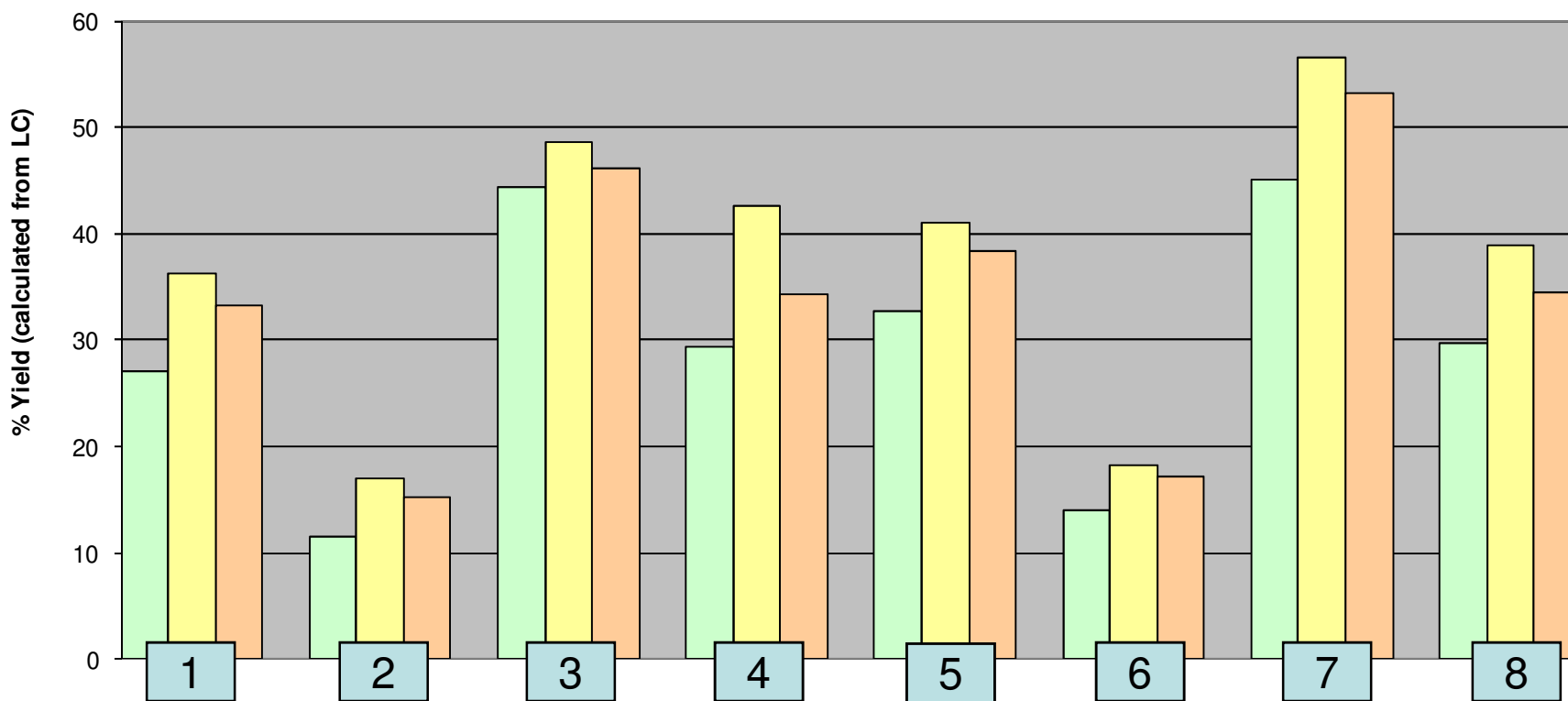
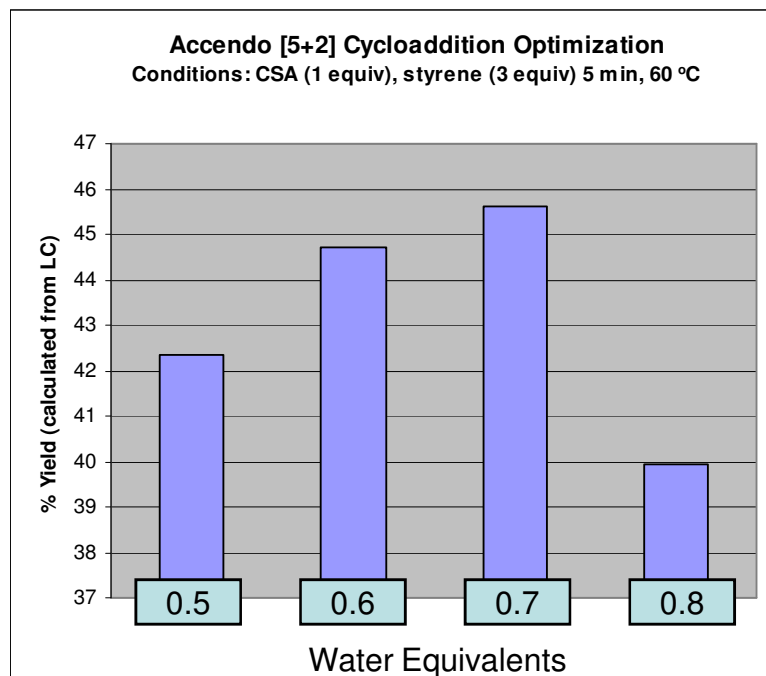


**Reaction Optimization on Conjure Flow Reactor System
[5+2] Cycloaddition Optimization**

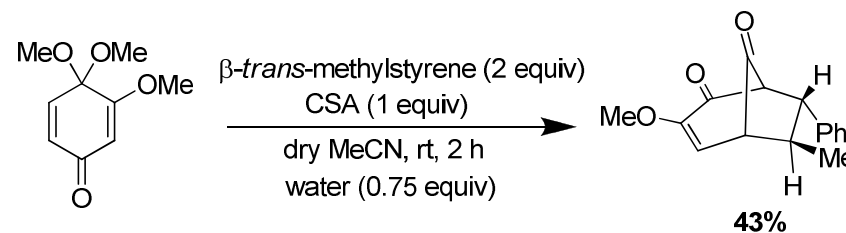


- 25 °C, 5 min
- 60 °C, 5 min
- 60 °C, 15 min

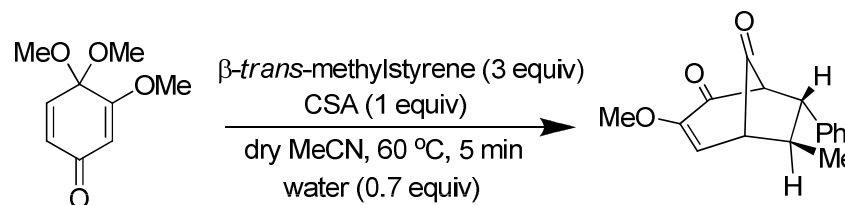
Reaction Set	CSA (equiv)	Styrene (equiv)	Water (equiv)
1	1.0	1.0	0.5
2	1.0	1.0	2.0
3	1.0	3.0	0.5
4	1.0	3.0	2.0
5	2.0	1.0	0.5
6	2.0	1.0	2.0
7	2.0	3.0	0.5
8	2.0	3.0	2.0



Bench Results:

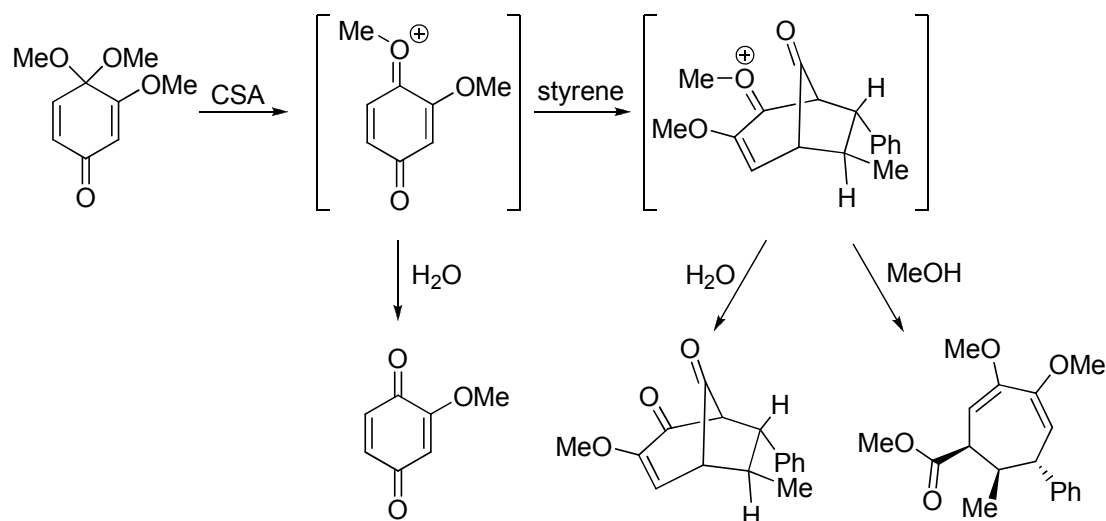


Conjure Flow Results: 1g (5 hrs)



~Total time = 5 h (1.4 g)

Reaction Mechanism:



**[5+2] Cycloaddition
 Optimization and Scale Up**
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