

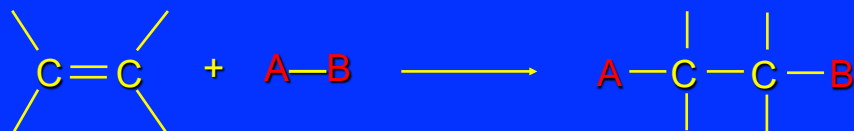
## Chapter 6

### Reactions of Alkenes: Addition Reactions

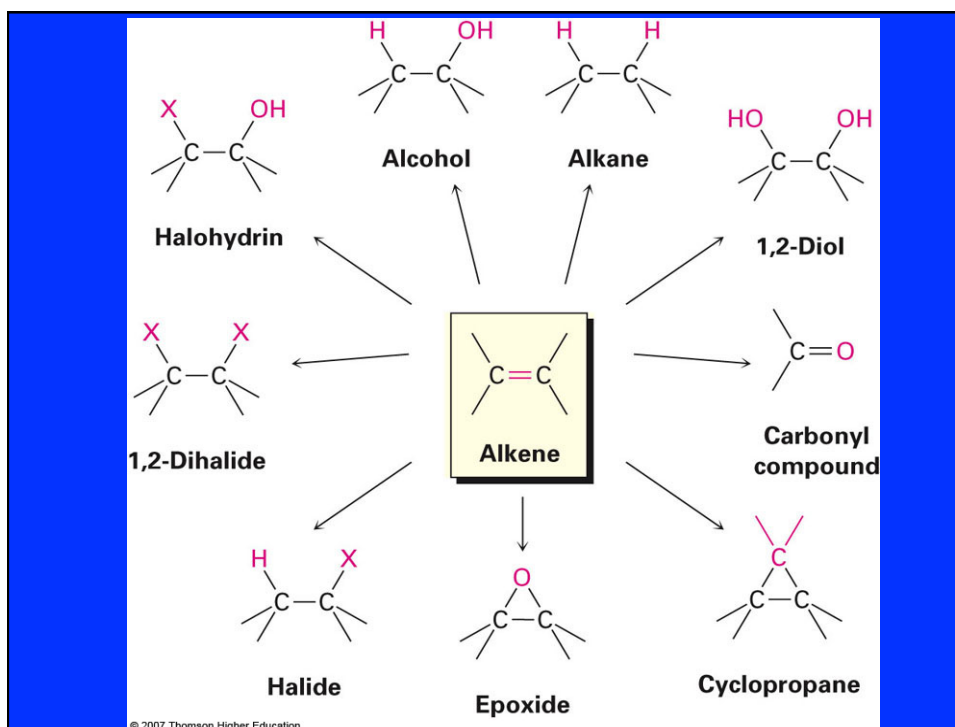
6-1

#### Reactions of Alkenes

The characteristic reaction of alkenes  
is addition to the double bond.

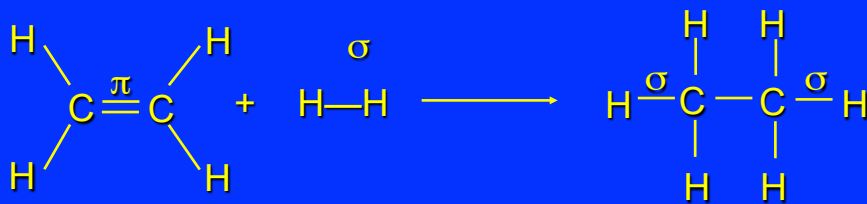


6-2



## Hydrogenation of Alkenes

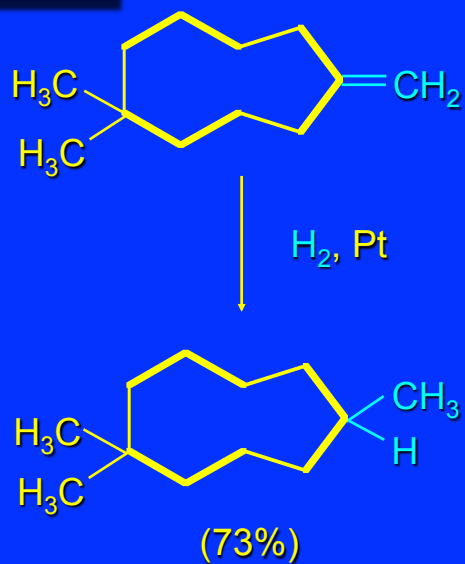
### Hydrogenation of ethylene



exothermic  $\Delta H^\circ = -136 \text{ kJ/mol}$

catalyzed by finely divided Pt, Pd, Rh, Ni

**Example**



6-5

**Problem 6.1**

What three alkenes yield 2-methylbutane on catalytic hydrogenation?



6-6

### Problem 6.1

What three alkenes yield 2-methylbutane on catalytic hydrogenation?

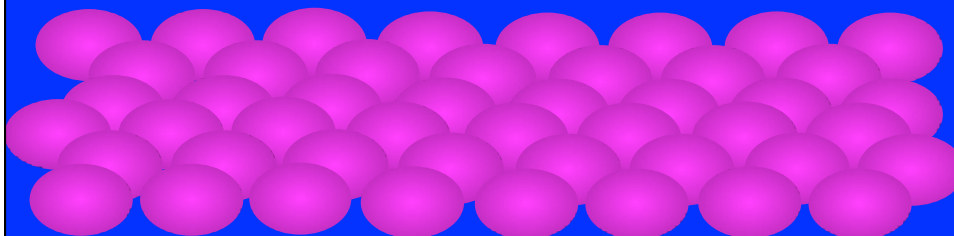
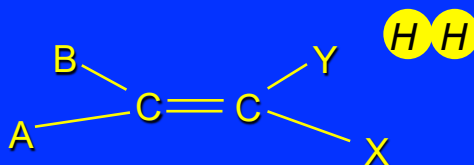


$\text{H}_2, \text{Pt}$



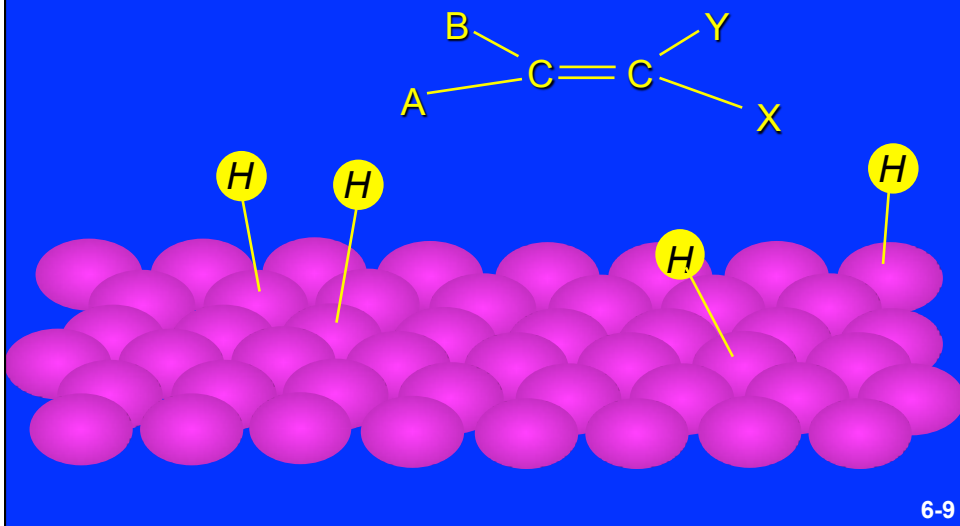
6-7

### Mechanism of catalytic hydrogenation. Figure 6.1



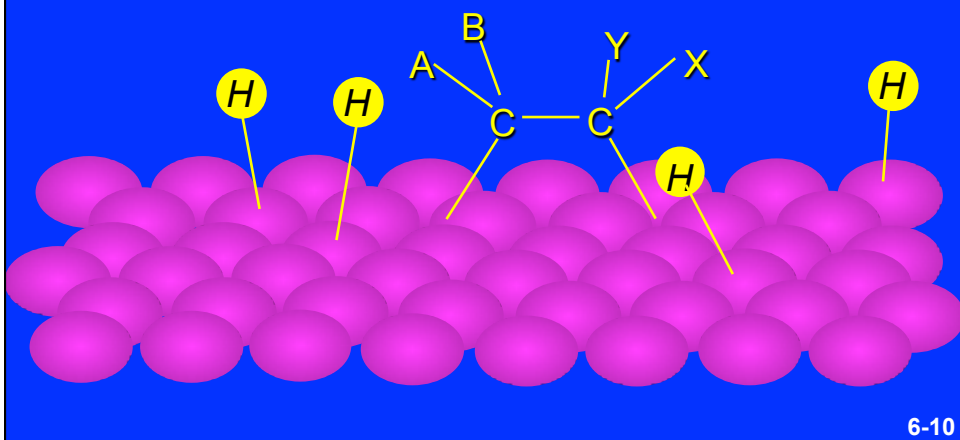
6-8

Mechanism of catalytic hydrogenation.  
Figure 6.1



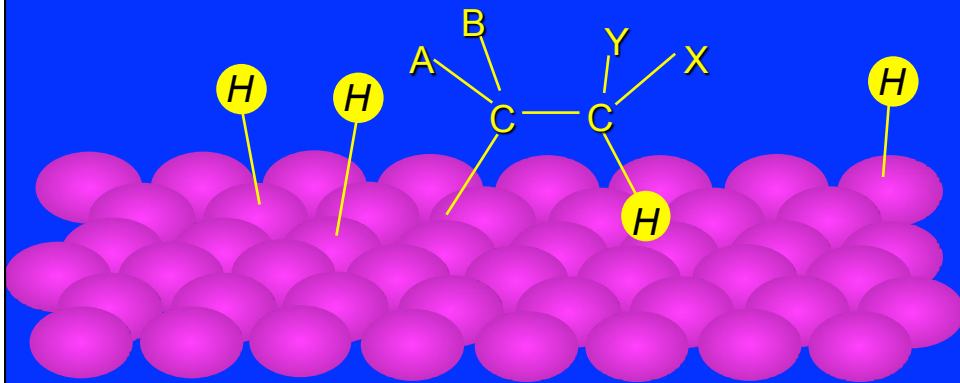
6-9

Mechanism of catalytic hydrogenation.  
Figure 6.1



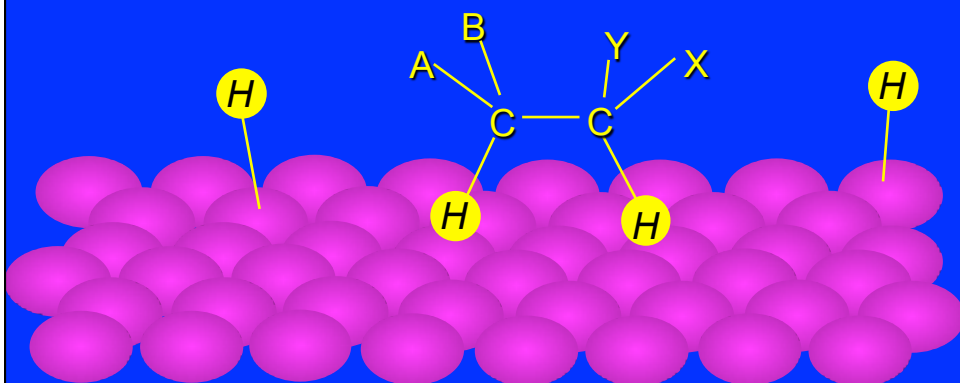
6-10

*Mechanism of catalytic hydrogenation.  
Figure 6.1*



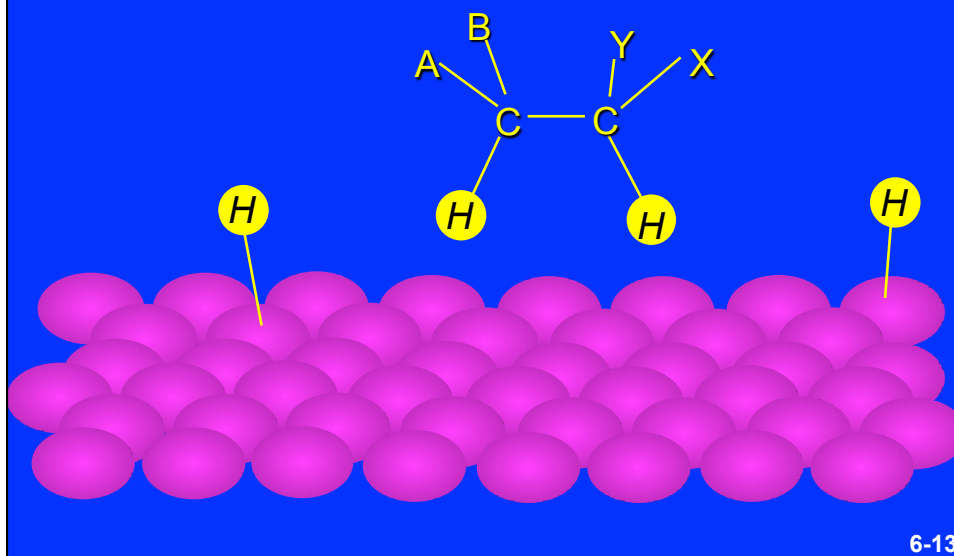
6-11

*Mechanism of catalytic hydrogenation.  
Figure 6.1*



6-12

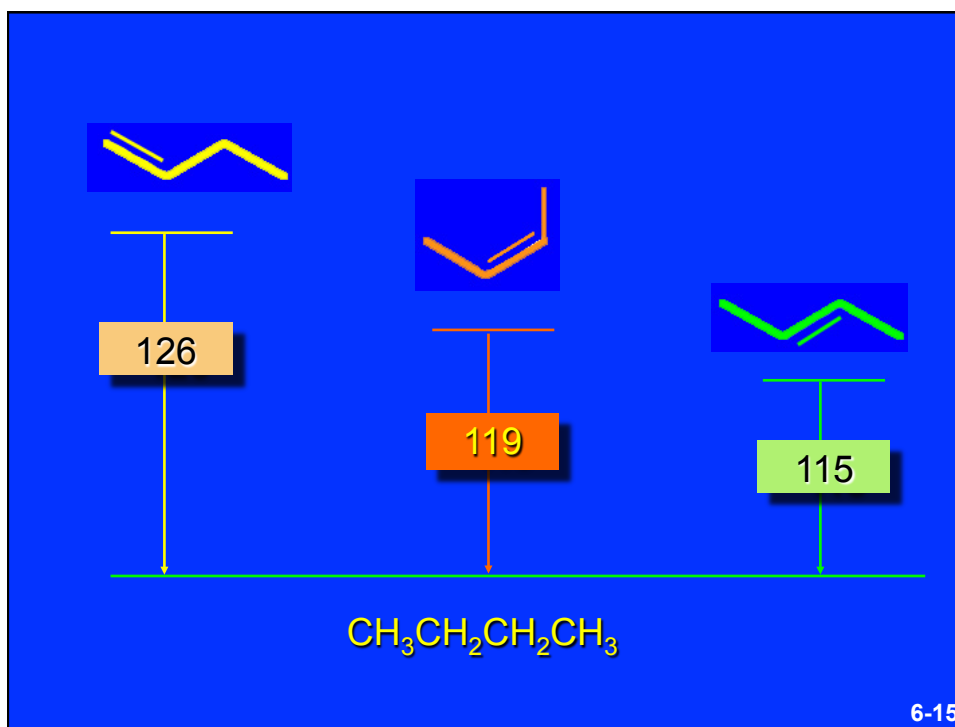
*Mechanism of catalytic hydrogenation.  
Figure 6.1*



## Heats of Hydrogenation

can be used to measure relative stability of isomeric alkenes

correlation with structure is same as when heats of combustion are measured



6-15

### Heats of Hydrogenation (kJ/mol)

Ethylene	136
Monosubstituted	125-126
<i>cis</i> -Disubstituted	117-119
<i>trans</i> -Disubstituted	114-115
Terminally disubstituted	116-117
Trisubstituted	112
Tetrasubstituted	110

6-16



### Problem 6.2

Match each alkene of Problem 6.1 with its correct heat of hydrogenation.

126 kJ/mol

118 kJ/mol

112 kJ/mol

6-17

### Problem 6.2

Match each alkene of Problem 6.1 with its correct heat of hydrogenation.

126 kJ/mol



highest heat of hydrogenation;  
least stable isomer

118 kJ/mol



112 kJ/mol



lowest heat of hydrogenation;  
most stable isomer

6-18

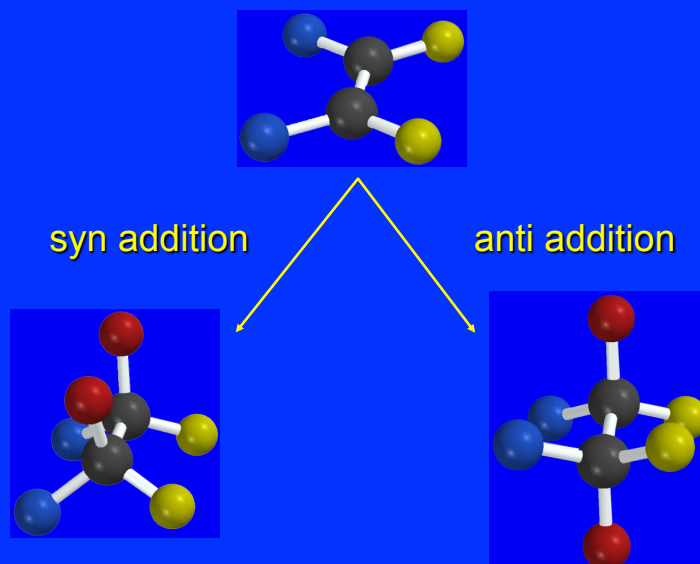
## Stereochemistry of Alkene Hydrogenation

*Two spatial (stereochemical) aspects of alkene hydrogenation:*

- syn addition of both H atoms to double bond
- hydrogenation is stereoselective, corresponding to addition to less crowded face of double bond

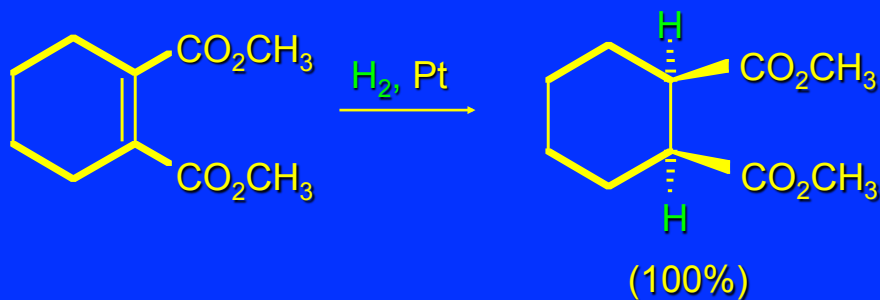
6-19

### syn-Addition versus anti-Addition



6-20

### Example of syn-Addition

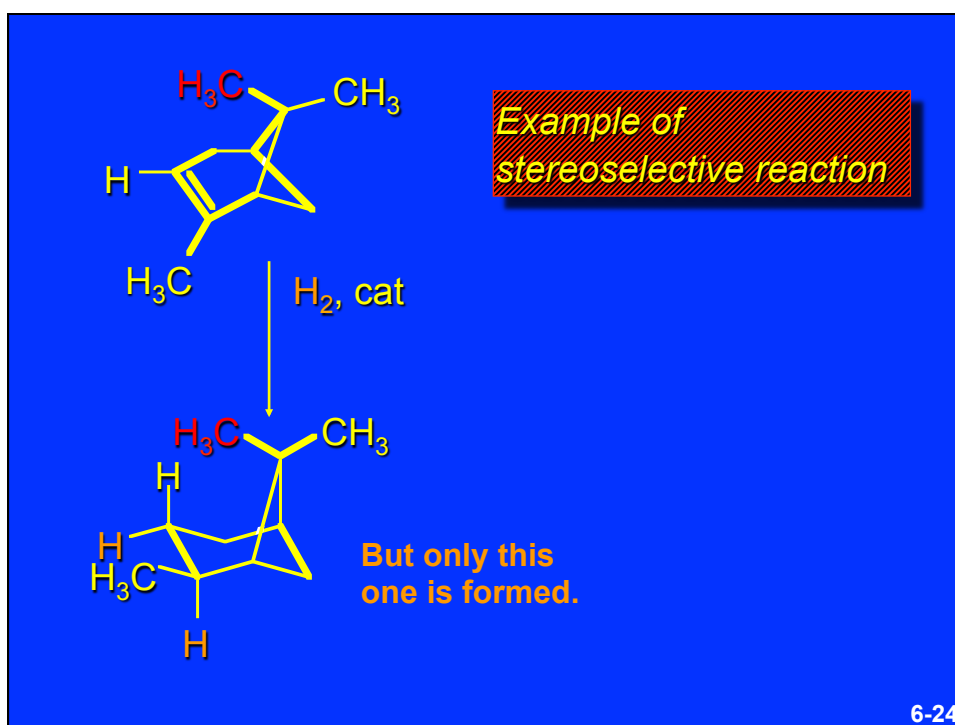
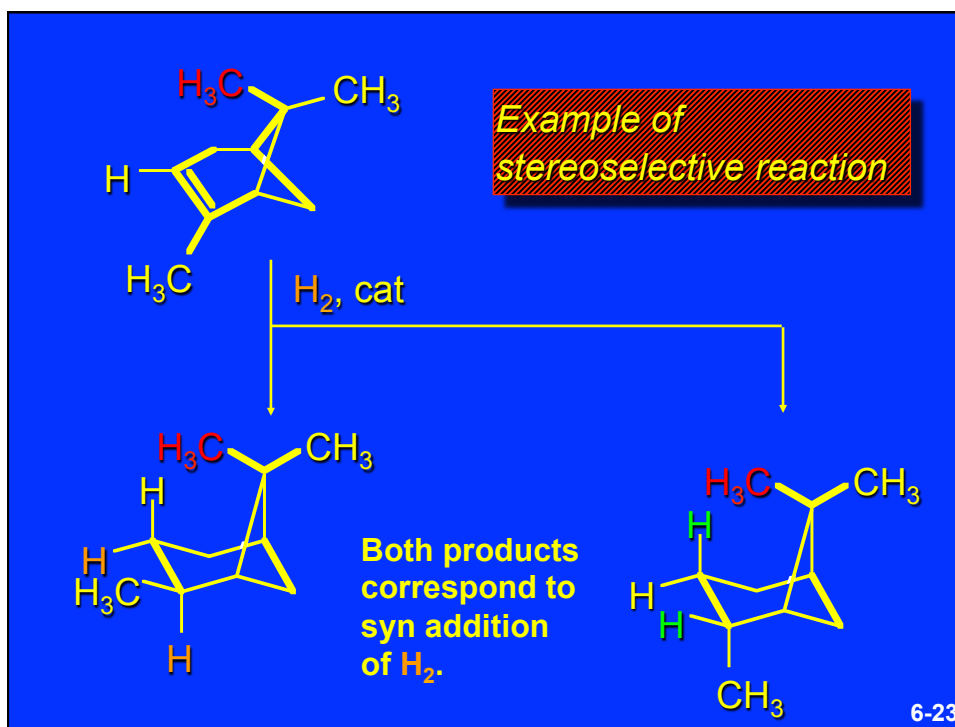


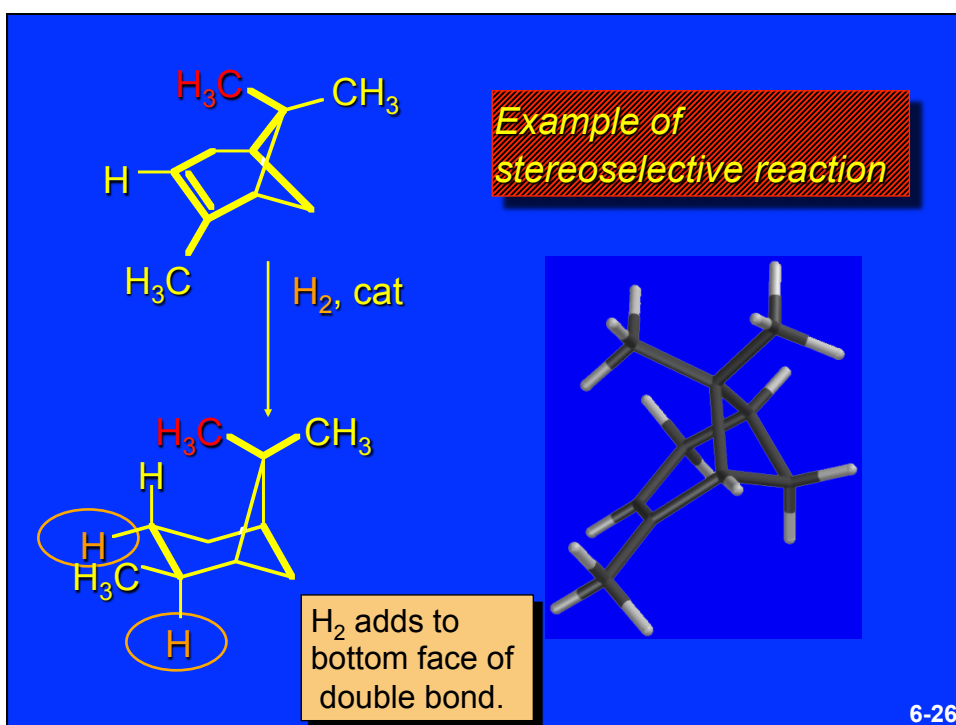
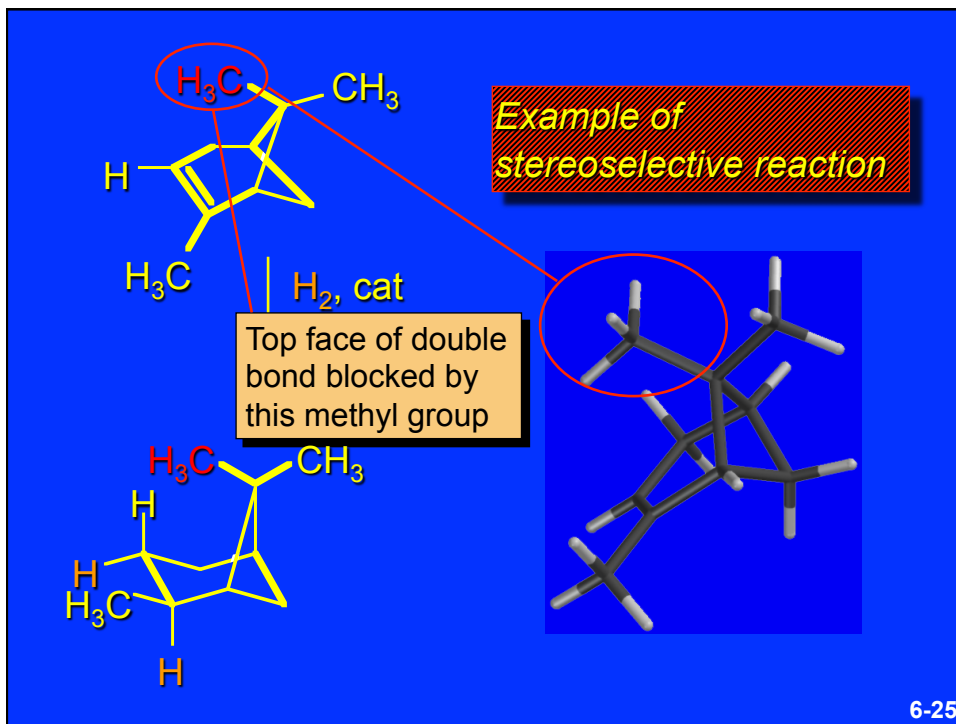
6-21

### Stereoselectivity

A reaction in which a single starting material can give two or more stereoisomeric products but yields one of them in greater amounts than the other (or even to the exclusion of the other) is said to be **stereoselective**.

6-22

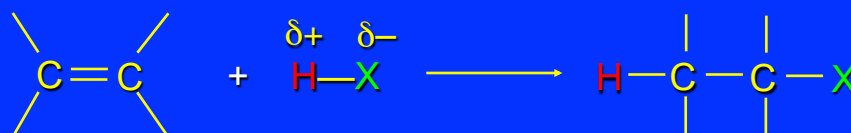




## Electrophilic Addition of Hydrogen Halides to Alkenes

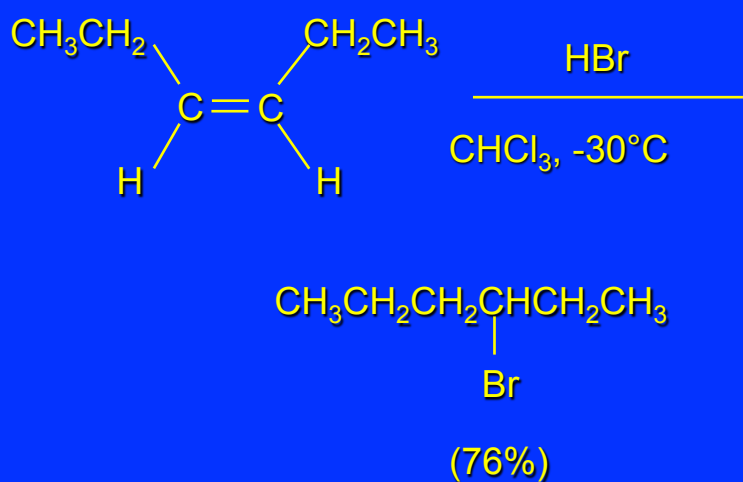


When EY is a hydrogen halide



6-27

### Example



6-28

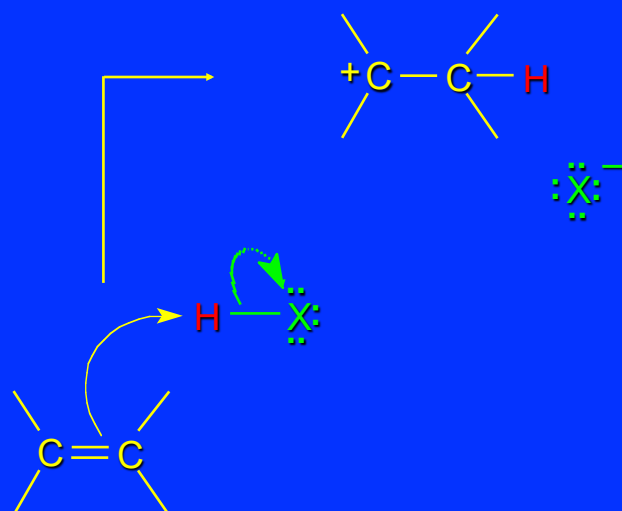
## Mechanism

Electrophilic addition of hydrogen halides to alkenes proceeds by rate-determining formation of a carbocation intermediate.

Electrons flow from the  $\pi$  system of the alkene (electron rich) toward the positively polarized proton of the hydrogen halide.

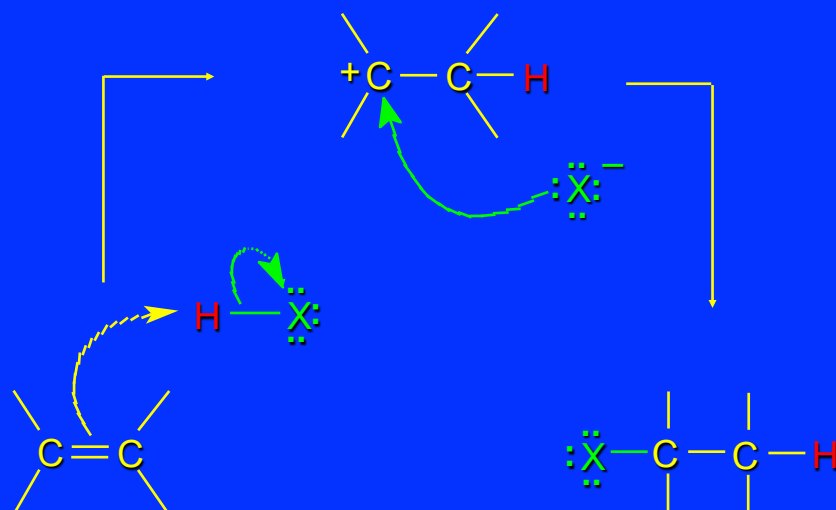
6-29

## Mechanism



6-30

### Mechanism



6-31

## Regioselectivity of Hydrogen Halide Addition: Markovnikov's Rule

When an unsymmetrically substituted alkene reacts with a hydrogen halide, **the hydrogen adds to the carbon that has the greater number of hydrogen substituents**, and the halogen adds to the carbon that has the fewer hydrogen substituents.

6-32



### Markovnikov's Rule



*Example 1*

6-33

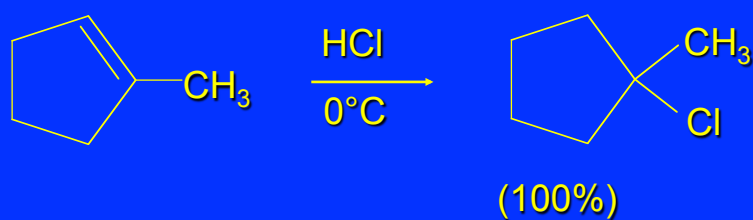
### Markovnikov's Rule



*Example 2*

6-34

## Markovnikov's Rule



*Example 3*

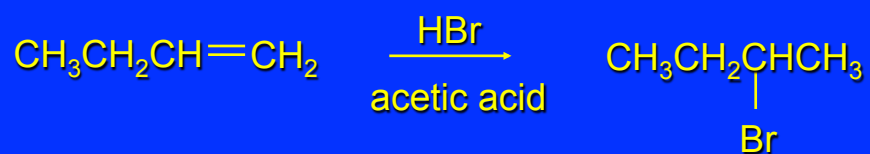
6-35

## Mechanistic Basis for Markovnikov's Rule

Protonation of double bond occurs in direction that gives more stable of two possible carbocations.

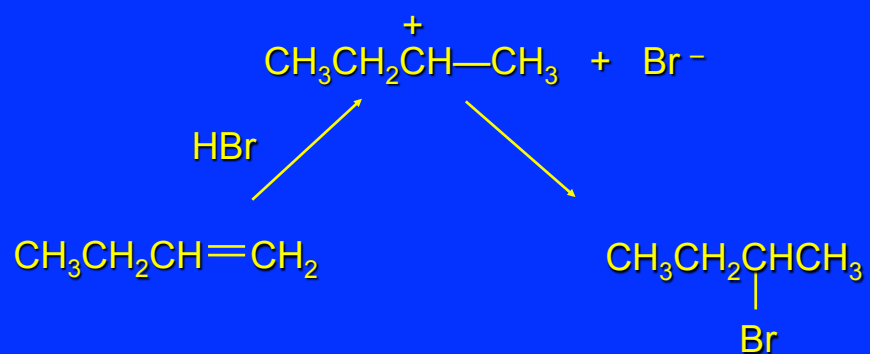
6-36

Mechanistic Basis for Markovnikov's Rule:  
Example 1



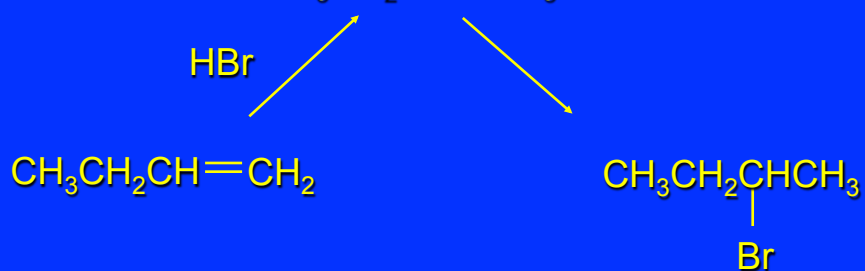
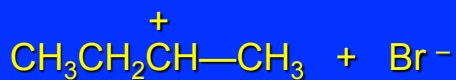
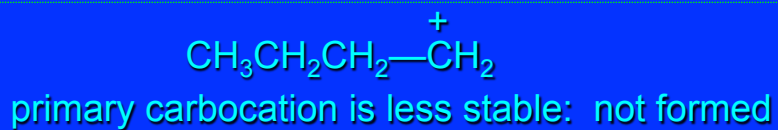
6-37

Mechanistic Basis for Markovnikov's Rule:  
Example 1



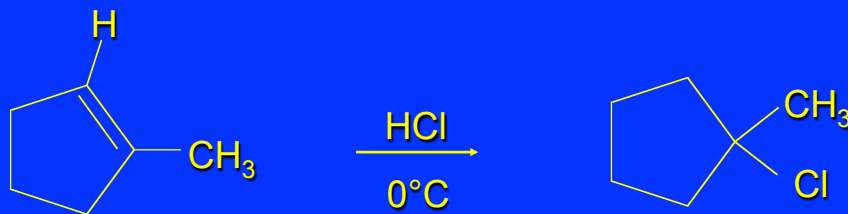
6-38

Mechanistic Basis for Markovnikov's Rule:  
Example 1



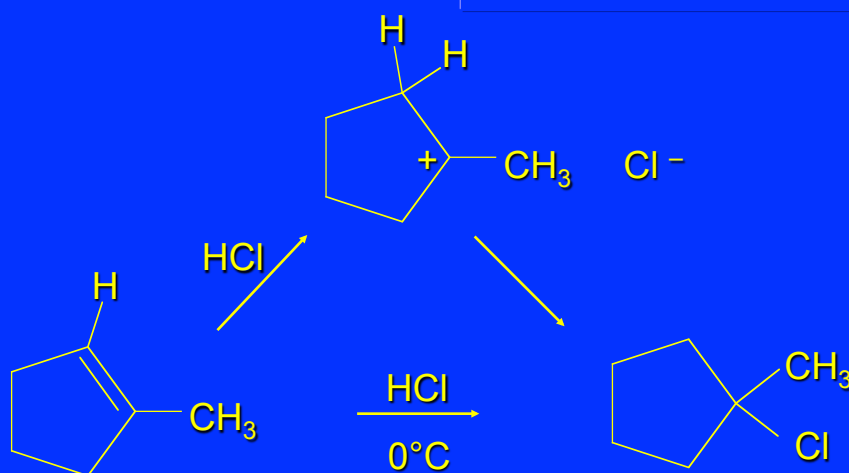
6-39

Mechanistic Basis for  
Markovnikov's Rule:  
Example 3



6-40

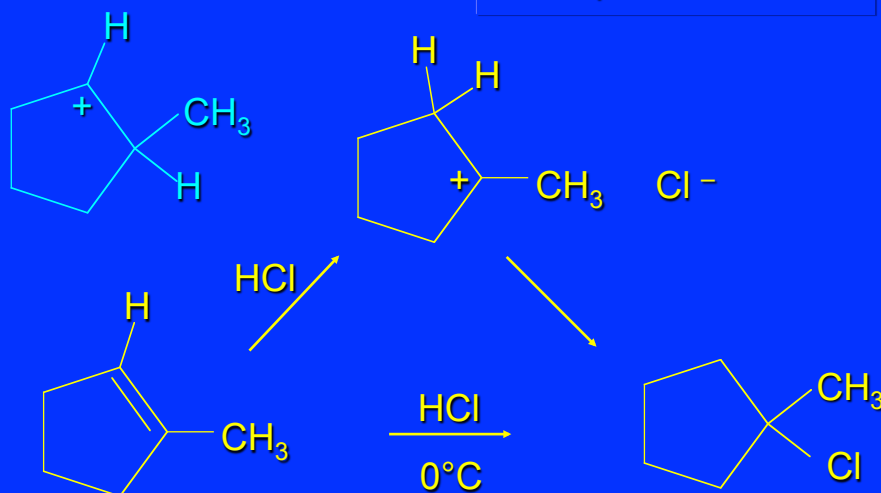
Mechanistic Basis for  
Markovnikov's Rule:  
Example 3



6-41

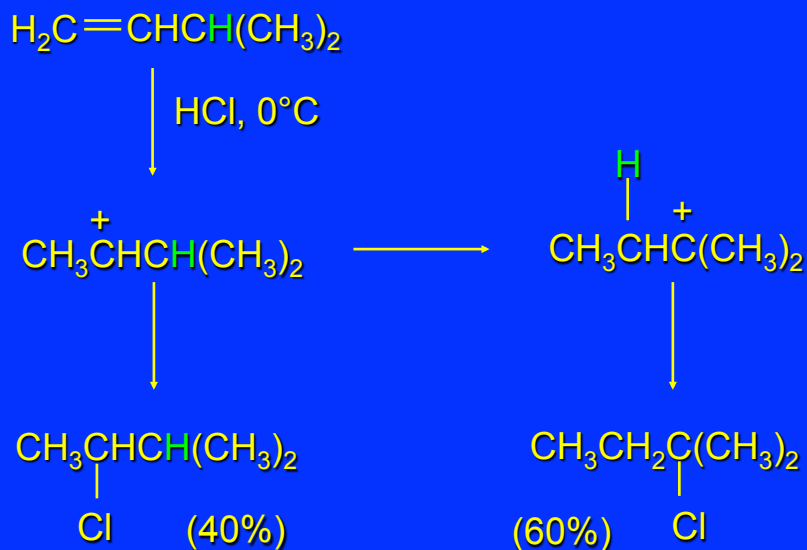
secondary carbocation  
is less stable:  
not formed

Mechanistic Basis for  
Markovnikov's Rule:  
Example 3



6-42

**Carbocation rearrangements sometimes occur**



6-43

**Free-radical Addition of HBr to Alkenes**  
The "peroxide effect"

Markovnikov's Rule



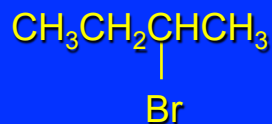
**Example 1**

6-44

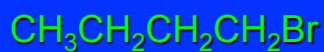
### Addition of HBr to 1-Butene



HBr



only product in  
absence of peroxides



only product when  
peroxides added to  
reaction mixture

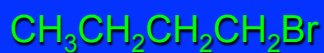
6-45

### Addition of HBr to 1-Butene



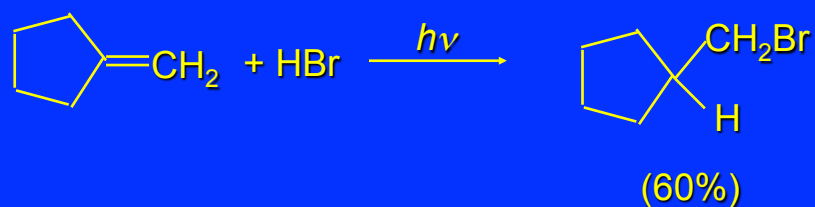
HBr

addition opposite to  
Markovnikov's rule  
occurs with HBr (not  
HCl or HI)



only product when  
peroxides added to  
reaction mixture

6-46



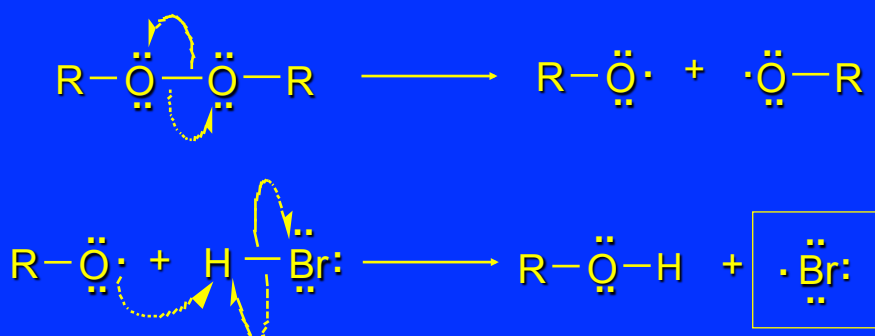
Addition of HBr with a regiochemistry opposite to Markovnikov's rule can also occur when initiated with light with or without added peroxides.

6-47

### Mechanism

Addition of HBr opposite to Markovnikov's rule proceeds by a free-radical chain mechanism.

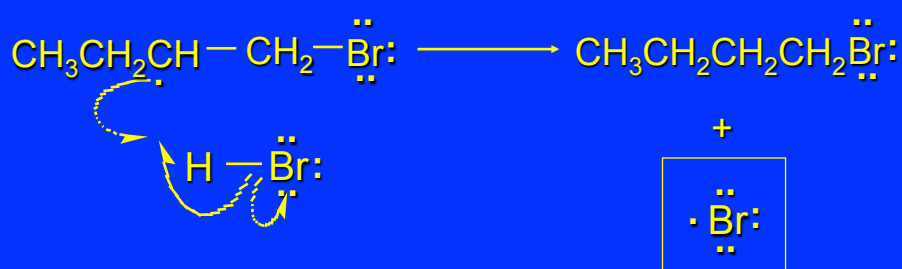
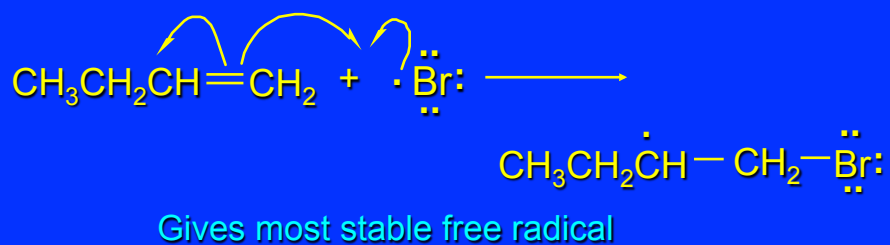
*Initiation steps:*



6-48

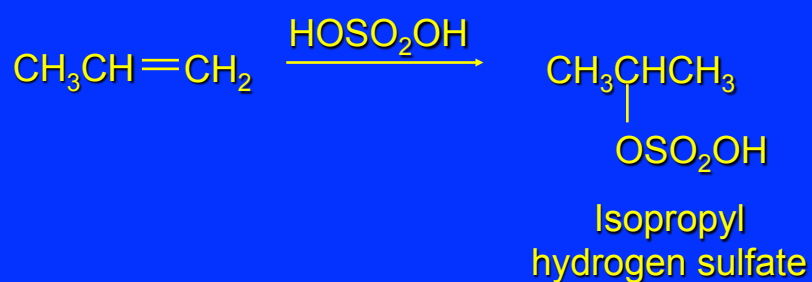


**Propagation steps:**



6-49

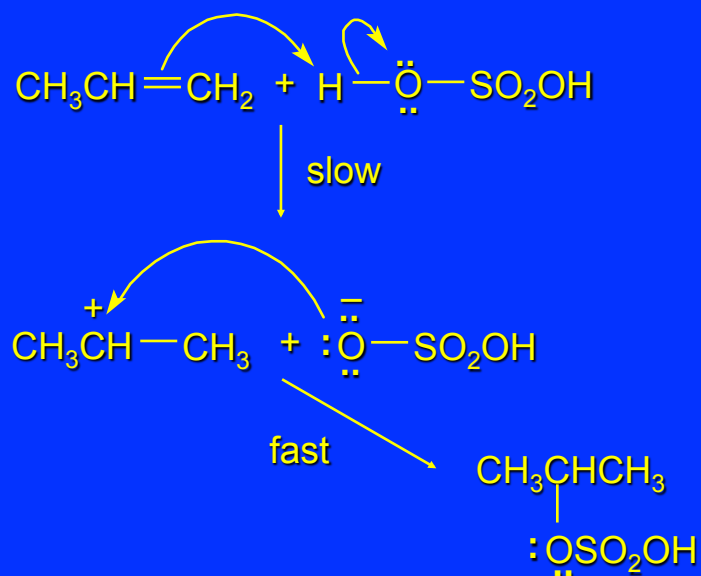
### Addition of Sulfuric Acid (H<sub>2</sub>SO<sub>4</sub>) to Alkenes



*follows Markovnikov's rule:  
yields an alkyl hydrogen sulfate*

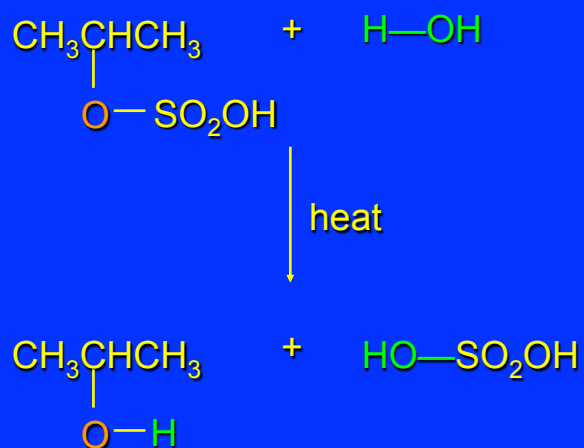
6-50

### Mechanism



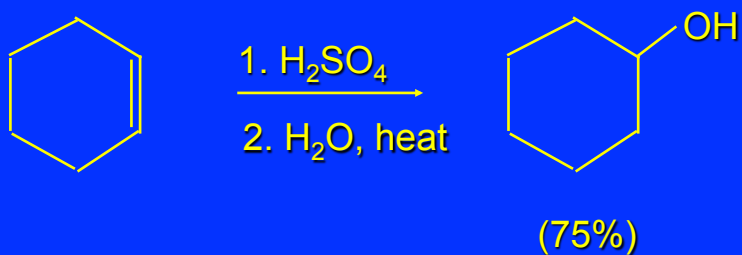
6-51

Alkyl hydrogen sulfates undergo hydrolysis in hot water



6-52

*Application: Conversion of alkenes to alcohols*



6-53

*But...*

not all alkenes yield alkyl hydrogen sulfates on reaction with sulfuric acid (concentrated).

these do:



these don't:

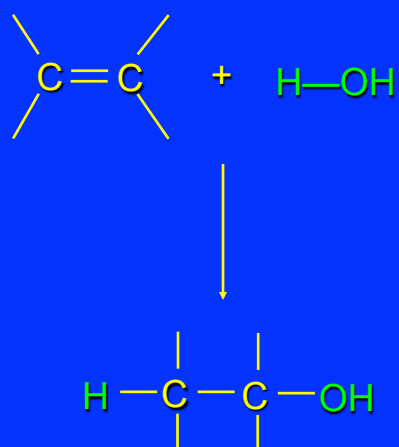


(These form polymers, sec 6.21)

6-54

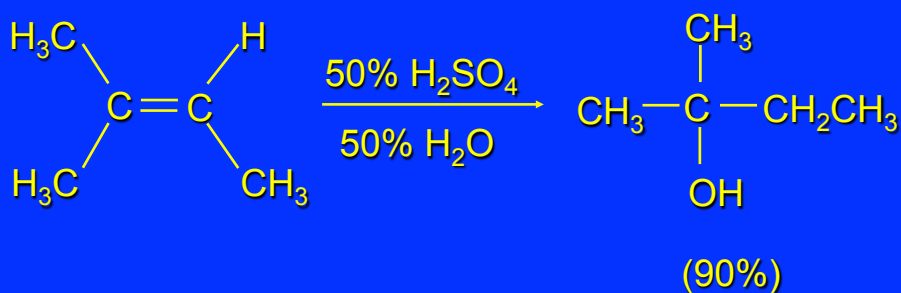
## Acid-Catalyzed Hydration of Alkenes

reaction is acid catalyzed; typical hydration medium is 50% H<sub>2</sub>SO<sub>4</sub>-50% H<sub>2</sub>O



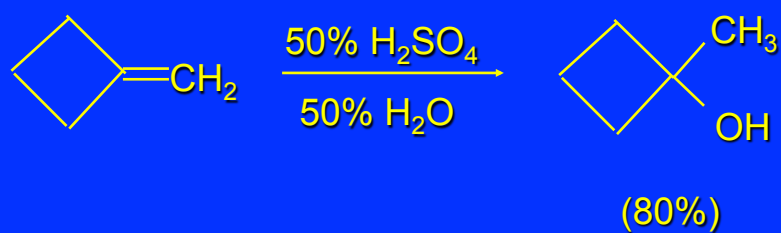
6-55

## Follows Markovnikov's Rule



6-56

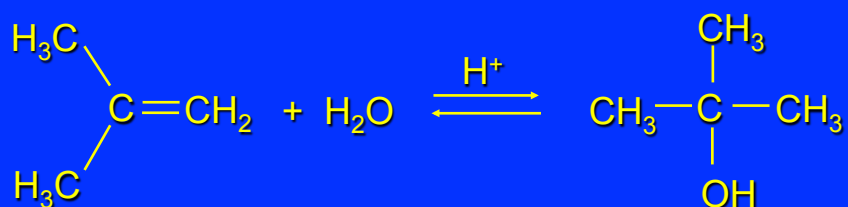
*Follows Markovnikov's Rule*



6-57

*Mechanism*

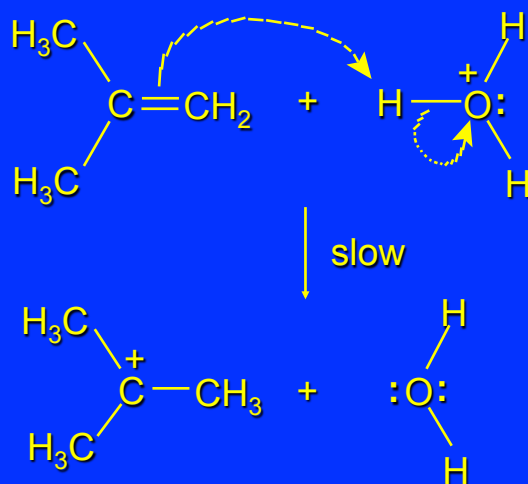
involves a carbocation intermediate and is the reverse of acid-catalyzed dehydration of alcohols to alkenes



6-58

### Mechanism

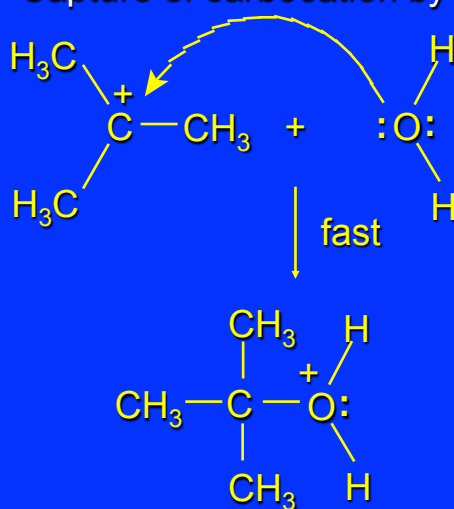
Step (1) Protonation of double bond



6-59

### Mechanism

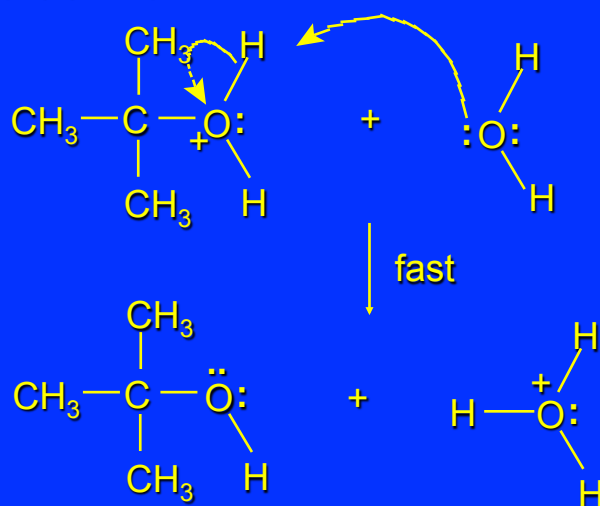
Step (2) Capture of carbocation by water



6-60

## Mechanism

Step (3) Deprotonation of oxonium ion



6-61

## Relative Rates

### Acid-catalyzed hydration

ethylene	$\text{CH}_2=\text{CH}_2$	1.0
propene	$\text{CH}_3\text{CH}=\text{CH}_2$	$1.6 \times 10^6$
2-methylpropene	$(\text{CH}_3)_2\text{C}=\text{CH}_2$	$2.5 \times 10^{11}$

The more stable the carbocation, the faster it is formed, and the faster the reaction rate.

6-62

### Principle of microscopic reversibility

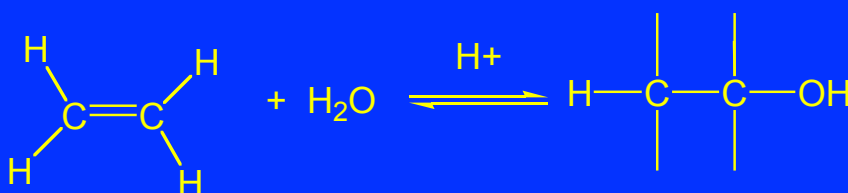


In an equilibrium process, the same intermediates and transition states are encountered in the forward direction and the reverse, but in the opposite order.

6-63

## Thermodynamics of Addition-Elimination Equilibria

Hydration-Dehydration Equilibrium



How do we control the position of the equilibrium and maximize the product?

6-64



## Le Chatelier' s Principle

A system at equilibrium adjusts so to minimize any stress applies to it.

For the hydration-dehydration equilibria, **the key stress is water.**

Adding water pushes the equilibrium toward more product (alcohol).

Removing water pushes the equilibrium toward more reactant (alkene).

6-65

## Le Chatelier' s Principle

At constant temperature and pressure a reaction proceeds in a direction which is spontaneous or decreases free energy (G).

The sign of G is always positive, but  $\Delta G$  can be positive or negative.

$$\Delta G = G_{\text{products}} - G_{\text{reactants}}$$

Spontaneous when  $\Delta G < 0$

## Le Chatelier's Principle

For a reversible reaction:



The relationship between  $\Delta G$  and  $\Delta G^\circ$  is:

$$\Delta G = \Delta G^\circ + RT \ln \frac{[C]^c [D]^d}{[A]^a [B]^b}$$

$R = 8.314 \text{ J}/(\text{mol}\cdot\text{K})$  and  $T$  is the temperature in K

## Le Chatelier's Principle

At equilibrium,  $\Delta G = 0$  and the following becomes true:

$$K_{\text{eq}} = \frac{[C]^c [D]^d}{[A]^a [B]^b}$$

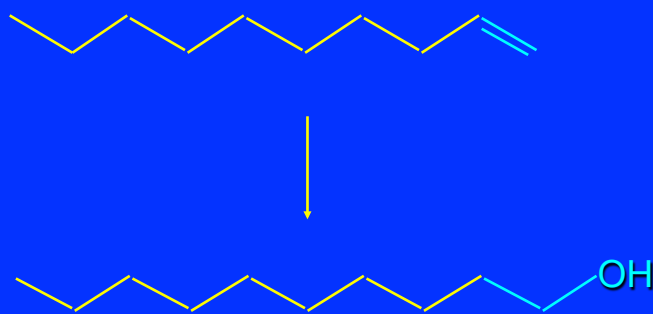
Substituting  $K_{\text{eq}}$  into the previous equation gives:

$$\Delta G^\circ = -RT \ln K_{\text{eq}}$$

Reactions for  $\Delta G^\circ$  positive are endergonic and for  $\Delta G^\circ$  negative are exergonic.

## Hydroboration-Oxidation of Alkenes

Suppose you wanted to prepare 1-decanol from 1-decene?



6-69

## Synthesis

Suppose you wanted to prepare 1-decanol from 1-decene?



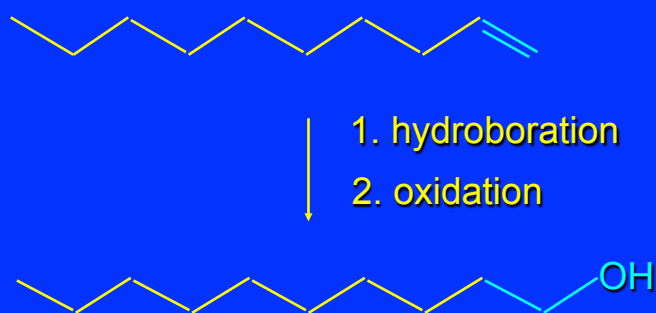
Needed: a method for hydration of alkenes with a regioselectivity opposite to Markovnikov's rule.



6-70

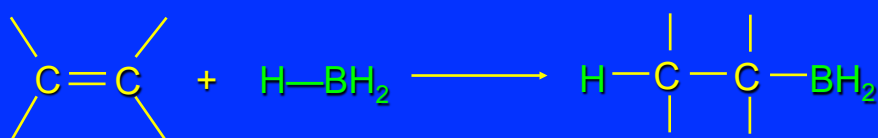
## Synthesis

Two-step reaction sequence called hydroboration-oxidation converts alkenes to alcohols with a regiochemistry opposite to Markovnikov's rule.



6-71

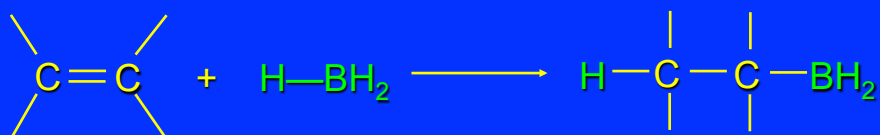
## Hydroboration step



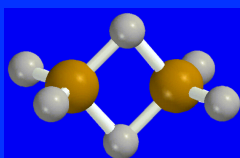
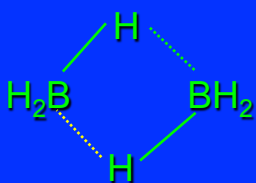
Hydroboration can be viewed as the addition of borane ( $\text{BH}_3$ ) to the double bond. But  $\text{BH}_3$  is not the reagent actually used.

6-72

### Hydroboration step



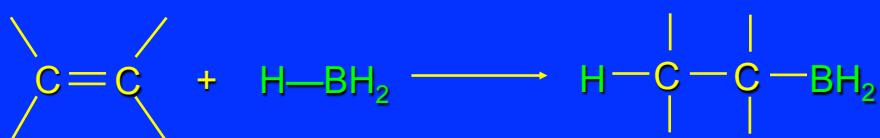
Hydroboration reagents:



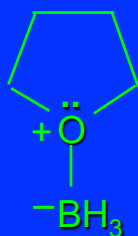
Diborane ( $\text{B}_2\text{H}_6$ ) normally used in an ether-like solvent called "diglyme"

6-73

### Hydroboration step



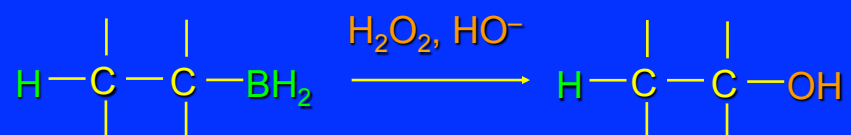
Hydroboration reagents:



Borane-tetrahydrofuran complex ( $\text{H}_3\text{B}-\text{THF}$ )

6-74

### Oxidation step



Organoborane formed in the hydroboration step is oxidized with hydrogen peroxide.

6-75

### Example



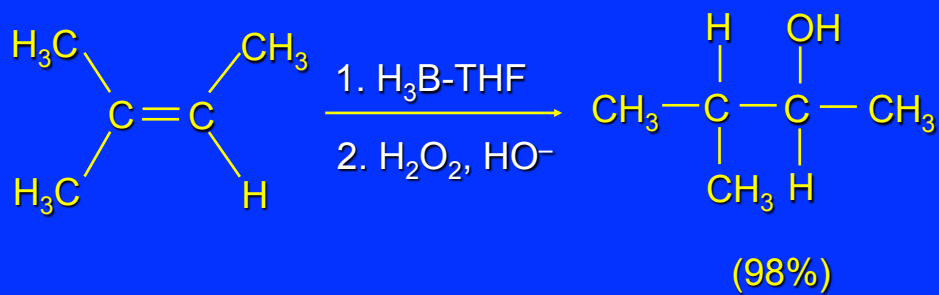
1.  $\text{B}_2\text{H}_6$ , diglyme
2.  $\text{H}_2\text{O}_2$ ,  $\text{HO}^-$



(93%)

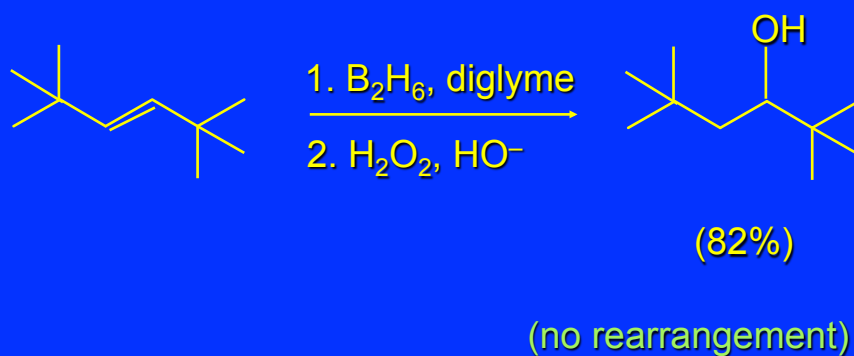
6-76

**Example**



6-77

**Example**



6-78

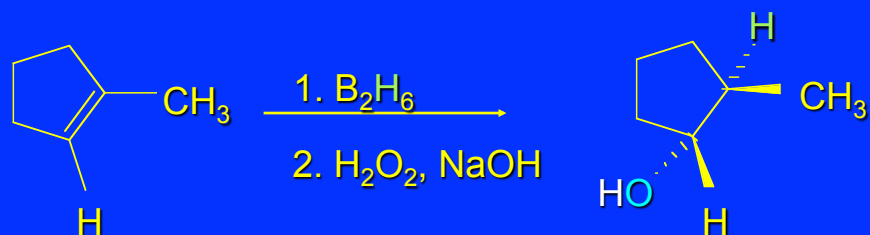
## Features and Stereochemistry of Hydroboration-Oxidation

- hydration of alkenes
- regioselectivity opposite to Markovnikov's rule
- no rearrangement
- stereospecific *syn* addition

6-79

## *syn*-Addition

- H and OH attach to the same face of double bond

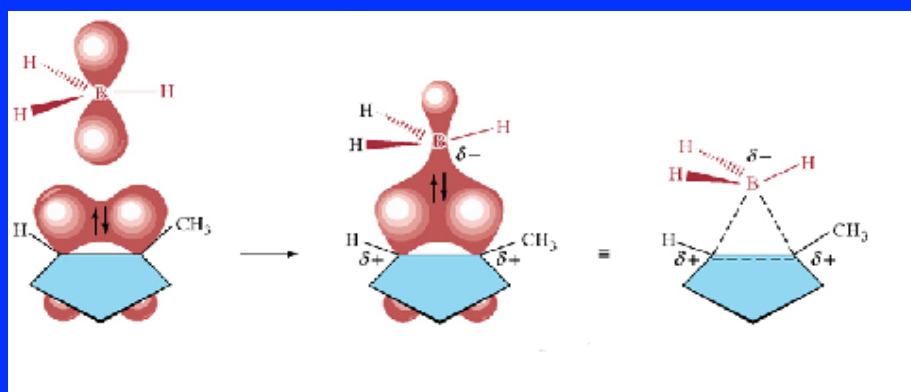


only product is *trans*-2-methylcyclopentanol  
(86%) yield

6-80



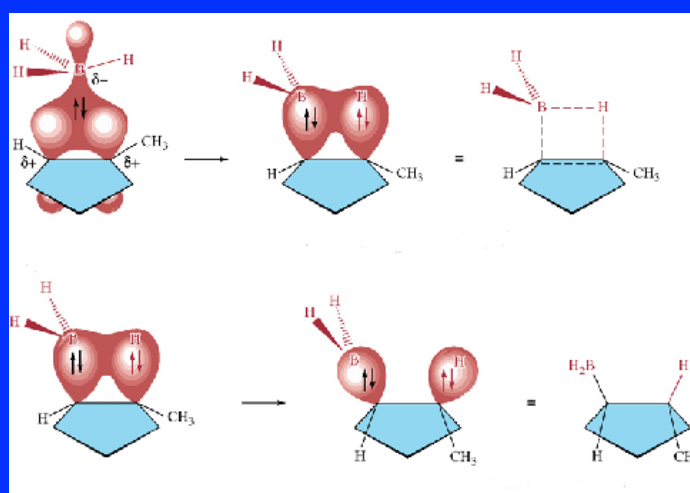
## Mechanism of Hydroboration-oxidation



$\pi$  electrons from alkene flow into 2p orbital of boron

6-81

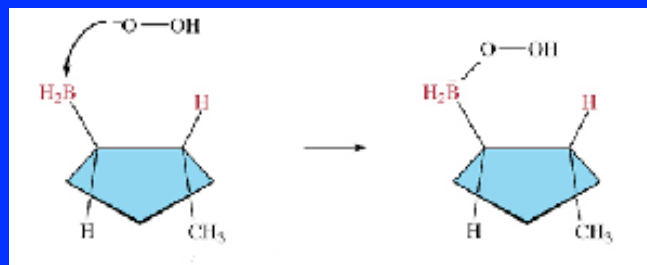
## Hydroboration-oxidation



H atom with 2 electrons migrates to C with greatest (+) charge (most highly substituted). Syn add.

6-82

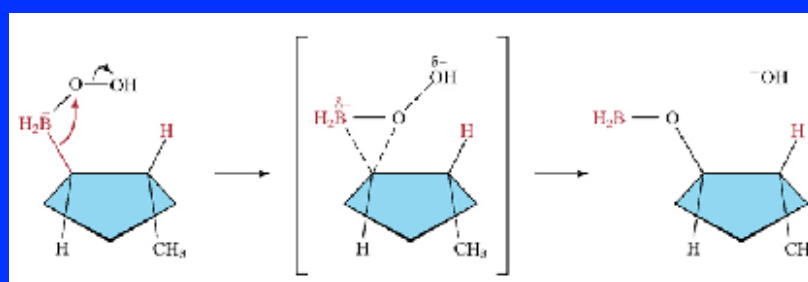
## Hydroboration-oxidation



Anion of hydrogen peroxide attacks boron

6-83

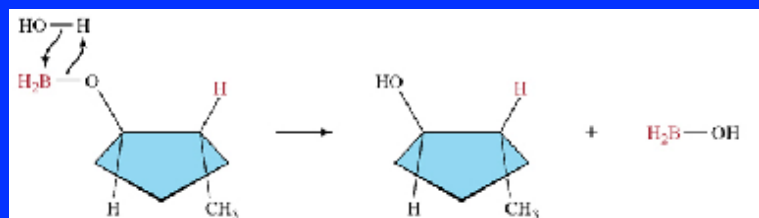
## Hydroboration-oxidation



Carbon with pair of electrons migrates to oxygen, displacing hydroxide. Oxygen on same side as boron

6-84

## Hydroboration-oxidation

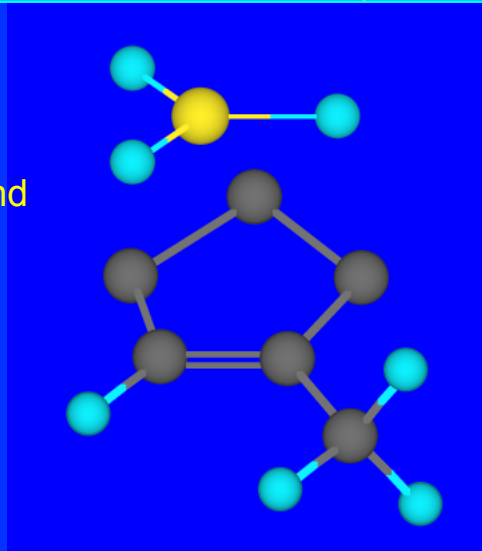


Hydrolysis cleaves boron-oxygen bond resulting in anti-Markovnikov addition

6-85

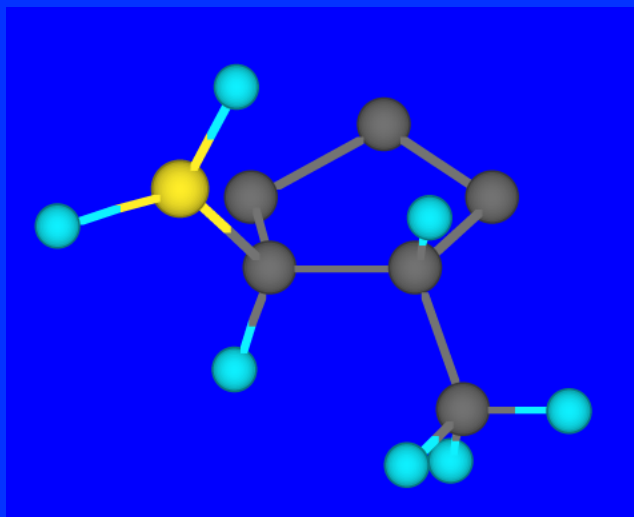
## 1-Methylcyclopentene + $BH_3$

- syn addition of H and B to double bond
- B adds to less substituted carbon



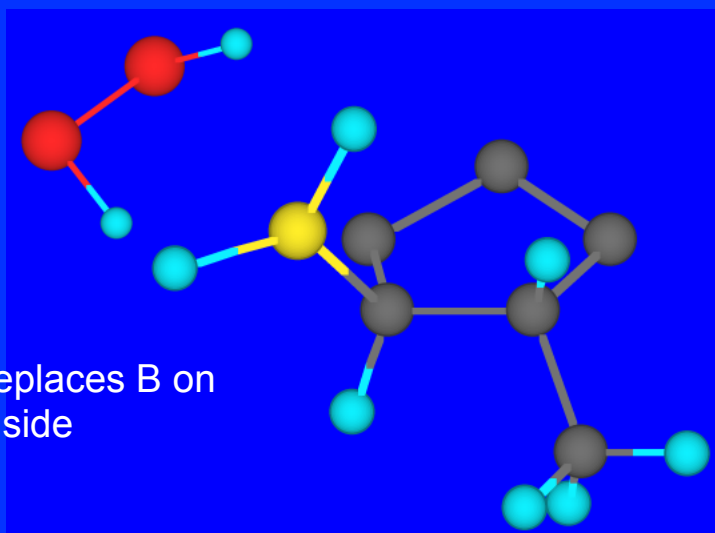
6-86

## Organoborane intermediate



6-37

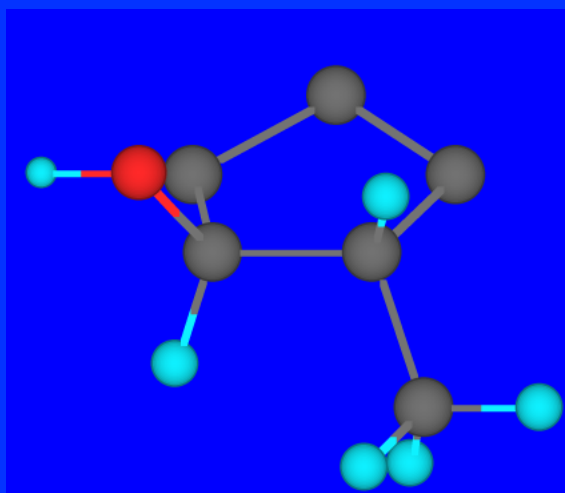
## Add hydrogen peroxide



•OH replaces B on same side

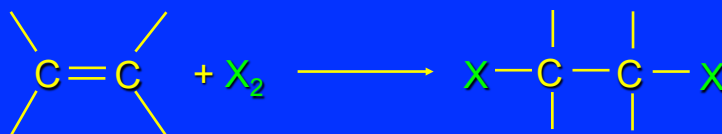
6-88

## *trans*-2-Methylcyclopentanol



v-89

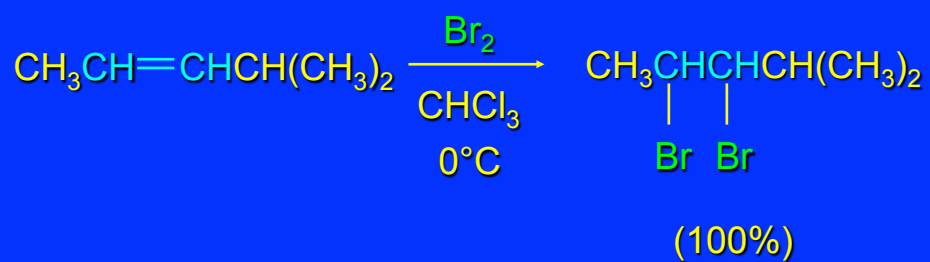
## Addition of Halogens to Alkenes



*electrophilic addition to double bond forms a dihalide*

6-90

### Example



6-91

### Scope

Limited to  $\text{Cl}_2$  and  $\text{Br}_2$

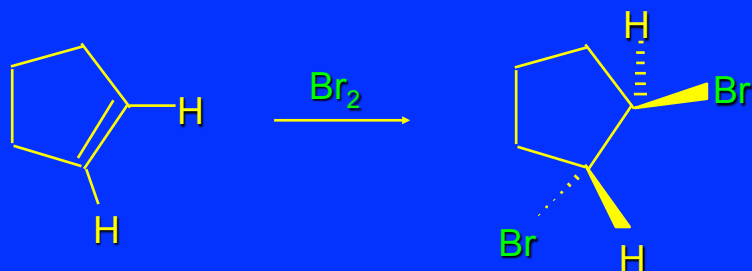
$\text{F}_2$  addition proceeds with explosive violence

$\text{I}_2$  addition is endothermic:

vicinal diiodides dissociate to an alkene and  $\text{I}_2$

6-92

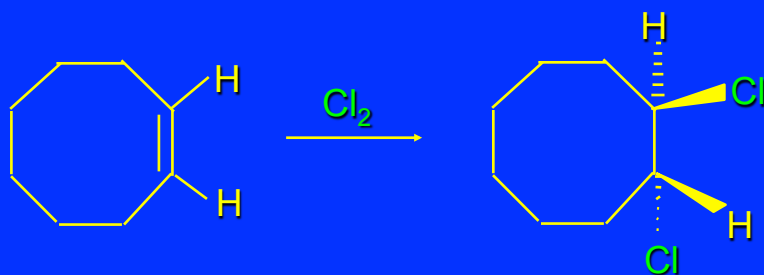
Stereochemistry of Halogen Addition:  
***Anti-Addition***



*trans*-1,2-Dibromocyclopentane  
80% yield; only product

6-93

**Example**



*trans*-1,2-Dichlorocyclooctane  
73% yield; only product

6-94

## Relative Rates

### Bromination

ethylene	$\text{H}_2\text{C}=\text{CH}_2$	1
propene	$\text{CH}_3\text{CH}=\text{CH}_2$	61
2-methylpropene	$(\text{CH}_3)_2\text{C}=\text{CH}_2$	5400
2,3-dimethyl-2-butene	$(\text{CH}_3)_2\text{C}=\text{C}(\text{CH}_3)_2$	920,000

More highly substituted double bonds react faster.  
Alkyl groups on the double bond make it more "electron rich."

6-95

## Mechanism of Halogen Addition to Alkenes: Halonium Ions

*Mechanism is electrophilic addition*

$\text{Br}_2$  is not polar, but it is polarizable

two steps involved

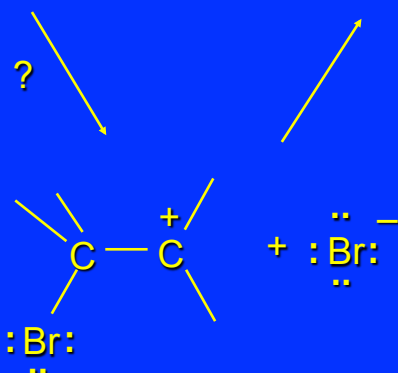
(1) formation of bromonium ion

(2) nucleophilic attack on bromonium ion by bromide

6-96



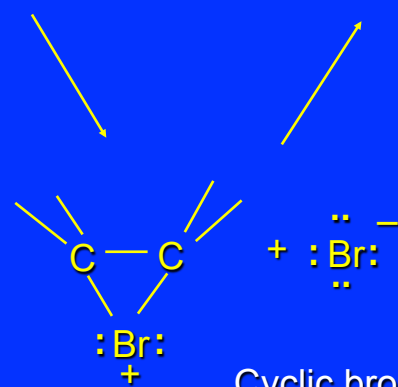
### Mechanism?



No obvious explanation for anti addition provided by this mechanism.

6-97

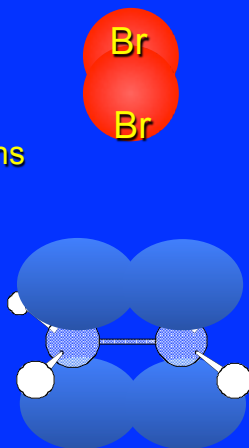
### Mechanism



6-98

### Formation of bromonium ion

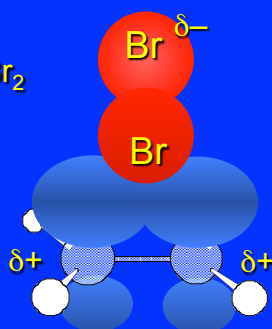
Mutual polarization  
of electron distributions  
of Br<sub>2</sub> and alkene



6-99

### Formation of bromonium ion

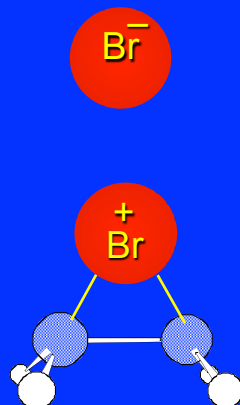
Electrons flow  
from alkene toward Br<sub>2</sub>



6-100

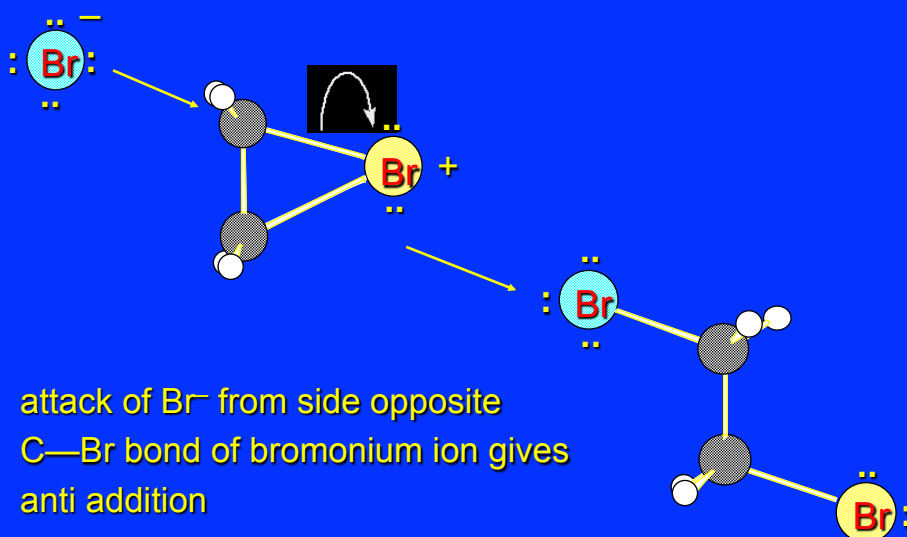
### Formation of bromonium ion

$\pi$  electrons of alkene  
displace  $\text{Br}^-$  from  $\text{Br}$



6-101

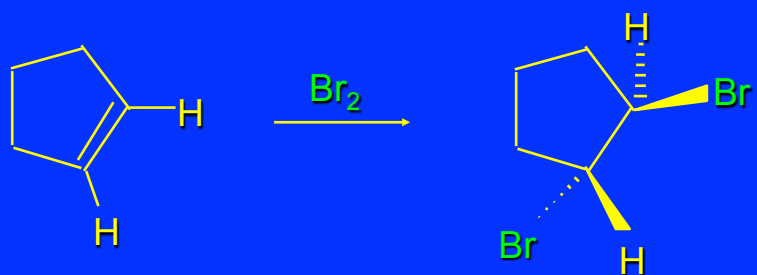
### Stereochemistry



attack of  $\text{Br}^-$  from side opposite  
 $\text{C}-\text{Br}$  bond of bromonium ion gives  
anti addition

6-102

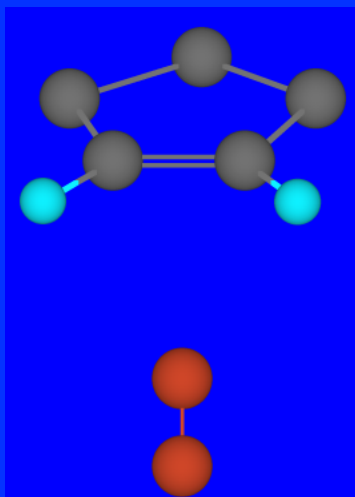
Example



*trans*-1,2-Dibromocyclopentane  
80% yield; only product

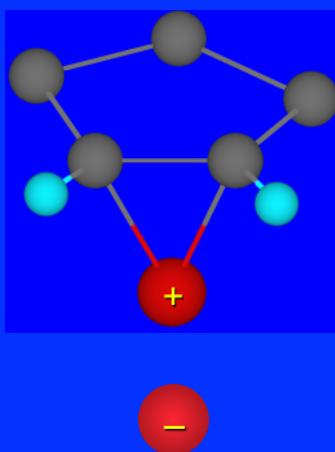
6-103

Cyclopentene  
+  $\text{Br}_2$



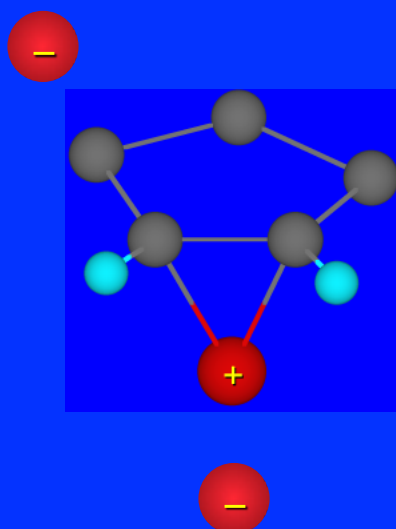
6-104

## Bromonium ion

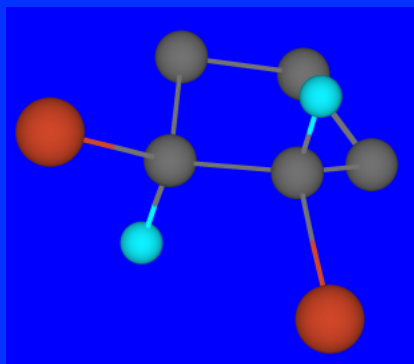


6-105

Bromide ion attacks the bromonium ion from side opposite carbon-bromine bond



6-106

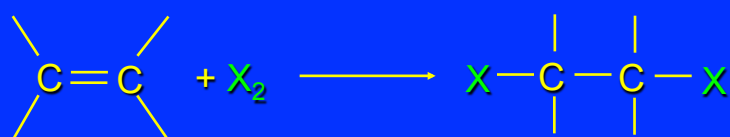


trans-Stereochemistry in  
vicinal dibromide

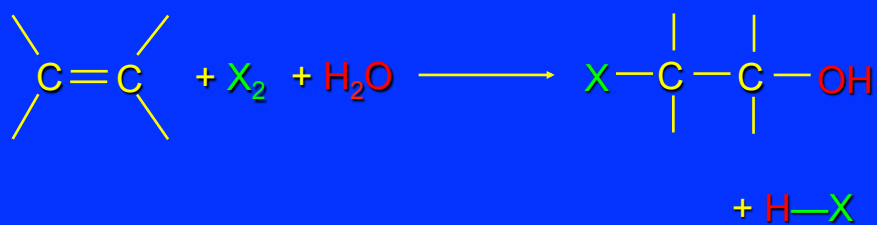
6-107

## Conversion of Alkenes to Vicinal Halohydrins

*alkenes react with  $X_2$  to form vicinal dihalides*

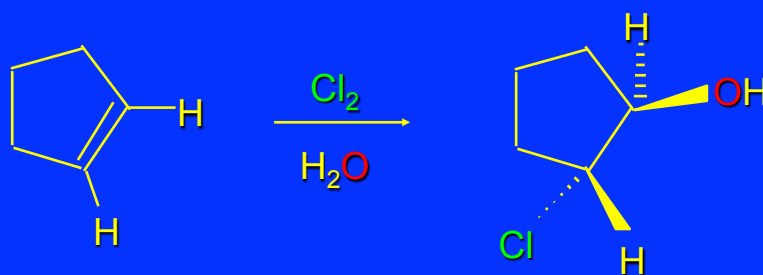
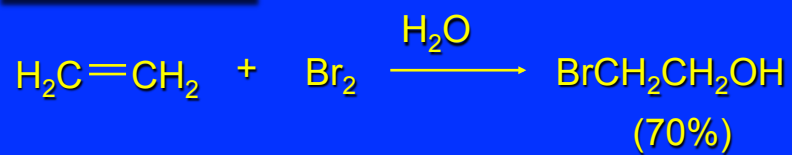


*alkenes react with  $X_2$  in water to give vicinal halohydrins*



6-108

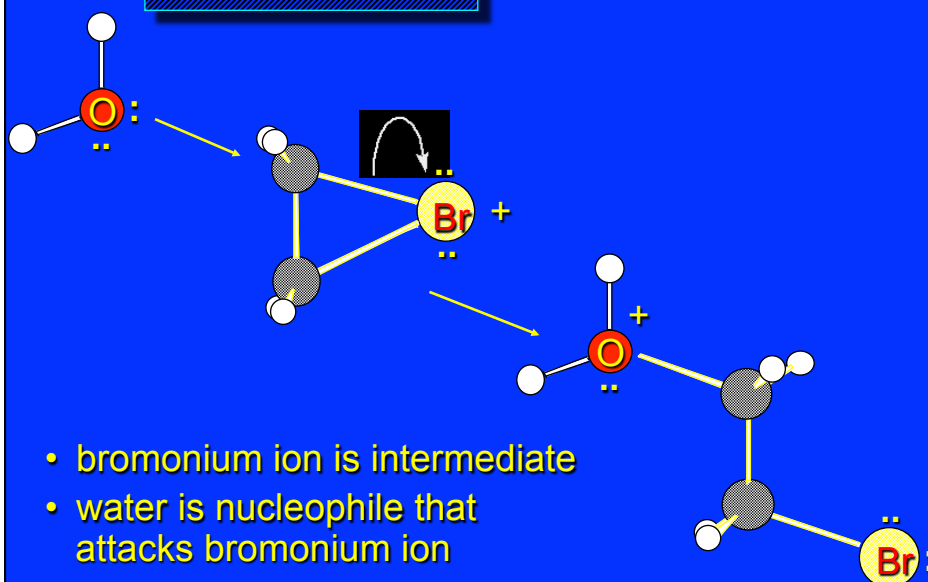
## Examples



*anti* addition: only product

6-109

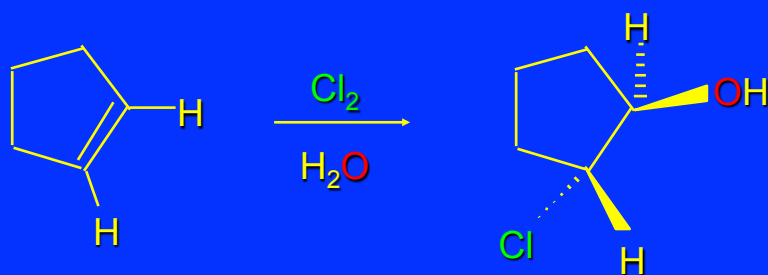
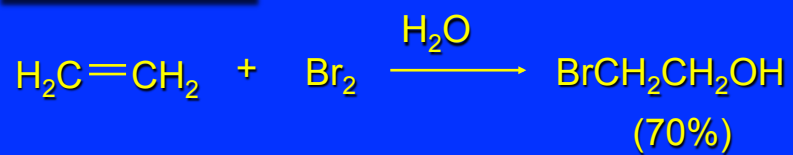
## Mechanism



- bromonium ion is intermediate
- water is nucleophile that attacks bromonium ion

6-110

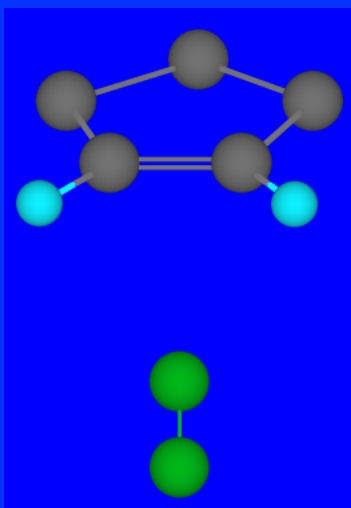
### Examples



*anti* addition: only product

6-111

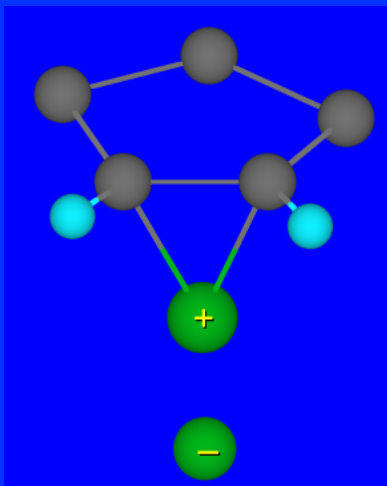
### Cyclopentene + $\text{Cl}_2$



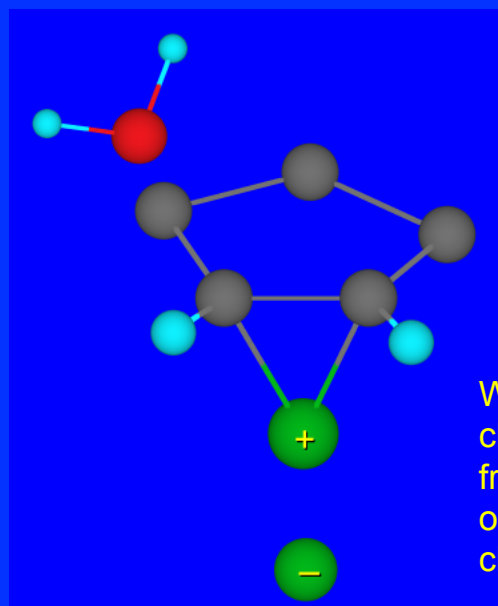
6-112



Chloronium  
ion



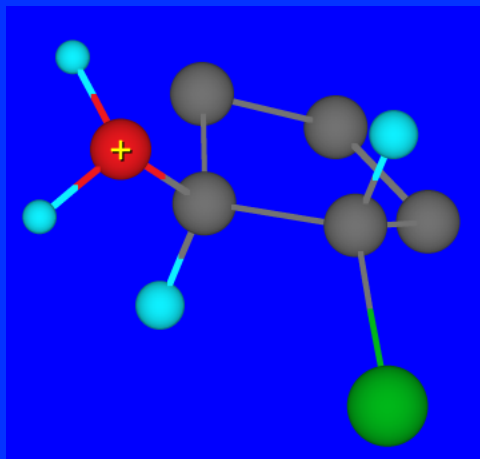
6-113



Water attacks  
chloronium ion  
from side  
opposite carbon-  
chlorine bond

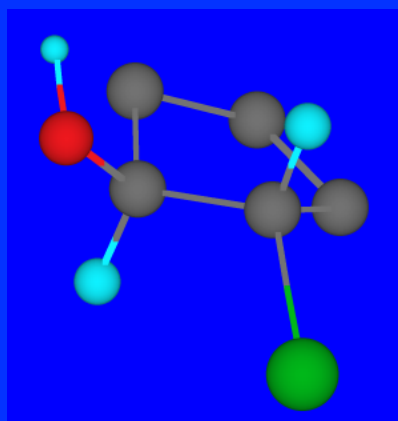
6-114

trans-Stereochemistry in oxonium ion



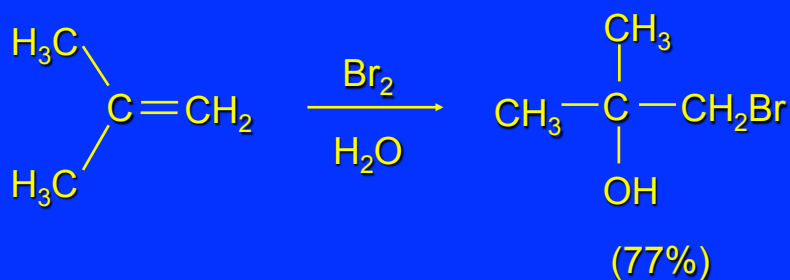
6-115

trans-2-Chlorocyclopentanol



6-116

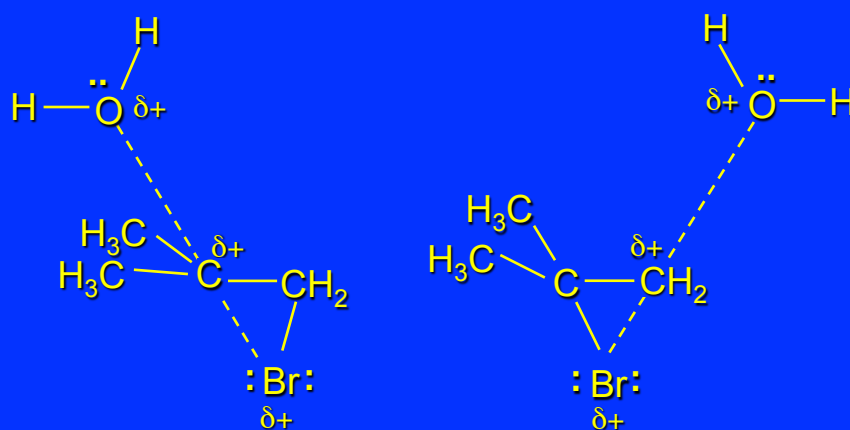
## Regioselectivity



**Markovnikov's rule applies to halohydrin formation:** the halogen adds to the carbon having the greater number of hydrogens and OH adds to carbon having fewer number of hydrogens.

6-117

## Explanation

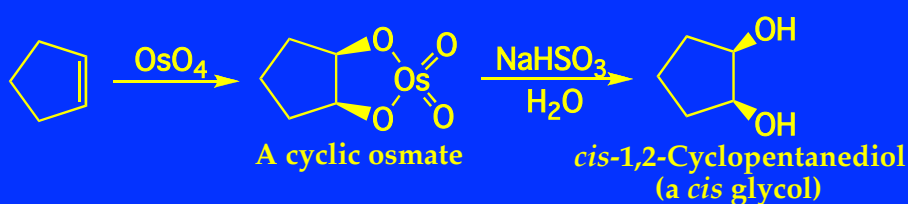


**transition state for attack of water on bromonium ion has carbocation character; more stable transition state (left) has positive charge on more highly substituted carbon**

6-118

## Oxidation of Alkenes: Glycol Formation

- Osmium tetroxide ( $\text{OsO}_4$ ) is an oxidizing agent that converts an alkene to a **glycol** - a compound with two hydroxyl groups (-OH) on adjacent carbon atoms



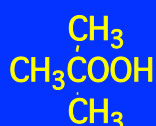
- The oxidation of an alkene by  $\text{OsO}_4$  is **stereoselective** and proceeds with **syn-stereoselectivity**:
  - addition of -OH groups on the same side of the carbon-carbon double bond

## Oxidation of Alkenes: Glycol Formation

- Syn-addition** is due to the formation of the five-membered cyclic osmate intermediate that fuses *cis* to the original alkene
- $\text{OsO}_4$  is very expensive and *highly* toxic
- Used in catalytic amounts with stoichiometric amount of another oxidizing agent to reoxidize its reduced form and thus recycle the catalyst.



Hydrogen peroxide



*tert*-Butyl hydroperoxide  
(*t*-BuOOH)

## Oxidation of Alkenes: Glycol Formation

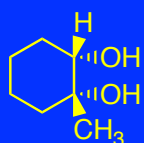
- Draw the product formed by treating each alkene with aqueous  $\text{OsO}_4/\text{H}_2\text{O}_2$ .

a) 1-Methylcyclopentene

b) *cis*-2-Pentene

- What alkene when treated with  $\text{OsO}_4/\text{ROOH}$ , gives each glycol?

a)



b)

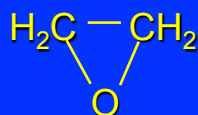


## Epoxidation of Alkenes

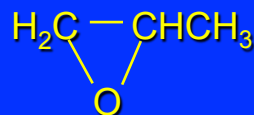
### Epoxides

- are examples of heterocyclic compounds
- three-membered rings that contain oxygen

ethylene oxide



propylene oxide

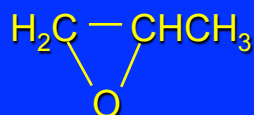


## Epoxyde Nomenclature

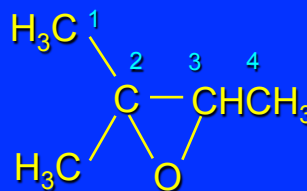
Substitutive nomenclature:

- named as epoxy-substituted alkanes.
- “epoxy” precedes name of alkane

1,2-epoxypropane

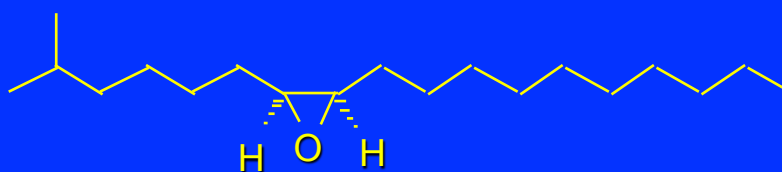


2-methyl-2,3-epoxybutane



6-123

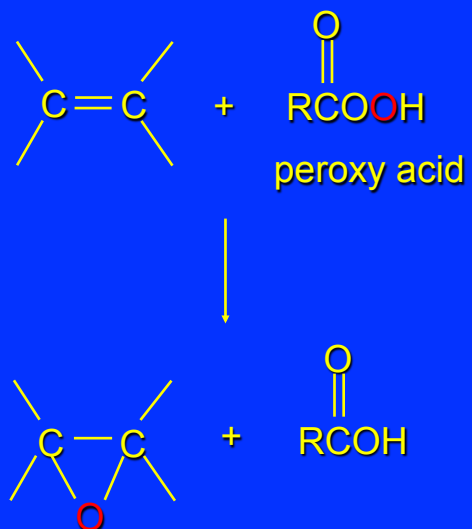
**Problem 6.17** Give the IUPAC name, including stereochemistry, for disparlure.



*cis*-2-Methyl-7,8-epoxyoctadecane

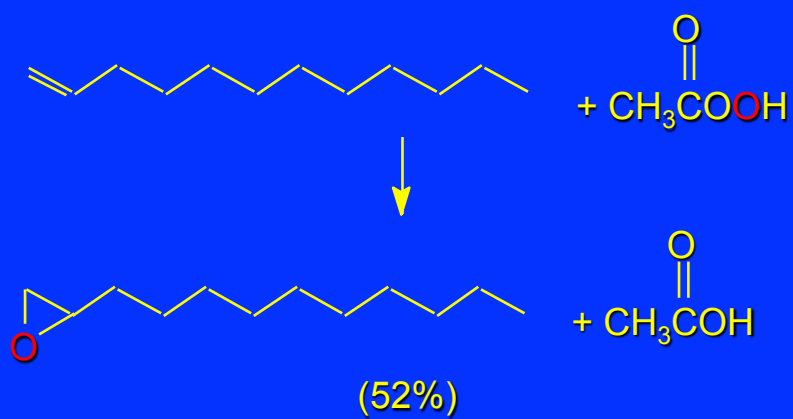
6-124

## Epoxidation of Alkenes



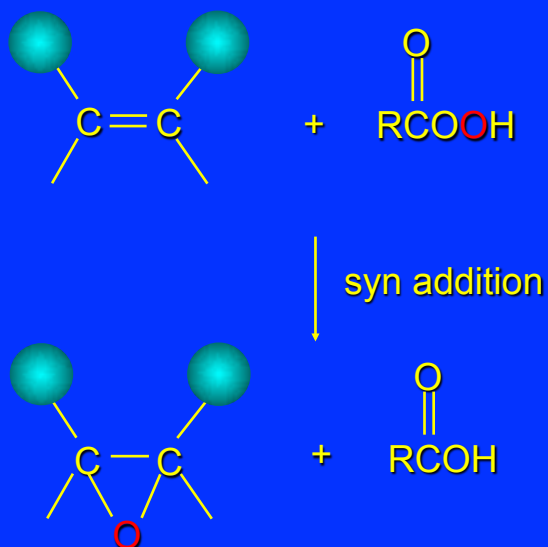
6-125

### Example



6-126

## Epoxidation of Alkenes



6-127

## Relative Rates of Epoxidation

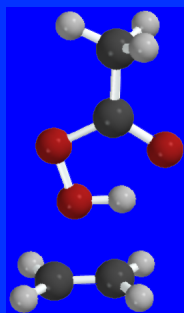
ethylene	$\text{H}_2\text{C}=\text{CH}_2$	1
propene	$\text{CH}_3\text{CH}=\text{CH}_2$	22
2-methylpropene	$(\text{CH}_3)_2\text{C}=\text{CH}_2$	484
2-methyl-2-butene	$(\text{CH}_3)_2\text{C}=\text{CHCH}_3$	6526

More highly substituted double bonds react faster.  
Alkyl groups on the double bond make it more  
“electron rich.”

6-128

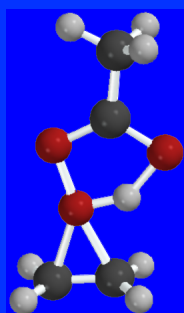


## Mechanism of Epoxidation



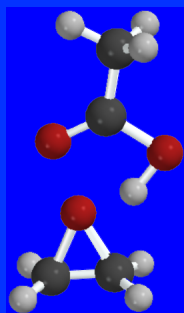
6-129

## Mechanism of Epoxidation



6-130

## Mechanism of Epoxidation



6-131

## Ozonolysis of Alkenes

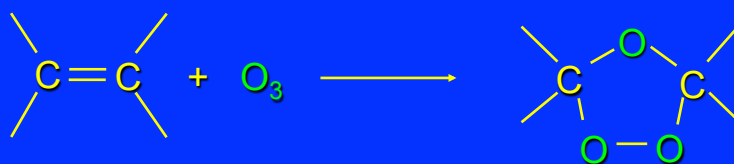
Ozonolysis has both synthetic and analytical applications.

- synthesis of aldehydes and ketones
- identification of substituents on the double bond of an alkene

6-132

## Ozonolysis of Alkenes

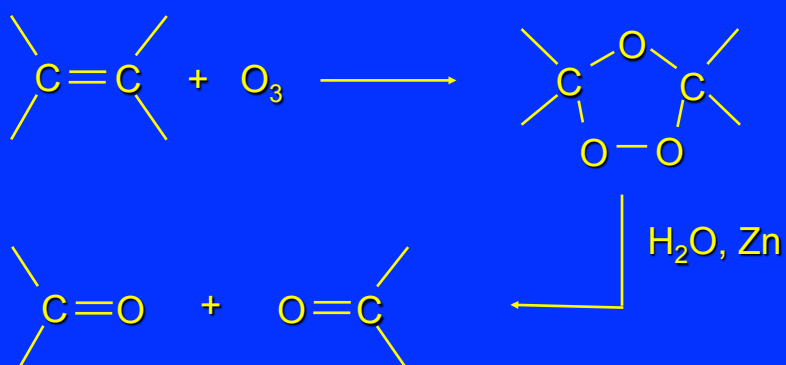
First step is the reaction of the alkene with ozone.  
The product is an **ozonide**.



6-133

## Ozonolysis of Alkenes

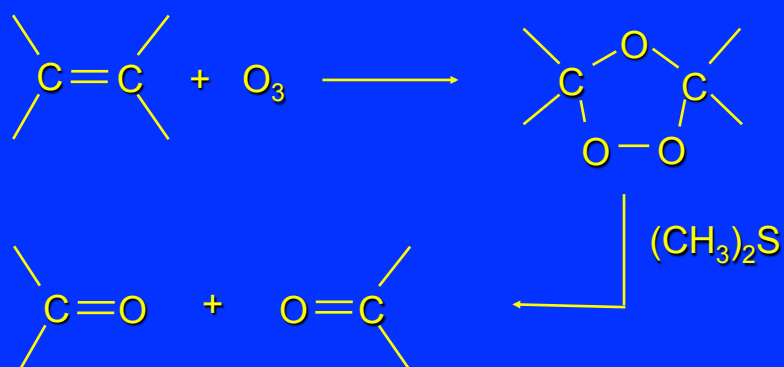
Second step is hydrolysis of the ozonide. Two ketones, two aldehydes, or an aldehyde and a ketone are formed.



6-134

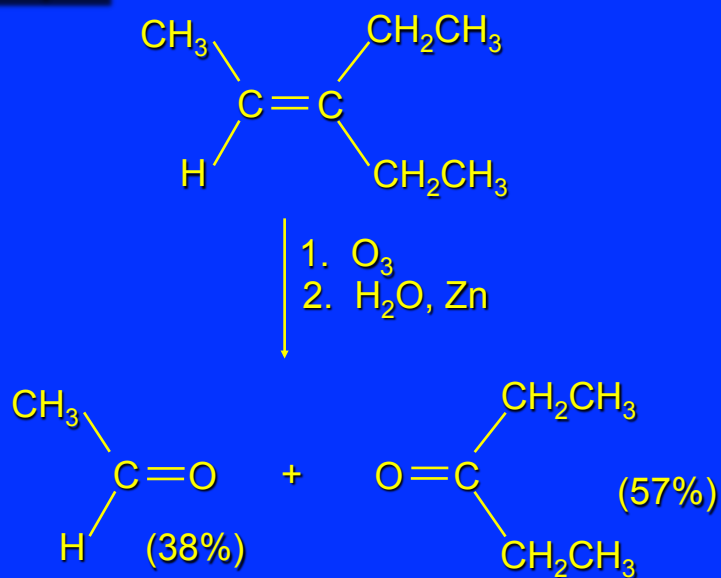
## Ozonolysis of Alkenes

As an alternative to hydrolysis, the ozonide can be treated with dimethyl sulfide.



6-135

### Example

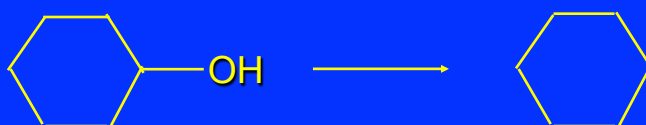


6-136

# Introduction to Organic Chemical Synthesis

6-137

*Prepare cyclohexane from cyclohexanol*



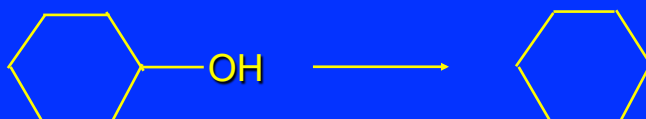
devise a synthetic plan

reason backward from the target molecule

always use reactions that you are sure will work

6-138

*Prepare cyclohexane from cyclohexanol*

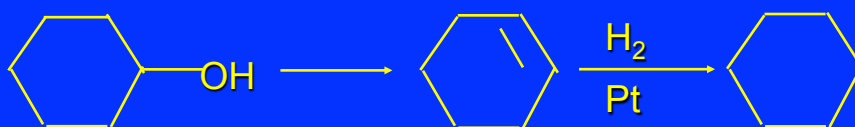


ask yourself the key question

"Starting with anything, how can I make cyclohexane in a single step by a reaction I am sure will work?"

6-139

*Prepare cyclohexane from cyclohexanol*

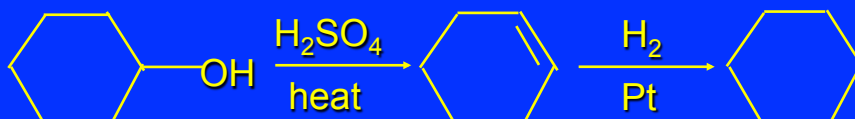


The only reaction covered so far for preparing alkanes is catalytic hydrogenation of alkenes.

This leads to a new question. "Starting with anything, how can I prepare cyclohexene in a single step by a reaction I am sure will work?"

6-140

*Prepare cyclohexane from cyclohexanol*

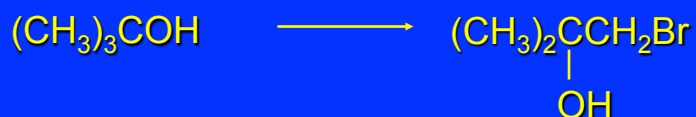


Alkenes can be prepared by dehydration of alcohols.

The synthesis is complete.

6-141

*Prepare 1-bromo-2-methyl-2-propanol from tert-butyl alcohol*

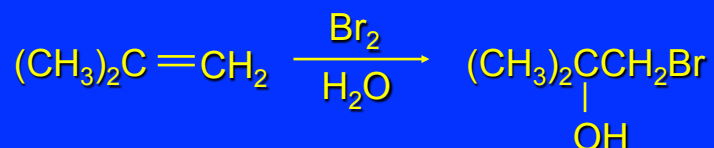


"Starting with anything, how can I make the desired compound in a single step by a reaction I am sure will work?"

The desired compound is a vicinal bromohydrin.  
How are vicinal bromohydrins prepared?

6-142

Prepare 1-bromo-2-methyl-2-propanol  
from *tert*-butyl alcohol

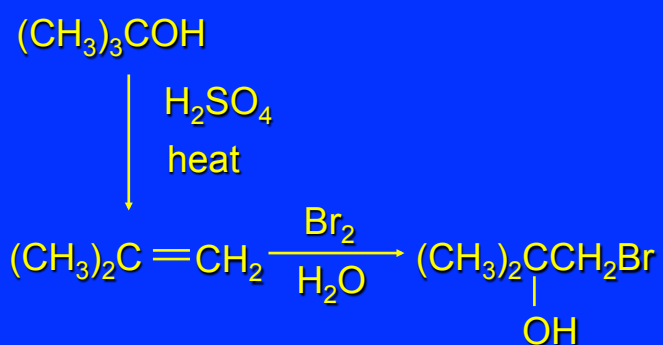


Vicinal bromohydrins are prepared by treatment of alkenes with  $\text{Br}_2$  in water.

How is the necessary alkene prepared?

6-143

Prepare 1-bromo-2-methyl-2-propanol  
from *tert*-butyl alcohol



2-Methylpropene is prepared from *tert*-butyl alcohol by acid-catalyzed dehydration.

The synthesis is complete.

6-144



## Reaction of Alkenes with Alkenes: Polymerization

cationic polymerization

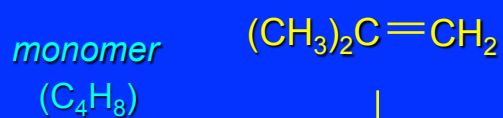
free-radical polymerization

coordination polymerization

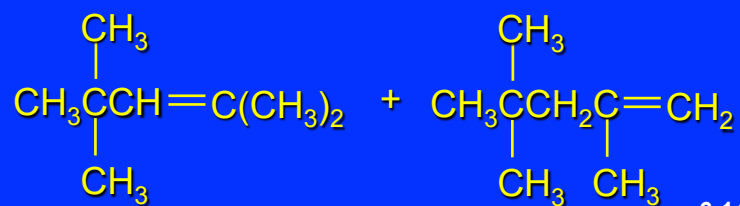
6-145

## Cationic Polymerization

Dimerization of 2-methylpropene

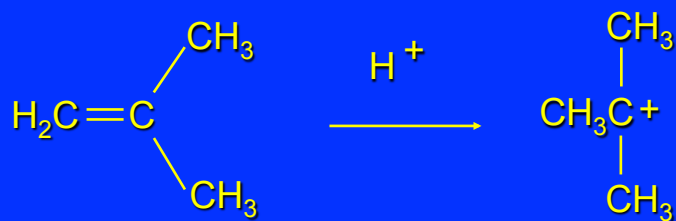


two dimers  
(C<sub>8</sub>H<sub>16</sub>)



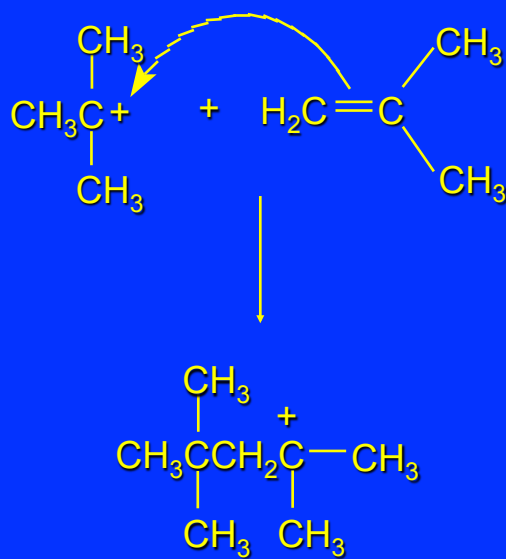
6-146

### Mechanism of Cationic Polymerization



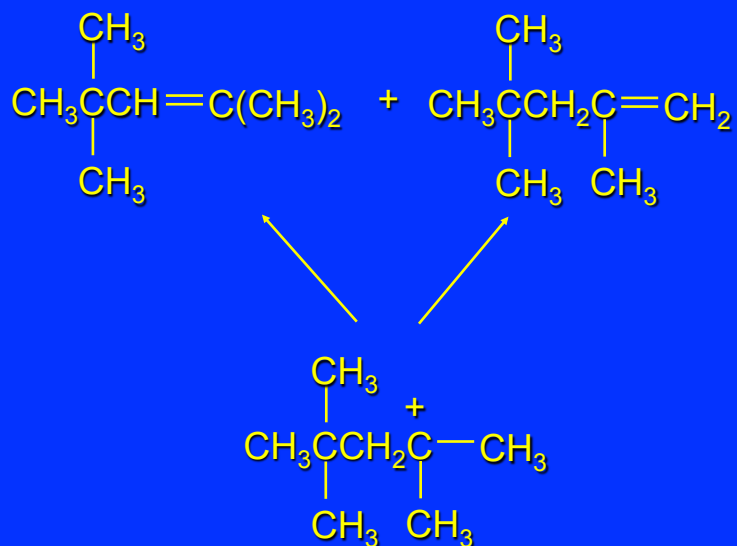
6-147

### Mechanism of Cationic Polymerization



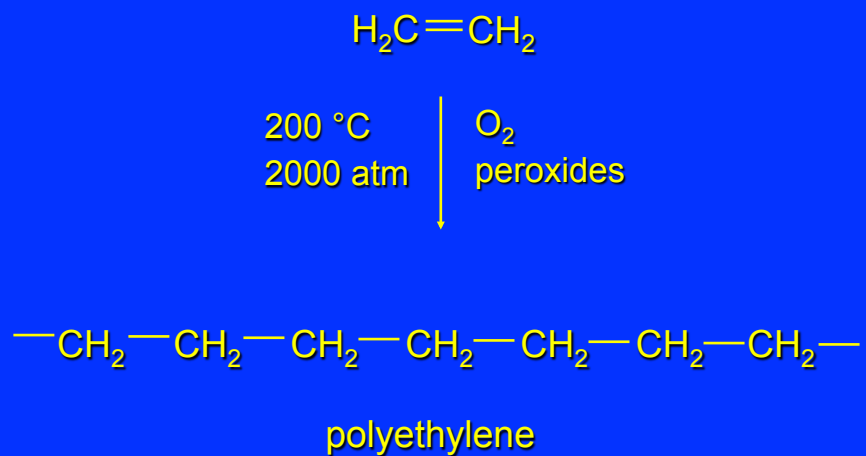
6-148

### Mechanism of Cationic Polymerization

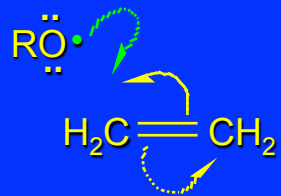


6-149

### Free-Radical Polymerization of Ethylene

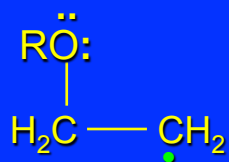


6-150



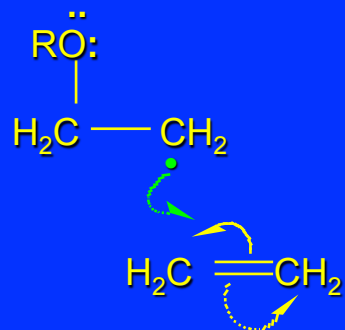
*Mechanism*

6-151



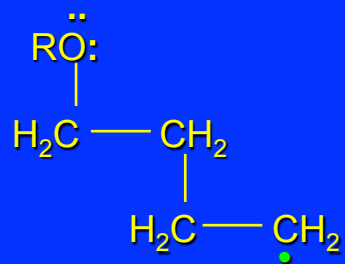
*Mechanism*

6-152



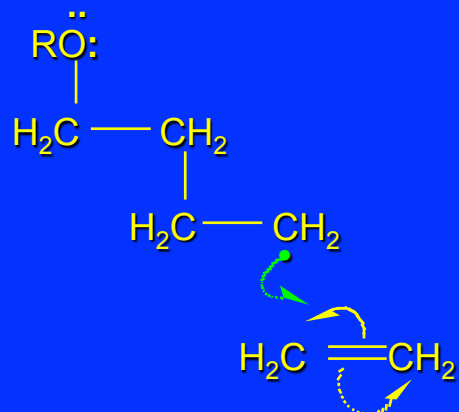
*Mechanism*

6-153



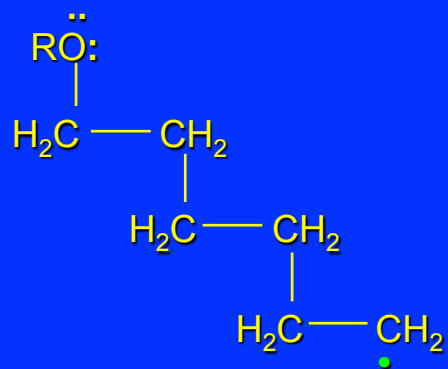
*Mechanism*

6-154



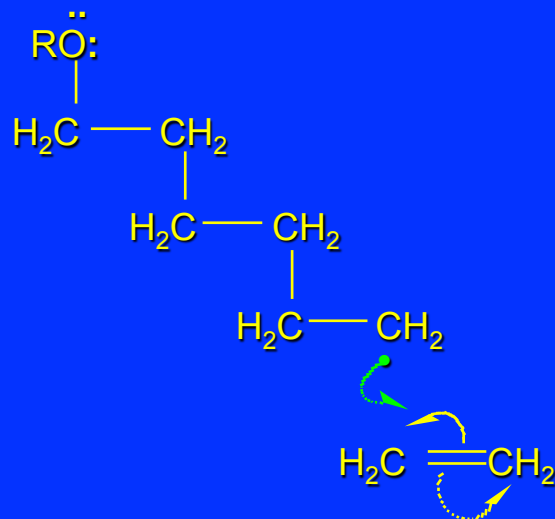
*Mechanism*

6-155



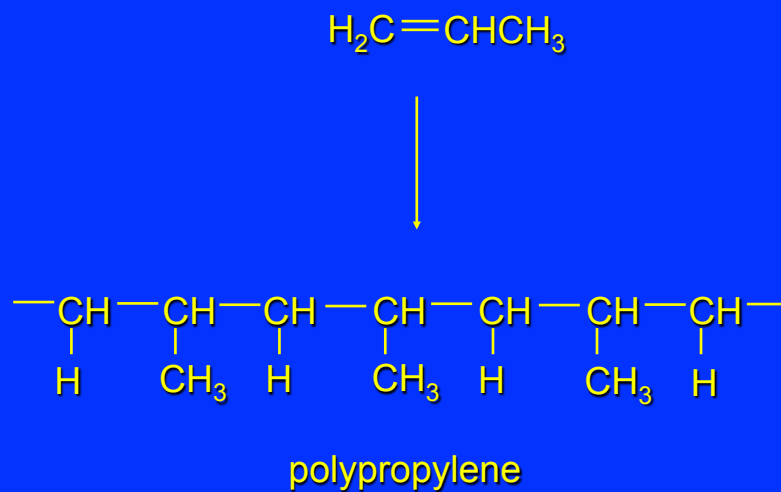
*Mechanism*

6-156

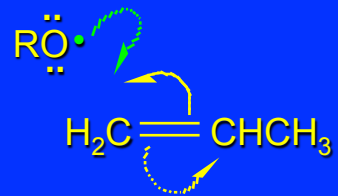


6-157

### Free-Radical Polymerization of Propene

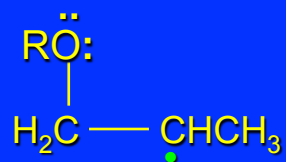


6-158



*Mechanism*

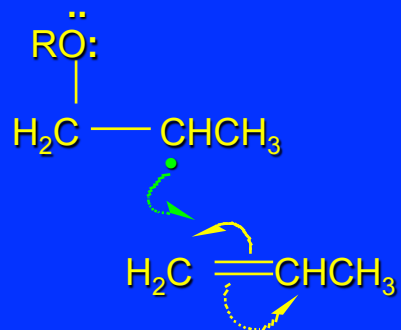
6-159



*Mechanism*

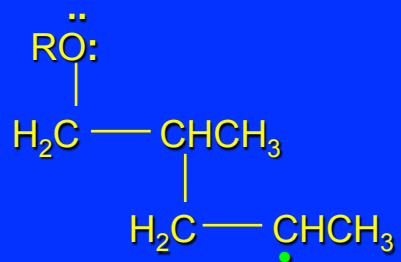
6-160





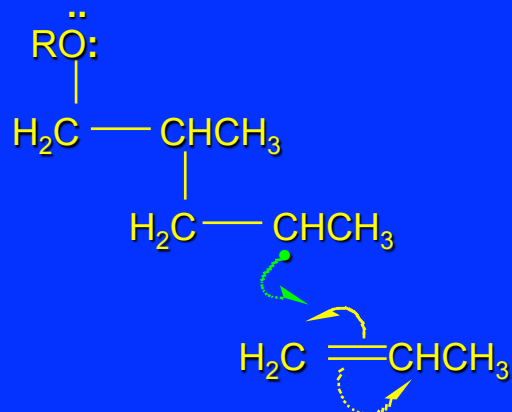
*Mechanism*

6-161

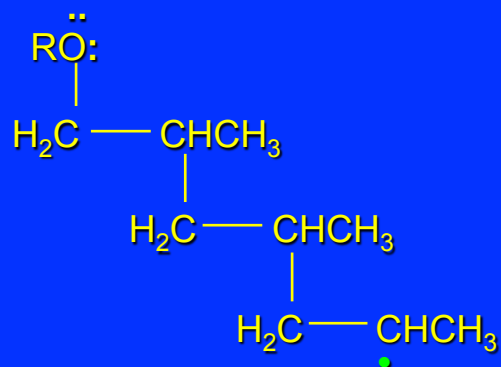


*Mechanism*

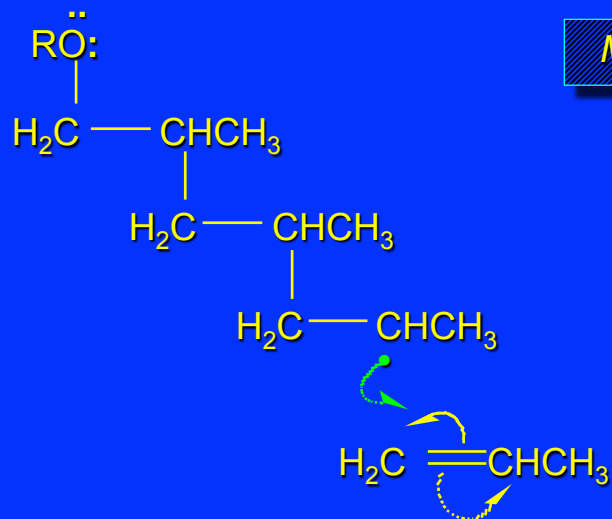
6-162



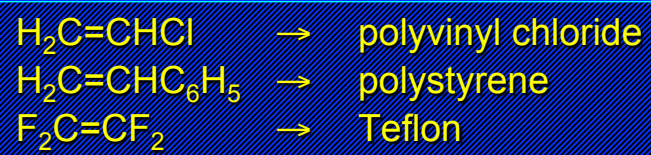
6-163



6-164



6-165



6-166

## Coordination Polymerization

An alternative polymerization technique that employs novel transition metal catalysts.

The Ziegler route to polyethylene is even more important because it occurs at modest temperatures and pressures and produces *high density polyethylene* which has properties superior to the low density material produced by free-radical polymerization.

End of Chapter 6