

Contents

Preface V

1	Introduction to Enzyme Technology	1
1.1	Introduction	1
1.1.1	What are Biocatalysts?	2
1.2	Goals and Potential of Biotechnological Production Processes	2
1.3	Historical Highlights of Enzyme Technology/Applied Biocatalysis	6
1.3.1	Early Developments	6
1.3.2	Scientific Progress Since 1890: The Biochemical Paradigm; Growing Success in Application	8
1.3.3	Developments Since 1950	11
1.4	Biotechnological Processes: The Use of Isolated or Intracellular Enzymes as Biocatalysts	14
1.5	Advantages and Disadvantages of Enzyme-Based Production Processes	15
1.6	Goals, and Essential System Properties for New or Improved Enzyme Processes	19
1.6.1	Goals	19
1.6.2	Essential System Properties for Rational Design of an Enzyme Process	19
1.6.3	Current Use and Potential of Enzyme Technology	23
1.7	Exercises	24
	<i>Literature</i>	25
2	Basics of Enzymes as Biocatalysts	27
2.1	Introduction	29
2.2	Enzyme Classification	29
2.3	Enzyme Synthesis and Structure	31
2.4	Enzyme Function and its General Mechanism	34
2.5	Free Energy Changes and the Specificity of Enzyme-Catalyzed Reactions	40

2.6	Equilibrium- and Kinetically Controlled Reactions Catalyzed by Enzymes	42
2.7	Kinetics of Enzyme-Catalyzed Reactions	46
2.7.1	Quantitative Relations for Kinetic Characteristics and Selectivities of Enzyme-Catalyzed Reactions	47
2.7.1.1	Turnover Number (k_{cat}) and Michaelis–Menten Constant (K_m)	47
2.7.1.2	Stereoselectivities for Equilibrium- and Kinetically Controlled Reactions	53
2.7.2	Dependency of k_{cat} , K_m and Selectivities on pH, Temperature, Inhibitors, Activators and Ionic Strength in Aqueous Solutions	57
2.7.2.1	pH Dependency	57
2.7.2.2	Temperature Dependency	59
2.7.2.3	Binding of Activator and Inhibitor Molecules	61
2.7.2.4	Influence of Ionic Strength	63
2.8	End-points of Enzyme Processes and Amount of Enzyme Required to Reach the Endpoint in a Given Time	65
2.8.1	Temperature-Dependency of the Product Yield	67
2.8.2	pH-Dependency of the Yield at the End-point	68
2.8.3	End-points for Kinetic Racemate Resolutions	70
2.9	Enzyme-catalyzed Processes with Slightly Soluble Products and Substrates	71
2.9.1	Enzyme-catalyzed Processes in Aqueous Suspensions	72
2.9.1.1	Changes in Rates, k_{cat} , K_m , and Selectivities in these Systems Compared with Homogeneous Aqueous Solutions	73
2.9.2	Enzyme-catalyzed Processes in Non-conventional Solvents Where Products and Substrates Are Dissolved	74
2.9.2.1	Changes in Rates, k_{cat} , K_m , and Selectivities in These Systems Compared with Homogeneous Aqueous Solutions	77
2.10	Stability, Denaturation, and Renaturation of Enzymes	78
2.11	Better Enzymes by Natural Evolution, <i>in vitro</i> Evolution, or Rational Enzyme Engineering	80
2.11.1	Changes in Enzyme Properties by Natural Evolution	83
2.11.2	Methods to Improve the Properties of Enzymes by <i>in vitro</i> Evolution	87
2.11.2.1	Methods to Create Mutant Libraries	88
2.11.2.2	Assay Systems	91
2.11.3	Rational Enzyme Engineering	97
2.11.4	New Enzymes by Biosynthesis (Catalytic Antibodies) or Chemical Synthesis (Synzymes)	100
2.12	Exercises	100
	Literature	104

3	Enzymes in Organic Chemistry	109
3.1	Introduction	109
3.1.1	Kinetic Resolution or Asymmetric Synthesis	110
3.2	Examples	111
3.2.1	Oxidoreductases (EC 1)	111
3.2.1.1	Dehydrogenases (EC 1.1.1-, EC 1.2.1-, EC 1.4.1-)	112
3.2.1.2	Oxygenases	116
3.2.1.3	Peroxidases (e.g., EC 1.11.1.10)	126
3.2.2	Hydrolases (EC 3.1)	127
3.2.2.1	Lipases (EC 3.1.1.3)	127
3.2.2.2	Esterases (EC 3.1.1.1)	134
3.2.2.3	Peptidases, Acylases, and Amidases	138
3.2.2.4	Epoxide Hydrolases (EC 3.3.2.3)	141
3.2.2.5	Nitrilases (EC 3.5.5.1)	146
3.2.2.6	Hydantoinases (EC 3.5.2.-)	150
3.2.3	Lyases (EC 4)	152
3.2.3.1	Hydroxynitrile Lyases (EC 4.1.2.-)	152
3.2.3.2	Aldolases (EC 4.1.2.-; 4.1.3.-)	157
3.2.4	Isomerases (EC 5)	161
3.3	Exercises	163
	<i>Literature</i>	164
4	Enzyme Production and Purification	171
4.1	Introduction	172
4.2	Enzyme Sources	173
4.2.1	Animal and Plant Tissues	173
4.2.2	Wild-type Microorganisms	175
4.3	Improving Enzyme Yield	177
4.3.1	Processes that Influence Enzyme Yield	177
4.4	Increasing the Yield of Periplasmic and Extracellular Enzymes	180
4.4.1	Penicillin Amidase	180
4.4.2	Lipase	184
4.5	Downstream Processing of Enzymes	186
4.5.1	Technical Enzymes	189
4.5.2	Enzymes for Therapy and Diagnostics	191
4.6	Exercises	192
	<i>Literature</i>	194
5	Application of Enzymes in Solution: Soluble Enzymes and Enzyme Systems	197
5.1	Introduction and Areas of Application	198
5.1.1	The Impact of Genetic Engineering	200
5.1.2	Medium Design	201
5.1.3	Safety Aspects	202

5.2	Space-Time-Yield and Productivity	203
5.3	Examples for the Application of Enzymes in Solution	208
5.3.1	Survey	208
5.3.1.1	Food Applications	211
5.3.1.2	Textile Applications	211
5.3.2	Starch Processing	212
5.3.2.1	Mechanism	214
5.3.2.2	Process Steps	218
5.3.3	Further Examples and Perspectives	220
5.3.3.1	Detergents	220
5.3.3.2	Food Processing	222
5.4	Membrane Systems and Processes	227
5.5	Exercises	234
5.5.1	Exercise 1: Production of Invert Sugar by Invertase	234
5.5.2	Exercise 2: Calculation of Enzyme Inactivation under Different Conditions	236
5.5.3	Exercise 3: Hydrolysis of Penicillin with Penicillin Amidase	237
	<i>Literature</i>	238
6	Immobilization of Enzymes (Including Applications)	243
6.1	Principles	244
6.1.1	Parameters of Immobilization	247
6.2	Carriers	248
6.2.1	Inorganic Carriers	252
6.2.2	Polysaccharides	252
6.2.3	Synthetic Polymers	254
6.3	Binding Methods	258
6.3.1	Adsorption	258
6.3.2	Covalent Binding	259
6.4	Examples: Application of Immobilized Enzymes	262
6.4.1	Hydrolysis and Modification of Carbohydrates	263
6.4.2	Hydrolysis and Synthesis of Penicillins and Cephalosporins	271
6.4.3	Further Processes	273
6.4.3.1	Some Further Principles for Amino Acid Synthesis	274
6.5	Exercises	275
6.5.1	Immobilization of Enzymes on Ion Exchangers	275
	<i>Literature</i>	279
7	Immobilization of Microorganisms and Cells	283
7.1	Introduction	283
7.1.1	Fundamental Aspects	285
7.2	Immobilization by Aggregation/Flocculation	287
7.3	Immobilization by Entrapment	291
7.3.1	Entrapment in Polymeric Networks	291

7.3.2	Entrapment in Ionotropic Gels	293
7.3.2.1	Principle	293
7.3.2.2	Examples	296
7.4	Adsorption	301
7.5	Adhesion	302
7.5.1	Basic Considerations	303
7.5.2	Applications	309
7.5.2.1	Anaerobic Wastewater Treatment	309
7.5.2.2	Nitrogen Elimination (Nitrification and Denitrification)	317
7.5.2.3	Exhaust Gas Purification	318
7.6	Outlook: Designed Cells	321
7.7	Exercises	325
7.7.1	Entrapment of Yeast in Calcium Alginate for Ethanol Production	325
7.7.2	Characterization of an Anaerobic Fluidized-Bed Reactor	327
	<i>Literature</i>	328
8	Characterization of Immobilized Biocatalysts	333
8.1	Introduction	334
8.2	Factors Influencing the Space-Time Yield of Immobilized Biocatalysts	334
8.3	Effectiveness Factors for Immobilized Biocatalysts	336
8.4	Mass Transfer and Reaction	338
8.4.1	Maximal Reaction Rate of Immobilized Biocatalysts as Function of Particle Radius	338
8.4.2	Calculation of Effectiveness Factors and Concentration Profiles Inside and Outside the Particles	340
8.5	Space-Time Yields and Effectiveness Factors for Different Reactors	343
8.5.1	Continuous Stirred-Tank Reactor	344
8.5.3	Comparison of CST and PB Reactors	346
8.6	Determination of Essential Properties of Immobilized Biocatalysts	347
8.6.1	Physico-chemical Properties	347
8.6.2	Kinetic Characterization of Immobilized Biocatalysts; Influence of Support Properties on the Nano- and Micrometer Level in Aqueous and other Systems	349
8.6.2.1	Determination of $V_{\max}$ and k_{cat}	351
8.6.2.2	K_m and K_i	354
8.6.2.3	Selectivities	355
8.6.2.4	Determinations of Effectiveness Factors	356
8.6.3	Productivity and Stability under Process Conditions	356
8.7	Comparison of Calculated and Experimental Data for Immobilized Biocatalysts	357

8.8	Application of Immobilized Biocatalysts for Enzyme Processes in Aqueous Suspensions	359
8.9	Improving the Performance of Immobilized Biocatalysts	362
8.10	Exercises	363
	<i>Literature</i>	365
9	Reactors and Process Technology	369
9.1	Types of Reactors	371
9.1.1	Basic Types and Mass Balances	371
9.1.2	Further Reactor Types and Configurations: Application Examples	376
9.2	Case Study 1: The Enzymatic Production of 7-ACA from Cephalosporin C	381
9.2.1	Enzyme Processes in the Production of β -Lactam Antibiotics	381
9.2.2	Overall Process for the Production of 7-ACA	384
9.2.3	Conversion of Cephalosporin C to 7-ACA	385
9.2.4	Reaction Characterization and Identification of Constraints	386
9.2.4.1	Enzymatic Deamination and Chemical Decarboxylation	386
9.2.4.2	Hydrolysis of Glu-7-ACA	386
9.2.5	Enzyme Characterization and Identification of Constraints	388
9.2.5.1	(R)-Amino Acid Oxidase	388
9.2.5.2	Glutaryl Amidase (also named Acylase)	388
9.2.6	Evaluation of Process Options	389
9.2.6.1	Process Windows	389
9.2.6.2	Suitable Reactors and pH-controlling Buffers	389
9.2.6.3	Reaction Endpoint and Immobilized Enzyme Requirement for Minimum Space-Time Yield	391
9.3	Residence Time Distribution, Mixing, Pressure Drop and Mass Transfer in Reactors	392
9.3.1	Scale-up, Dimensionless Numbers	392
9.3.2	Residence Time Distribution	393
9.3.3	Mixing in Stirred-Tank Reactors	397
9.3.4	Mass Transfer in Reactors	402
9.3.5	Pressure Drop and Fluidization in Tubular Reactors	403
9.4	Process Technology	404
9.4.1	Survey	404
9.4.2	Case Study 2: The Manufacture of Glucose-Fructose Syrup	406
9.4.3	Reactor Instrumentation	410
9.4.4	Outlook: Perspectives for Integrated Process Engineering	412
9.5	Exercises	413
9.5.1	Exercises Relating to Case Study 9.2	413
9.5.2	Exercises Relating to Mixing and Shear	413
	<i>Literature</i>	414

Appendix I**The World of Biotechnology Information:****Eight Points for Reflecting on Your Information Behavior** 419

- 1 Thinking About Your Information Behavior 419
- 2 Playing with Databases and Search Terms 420
- 3 Tutorials, Subject Gateways and Literature Guides 420
- 4 Using Your Local Library 421
- 5 Using Encyclopedias 421
- 6 Searching Journal Articles, Patents, and Data 421
- 7 After Searching: Evaluating and Processing Information 425
- 8 Information and the World 426
 - Literature* 426

Appendix II**Symbols** 427**Subject Index** 431