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(54) **FERROCENYL DIPHOSPHINES AS LIGANDS FOR HOMOGENEOUS CATALYSTS**

(I)

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 (58) **Field of Search** **556/11, 14, 13, 556/22, 143; 502/152, 158**

(56) **References Cited**

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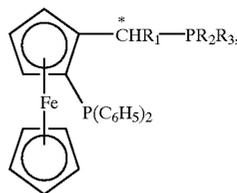
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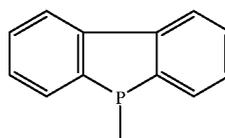
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(57) **ABSTRACT**

Compounds of formula I



wherein R_1 is C_1 - C_8 alkyl, phenyl or phenyl which is substituted by 1 to 3 C_1 - C_4 alkyl or C_1 - C_4 alkoxy groups; R_2 and R_3 are identical and are C_1 - C_{12} alkyl, C_5 - C_{12} cycloalkyl or C_1 - C_4 alkyl- or C_1 - C_4 alkoxy-substituted C_5 - C_{12} cycloalkyl, or phenyl which is substituted by one to three identical or different members selected from the group consisting of C_1 - C_4 alkyl, C_1 - C_4 alkoxy, $-\text{SiR}_4\text{R}_5\text{R}_6$, halogen, $-\text{SO}_3\text{M}$, $-\text{CO}_2\text{M}$, $-\text{PO}_3\text{M}$, $-\text{NR}_7\text{R}_8$ and $-\text{[}\oplus\text{NR}_7\text{R}_8\text{R}_9\text{]X}^\ominus$; or R_2 and R_3 are different and are C_1 - C_{12} alkyl, C_5 - C_{12} cycloalkyl, C_1 - C_4 alkyl- or C_1 - C_4 alkoxy-substituted C_5 - C_{12} cycloalkyl, phenyl or phenyl which is substituted by one to three identical or different members selected from the group consisting of C_1 - C_4 alkyl, C_1 - C_4 alkoxy, $-\text{SiR}_4\text{R}_5\text{R}_6$, halogen, $-\text{SO}_3\text{M}$, $-\text{CO}_2\text{M}$, $-\text{PO}_3\text{M}_2$, $-\text{NR}_7\text{R}_8$ and $-\text{[}\oplus\text{NR}_7\text{R}_8\text{R}_9\text{]X}^\ominus$; or the group $-\text{PR}_2\text{R}_3$ is a radical of formula II



(II)

and R_4 , R_5 and R_6 are each independently of one another C_1 - C_{12} alkyl or phenyl, R_7 and R_8 are H, C_1 - C_2 alkyl, phenyl or R_7 and R_8 , taken together, are tetramethylene, pentamethylene or 3-oxa-1,5-pentylene, R_9 is H or C_1 - C_4 alkyl, M is H or an alkali metal, X^\ominus is the anion of a monobasic acid, and * is a stereogenic carbon atom, in the form of their racemates and diastereomers or mixtures of diastereoisomers. Rhodium and iridium complexes with these ligands are suitable for use as homogeneous enantioselective catalysts for the hydrogenation of prochiral compounds, containing carbon double bonds or carbon/hetero atom double bonds.

14 Claims, No Drawings

FERROCENYL DIPHOSPHINES AS LIGANDS FOR HOMOGENEOUS CATALYSTS

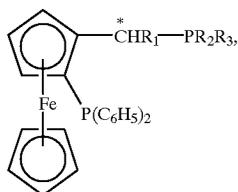
Matter enclosed in heavy brackets [] appears in the original patent but forms no part of this reissue specification; matter printed in italics indicates the additions made by reissue.

The present invention relates to 1-[2-(diphenylphosphino)ferrocenyl]alkylidene phosphines in the form of racemates and stereoisomers, to a process for their preparation, to iridium and rhodium complexes containing these ligands, and to the use thereof as enantioselective hydrogenation catalysts for the homogeneous hydrogenation of prochiral unsaturated compounds.

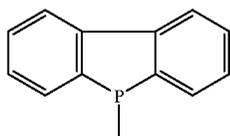
T. Hayashi et al. describe in Bull. Chem. Soc. Jpn., 53, pages 1136-1151, the preparation of a chiral ferrocenyl phosphine as ligand for transition metal complexes for asymmetric synthesis, namely [(R)-[(S)-2-(diphenylphosphino)ferrocenyl]ethyl]diphenylphosphine. Our investigations have revealed that homogeneous hydrogenation of prochiral compounds with rhodium complexes, which contain these ligands give only low optical yields.

It has now been found that, in the same or seven shorter reaction times, the enantioselectivity can be substantially enhanced if the substituents in the alkylidene phosphine group are not both phenyl.

In one of its aspects, the invention relates to compounds of formula I



wherein R_1 is C_1 - C_8 alkyl, phenyl or phenyl which is substituted by 1 to 3 C_1 - C_4 , alkyl or C_1 - C_4 alkoxy groups; R_2 and R_3 are identical and are C_1 - C_{12} alkyl, C_5 - C_{12} cycloalkyl or C_1 - C_4 alkyl- or C_1 - C_4 alkoxy-substituted C_5 - C_{12} cycloalkyl, or phenyl which is substituted by one to three identical or different members selected from the group consisting of C_1 - C_4 alkyl, C_1 - C_4 alkoxy, $-\text{SiR}_4\text{R}_5\text{R}_6$, halogen, $-\text{SO}_3\text{M}$, $-\text{CO}_2\text{M}$, $-\text{PO}_3\text{M}$, $-\text{NR}_7\text{R}_8$ and $-\text{[}\oplus\text{NR}_7\text{R}_8\text{R}_9\text{]X}^\ominus$; or R_2 and R_3 are different and are C_1 - C_{12} alkyl, C_5 - C_{12} cycloalkyl, C_1 - C_4 alkyl- or C_1 - C_4 alkoxy-substituted C_5 - C_{12} cycloalkyl, phenyl or phenyl which is substituted by one to three identical or different members selected from the group consisting of C_1 - C_4 alkyl, C_1 - C_4 alkoxy, $-\text{SiR}_4\text{R}_5\text{R}_6$, halogen, $-\text{SO}_3\text{M}$, $-\text{CO}_2\text{M}$, $-\text{PO}_3\text{M}_2$, $-\text{NR}_7\text{R}_8$ and $-\text{[}\oplus\text{NR}_7\text{R}_8\text{R}_9\text{]X}^\ominus$; or the group $-\text{PR}_2\text{R}_3$ is a radical of formula II



and R_4 , R_5 and R_6 are each independently of one another C_1 - C_{12} alkyl or phenyl, R_7 and R_8 are H, C_1 - C_{12} alkyl, phenyl or R_7 and R_8 , taken together, are tetramethylene,

pentamethylene or 3-oxa-1,5-pentylene, R_9 is H or C_1 - C_4 alkyl, M is H or an alkali metal, X^\ominus is the anion of a monobasic acid, and * is a stereogenic carbon atom, in the form of their racemates and diastereoisomers or mixtures of diastereoisomers.

R_1 as alkyl may be linear or branched and contains preferably 1 to 4 carbon atoms. Typical examples are methyl, ethyl, n- and isopropyl, n-, iso- and tert-butyl, pentyl, hexyl, heptyl and octyl. Methyl and ethyl are preferred and methyl is especially preferred.

R_1 as substituted phenyl preferably contains 1 or 2 substituents. Alkyl substituents may typically be methyl, ethyl, n- and isopropyl, n-, iso- and tert-butyl; methyl and ethyl are preferred. Alkoxy substituents may be methoxy, ethoxy, n- and isopropoxy, n-, iso- and tert-butoxy. Methoxy and ethoxy are preferred.

R_2 and R_3 as alkyl may be linear or branched and contain preferably 1 to 8, most preferably 1 to 4, carbon atoms. Typical examples are methyl, ethyl, n- and isopropyl, n-, iso- and tert-butyl, pentyl, hexyl, heptyl, octyl nonyl, decyl, undecyl and dodecyl. Methyl, ethyl, n- and isopropyl, n-, iso- and tert-butyl are preferred. When R_2 and R_3 are identical and alkyl they are most preferably isopropyl or tert-butyl.

R_2 and R_3 defined as cycloalkyl preferably contain 5 to 8, most preferably 5 or 6, ring carbon atoms. Exemplary of cycloalkyl are cyclopentyl, cyclohexyl, cycloheptyl, cyclooctyl, cyclodecyl and cyclododecyl. Cyclopentyl and cyclohexyl are preferred and cyclohexyl is especially preferred.

Cycloalkyl may be substituted, conveniently by 1 to 3 alkyl or alkoxy groups. Examples of such groups have been indicated above. Methyl and ethyl are preferred, as are also methoxy and ethoxy. Substituted cycloalkyl is typically methyl- and methoxycyclopentyl and methyl- and methoxycyclohexyl.

R_2 and R_3 defined as substituted phenyl preferably contains 1 or 2 substituents. Where phenyl contains 2 or 3 substituents, these may be identical or different.

Examples of alkyl and alkoxy substituents have been indicated above. Preferred alkyl and alkoxy substituents of phenyl are methyl, ethyl as well as methoxy and ethoxy.

Halogen as a substituent of phenyl may preferably be selected from the group consisting of $-\text{F}$, $-\text{Cl}$ and $-\text{Br}$.

R_4 , R_5 and R_6 may be linear or branched alkyl that preferably contains 1 to 8 and, most preferably, 1 to 4, carbon atoms. Exemplary alkyl substituents have been indicated above. Preferably alkyl is methyl, ethyl, n-propyl, n-butyl and tert-butyl. The substituent $-\text{SiR}_4\text{R}_5\text{R}_6$ is most preferably trimethylsilyl.

Among the acid phenyl substituents $-\text{SO}_3\text{M}$, $-\text{CO}_2\text{M}$ and $-\text{PO}_3\text{M}$, the $-\text{SO}_3\text{M}$ group is preferred. M is preferably H, Li, Na and K.

R_7 and R_8 as alkyl preferably contains 1 to 6, most preferably 1 to 4, carbon atoms. Alkyl is preferably linear. Preferred examples are methyl, ethyl, n-propyl and n-butyl. R_9 as alkyl is preferably methyl.

X^\ominus as anion of a monobasic acid is preferably Cl^\ominus , Br^\ominus or the anion of a carboxylic acid, typically formate, acetate, trichloroacetate or trifluoroacetate.

Representative examples of substituted phenyl are 2-methylphen-1-yl, 3-methylphen-1-yl, 4-methylphen-1-yl, 2- or 4-ethylphen-1-yl, 2- or 4-isopropylphen-1-yl, 2- or 4-tert-butylphen-1-yl, 2-methoxyphen-1-yl, 3-methoxyphen-1-yl, 4-methoxyphen-1-yl, 2- or 4-ethoxyphen-1-yl, 4-trimethylsilylphen-1-yl, 2- or 4-fluorophen-1-yl, 2,4-difluorophen-1-yl, 2- or

4-chlorophen-1-yl, 2,4-dichlorophen-1-yl, 2,4-dimethylphen-1-yl, 3,5-dimethylphen-1-yl, 2-methoxy-4-methylphen-1-yl, 3,5-dimethyl-4-methoxyphen-1-yl, 3,5-dimethyl-4-(dimethylamino)phen-1-yl, 2- or 4-aminophen-1-yl, 2- or 4-methylaminophen-1-yl, 2- or 4-(dimethylamino)phen-1-yl, 2- or 4-SO₃H-phen-1-yl, 2- or 4-SO₃Na-phen-1-yl, 2- or 4-[[⊕]NH₃Cl[⊖]]phen-1-yl, 3,4,5-trimethylphen-1-yl or 2,4,6-trimethylphen-1-yl.

R₂ and R₃ as identical substituents are preferably cyclohexyl, 2- or 4-methylphen-1-yl, 2- or 4-methoxyphen-1-yl, 2- or 4-(dimethylamino)phen-1-yl, 3,5-dimethyl-4-(dimethylamino)phen-1-yl and 3,5-dimethyl-4-methoxyphen-1-yl.

Where R₂ and R₃ are different substituents, R₂ is preferably phenyl and R₃ is preferably cyclohexyl, 2- or 4-methylphen-1-yl, 2- or 4-methoxyphen-1-yl, 4-(dimethylamino)phen-1-yl, 3,5-dimethyl-4-(dimethylamino)phen-1-yl, 3,5-dimethyl-4-methoxyphen-1-yl or 4-tert-butyl-phen-1-yl.

In a preferred embodiment of the invention, R₂ and R₃ are identical substituents and are cyclohexyl.

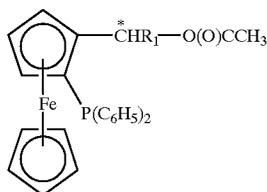
In another preferred embodiment of the invention, R₂ and R₃ are identical substituents and are tert-butyl or o-anisyl.

In yet a further preferred embodiment of the invention, R₂ is phenyl and R₃ is o-anisyl.

In a particularly preferred preferred embodiment of the invention, R₁ in formula I is methyl and R₂ and R₃ are each cyclohexyl.

In another of its aspects, the invention provides a process for the preparation of compounds of formula I, which comprises reacting a compound of formula III

(III)



in the presence of an inert solvent at room temperature or at elevated temperature, with a phosphine of formula IV



The reaction is known per se and is described by T. Hayashi et al. in Bull. Chem. Soc. Jpn., 53, pp. 1136-1151. The preparation of compounds of formula III is also described in this reference or can be carried out in analogous manner. The phosphines of formula IV are known or are obtainable by known methods in analogous manner.

The reaction temperature may be in the range from 20° to 150° C., preferably from 40° to 100° C. Suitable solvents are polar protic and aprotic solvents which may be used singly or as mixtures of two or more solvents. Typical examples of solvents are alkanols such as methanol and ethanol, and carboxylic acids such as formic acid and acetic acid.

The compounds of formula I are obtained as racemates, mixtures of stereoisomers or as stereoisomers, depending on whether the compounds of formula III are used as racemates, mixtures of stereoisomers or as stereoisomers. Mixtures of stereoisomers can be separated by known methods into the stereoisomers, preferably as a rule by chromatographic methods.

The compounds of formula I are isolated and purified by per se known methods, typically by distillation, extraction, crystallisation and/or chromatographic methods.

The compounds of formula I are suitable for use as ligands for rhodium and iridium complexes. In another of its aspects, the invention relates to complexes of formulae V and VI,



wherein X₁ is two C₂-C₁₂olefins or a C₅-C₁₂diene, Z is Cl, Br or I, A₁[⊖] is the anion of an oxyacid or complex acid, M₁ is Rh or Ir, and Y is a diphosphine of formula I. The complexes of formula VI are preferred.

With respect to the diphosphines of formula I, the same preferences and exemplifications apply as stated previously. X₁ as olefin preferably contains 2 to 6 and, most preferably, 2 to 4, carbon atoms. Ethylene is particularly preferred. Further examples are propene and 1-butene, X₁ as diene preferably contains 5 to 8 carbon atoms. The diene may be an open-chain or mono- or bicyclic diene. The two olefinic groups of the diene are preferably linked through one or two CH₂ groups. Typical examples are 1,3-pentadiene, cyclopentadiene, 1,5-hexadiene, 1,4-cyclohexadiene, 1,4- or 1,5-heptadiene, 1,4- or 1,5-cycloheptadiene, 1,4- or 1,5-octadiene, 1,4- or 1,5-cyclooctadiene, norbornadiene. X₁ is preferably two ethylene, 1,5-hexadiene, 1,5-cyclooctadiene or norbornadiene.

Z in formula V is preferably Cl or Br. Typical examples of A₁[⊖] in formula VI are ClO₄[⊖], FSO₃[⊖], CH₃SO₃[⊖], CF₃SO₃[⊖], BF₄[⊖], PF₆[⊖], SbCl₆[⊖], AsF₆[⊖] and SbF₆[⊖]. Preferably A₁ is [⊖]ClO₄[⊖], CF₃SO₃[⊖], BF₄[⊖], PF₆[⊖] and SbF₆[⊖].

The novel complexes are obtained in per se known manner by the reaction of equimolar amounts of a compound of formula I with a metal complex of formula [M₁(X₁)Z]₂ or M₁(X₁)₂[⊕]A₁[⊖], wherein M₁, X₁, Z and A₁[⊖] have the meanings previously assigned to them. The metal complexes are known, q.v. inter alia EP-A-0 302 021 and U.S. Pat. No. 5,011,995.

The reaction is conveniently carried out under an inert gas atmosphere, typically argon, and expediently in the temperature range from 0° to 40° C., preferably at room temperature. The concurrent use of a solvent or mixture of solvents is advantageous, conveniently selected from the group consisting of hydrocarbons (benzene, toluene, xylene), halogenated hydrocarbons (methylene chloride, chloroform, chlorobenzene), alkanols (methanol, ethanol, ethylene glycol monomethyl ether), and ethers (diethyl ether, dibutyl ether, ethylene glycol dimethyl ether, tetrahydrofuran, dioxane) or mixture thereof. The novel complexes can be isolated and purified by conventional methods, or they can be prepared in situ prior to hydrogenation and then used in dissolved form direct as hydrogenation catalyst.

The novel complexes are preeminently suitable for use as homogeneous catalysts for the enantioselective hydrogenation of prochiral compounds containing carbon double bonds and carbon/hetero atom double bonds, typically compounds that contain a group selected from C=C, C=N, C=O, C=C-N and C=C-O [q.v. inter alia K. E. König, The Applicability of Asymmetric Homogeneous Catalysis, in James D. Morrison (ed.), Asymmetric Synthesis, Vol. 5, Academic Press, 1985]. Examples of such compounds are prochiral olefins, enamines, imines and ketones. Surprisingly high yields are obtained, normally even a quantitative chemical conversion, in short reaction times. Particularly surprising are the very high optical yields which are obtained with the novel complexes. The enantiomer excess

methoxyphenyl)phosphine. The yield is 555 mg of C (54%) as an orange crystalline substance. ³¹P-NMR (CDCl₃): -6.1(d,J=16), -25.5(d,J=16)(1st stereoisomer); -7.9(d,J=14), -25.1(d,J=14)(2nd stereoisomer).

Example A4:

[Norbornadiene-{(R)-1-[(S)-2-diphenylphosphino]ferrocenyl}]ethyl-dicyclohexylphosphinorhodium tetrafluoroborate](D)

In a 25 ml Schlenk flask, 100 mg (0.267 mmol) of bis(norbornadiene)rhodium tetrafluoroborate are dissolved, under argon, in 10 ml of a mixture of methanol/methylene chloride (1:1) and then 159 mg (0.267 mmol) of A are added. This reaction is stirred for 60 minutes at room temperature and the solvent is subsequently removed under a high vacuum. The crude product is dissolved in 4 ml of methylene chloride. Precipitation with 15 ml of diethyl ether gives 192 mg of an orange crystalline substance (D) (82%), ³¹P-NMR (CDCl₃): 23.1(J_{RhP}=153, J_{PP}=36), 52.6(J_{RhP}=154, J_{PP}=36).

Example A5:

{(R)-1-[(S)-2-(diphenylphosphino)ferrocenyl]}ethyl-di-tert-butylphosphine (E)

The general procedure described in Example A1 is repeated, but using 1 g of (R)-(S)-PPFOAc (2.2 mmol) and 0.37 g of di-tert-butylphosphine (2.5 mmol). The yield is 704 mg of E (59%) as an orange crystalline substance. ³¹P-NMR (CDCl₃): 49.9(d,J=50), -26.1(d,J=50).

Example A6:

{(R)-1-[(S)-2-(diphenylphosphino)ferrocenyl]}ethyl-bis(2,4,6-trimethylphenyl)phosphine (F)

The general procedure described in Example A1 is repeated, but using 0.5 g of (R)-(S)-PPFOAc (1.1 mmol) and 0.37 g of bis(2,4,6-trimethylphenyl)phosphine (13.3 mmol). The yield is 313 mg of F (47%) as an orange crystalline substance. ³¹P-NMR (CDCl₃): -6.8(d,J=17), -25.0(d,J=17).

Example A7:

{(R)-1-[(S)-2-(diphenylphosphino)ferrocenyl]}ethyl-bis(4-methoxyphenyl)phosphine (G)

The general procedure described in Example A1 is repeated, but using 0.548 g (1.2 mmol) of (R)-(S)-PPFOAc and 0.29 ml of bis(4-methoxyphenyl)phosphine (1.3 mmol). The yield is 0.3 g (39%) as an orange foam. ³¹P-NMR (CDCl₃): 2.5(d,J=16), -25.5(d,J=16).

Example A8:

{(R_p)-(R)-1-[(S)-2-(diphenylphosphino)ferrocenyl]}ethyl-(2-methoxyphenyl)phenylphosphine (H)

2.793 g of the mixture of diastereoisomers C (4.6 mmol) are added to a suspension of 1.325 g of [Pd₂Cl₂((R)-(+)-C₆H₄CHCH₃N(CH₃)₂)] (2.3 mmol) in 25 ml of methanol. The resultant red solution is stirred at room temperature for 30 minutes and then filtered. A solution of 0.372 g of NH₄PF₆ (2.3 mmol) in 6 ml of H₂O is slowly added dropwise and the orange suspension is stirred for a further 16 hours. The yellow precipitate is collected by filtration and washed with 20 ml of methanol (50%) and 20 ml of Et₂O. (The working up of filtrate I is described in Example A9).

Two recrystallisations from acetone give 1.4 g of [Pd((R)-(+)-C₆H₄CHCH₃N(CH₃)₂(H))] (Yield: 61%). ³¹P-NMR (CDCl₃): 57.0(d, J=43.8), 4.7(d,J=43.8).

1.2 g of [Pd((R)-(+)-C₆H₄CHCH₃N(CH₃)₂(H))] (1.19 mmol) are dissolved in a mixture of 9 ml of acetone and 0.8 ml of hydrochloric acid (10N) and the solution is stirred for 10 minutes at reflux temperature. Then 20 ml of water are added at room temperature. The orange suspension is concentrated and filtered. The orange-red solid is washed with water and dried under a high vacuum. To a suspension of this solid in 20 ml of methanol are added 3.0 g of KCN (46.1 mmol). After addition of 10 ml of water and 15 ml of dichloromethane two phases form. The organic phase is dried over MgSO₄ and concentrated. Chromatography of the orange powder (basic alumina, hexane/ethyl acetate=9:1) gives the free ligand H in quantitative yield. Recrystallisation from ethanol gives the pure diastereoisomer ligand in a yield of 0.589 g (81.4%). ³¹P-NMR (CDCl₃): -6.1(d,J=16), -25.5(d,J=16).

Example A9:

{(S_p)-(R)-1-[(S)-2-(diphenylphosphino)ferrocenyl]}ethyl-(2-methoxyphenyl)phenylphosphine (J)

The general procedure described in Example A8 is repeated. The filtrate I obtained in Example A8 is reacted with a solution of 0.5 g of NH₄PF₆ (3.1 mmol) in 6 ml of water. The brownish-red precipitate is collected by filtration and washed with 20 ml of aqueous methanol (50%) and 20 ml of Et₂O. Two recrystallisations from acetone/Et₂O give 1.2 g of red crystals (yield: 52%). ³¹P-NMR (CDCl₃): 30.6(d,J=43.5), 36.2(d,J=43.5). 1.2 g of [Pd((R)-(+)-C₆H₄CHCH₃N(CH₃)₂(J))] (1.19 mmol) are reacted with KCN as described in Example A8, giving 0.617 g (yield: 85%) of pure diastereoisomer J. ³¹P-NMR (CDCl₃): -7.9(d,J=14), -25.1(d,J=14).

Example A10:

{(R)-1-[(S)-2-(diphenylphosphino)ferrocenyl]}ethyl-bis(4-trifluoromethylphenyl)phosphine (K)

The general procedure described in Example A1 is repeated, but using 1.0 g of (R)-(S)-PPFOAc (2.2 mmol) and 0.82 g of bis(4-trifluoromethylphenyl)phosphine (2.55 mmol). The yield is 1.20 g of K (76%) as an orange crystalline substance. ³¹P-NMR (CDCl₃): 6.6(d,J=24), -26.4(d,J=24).

B) USE EXAMPLES

Example B1: Preparation of N-acetylalanine methyl ester

A catalyst solution (prepared under argon) consisting of 12.9 mg (0.034 mmol) of [Rh(norbornadiene)₂]BF₄, 19.0 mg (0.037 mmol) of A and 5 ml of methanol is transferred by a steel capillary to a 200 ml glass reactor under argon. A solution of 750 mg (3.42 mmol) of Z-methyl-2-acetoamidocinnamate (substrate) and 5 ml of methanol are then added in analogous manner. The molar ratio of substrate/catalyst is 100. Then hydrogenation is carried out with hydrogen in three cycles under a pressure of 0.1 MPa and the hydrogen pressure is adjusted to 0.108 MPa. The reaction mixture is stirred for 30 minutes at 25° C. and then transferred to a flask and the solvent is stripped off on a rotary evaporator. The chemical conversion is 100%, and the N-acetylalanine methyl ester is obtained in an enantiomer excess (ee) of 94% (R).

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Example B2: Preparation of N-acetylalanine methyl ester

The general procedure described in Example B1 is repeated, with the following modifications to the reaction conditions: 24.4 mg (0.037 mmol) of B; reaction time 1 hour; hydrogen pressure 50 bar. The conversion is 100%, ee: 83% (R).

Example B3: Preparation of N-acetylalanine methyl ester

The general procedure described in Example B1 is repeated, with the following modifications to the reaction conditions: [Rh(norbornadiene)₂]BF₄ 8.3 mg (0.022 mmol); 15 mg (0.025 mmol) of C (ratio of the two stereoisomers 1); Z-methyl-2-acetamidocinnamate 0.49 g (2.22 mmol); reaction time 2 hours. The conversion is 100%, ee: 79% (R).

Example B4: Preparation of dimethyl-2-methylsuccinate

The general procedure described in Example B1 is repeated, with the following modifications to the reaction conditions: [Rh(norbornadiene)₂]BF₄ 11.8 mg (0.032 mmol); 20.7 mg (0.035 mmol) of A; dimethyl itaconate (substrate) 0.5 g (3.2 mmol); reaction time 30 minutes. The conversion is 100%, ee>95%.

Example 5: Preparation of N-acetylalanine methyl ester

The general procedure described in Example B1 is repeated, with the following modifications to the reaction conditions: [Rh((norbornadiene)Cl)₂]: 3.9 mg (0.0085 mmol); E: 10.3 mg (0.019 mmol); solvent: 11 ml of toluene/methanol (10:1); hydrogen: 15 bar, temperature: 0° C.; reaction time: 20 hours. The conversion is 100%, ee: 73.6% (R).

Example B6: Preparation of N-(2',6'-dimethylphenyl)-1-methoxymethylethylamine

The general procedure described in Example B1 is repeated, with the following modifications to the reaction conditions: A catalyst solution is prepared consisting of 5.3 mg of [Ir((1,5-cyclooctadiene)Cl)₂] (0.0079 mmol), 10.2 mg of A (0.017 mmol) and 11.9 mg of tetrabutylammonium iodide (0.032 mmol) in 5 ml of tetrahydrofuran/dichloromethane (1:1). A substrate solution consisting of 1.5 g of N-(2',6'-dimethylphenyl)-1-methoxymethylethylideneamine (7.8 mmol) in 5 ml of tetrahydrofuran is also used. Hydrogenation is carried out with hydrogen under a pressure of 40 bar. The reaction temperature is 30° C. After 91 hours the conversion is 90%, the ee is 59% CR.

Example 7: Preparation of N-(2',6'-dimethylphenyl)-1-methoxymethylethylamine

The general procedure described in Example B1 is repeated, with the following modifications to the reaction conditions: A catalyst solution is prepared consisting of 5.3 mg of [Ir((1,5-cyclooctadiene)Cl)₂] (0.0079 mmol) and 11.1 mg of G (0.017 mmol); reaction time: 20 hours. The conversion is 100%, ee: 56.6% (S).

Example B8: Preparation of methyl-2-hydroxy-2-phenylacetate

The general procedure described in Example B1 is repeated, with the following modifications to the reaction

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conditions: [Rh((norbornadiene)Cl)₂]: 3.9 mg (0.0082 mmol); E: 9.7 mg (0.018 mmol); methyl phenyl glyoxylate (substrate): 0.268 mg (1.64 mmol); solvent: 10 ml of toluene; hydrogen: 40 bar, temperature: 70° C.; reaction time: 20 hours. The conversion is 100%, ee: 41%.

Example B9: Preparation of N-acetylalanine

The general procedure described in Example B1 is repeated, with the following modifications to the reaction conditions: acetamidocinnamic acid (substrate): 0.83 g (3.43 mmol). The conversion is 100%, ee: 81% (R).

Example B10: Preparation of N-acetylalanine methyl ester

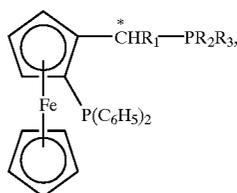
The general procedure described in Example B1 is repeated, with the following modifications to the reaction conditions: H: 18.3 mg (0.037 mmol). The conversion is 100%, ee: 79% (R).

Example B11: Preparation of ethyl-4-phenyl-2-hydroxybutyrate

The general procedure described in Example B1 is repeated, with the following modifications to the reaction conditions: ethyl-4-phenyl-2-oxobutyrate (substrate): 0.352 g (1.7 mmol); solvent: 10 ml of toluene/methanol (1:1); hydrogen: 50 bar, temperature: 50° C.; reaction time: 19 hours. The conversion is 100%, ee: 44% (R).

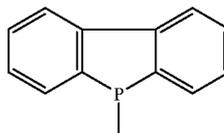
What is claimed is:

[1. A compound of formula I



(I)

wherein R₁ is C₁-C₈alkyl, phenyl or phenyl which is substituted by 1 to 3 C₁-C₄alkyl or C₁-C₄alkoxy groups; R₂ and R₃ are identical and are C₁-C₁₂alkyl, C₅-C₁₂cycloalkyl or C₁-C₄alkyl- or C₁-C₄alkoxy-substituted C₅-C₁₂cycloalkyl or phenyl which is substituted by one to three identical or different members selected from the group consisting of C₁-C₄alkyl, C₁-C₄alkoxy, -SiR₄R₅R₆, halogen, -SO₃M, -CO₂M, -PO₃M, -NR₇R₈ and -[⊕NR₇R₈R₉]X[⊖]; or R₂ and R₃ are different and are C₁-C₁₂alkyl, C₅-C₁₂cycloalkyl, C₁-C₄alkyl- or C₄alkoxy-substituted C₅-C₁₂cycloalkyl, phenyl or phenyl which is substituted by one to three identical or different members selected from the group consisting of C₁-C₄alkyl, C₁-C₄alkoxy, -SiR₄R₅R₆, halogen, -SO₃M, -CO₂M, -PO₃M₂, -NR₇R₈ and -[⊕NR₇R₈R₉]X[⊖]; or the group -PR₂R₃ is a radical of formula II



and R₄, R₅ and R₆ are each independently of one another C₁-C₁₂alkyl or phenyl, R₇ and R₈ are H, C₁-C₁₂alkyl,

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phenyl, or R_7 and R_8 , taken together, are tetramethylene, pentamethylene or 3-oxa-1,5-pentylene, R_9 is H or C_1-C_4 alkyl, M is H or an alkali metal, X^\ominus is the anion of a monobasic acid, and * is a stereogenic carbon atom, in the form of the racemate or diastereoisomer or mixture of diastereoisomers.]

2. A compound of formula I according to claim [1] 16, wherein R_1 is C_1-C_4 alkyl.

3. A compound of formula I according to claim 2, wherein R_1 is methyl or ethyl.

4. A compound of formula I according to claim [1] 16, wherein R_1 is phenyl or phenyl which is substituted by 1 or 2 C_1-C_4 alkyl or C_1-C_4 alkoxy groups.

5. A compound of formula I according to claim [1] 16, wherein R_2 and R_3 are C_1-C_8 alkyl.

6. A compound of formula I according to claim [1] 16, wherein R_2 and R_3 are identical and are isopropyl or tert-butyl.

7. A compound of formula I according to claim [1] 16, wherein R_2 and R_3 as cycloalkyl contain 5 to 8 ring carbon atoms.

8. A compound of formula I according to claim 7 wherein R_2 and R_3 as cycloalkyl are cyclopentyl or cyclohexyl.

[9. A compound of formula I according to claim 1, wherein R_2 and R_3 as substituted phenyl are selected from the group consisting of 2-methylphen-1-yl, 3-methylphen-1-yl, 4-methylphen-1-yl, 2- or 4-ethylphen-1-yl, 2- or 4-isopropylphen-1-yl, 2- or 4-tert-butylphen-1-yl, 2-methoxyphen-1-yl, 3-methoxyphen-1-yl, 4-methoxyphen-1-yl, 2- or 4-ethoxyphen-1-yl, 4-trimethylsilyphen-1-yl, 2- or 4-fluorophen-1-yl, 2,4-difluorophen-1-yl, 2- or 4-chlorophen-1-yl, 2,4-dichlorophen-1-yl, 2,4-dimethylphen-1-yl, 3,5-dimethylphen-1-yl, 2-methoxy-4-methylphen-1-yl, 3,5-dimethyl-4-methoxyphen-1-yl, 3,5-dimethyl-4-(dimethylamino)-phen-1-yl, 2- or 4-aminophen-1-yl, 2- or 4-methylaminophen-1-yl, 2- or 4-(dimethylamino)phen-1-yl, 2- or 4- SO_3H -phen-1-yl, 2- or 4- SO_3Na -phen-1-yl, 2- or 4- $[\oplus NH_3 Cl^\ominus]$ phen-1-yl, 3,4,5-trimethylphen-1-yl and 2,4,6-trimethylphen-1-yl.]

10. A compound of formula I according to claim [1] 16, wherein R_2 and R_3 are identical substituents selected from the group consisting of cyclohexyl, 2- or 4-methylphen-1-yl, 2- or 4-methoxyphen-1-yl, 2- or 4-(dimethylamino)phen-1-yl, 3,5-dimethyl-4-(dimethylamino)phen-1-yl and 3,5-dimethyl-4-methoxyphen-1-yl.

11. A compound of formula I according to claim [1] 16, wherein R_2 and R_3 are different and R_2 is phenyl and R_3 is selected from the group consisting of cyclohexyl, 2- or 4-methylphen-1-yl, 2- or 4-methoxyphen-1-yl, 3,5-dimethyl-4-(dimethylamino)phen-1-yl, 3,5-dimethyl-4-methoxyphen-1-yl and 4-tert-butyl-phen-1-yl.

12. A compound of formula I according to claim [1] 16, wherein R_2 and R_3 are identical substituents and are cyclohexyl.

13. A compound of formula I according to claim [1] 16, wherein R_2 and R_3 are identical substituents and are tert-butyl or o-anisyl.

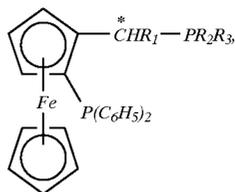
14. A compound of formula I according to claim [1] 16, wherein R_2 is phenyl and R_3 is o-anisyl.

[15. A compound of formula I according claim 1, wherein R_1 is methyl and R_2 and R_3 are each cyclohexyl.]

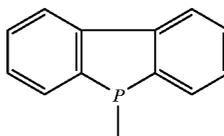
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16. A compound of formula I

(I)



wherein R_1 is C_1-C_8 alkyl, phenyl or phenyl which is substituted by 1 to 3 C_1-C_4 alkyl or C_1-C_4 alkoxy groups; R_3 and R_3 are identical and are C_1-C_{12} alkyl, C_5-C_{12} cycloalkyl or C_1-C_4 alkyl- or C_1-C_4 alkoxy-substituted C_5-C_{12} cycloalkyl or phenyl which is substituted by one to three identical or different members selected from the group consisting of C_1-C_4 alkyl, C_1-C_4 alkoxy, $-SiR_4R_5R_6$, halogen, $-SO_3M$, $-CO_2M$, $-PO_3M$, $-NR_7R_8$ and $-\{ \oplus NR_7R_8R_9 \} X^\ominus$; or R_2 and R_3 are different and are C_1-C_{12} alkyl, C_5-C_{12} cycloalkyl, C_1-C_4 alkyl- or C_1-C_4 alkoxy-substituted C_5-C_{12} cycloalkyl, phenyl or phenyl which is substituted by one to three identical or different members selected from the group consisting of C_1-C_4 alkyl, C_1-C_4 alkoxy, $-SiR_4R_5R_6$, halogen, $-SO_3M$, $-CO_2M$, $-PO_3M_2$, $-NR_7R_8$ and $-\{ \oplus NR_7R_8R_9 \} X^\ominus$; or a group $-PR_2R_3$ is a radical of formula II



and R_4 , R_5 and R_6 are each independently of one another C_1-C_{12} alkyl or phenyl, R_7 and R_8 are H, C_1-C_{12} alkyl, phenyl, or R_7 and R_8 , taken together, are tetramethylene, pentamethylene or 3-oxa-1,5-pentylene, R_9 is H or C_1-C_4 alkyl, M is H or an alkali metal, X^\ominus is the anion of a monobasic acid, and * is a stereogenic carbon atom, in the form of the racemate or diastereoisomer or mixture of diastereoisomers, excluding the compound of formula I wherein R_1 is methyl and R_2 and R_3 are each cyclohexyl, and the compound of formula I wherein R_1 is methyl and the group $-PR_2R_3$ is a radical of formula II.

17. A compound of formula I according to claim 16, wherein R_2 and R_3 as substituted phenyl are selected from the group consisting of 2-methylphen-1-yl, 3-methylphen-1-yl, 4-methylphen-1-yl, 2- or 4-ethylphen-1-yl, 2- or 4-isopropylphen-1-yl, 2- or 4-tert-butylphen-1-yl, 2-methoxyphen-1-yl, 3-methoxyphen-1-yl, 4-methoxyphen-1-yl, 2- or 4-ethoxyphen-1-yl, 4-trimethylsilyphen-1-yl, 2- or 4-fluorophen-1-yl, 2,4-difluorophen-1-yl, 2- or 4-chlorophen-1-yl, 2, 4-dichlorophen-1-yl, 2,4-dimethylphen-1-yl, 3,5-dimethylphen-1-yl, 2-methoxy-4-methylphen-1-yl, 3,5-dimethyl-4-methoxyphen-1-yl, 3,5-dimethyl-4-(dimethylamino)-phen-1-yl, 2- or 4-aminophen-1-yl, 2- or 4-methylaminophen-1-yl, 2- or 4-(dimethylamino)phen-1-yl, 2- or 4- SO_3H -phen-1-yl, 2- or 4- SO_3Na -phen-1-yl, 2- or 4- $[\oplus NH_3 Cl^\ominus]$ phen-1-yl, 3,4,5-trimethylphen-1-yl and 2,4,6-trimethylphen-1-yl.

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