

safety moment: responsible reaction scale-up – the rule of three

small (0.75 g) → medium (7.5 g) → large (30 g)

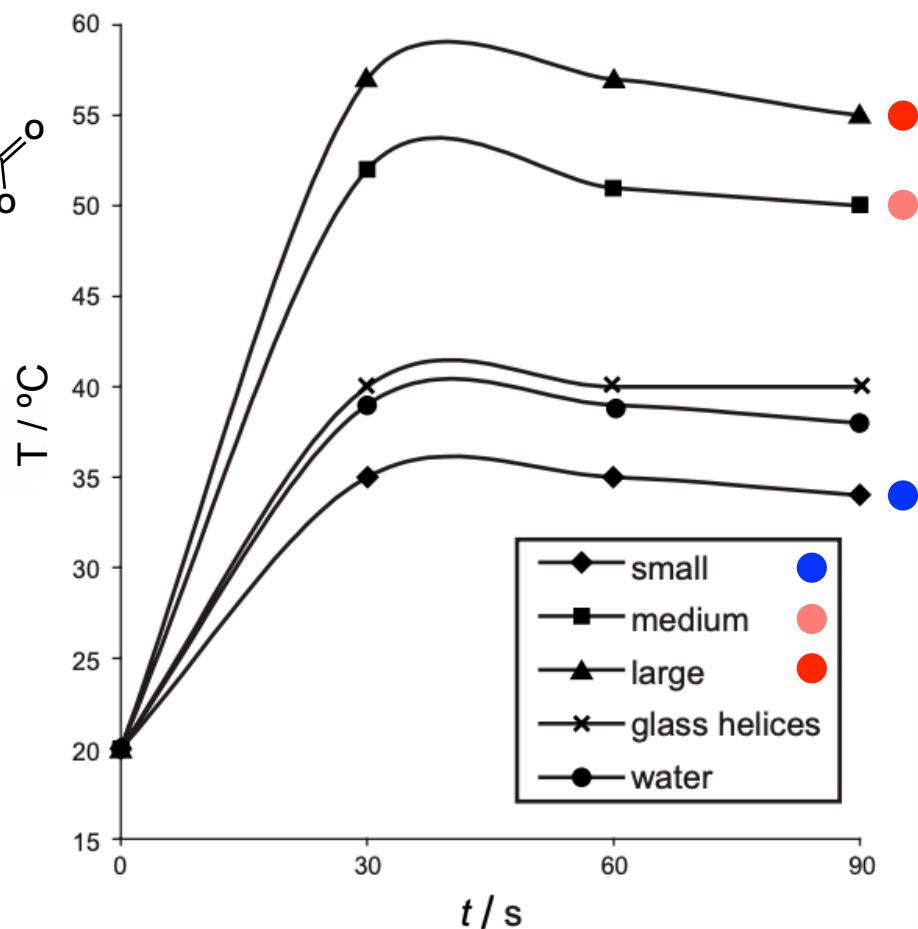
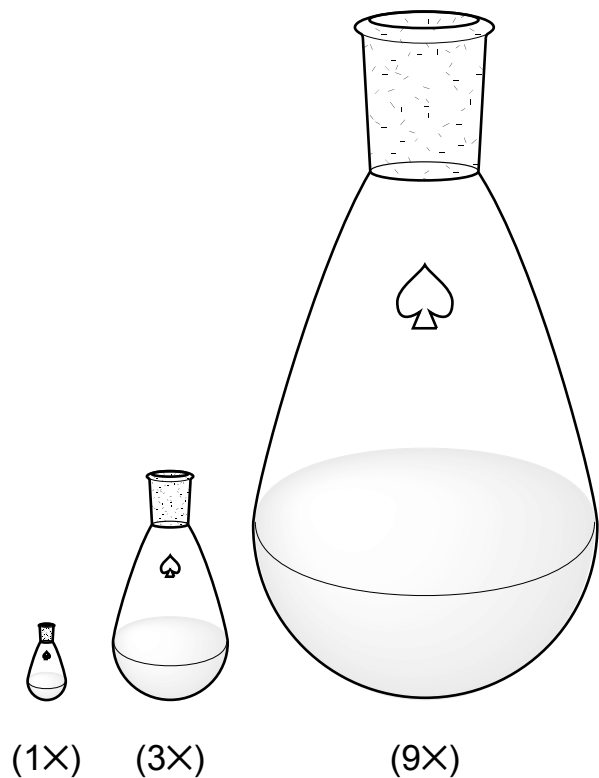
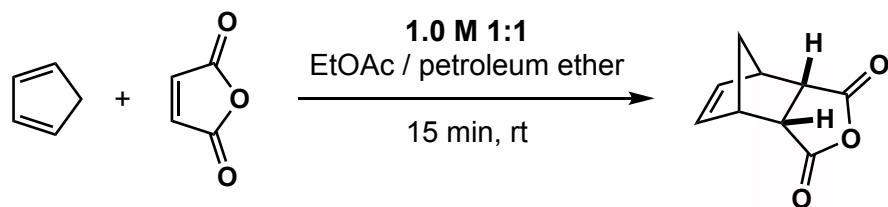


Figure 1. Dependence of reaction temperature on reaction size and the presence of glass helices or water in the Diels–Alder reaction between cyclopentadiene and maleic anhydride.

