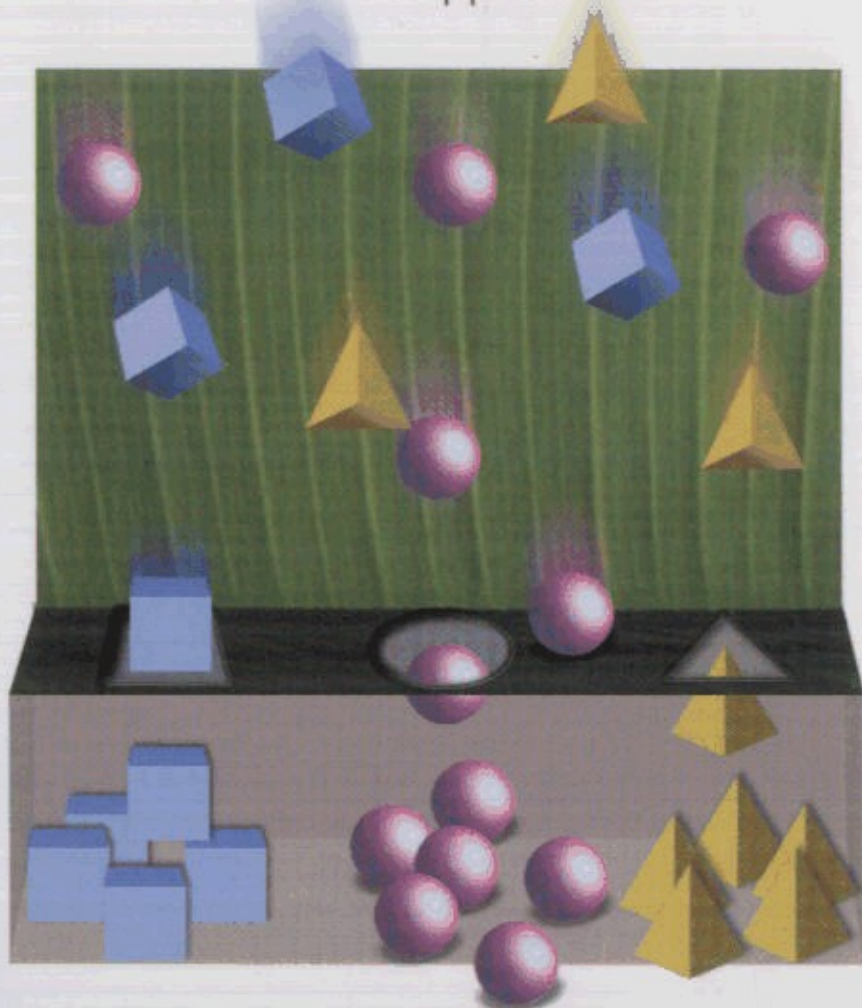


Edited by Carlos A.M. Afonso  
and João G. Crespo

 WILEY-VCH

# Green Separation Processes

Fundamentals and Applications



## Table of Contents

Foreword V

Preface XV

List of Authors XVII

<b>Part 1</b>	<b>Green Chemistry for Sustainable Development</b>	<b>1</b>
<b>1.1</b>	<b>Green Chemistry and Environmentally Friendly Technologies</b>	<b>3</b>
	<i>James H. Clark</i>	
1.1.1	Introduction	3
1.1.2	Objectives for Green Chemistry: The Costs of Waste	4
1.1.3	Green Chemistry	5
1.1.4	Environmentally Friendly Technologies	10
1.1.5	Green Chemistry Metrics	16
	<i>References</i>	18
<b>1.2</b>	<b>Sustainable Development and Regulation</b>	<b>19</b>
	<i>Diana Cook and Kevin Prior</i>	
1.2.1	Introduction	19
1.2.1.1	Sustainable Development and the European Union	20
1.2.1.2	Why Regulation is Required to Achieve Sustainable Development	20
1.2.1.3	Environmental Policy and Innovation	21
1.2.2	Environmental Policy Instruments	22
1.2.2.1	“Command and Control” Regulation	22
1.2.2.2	Government Subsidies	23
1.2.2.3	Alternative Approaches	24
1.2.3	Future Trends and Challenges	26
1.2.4	The Implications for Green Separation Processes	30
1.2.5	Conclusion	30
	<i>References</i>	31

<b>Part 2</b>	<b>New Synthetic Methodologies and the Demand for Adequate Separation Processes</b>	<b>33</b>
<b>2.1</b>	<b>Microreactor Technology for Organic Synthesis</b>	<b>35</b>
	<i>G. Jas, U. Kunz, and D. Schmalz</i>	
2.1.1	Introduction	35
2.1.2	Key Features of Microreactors	36
2.1.3	Applications of Microreactors	38
2.1.3.1	Microreactors in Organic Synthesis	39
2.1.3.2	Applications of MRT in Process Development	41
2.1.3.3	MRT in Industrial Production	42
2.1.4	Microstructured Unit Operations for Workup	44
2.1.5	Industrial Needs Relating to MRT	45
2.1.6	How can Microreactors Contribute to a Greener Chemistry?	47
2.1.7	Conclusions and Outlook	48
	<i>References</i>	<i>50</i>
<b>2.2</b>	<b>Solventless Reactions (SLR)</b>	<b>53</b>
	<i>Rajender S. Varma and Yuhong Ju</i>	
2.2.1	Introduction	53
2.2.2	Solventless (Neat) Reactions (by Mixing or Grinding)	54
2.2.2.1	Solvent-free Robinson Annulation	54
2.2.2.2	Chemoselective, Solvent-free aldol Condensation Reactions	55
2.2.2.3	Knoevenagel Condensation Free of Solvent and Catalyst	56
2.2.2.4	Solventless Oxidation Using the Urea–Hydrogen Peroxide Complex (UHP)	57
2.2.2.5	Expeditious Synthesis of 1-Aryl-4-methyl-1,2,4-triazolo[4,3-a]-quinoxalines	58
2.2.2.6	Solventless Wittig Olefination	59
2.2.3	Solventless Microwave-assisted Reactions	60
2.2.3.1	Microwave-assisted Solventless Synthesis of Heterocycles	60
2.2.3.2	Microwave-assisted Solventless Condensations	62
2.2.3.3	Microwave-assisted Solventless Oxidation	64
2.2.3.4	Amination of Aryl Halides without a Transition Metal Catalyst	64
2.2.3.5	Microwave-accelerated Transformation of Carbonyl Functions to their Thio Analogues	65
2.2.4	Microwave-assisted Solventless Reactions on Solid Supports	66
2.2.4.1	Protection–Deprotection (Cleavage) Reactions	67
2.2.4.2	Condensation Reactions	72
2.2.4.3	Solventless Rearrangement Promoted by MW Irradiation	73
2.2.4.4	Oxidation Reactions – Oxidation of Alcohols and Sulfides	73
2.2.4.5	Reduction Reactions	76
2.2.4.6	Microwave-assisted Synthesis of Heterocyclic Compounds on Solid Supports	78
2.2.5	Miscellaneous Reactions	80

2.2.5.1	Solvent-free Preparation of Ionic Liquids Using Microwaves	80
2.2.5.2	Enzyme-catalyzed Reactions	82
2.2.6	Conclusion	82
	<i>References</i>	83
<b>2.3</b>	<b>Combinatorial Chemistry on Solid Phases</b>	<b>89</b>
	<i>Mazaahir Kidwai and Richa Mohan</i>	
2.3.1	Introduction	89
2.3.2	Theory	90
2.3.3	Combinatorial Chemistry Applications on a Solid Phase (CCSP)	90
2.3.4	Microwave-assisted Solid-phase Synthesis	97
2.3.4.1	Microwave-assisted Combinatorial Synthesis on Solid Phases	98
2.3.4.2	Microwave-assisted Polymer-supported Library Synthesis	98
2.3.4.3	Microwave-assisted Solvent-free Library Synthesis	99
2.3.4.5	Microwave-assisted Parallel Library Synthesis on Planar Supports	100
2.3.5	Conclusion	101
	<i>References</i>	102
<b>Part 3</b>	<b>New Developments in Separation Processes</b>	<b>103</b>
<b>3.1</b>	<b>Overview of “Green” Separation Processes</b>	<b>105</b>
	<i>Richard D. Noble</i>	
3.1.1	Background	105
3.1.2	Pollution Sources	106
3.1.3	Environmental Separations	108
3.1.4	Historical Perspective on Environmental Pollution	110
3.1.5	Unit Operations	112
3.1.6	Separation Mechanisms	113
3.1.7	Equilibrium Processes	115
3.1.8	Rate Processes	116
3.1.9	Countercurrent Operation	117
3.1.10	Productivity and Selectivity	119
3.1.10.1	Equilibrium Processes	119
3.1.10.2	Rate Processes	120
3.1.10.3	Membrane Separation	120
3.1.11	Separating Agents	121
3.1.12	Selection of a Separation Process	124
3.1.13	A Unified View of Separations	125
	Acknowledgement	126
	<i>References</i>	126

<b>3.2</b>	<b>Distillation</b>	<b>127</b>
	<i>Sven Steinigeweg and Jürgen Gmehling</i>	
3.2.1	Introduction	127
3.2.2	Phase Equilibria	128
3.2.2.1	Calculation of Vapor-liquid Equilibria	128
3.2.2.1.1	Using Activity-Coefficient Models	130
3.2.2.1.2	Using Equations of State (EOS) for VLE Calculations	132
3.2.2.1.3	Azeotropy	133
3.2.2.2	Calculation of Distillation Processes	134
3.2.3	Distillation Processes	136
3.2.3.1	Separating Azeotropic Mixtures	136
3.2.3.2	Coupled Columns	139
3.2.3.3	Reactive Distillation	141
3.2.3.3.1	Thermodynamic Properties	144
3.2.3.3.2	Reaction Kinetics and Modeling	145
3.2.3.4	Combination of Distillation with Other Unit Operations	146
3.2.4	Column Internals	148
3.2.4.1	Internals for Conventional Distillation Processes	148
3.2.4.2	Internals for Reactive Distillation Processes	150
3.2.5	Summary	151
	<i>References</i>	<i>153</i>
<b>3.3</b>	<b>Green Enantiomeric Separations by Inclusion Complexation</b>	<b>155</b>
	<i>Fumio Toda</i>	
3.3.1	Introduction	155
3.3.2	Enantiomeric Separations	156
3.3.2.1	Enantiomeric Separation of Hydrocarbons and Their Halogeno Derivatives	156
3.3.2.2	Amines, Amine N-Oxides, Oximes, and Amino Acid Esters	157
3.3.2.3	Alcohols and Cyanohydrins	159
3.3.2.4	Epoxides and Oxaziridines	163
3.3.2.5	Ketones, Esters, Lactones and Lactams	164
3.3.2.6	Sulfoxides, Sulfinates, Sulfoximines, Phosphinates and Phosphine Oxides	170
3.3.3	Green One-Pot Preparative Process for Obtaining Optically Active Compounds by a Combination of Solid-state Reaction and Enantiomeric Separation in a Water Suspension Medium	172
3.3.4	Enantiomeric Separation by Inclusion Complexation in Suspension Media and by Fractional Distillation	175
3.3.5	Enantiomeric Separation Without Using a Chiral Source	177
3.3.5.1	Enantiomeric Separation of rac-7-Bromo-1,4,8-triphenyl-2,3-benzo[3.3.0]octa-2,4,7-trien-6-one	177
3.3.5.2	Enantiomeric Separation by Complexation with Achiral 2,3,6,7,10,11-Hexahydroxy-triphenylene	179

3.3.5.3	Enantiomeric Separation of 2,2'-Dihydroxy-1,1'-binaphthyl by Complexation with Racemic or Achiral Ammonium Salts	180
3.3.6	Conclusions and Perspectives	184
	<i>References</i>	184
<b>3.4</b>	<b>Chromatography: a Non-analytical View</b>	187
	<i>Alirio E. Rodrigues and Mirjana Minceva</i>	
3.4.1	Introduction	187
3.4.2	Perfusion Chromatography	189
3.4.2.1	The Concept of "Augmented Diffusivity by Convection"	191
3.4.2.2	The Efficiency of a Chromatographic Column Measured by its HETP	193
3.4.3	Simulated Moving Bed (SMB) Processes	195
3.4.3.1	The Concept of SMB	195
3.4.3.2	Modeling of SMB	198
3.4.3.3	Design of SMB	201
3.4.3.4	Future Directions in SMB: Multicomponent Separations and SMBR	203
	<i>References</i>	205
<b>3.5</b>	<b>Fluid Extraction</b>	207
3.5.1	Supercritical Fluids	207
	<i>Anna Banet Osuna, Ana Šerbanović, and Manuel Nunes da Ponte</i>	
3.5.1.1	Introduction	207
3.5.1.2	Supercritical Fluids and Clean Separations	208
3.5.1.3	Extraction with Carbon Dioxide	208
3.5.1.4	Fractionation of Liquid Mixtures	210
3.5.1.5	Supercritical, Near-critical and "Expanded" Solvents in Chemical Reactions	210
3.5.1.6	Phase Equilibrium and Reaction-rate Control	212
3.5.1.7	Hydrogenations in CO <sub>2</sub>	213
3.5.1.8	Ionic Liquids and Supercritical Carbon Dioxide	214
3.5.1.9	A Note on Supercritical Water	217
	Acknowledgments	217
	<i>References</i>	218
3.5.2	Fluorinated Solvents	219
	<i>Hiroshi Matsubara and Ilhyong Ryu</i>	
3.5.2.1	Introduction	219
3.5.2.2	Benzotrifluoride (BTF)	221
3.5.2.3	Fluorous Ether F-626	223
3.5.2.4	F-DMF	224
3.5.2.5	FC-72 (Perfluorohexanes)	225
3.5.2.6	Conclusion	227
	<i>References</i>	228

3.5.3	Ionic Liquids: Structure, Properties and Major Applications in Extraction/Reaction Technology	229
	<i>Jairton Dupont</i>	
3.5.3.1	Introduction	229
3.5.3.2	Ionic Liquids: Overview	229
3.5.3.3	Preparation and Some Physico-Chemical Properties of 1,3-Dialkylimidazolium ILs	231
3.5.3.4	Chemical Stability and Toxicity of 1,3-Dialkylimidazolium Ionic Liquids	232
3.5.3.5	“Solvent” Properties and Structure of Imidazolium ILs	234
3.5.3.6	Solubility of Ionic Liquids	238
3.5.3.7	Extraction/Separation Processes Involving Ionic Liquids.	240
3.5.3.8	Multiphase Catalysis Employing Ionic Liquids	242
3.5.3.9	Conclusions and Perspectives	245
	<i>References</i>	245
<b>3.6</b>	<b>Membrane Processes</b>	<b>251</b>
3.6.1	Pressure-driven Membrane Processes	251
	<i>Ivo F.J. Vankelecom and Lieven E.M. Gevers</i>	
3.6.1.1	Introduction	251
3.6.1.2	Fundamentals of the Processes	252
3.6.1.2.1	Microfiltration	252
3.6.1.2.2	Ultrafiltration	253
3.6.1.2.3	Hyperfiltration	253
3.6.1.2.4	Diafiltration	254
3.6.1.3	Main Problems	254
3.6.1.3.1	Introduction	254
3.6.1.3.2	Membrane Fouling	255
3.6.1.3.3	Concentration Polarization	256
3.6.1.3.4	Membrane wetting	257
3.6.1.4	Membrane Materials and Preparation	257
3.6.1.4.1	Introduction	257
3.6.1.4.2	Sintering	257
3.6.1.4.3	Stretching	257
3.6.1.4.4	Track-etching	258
3.6.1.4.5	Anodic Oxidation	258
3.6.1.4.6	Phase Inversion	259
3.6.1.4.7	Interfacial Polymerization	260
3.6.1.4.8	Coating	261
3.6.1.4.9	Surface Modification of Membranes	261
3.6.1.4.10	Ceramic Membranes	262
3.6.1.4.11	Supports	262
3.6.1.5	Applications in Organic Media	263
3.6.1.5.1	Introduction	263
3.6.1.5.2	Catalysis	263

3.6.1.5.3	Food Industry	264
3.6.1.5.4	Petrochemical Industry	265
3.6.1.5.5	Fine Chemical Synthesis	267
3.6.1.6	Current Market	267
3.6.1.7	Perspectives	268
	Acknowledgements	269
	References	269
3.6.2	Vapor Permeation and Pervaporation	271
	<i>Thomas Schäfer and João G. Crespo</i>	
3.6.2.1	Introduction	271
3.6.2.2	Process Fundamentals	271
3.6.2.2.1	Principal Mass-Transport Phenomena	271
3.6.2.2.2	Vapor Permeation/Pervaporation Separation Characterization	273
3.6.2.3	Non-ideal Phenomena	276
3.6.2.3.1	Membrane Swelling and Flux Coupling	276
3.6.2.3.2	Concentration Polarization	278
3.6.2.4	Technical Aspects of Vapor Permeation/Pervaporation	280
3.6.2.4.1	Feed-Fluid Dynamic Conditions	282
3.6.2.4.2	Downstream Pressure and Condensation Strategy	282
3.6.2.5	Implementation of Vapor Permeation/Pervaporation in Chemical Processes	283
3.6.2.5.1	Hybrid Processes Involving Evaporation/Distillation	284
3.6.2.5.2	Hybrid Processes Involving (Bio)catalytic Reactors	285
3.6.2.5.3	Other Relevant Separation Applications	286
3.6.2.5.4	Analytical Applications	287
3.6.2.6	Perspectives	287
	References	289
<b>3.7</b>	<b>Nanostructures in Separation</b>	<b>291</b>
3.7.1	Functionalized Magnetic Particles	291
	<i>Costas Tsouris, Jeremy Noonan, Tung-yu Ying, Ching-Ju Chin, and Sotira Yiacoymi</i>	
3.7.1.1	Introduction	291
3.7.1.2	Examples of Functionalized Magnetic Particles in Separations	296
3.7.1.3	Theory of Magnetic Separations	298
3.7.1.4	High-gradient Magnetic Separation Modeling	298
	References	303
3.7.2	Dendrimers	304
	<i>Karsten Gloe, Bianca Antonioli, Kerstin Gloe, and Holger Stephan</i>	
3.7.2.1	Introduction	304
3.7.2.2	Dendrimers – Promising Reagents for Separation Processes	305
3.7.2.3	Examples of Dendrimers in Separation Processes	313
3.7.2.4	Conclusions and Future Prospects	319



Acknowledgements 320

*References* 321

**3.8 Separations Using Superheated Water 323**

*Anthony A. Clifford*

3.8.1 Introduction 323

3.8.1.1 Polarity 324

3.8.1.2 Solubilities of Organic Compounds 325

3.8.1.3 Laboratory-scale Extraction 326

3.8.1.4 Pilot-plant Equipment 326

3.8.1.5 Energy Considerations 327

3.8.2 Extraction and Degradation Studies 328

3.8.2.1 Extraction From Solids and Semi-solids Other Than Biomass 329

3.8.2.2 Extraction with Simultaneous Degradation 330

3.8.2.3 Pilot-scale Studies of Decontamination 330

3.8.3 Extraction of Biomass 331

3.8.3.1 Laboratory-scale Extractions 331

3.8.3.2 Extraction with Reaction 334

3.8.3.3 Process Development 335

3.8.4 Extraction of Liquids 336

3.8.5 Chromatography 336

*References* 337

**Part 4 Concluding Remarks 341**

**Concluding Remarks 343**

*Carlos A. M. Afonso and João G. Crespo*

**Index 345**