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(54) Title: PROCESS FOR THE PREPARATION OF A CARBOXAMIDE DERIVATIVE

(57) Abstract: Process for the preparation of a carboxamide derivative of general formula (I) or a salt thereof Intermediates for preparing this compound.

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Process for the preparation of a carboxamide derivative

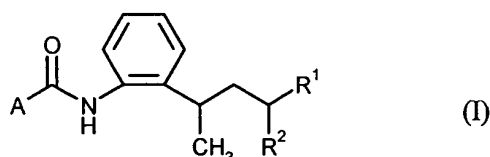
The present invention relates to a novel process for the preparation of a carboxamide derivative which is useful as a pesticide compound, starting with a nitrobenzene derivative.

Patent application EP-A-0824099 discloses a process for the preparation of a carboxamide derivative starting from a nitrobenzene derivative. The process disclosed in this patent application presents the drawback in that the aromatic amine is prepared by reacting a nitro derivative with a Grignard reagent. This reaction yields to numerous by-products which decreases severely the reaction yield. This process can not be used at an industrial scale.

Furthermore, Journal of Organometallic Chemistry **2001**, *624*, pages 167-171 teaches that quenching the reaction with ammonia allows to increase the selectivity and thus, the reaction yield, but that such a process is not efficient when secondary magnesium halides are involved.

We have now found an alternative method to prepare carboxamide derivative from nitro compounds which overcomes these problems and which is applicable to industrial scale operation.

Accordingly, the present invention relates to a process for the preparation of a carboxamide derivative of general formula (I) or a salt thereof



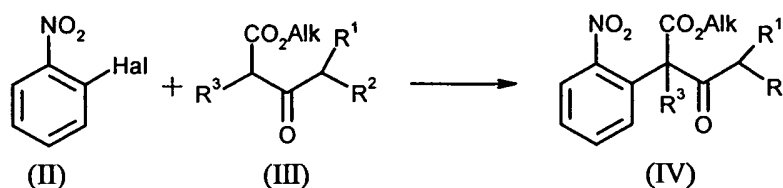
in which:

- R^1 represents a methyl group, an ethyl group or a C_1 - C_4 -haloalkyl group substituted with 1 to 9 halogen atoms chosen from fluorine, chlorine and bromine;
- R^2 represents a halogen atom, a C_1 - C_4 -alkyl group or a C_1 - C_4 -haloalkyl group substituted with 1 to 9 halogen atoms chosen from fluorine, chlorine and bromine; and
- A represents an optionally substituted 5-, 6- or 7-membered non-fused heterocycle with one, two or three heteroatoms which may be the same or different, the heterocycle being linked by a carbon atom;

said process comprising:

(A) a first step according to reaction Scheme 1:

Scheme 1



in which:

R¹ and R² are as defined above; and

5 R³ represents a hydrogen atom or a methyl group;

Hal represents a halogen atom; and

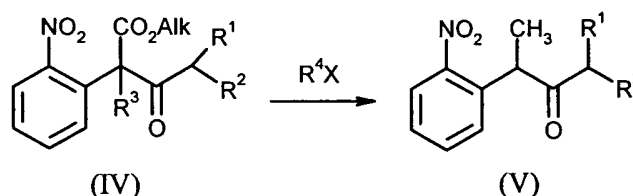
Alk represents a C₁-C₁₀ alkyl group;

comprising the reaction of a nitrobenzene derivative of general formula (II) with a ketoester derivative of general formula (III), in a compound (III) / compound (II) molar ratio of from 1 to 10, in a solvent and in the presence of a base, the base / compound (II) molar ratio being of from 0.5 to 5;

to provide a nitrophenyl ketoester derivative of general formula (IV);

(B) a second step according to reaction Scheme 2:

Scheme 2



15

in which:

R¹ and R² are as defined above; and

R³ represents a hydrogen atom or a methyl group;

Alk represents a C₁-C₁₀ alkyl group;

20 R⁴ represents a hydrogen atom or a metal specie; and

X represents a halogen atom;

comprising:

a) in the case R³ is a methyl group, the decarboxylation reaction of a nitrophenyl ketoester derivative of formula (IV) obtained in step one in the presence of an agent R⁴X, in a (R⁴X) / compound (IV) molar ratio of from 0.1 to 50; in a solvent and at a temperature of from 20°C to 180°C; or

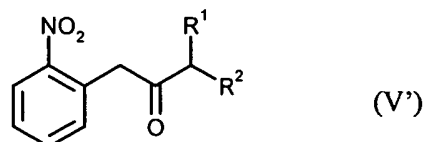
25

b) in the case R³ is a hydrogen atom,

1/ the decarboxylation of a nitrophenyl ketoester derivative of formula (IV) obtained in step one in the presence of an agent R⁴X, in a (R⁴X) / compound

(III) molar ratio of from 0.1 to 50; in a solvent and at a temperature of from 20°C to 180°C;

which is then completed by the methylation of the intermediate of general formula (V') previously obtained



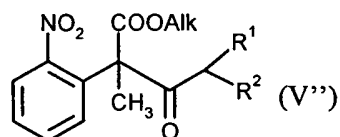
by adding methylating agent, in a methylating agent / compound (V') molar ratio of from 0.5 to 2; in a solvent and in the presence of a base, in a base / compound (V') molar ratio of from 0.5 to 2;

to provide a nitrophenyl ketone derivative of general formula (V);

or

2/ the methylation of a nitrophenyl ketoester derivative of formula (IV) obtained in step one by adding methylating agent, in a methylating agent / compound (IV) molar ratio of from 0.5 to 2; in a solvent and in the presence of a base, in a base / compound (IV) molar ratio of from 0.5 to 2;

which is then completed by the decarboxylation of the intermediate of general formula (V'') previously obtained

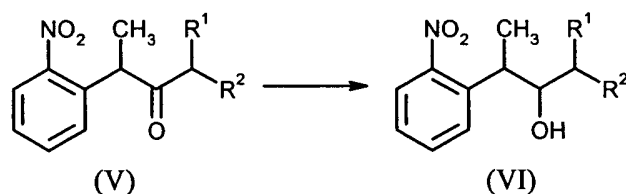


in the presence of an agent R⁴X, in a (R⁴X) / compound (V'') molar ratio of from 0.1 to 50; in a solvent and at a temperature of from 20°C to 180°C;

to provide a nitrophenyl ketone derivative of general formula (V);

(C) a third step according to reaction Scheme 3:

Scheme 3



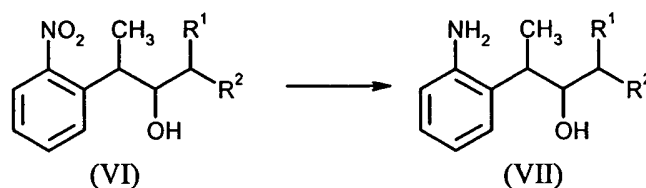
in which R¹ and R² are as defined above;

comprising the reduction of a nitrophenyl ketone of general formula (V) obtained in step two by adding to it from 0.5 to 10 molar equivalent of a reduction agent, in a polar protic solvent and at a temperature of from -20°C to 80°C;

to provide a nitrophenyl alcohol derivative of general formula (VI);

(D) a fourth step according to reaction Scheme 4:

Scheme 4

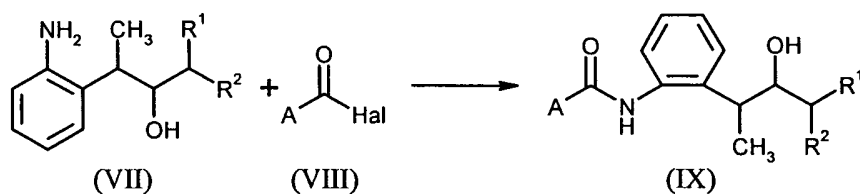


in which R¹ and R² are as defined above;

- 5 comprising the reduction by H₂ of a nitrophenyl alcohol of general formula (VI) obtained in step three in the presence of a metal catalyst, in a solvent and under a pressure of from 1 to 10 bar;
to provide an aminophenyl alcohol derivative of general formula (VII);

10 (E) a fifth step according to reaction Scheme 5:

Scheme 5



in which:

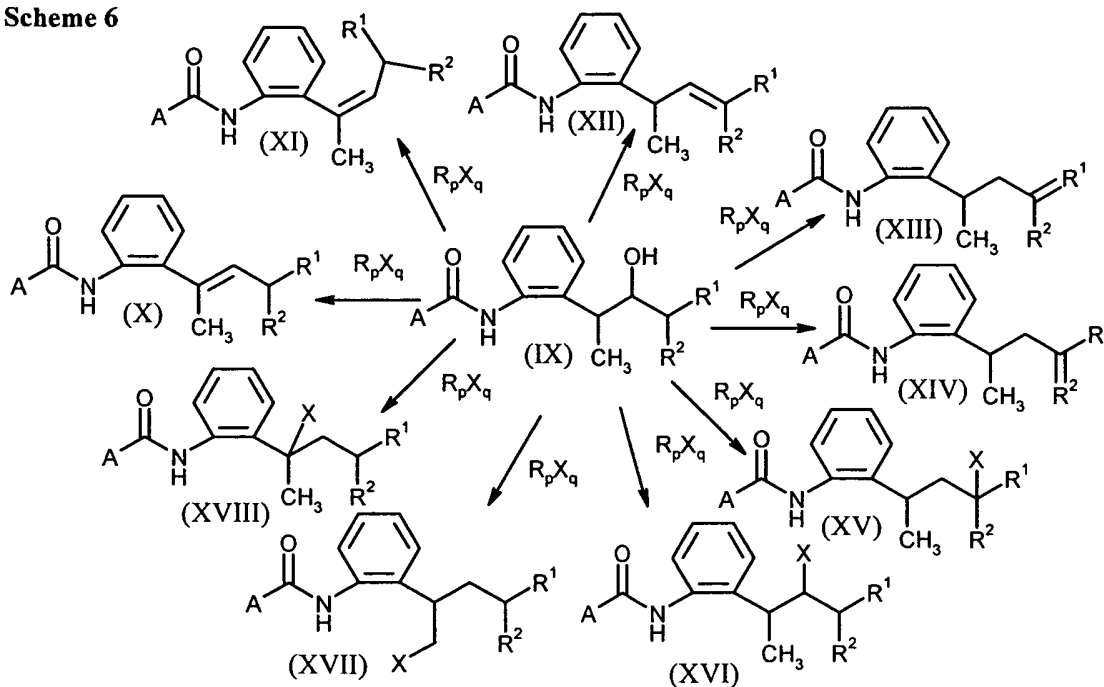
A, R¹ and R² are as defined above; and

Hal represents a halogen atom;

- 15 comprising the coupling reaction of an aminophenyl alcohol derivative of general formula (VII) obtained in step four with an acyl halide derivative of general formula (VIII), in a solvent and in the presence of a base in a base / compound (VII) molar ratio of 0.5 to 3;
to provide a hydroxycarboxamide derivative of general formula (IX);

(F) a sixth step according to reaction Scheme 6:

Scheme 6



in which:

A, R^1 and R^2 are as defined above;

p and q are independently chosen as being 1, 2 or 3;

R represents a phosphorous atom, $-P=O$, $-S=O$, a mesyl group or a tosyl group;

X represents a halogen atom;

comprising the reaction of a hydroxycarboxamide derivative of general formula (IX) obtained in step five with a compound of formula R_pX_q at a temperature of from 0°C to 100°C ;

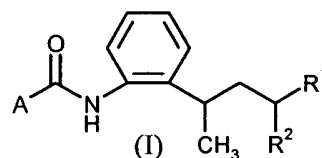
to provide a carboxamide derivative of general formula (X), (XI), (XII), (XIII), (XIV), (XV), (XVI), (XVII) or (XVIII), or a mixture thereof;

(G) a seventh step according to reaction Scheme 7:

Scheme 7

Mixture of carboxamide derivatives of formula (X) to (XVIII)

Reduction



in which A, R^1 and R^2 are as defined above;

comprising the reduction by H_2 of all carboxamide derivatives of general formula (X) to (XVIII) obtained in step six, in the presence of a metal catalyst, in a solvent, at a temperature of from 10°C to 250°C and under a pressure of from 1 to 50 Bar;

to provide a carboxamide derivative of general formula (I).

For the purposes of the present invention:

a halogen atom may be a bromine atom, a chlorine atom, an iodine atom or a fluorine atom; preferably, halogen atom means chlorine atom;

carboxy means -C(=O)OH ; carbonyl means -C(=O)- ; carbamoyl means -C(=O)NH_2 ; - an alkyl group as well as moieties containing this term, can be linear or branched;

5 a heteroatom may be a sulphur, a nitrogen or an oxygen atom; and

a "metal specie" means alkali metal or alkaline earth metal. Preferably, a "metal specie" means a specie chosen from Li, Na or K;

DMA means dimethylacetamide;

DME means 1,2-dimethoxyethane;

10 DMF means dimethylformamide;

DMSO means dimethyl sulfoxide;

MTBE means methyl *tert*-butyl ether;

NMP means 1-methyl-2-pyrrolidinone; and

THF means tetrahydrofuran.

15

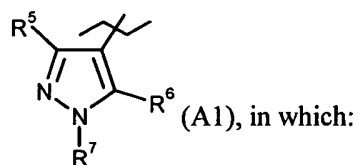
Process according to the present invention allows production of a compound of formula (I) starting from a nitro derivative in good yields. This process can be used at an industrial scale.

According to the present invention, substituent R^1 of the compound of general formula (I) is defined as
20 being a methyl group, an ethyl group or a C_1 - C_4 -haloalkyl group substituted with 1 to 9 halogen atoms chosen from fluorine, chlorine and bromine. Preferably, R^1 is chosen as being methyl, ethyl, trifluoromethyl, difluoromethyl, fluoromethyl, trichloromethyl, dichloromethyl, chloromethyl, chlorofluoromethyl, fluorodichloromethyl, difluorochloromethyl, pentafluoroethyl, 1-fluoroethyl, 2-fluoroethyl, 2,2-difluoroethyl, 2,2,2-trifluoroethyl, 2-chloro-2-fluoroethyl, 2-chloro-2,2-difluoroethyl, 2-chloro-2,2-di-
25 fluoroethyl, 2,2-dichloro-2-fluoroethyl, 2,2,2-trichloroethyl, 1-chlorobutyl, heptafluoro-*n*-propyl or heptafluoroisopropyl. More preferably, R^1 is chosen as being methyl, ethyl or trifluoromethyl.

According to the present invention, substituent R^2 of the compound of general formula (I) is defined as being a halogen atom, a C_1 - C_4 -alkyl group or a C_1 - C_4 -haloalkyl group substituted with 1 to 9 halogen
30 atoms chosen from fluorine, chlorine and bromine. Preferably, R^2 is chosen as being methyl, ethyl, fluorine, chlorine, bromine, trifluoromethyl, difluoromethyl, fluoromethyl, trichloromethyl, dichloromethyl, chloromethyl, chlorofluoromethyl, fluorodichloromethyl, difluorochloromethyl, pentafluoroethyl, 1-fluoroethyl, 2-fluoroethyl, 2,2-difluoroethyl, 2,2,2-trifluoroethyl, 2-chloro-2-fluoroethyl, 2-chloro-2,2-difluoroethyl, 2-chloro-2,2-difluoroethyl, 2,2-dichloro-2-fluoroethyl, 2,2,2-trichloroethyl, 1-chlorobutyl, heptafluoro-*n*-propyl or heptafluoroisopropyl. More preferably, R^2 is chosen as being
35 methyl, ethyl, chlorine or trifluoromethyl.

According to the present invention, the "A" group of the compound of general formula (I) may be a five, six or seven membered ring non-fused heterocycle. Preferably:

*A represents a heterocycle of general formula (A1)



5

R^5 represents hydrogen, cyano, halogen, nitro, C₁-C₄-alkyl, C₁-C₄-alkoxy, C₁-C₄-alkylthio, C₃-C₆-cycloalkyl, C₁-C₄-halogenoalkyl, C₁-C₄-halogenoalkoxy or C₁-C₄-halogenoalkylthio having in each case 1 to 5 halogen atoms, aminocarbonyl or aminocarbonyl-C₁-C₄-alkyl;

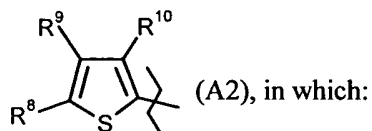
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R^6 represents hydrogen, halogen, cyano, C₁-C₄-alkyl, C₁-C₄-alkoxy or C₁-C₄-alkylthio;

R^7 represents hydrogen, C₁-C₄-alkyl, hydroxy-C₁-C₄-alkyl, C₂-C₆-alkenyl, C₃-C₆-cycloalkyl, C₁-C₄-alkylthio-C₁-C₄-alkyl, C₁-C₄-alkoxy-C₁-C₄-alkyl, C₁-C₄-halogenoalkyl, C₁-C₄-halogenoalkylthio-C₁-C₄-alkyl, C₁-C₄-halogenoalkoxy-C₁-C₄-alkyl having in each case 1 to 5 halogen atoms, or phenyl;

15 or

* A represents a heterocycle of general formula (A2)



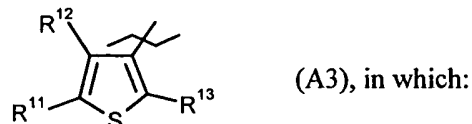
R^8 and R^9 independently each represents hydrogen, halogen, C₁-C₄-alkyl or C₁-C₄-halogenoalkyl having 1 to 5 halogen atoms;

20

R^{10} represents halogen, cyano or C₁-C₄-alkyl, or C₁-C₄-halogenoalkyl or C₁-C₄-halogenoalkoxy having in each case 1 to 5 halogen atoms;

or

* A represents a heterocycle of general formula (A3)



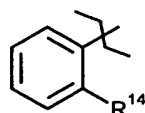
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R^{11} and R^{12} independently each represents hydrogen, halogen, C₁-C₄-alkyl or C₁-C₄-halogenoalkyl having 1 to 5 halogen atoms;

R^{13} represents hydrogen, halogen, C₁-C₄-alkyl or C₁-C₄-halogenoalkyl having 1 to 5 halogen atoms;

or

30 * A represents a heterocycle of general formula (A4)

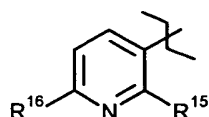


(A4), in which:

R^{14} represents hydrogen, halogen, hydroxy, cyano, C_1 - C_6 -alkyl, C_1 - C_4 -halogenoalkyl, C_1 - C_4 -halogenoalkoxy or C_1 - C_4 -halogenoalkylthio having in each case 1 to 5 halogen atoms;

5 or

* A represents a heterocycle of general formula (A5)



(A5), in which:

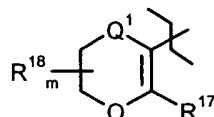
R^{15} represents halogen, hydroxy, cyano, C_1 - C_4 -alkyl, C_1 - C_4 -alkoxy, C_1 - C_4 -alkylthio, C_1 - C_4 -halogenoalkyl, C_1 - C_4 -halogenoalkylthio or C_1 - C_4 -halogenoalkoxy having in each case 1 to 5 halogen atoms;

10

R^{16} represents hydrogen, halogen, cyano, C_1 - C_4 -alkyl, C_1 - C_4 -alkoxy, C_1 - C_4 -alkylthio, C_1 - C_4 -halogenoalkyl, C_1 - C_4 -halogenoalkoxy having in each case 1 to 5 halogen atoms, C_1 - C_4 -alkylsulphinyl or C_1 - C_4 -alkylsulphonyl;

or

15 * A represents a heterocycle of general formula (A6)



(A6), in which:

R^{17} represents C_1 - C_4 -alkyl or C_1 - C_4 -halogenoalkyl having 1 to 5 halogen atoms;

R^{18} represents C_1 - C_4 -alkyl,

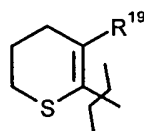
Q^1 represents S (sulphur), SO, SO_2 or CH_2 ;

20

m represents 0, 1 or 2, where R^{16} represents identical or different radicals, when p represents 2;

or

* A represents a heterocycle of general formula (A7)

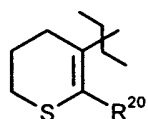


(A7), in which:

25 R^{19} represents C_1 - C_4 -alkyl or C_1 - C_4 -halogenoalkyl having 1 to 5 halogen atoms;

or

* A represents a heterocycle of general formula (A8)

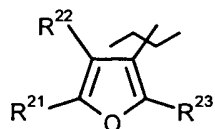


(A8), in which:

R^{20} represents C_1 - C_4 -alkyl or C_1 - C_4 -halogenoalkyl having 1 to 5 halogen atoms;

or

* A represents a heterocycle of general formula (A9)



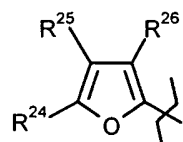
(A9), in which:

R^{21} and R^{22} independently each represents hydrogen, halogen, amino, C_1 - C_4 -alkyl or C_1 - C_4 -halogenoalkyl having 1 to 5 halogen atoms;

R^{23} represents hydrogen, halogen, C_1 - C_4 -alkyl or C_1 - C_4 -halogenoalkyl having 1 to 5 halogen atoms;

10 or

* A represents a heterocycle of general formula (A10)



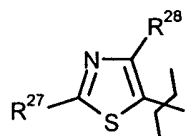
(A10), in which:

R^{24} and R^{25} independently each represents hydrogen, halogen, amino, nitro, C_1 - C_4 -alkyl or C_1 - C_4 -halogenoalkyl having 1 to 5 halogen atoms;

15 R^{26} represents hydrogen, halogen, C_1 - C_4 -alkyl or C_1 - C_4 -halogenoalkyl having 1 to 5 halogen atoms;

or

* A represents a heterocycle of general formula (A11)



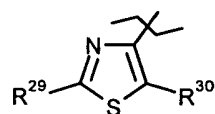
(A11), in which:

20 R^{27} represents hydrogen, halogen, amino, C_1 - C_4 -alkylamino, di- $(C_1$ - C_4 -alkyl)amino, cyano, C_1 - C_4 -alkyl or C_1 - C_4 -halogenoalkyl having 1 to 5 halogen atoms;

R^{28} represents halogen, C_1 - C_4 -alkyl or C_1 - C_4 -halogenoalkyl having 1 to 5 halogen atoms;

or

* A represents a heterocycle of general formula (A12)



(A12), in which

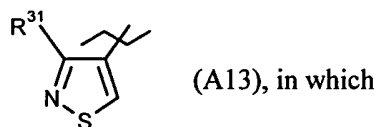
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R^{29} represents hydrogen, halogen, amino, C_1 - C_4 -alkylamino, di- $(C_1$ - C_4 -alkyl)amino, cyano, C_1 - C_4 -alkyl or C_1 - C_4 -halogenoalkyl having 1 to 5 halogen atoms;

R^{30} represents halogen, C_1 - C_4 -alkyl or C_1 - C_4 -halogenoalkyl having 1 to 5 halogen atoms;

or

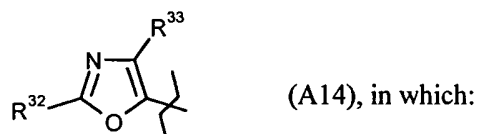
* A represents a heterocycle of general formula (A13)



5 R^{31} represents halogen, C_1 - C_4 -alkyl or C_1 - C_4 -halogenoalkyl having 1 to 5 halogen atoms;

or

* A represents a heterocycle of general formula (A14)

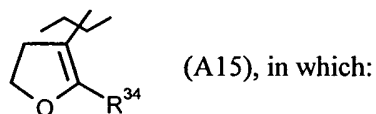


R^{32} represents hydrogen or C_1 - C_4 -alkyl;

10 R^{33} represents halogen or C_1 - C_4 -alkyl;

or

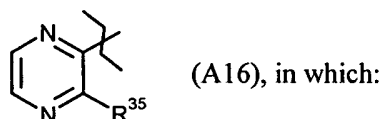
* A represents a heterocycle of general formula (A15)



R^{34} represents C_1 - C_4 -alkyl or C_1 - C_4 -halogenoalkyl having 1 to 5 halogen atoms;

15 or

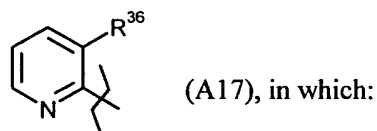
* A represents a heterocycle of general formula (A16)



R^{35} represents hydrogen, halogen, C_1 - C_4 -alkyl or C_1 - C_4 -halogenoalkyl having 1 to 5 halogen atoms;

20 or

* A represents a heterocycle of general formula (A17)

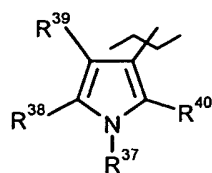


R^{36} represents halogen, hydroxy, C_1 - C_4 -alkyl, C_1 - C_4 -alkoxy, C_1 - C_4 -alkylthio, C_1 - C_4 -halogenoalkyl, C_1 - C_4 -halogenoalkylthio or C_1 - C_4 -halogenoalkoxy having in each case 1 to 5 halogen atoms;

25

or

* A represents a heterocycle of general formula (A18)

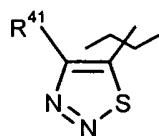


(A18), in which:

- 5 R^{37} represents hydrogen, cyano, C_1 - C_4 -alkyl, C_1 - C_4 -halogenoalkyl having 1 to 5 halogen atoms, C_1 - C_4 -alkoxy- C_1 - C_4 -alkyl, hydroxy- C_1 - C_4 -alkyl, C_1 - C_4 -alkylsulfonyl, di(C_1 - C_4 -alkyl)aminosulfonyl, C_1 - C_6 -alkylcarbonyl or in each case optionally substituted phenylsulfonyl or benzoyl;
- R^{38} represents hydrogen, halogen, C_1 - C_4 -alkyl or C_1 - C_4 -halogenoalkyl having 1 to 5 halogen atoms;
- R^{39} represents hydrogen, halogen, cyano, C_1 - C_4 -alkyl or C_1 - C_4 -halogenoalkyl having 1 to 5 halogen atoms;
- 10 R^{40} represents hydrogen, halogen, C_1 - C_4 -alkyl or C_1 - C_4 -halogenoalkyl having 1 to 5 halogen atoms;

or

* A represents a heterocycle of general formula (A19)



(A19), in which:

- 15 R^{41} represents C_1 - C_4 -alkyl.

More preferably, A represents a heterocycle of general formula (A1).

The first step (step A) of the process according to the present invention comprises the reaction of a nitrobenzene derivative of general formula (II) with a carbonyl ester derivative of general formula (III), in a compound (III) / compound (II) molar ratio of from 1 to 10, in a solvent and in the presence of a base, the base / compound (II) molar ratio being of from 0.5 to 5 to provide a nitrophenyl ketoester derivative of general formula (IV). Preferably, step A may be conducted in the following conditions, chosen alone or in combination:

- 25 - the compound (III) / compound (II) molar ratio is of from 1 to 5. More preferably, the compound (III) / compound (II) molar ratio is of from 1 to 2;
- the solvent is a polar solvent. Suitable polar solvent includes DMSO, DMF, NMP, DMA, acetonitrile and propionitrile. More preferably, the solvent is DMSO or DMA.
- the base is chosen as being hydride, alcolate or carbonate. Suitable hydrides includes NaH and KH.
- 30 Suitable alcolate includes tBuOK, MeONa and EtON. Suitable carbonate includes K_2CO_3 . More preferably, the base is K_2CO_3 ;

- the base / compound (II) molar ratio is of from 1 to 3. More preferably, the base / compound (II) molar ratio is of 2.

Step A does not necessarily require specific temperature conditions. Preferably, step A is conducted at a temperature of from 0°C to 140°C. More preferably, step A is conducted at a temperature of from 10°C to 100°C. Even more preferably, step A is conducted at a temperature of from 20°C to 80°C.

Step A does not necessarily require the use of a phase transfer agent. Preferably, step A is conducted in the presence of a phase transfer agent. Suitable phase transfer agent includes a halogeno ammonium salt such as tetraalkylammonium halide.

The second step (step B) of the process according to the present invention comprises a decarboxylation reaction of a nitrophenyl ketoester derivative of formula (IV) obtained in step one or of an intermediate compound of formula (V'') in the presence of an agent R⁴X, in a (R⁴X) / compound (IV) or (V'') molar ratio of from 0.1 to 50; in a solvent and at a temperature of from 20°C to 180°C to provide a nitrophenyl ketone derivative of general formula (V). Preferably, the decarboxylation reaction may be conducted in the following conditions, chosen alone or in combination:

- R⁴X is chosen as being LiCl or HBr;
- the (R⁴X) / compound (IV) or (V'') molar ratio is of from 0.5 to 30. More preferably, the (R⁴X) / compound (IV) molar ratio is of from 1 to 20.
- the solvent is a polar solvent. Suitable polar solvent includes AcOH, DMF, DMA, NMP and DMSO. More preferably, the solvent is wet polar aprotic when R⁴X is LiCl and is AcOH when R⁴X is HBr. More preferably, the solvent is wet DMSO or wet DMF when R⁴X is LiCl and is AcOH when R⁴X is HBr;
- the reaction is conducted at a temperature of from 100°C to 160°C. More preferably, the reaction is conducted at a temperature of from 110°C to 150°C.

The second step (step B) of the process according to the present invention may also comprise a methylation reaction of a compound of formula (IV) or an intermediate compound of formula (V') by adding methylating agent, in a methylating agent / compound (IV) or (V') molar ratio of from 0.5 to 2; in a solvent and in the presence of a base, in a base / compound (IV) or (V') molar ratio of from 0.5 to 2; to provide a nitrophenyl ketone derivative of general formula (V). Preferably, the methylation reaction may be conducted in the following conditions, chosen alone or in combination:

- the methylating agent is a haloalkyl group or an alkylsulfate group. More preferably, the methylating agent is MeI or Me₂SO₄;
- the methylating agent / compound (IV) or (V') molar ratio is of from 0.9 to 1.2;

- the base is chosen as being NaH, tBuOK, K₂CO₃, Na₂CO₃. More preferably, the base is NaH or K₂CO₃;
- the solvent is chosen as being hexane, diethylether, MTBE, THF, dioxane, ethyl acetate or a polar solvent. Suitable polar solvent includes acetone, acetonitrile, NMP, DMF, DMA and DMSO. More preferably, the solvent is a polar solvent.

The third step (step C) of the process according to the present invention comprises the reduction of a nitrophenyl ketone of general formula (V) obtained in step two by adding to it from 0.5 to 10 molar equivalent of a reduction agent, in a polar protic solvent and at a temperature of from -20°C to 80°C to provide a nitrophenyl alcohol derivative of general formula (VI). Preferably, step C may be conducted in the following conditions, chosen alone or in combination:

- the reduction agent is chosen as being BH₃ or RBH₄ in which R is chosen from Li, Na or K. More preferably, the reduction agent is NaBH₄;
- the polar protic solvent is an alcohol. More preferably, the polar protic solvent is chosen as being MeOH or EtOH;
- the reaction is conducted at a temperature of from -10°C to 20°C. More preferably, the reaction is conducted at a temperature of 0°C.

The fourth step (step D) of the process according to the present invention comprises the reduction by H₂ of a nitrophenyl alcohol derivative of general formula (VI) obtained in step three in the presence of a metal catalyst, in a solvent and under a pressure of from 1 to 10 Bar to provide an aminophenyl alcohol derivative of general formula (VII). Preferably, step D may be conducted in the following conditions, chosen alone or in combination:

- the catalyst is chosen as being palladium on charcoal (Pd-C), Raney-nickel or platinum (IV) oxide. More preferably, the catalyst is chosen as being Pd-C;
- the solvent is a polar protic solvent. More preferably, the solvent is an alcohol. Suitable alcohol solvent includes methanol and ethanol;
- the reaction is conducted under a pressure of from 2 to 5 Bar. More preferably the reaction is conducted under a pressure of 4 Bar.

The fifth step (step E) of the process according to the present invention comprises the coupling reaction of an aminophenyl alcohol derivative of general formula (VII) obtained in step four with an acyl halide derivative of general formula (VIII), in a solvent and in the presence of a base in a base / compound (VII) molar ratio of 0.5 to 3 to provide a hydroxyl carboxamide derivative of general formula (IX). Preferably, step E may be conducted in the following conditions, chosen alone or in combination:

- the base is chosen as being pyridine, triethylamine, trimethylamine, sodium carbonate, potassium carbonate, potassium or sodium bicarbonate, sodium hydroxide or potassium hydroxide. More preferably, the base is pyridine or triethylamine;
- the base / compound (VII) molar ratio is of 1;
- 5 - the solvent is chosen as being dichloroethane, dichloromethane, acetonitrile or toluene.

The sixth step (step F) of the process according to the present invention comprises comprising the reaction of a hydroxyl carboxamide derivative of general formula (IX) obtained in step five with a compound of formula R_pX_q at a temperature of from 0°C to 100°C ;

- 10 to provide a carboxamide derivative of general formula (X), (XI), (XII), (XIV), (XV), (XVI), (XVII) or (XVIII) or a mixture thereof;

Preferably, step F may be conducted in the following conditions, chosen alone or in combination:

- X is a chlorine atom;
- R_pX_q is chosen as being phosphorus oxychloride, thionyl chloride, phosphorous trichloride,
- 15 phosphorus pentachloride, mesylchloride, tosyl chloride, succinimide or phthalimide chloride;
- the reaction is conducted at a temperature of from 0°C to 80°C .

The step F is not necessarily conducted in the presence of a solvent. Preferably, the step F is conducted in the presence of a solvent. Suitable solvent includes dichloromethane, dichloroethane, toluene, pyridine, DMF, DMA, NMP, DMSO. More preferably the solvent is pyridine;

20

The step F is not necessarily conducted in the presence of an acid. Preferably the step F is conducted in the presence of an acid. Suitable acid includes phosphoric acid.

- 25 The seventh step (step G) of the process according to the present invention comprising the reduction by H_2 of all carboxamide derivatives of general formula (X) to (XVIII) obtained in step six, in the presence of a metal catalyst, in a solvent, at a temperature of from 10°C to 250°C and under a pressure of from 1 to 50 Bar;

to provide a carboxamide derivative of general formula (I). Preferably, step G may be conducted in the following conditions, chosen alone or in combination:

- 30 - the metal catalyst is chosen as being palladium on charcoal (Pd/C), Raney nickel, $PdCl_2$ or $NiCl_2$;
- the solvent is a protic solvent. Suitable protic solvent includes C_1 - C_{10} alcohol and acetic acid. More preferably, the solvent is octanol;
- the reaction is conducted at a temperature of from 40°C to 200°C;
- the reaction is conducted under a pressure of from 1 to 30 Bar.

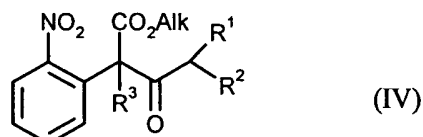
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The compound of general formula (I) according to the present invention can be prepared according to the above described process. It will nevertheless be understood that, on the basis of his general

knowledge and of available publications, the skilled worker will be able to adapt this method according to the specifics of each of the compounds, which it is desired to synthesise.

Certain of the intermediates used for the preparation of compound of general formula (I) are novel.

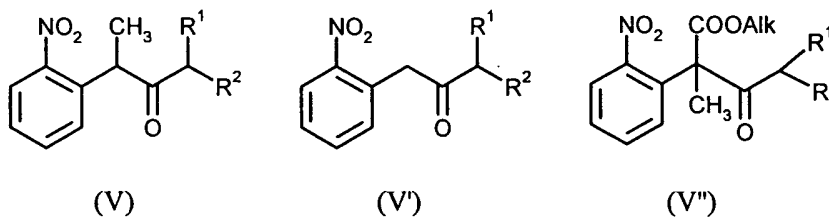
- 5 Therefore, the present invention also relates to novel intermediate compounds useful for the preparation of compound of general formula (I). Thus, according to the present invention, there is provided a compound of general formula (IV)



in which:

- 10 R^1 , R^2 , R^3 are as defined above; and
Alk represents a C_1 - C_{10} alkyl group.

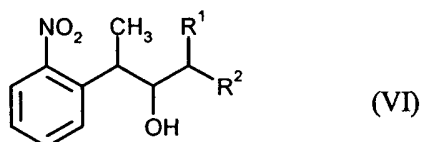
According to the present invention, there is also provided a compound of general formula (V), a compound of general formula (V') and a compound of general formula (V'')



- 15 in which:

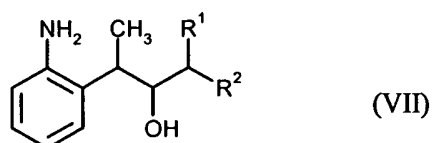
R^1 and R^2 are as defined above; and
Alk represents a C_1 - C_{10} alkyl group.

- 20 According to the present invention, there is also provided a compound of formula (VI)



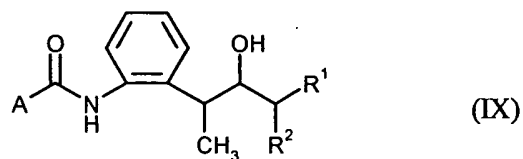
in which R^1 and R^2 are as defined above.

According to the present invention, there is also provided a compound of formula (VII)



- 25 in which R^1 and R^2 are as defined above.

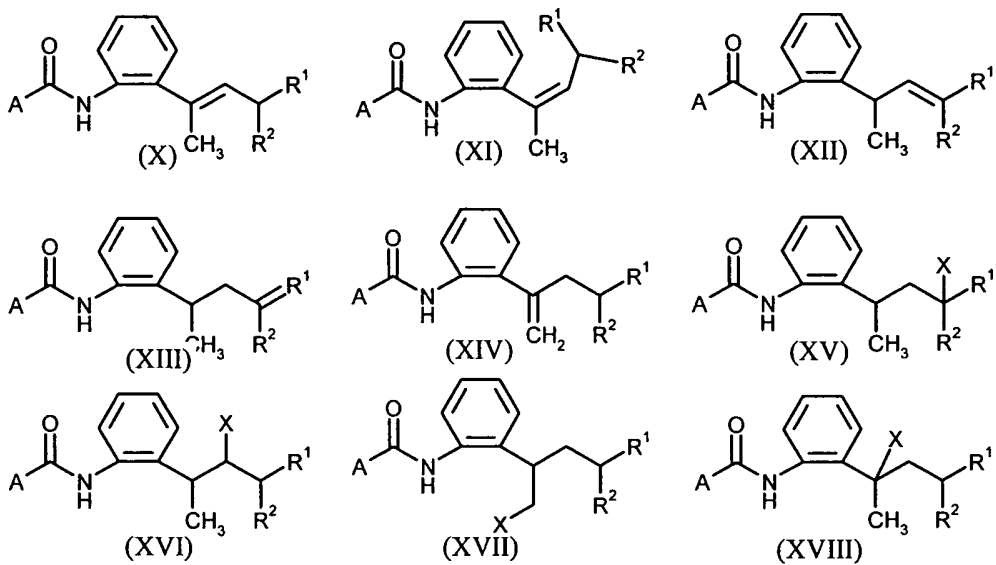
According to the present invention, there is also provided a compound of formula (IX)



in which A, R¹ and R² are as defined above.

5

According to the present invention, there are also provided compounds of formula (X) to (XVIII)



in which A, X, R¹ and R² are as defined above.

10 The present invention will now be illustrated with reference to the following examples.

Preparation of 5-fluoro-1,3-dimethyl-N-[2-(1,3-dimethyl)-butyl]-1H-pyrazole-4-carboxamide*Step 1: Preparation of 2-(2-nitro-phenyl)-3-oxy-4-methyl-pentanoic acid methyl ester*

To a solution of fluoronitrobenzene (10 g, 71 mmol) in DMSO (50 ml) were added methylisobutyryl-
5 acetate (11.4 ml, 71 mmol) and potassium carbonate (19 g, 138 mmol). The reaction mixture was
stirred at 20°C for 25 hours. It was then cooled to 0°C and water (50 ml), then aqueous HCl were
added to reach pH 7. Ethyl acetate was then added (150 ml). The two phases were separated. The
aqueous phase was extracted with ethyl acetate (1×50 ml). The combined organic phase were washed
two times with water (2×50 ml) and dried on magnesium sulfate. 12.6 g – yield 67 % – of the
10 expected product were obtained in a brown oil.

Further purification by column chromatography may be performed in order to obtain a pure sample of
the product as a bright yellow oil.

¹H NMR (400 MHz, CDCl₃, δ ppm): ketone form/enol form 20/80 – ketone form: 8.00 (1H, dd,
15 J=8Hz, J=1Hz), 7.62 (1H, dt, J=8Hz, J=1Hz), 7.49 (1H, dt, J=8Hz, J=1Hz), 5.61 (1H, s), 3.75 (3H, s),
2.83 (1H, m), 1.18 (3H, d, J=7Hz), 1.09 (3H, d, J=7Hz) – enol form: 13.0 (1H, d, J=1Hz), 7.97 (1H,
dd, J=8Hz, J=1Hz), 7.58 (1H, dt, J=8Hz, J=1Hz), 7.47 (1H, dt, J=8Hz, J=1Hz), 7.27 (1H, dd, J=8Hz,
J=1Hz), 3.61 (3H, s), 2.28 (1H, m), 1.09 (3H, d, J=7Hz), 1.00 (3H, d, J=7Hz).

*Step 2: Preparation of 2-methyl-4-(2-nitro-phenyl)-pentan-3-one**Process 1**a) Preparation of 2,4-dimethyl-2-(2-nitro-phenyl)-3-oxypentanoic acid methyl ester*

To a solution of 2-(2-nitro-phenyl)-3-oxy-4-methyl-pentanoic acid methyl ester (72%, 5g, 26 mmol)
in DMSO (30 ml) under nitrogen was added potassium carbonate (4.34 g, 31 mmol) and methyl-
25 iodide (2 ml, 31 mmol). The reaction mixture was then stirred at room temperature for two hours. It
was diluted with water (50 ml), and extracted with ethyl acetate (100 ml). The organic phase was then
washed with water (5×50ml), brine, and dried with magnesium sulfate. The crude product was then
purified by flash chromatography on biotage apparatus. 3.4 g (yield 90%) of 2,4-dimethyl-2-(2-nitro-
phenyl)-3-oxypentanoic acid methyl ester was collected as a yellow solid. Melting point was 57.4°C.

30

¹H NMR (400 MHz, CDCl₃, δ ppm): 8.02 (1H, dd, J=8Hz, J=1Hz), 7.59 (1H, dt, J=8Hz, J=1Hz), 7.46
(1H, dt, J=8Hz, J=1Hz), 7.21 (1H, dd, J=8Hz, J=1Hz), 3.67 (3H, s), 3.36 (1H, m), 1.93 (3H, s), 1.08
(3H, d, J=7Hz), 1.06 (3H, d, J=7Hz).

*b) Preparation of 2-methyl-4-(2-nitro-phenyl)-pentan-3-one*** Method 1*

To a solution of 2,4-dimethyl-2-(2-nitro-phenyl)-3-oxypentanoic acid methyl ester (92%, 3.4g, 11 mmol) in DMSO (30ml) was added LiCl (516 mg, 12 mmol) and water (438 mg, 24 mmol). The reaction mixture was heated at 140°C (bath temperature 150°C) for 2h. The total conversion was evaluated by HPLC. It was diluted with water (50 ml), and extracted with ethyl acetate (100 ml). The organic phase was then washed with water (5×50 ml), brine, and dried on magnesium sulfate. The crude product was then purified by flash chromatography on biotage apparatus. (2-methyl-4-(2-nitro-phenyl)-pentan-3-one (1.46 g, isolated yield 59%) was collected as a yellow oil.

10

¹H NMR (400 MHz, CDCl₃, δ ppm): 7.85 (1H, dd, J=8Hz, J=1Hz), 7.55 (1H, dt, J=8Hz, J=1Hz), 7.38 (2H, m, J=8Hz, J=1Hz), 4.52 (1H, q, J=7Hz), 2.68 (1H, m), 1.44 (3H, d, J=7Hz), 1.08 (3H, d, J=7Hz), 0.97 (3H, d, J=7Hz).

15 ** Method 2*

A solution of 2,4-dimethyl-2-(2-nitro-phenyl)-3-oxypentanoic acid methyl ester (92%, 1.20 g, 4.1 mmol) in acetic acid (38.6 ml) and aqueous bromhydric acid (47%, 13.6 ml) was quickly heated to reflux (internal temperature 108-110°C) and stirred for 2h30. The reaction mixture was cooled to room temperature and then slowly added to a cold (0°C) solution of aqueous sodium carbonate. Dichloromethane was added (100 ml). The organic phase was washed with water (2×50 ml), aqueous sodium carbonate (50 ml) water (50 ml), brine (50 ml) and dried with MgSO₄. Purification by flash chromatography afforded 2-methyl-4-(2-nitro-phenyl)-pentan-3-one (528 mg - yield 60%) as a yellow oil.

20

¹H NMR (400 MHz, CDCl₃, δ ppm): 7.85 (1H, dd, J=8Hz, J=1Hz), 7.55 (1H, dt, J=8Hz, J=1Hz), 7.38 (2H, m, J=8Hz, J=1Hz), 4.52 (1H, q, J=7Hz), 2.68 (1H, m), 1.44 (3H, d, J=7Hz), 1.08 (3H, d, J=7Hz), 0.97 (3H, d, J=7Hz).

25

*Process 2**a) Preparation of 2-methyl-1-(2-nitrophenyl)butan-2-one*

To a solution of 2-(2-nitro-phenyl)-3-oxy-4-methyl-pentanoic acid methyl ester (77 %, 3.70 g, 21 mmol) in acetic acid was added aqueous bromhydric acid (47 %, 50 ml). It was quickly heated to reflux (110°C) and stirred for 1h. The reaction mixture was cooled to room temperature, diluted with water (100 ml) and extracted with MTBE (2×50 ml). The combined organic layers were washed with water (2×50 ml), aqueous bicarbonate (2×50 ml), water (2×50 ml) and dried with MgSO₄. Light compounds were removed by distillation. The expected product was obtained in a black oil. Further purification by column chromatography may be performed in order to obtain a pure sample of the product as a yellow oil.

35

¹H NMR (400 MHz, CDCl₃, δ ppm): 8.08 (1H, dd, J=8Hz, J=1Hz), 7.55 (1H, dt, J=8Hz, J=1Hz), 7.42 (1H, dt, J=8Hz, J=1Hz), 7.24 (1H, m), 4.18 (2H, s), 2.80 (1H, m), 1.19 (6H, d, J=7Hz).

5 *b) Preparation of 2-methyl-4-(2-nitrophenyl)pentan-3-one*

The compound thus obtained was diluted in wet. NaH (60 %, 1.18g, 29.4 mmol) was then added. After gas evolution, MeI (1.83 ml, 29.4 mmol) was added and the reaction stirred at room temperature for 2h. The reaction was quenched by adding water (50 ml). The aqueous phase was extracted with MTBE (2×150 ml). The organic phase was washed with water (2×150 ml) and dried
10 with MgSO₄. Filtration through silica afforded pure 2-methyl-4-(2-nitro-phenyl)-pentan-3-one (1.83 g - yield 77 %) as a yellow oil.

¹H NMR (400 MHz, CDCl₃, δ ppm): 7.85 (1H, dd, J=8Hz, J=1Hz), 7.55 (1H, dt, J=8Hz, J=1Hz), 7.38 (2H, m, J=8Hz, J=1Hz), 4.52 (1H, q, J=7Hz), 2.68 (1H, m), 1.44 (3H, d, J=7Hz), 1.08 (3H, d, J=7Hz),
15 0.97 (3H, d, J=7Hz).

Step 3: Preparation of 2-methyl-4-(2-nitro-phenyl)-pentan-3-ol

In a 25 ml flask was prepared a solution of 2-methyl-4-(2-nitro-phenyl)-pentan-3-one (390 mg, 1.8 mmol) in dry methanol (9 ml). It is cooled with an ice-water bath. The temperature in the reaction
20 mixture was 4°C. Sodium borohydride (73 mg, 1.9 mmol) was added, spoon by spoon. It was stirred one hour at 0°C. The cooled mixture was added to HCl 1N (7ml). This addition was exothermic. Methanol was evaporated. The aqueous phase was extracted with ethyl acetate (50 ml). The organic phase was washed with water (1×25 ml), brine (1×25 ml) and dried with magnesium sulfate. 2-methyl-4-(2-nitro-phenyl)-pentan-3-ol (380 mg - yield 97 %) was then obtained as a pale yellow oil.

25

¹H NMR (400 MHz, CDCl₃, δ ppm): 7.70 (1H, dd, J=8Hz, J=1Hz), 7.60 (1H, dd, J=8Hz, J=1Hz), 7.56 (1H, ddd, J=8Hz, J=7Hz, J=1Hz), 7.34 (1H, ddd, J=8Hz, J=7Hz, J=1Hz), 3.49 (1H, m), 3.45 (1H, m), 1.90 (1H, m), 1.77 (1H, s), 1.29 (3H, d, J=7Hz), 0.99 (3H, d, J=7Hz), 0.92 (3H, d, J=7Hz).

30 *Step 4: Preparation of 2-methyl-4-(2-amino-phenyl)-pentan-3-ol*

In a 15 ml hydrogenation reactor was charged a solution of 2-methyl-4-(2-nitro-phenyl)-pentan-3-ol (370 mg, 1.7 mmol) in EtOH (12 ml). Pd/C 5 % was added. The reaction mixture was stirred under hydrogen (4 bars) at room temperature for 2 hours. Filtration through celite and evaporation of ethanol afforded 2-methyl-4-(2-amino-phenyl)-pentan-3-ol as a white solid (320 mg - quantitative yield).

35

¹H NMR (400 MHz, CDCl₃, δ ppm): 7.14 (1H, dd, J=8Hz, J=1Hz), 7.03 (1H, dt, J=8Hz, J=1Hz), 6.81 (1H, dt, J=8Hz, J=1Hz), 6.69 (1H, dd, J=8Hz, J=1Hz), 3.69 (1H, q, J=7Hz), 3.44 (1H, dd, J=9Hz, J=3Hz), 3.02 (1H, m), 1.77 (1H, s), 1.29 (3H, d, J=7Hz), 0.99 (3H, d, J=7Hz), 0.92 (3H, d, J=7Hz).
MS (EI) Found [M+H]⁺: 194.1537. C₁₂H₂₀NO requires 194.1545

5

Step 5: Preparation of 5-fluoro-1,3-dimethyl-N-[2-(1,3-dimethyl-2-hydroxybutyl)-phenyl]-1H-pyrazole-4-carboxamide

To a cold (0°C) solution of 2-methyl-4-(2-amino-phenyl)-pentan-3-ol (230 mg, 1.2 mmol) in toluene (10 ml) were added triethylamine (0.2 ml, 1.4 mmol) and a solution of 1,3-dimethyl-1H-pyrazole-4-carbonyl chloride in toluene (4.75M, 0.3 ml, 1.4 mmol). The reaction was stirred one hour at room temperature. Water (10 ml) was then added. The aqueous phase was washed with dichloromethane. The combined organic phases were washed with HCl 1N (10 ml), water (10 ml) and brine (10 ml), then dried with magnesium sulfate. Washing the solid residue with toluene afforded 5-fluoro-1,3-dimethyl-N-[2-(1,3-dimethyl-2-hydroxybutyl)phenyl]-1H-pyrazole-4-carboxamide (315 mg - yield 79 %) as a white solid. Melting point was 117.8°C.

¹H NMR (400 MHz, CDCl₃, δ ppm): ¹H NMR (400 MHz, CDCl₃, δ ppm): 8.61 (1H,s), 7.66 (1H, dd, J=8Hz, J=1Hz), 7.26 (1H, dd, J=8Hz, J=1Hz), 7.19 (1H, m), 7.15 (1H, m), 3.65 (3H, d, J=1Hz), 3.36 (1H, ddd, J=10Hz, J=4Hz, J=2Hz), 3.10 (1H, m), 2.43 (3H, s), 2.33 (1H,d, J=4Hz), 1.95 (1H, m), 1.19 (3H, d, J=7Hz), 0.98 (3H, d, J=7Hz), 0.92 (3H, d, J=7Hz).
MS (EI) Found [M+Na]⁺: 356.1742. C₁₈H₂₄N₃O₂FNa requires 356.1750

Step 6: Preparation and catalytic reduction of a mixture of 5-fluoro-1,3-dimethyl-N-[2-(1,3-dimethyl)-buten-1-yl]-1H-pyrazole-4-carboxamide, 5-fluoro-1,3-dimethyl-N-[2-(1,3-dimethyl)-buten-2-yl]-1H-pyrazole-4-carboxamide and 5-fluoro-1,3-dimethyl-N-[2-(2-chloro-1,3-dimethyl)-butyl]-1H-pyrazole-4-carboxamide (45: 39: 16 w)

To a solution of 5-fluoro-1,3-dimethyl-N-[2-(1,3-dimethyl-2-hydroxy)-butyl]-1H-pyrazole-4-carboxamide (307 mg, 0.9 mmol) in pyridine were added H₃PO₄ (aq. 85 %, 0.08 ml) and phosphorous oxychloride (1.52 ml, 16 mmol). The reaction mixture was stirred for 3h. It was then added onto cooled water and extracted with ethyl acetate. The organic phase was washed with 1N HCl, brine, and dried with MgSO₄. The mixture of compounds (280 mg, yield 95 %) was obtained as a white solid.

These compounds are fully characterised in mixture (HPLC-MS and ¹H NMR, ¹³C NMR, ¹⁹F NMR).
¹H NMR (400 MHz, CDCl₃, δ ppm): 5-fluoro-1,3-dimethyl-N-[2-(1,3-dimethylbuten-1-yl)phenyl]-1H-pyrazole-4-carboxamide: 8.42 (1H,d, J=8Hz), 7.76 (1H, m), 7.27 (1H, m), 7.02 (1H, m), 7.01 (1H, m), 5.53 (1H, d, J=10Hz), 3.71 (3H, m), 2.45 (3H, s), 2.02 (1H,m), 1.92 (3H, s), 0.84 (6H,m) – 5-fluoro-1,3-dimethyl-N-[2-(1,3-dimethylbuten-2-yl)phenyl]-1H-pyrazole-4-carboxamide: 7.72 (1H,

35

dd, J=8Hz, J=1Hz), 7.45 (1H, s), 7.20-7.14 (3H, m), 5.18 (1H, d, J=9Hz), 3.71 (4H, m), 2.45 (3H, s), 1.70 (3H, s), 1.60 (3H, s), 1.30 (3H, d, J=7Hz) – 5-fluoro-1,3-dimethyl-N-[2-(2-chloro-1,3-dimethylbutyl)phenyl]-1H-pyrazole-4-carboxamide: 7.28-7.02 (4H, m), 4.04 (1H, dd, J=9Hz, J=1Hz), 3.71 (3H, m), 3.25 (1H, dq, J=9Hz, J=1Hz), 2.47 (3H, m), 1.75 (1H, m), 1.41 (3H, d, J=7Hz), 0.92 (3H, d, J=7Hz), 0.87 (3H, d, J=7Hz).

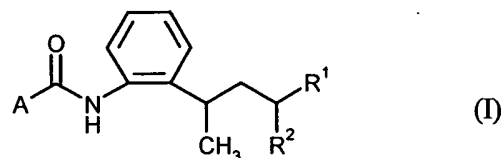
Step 7: Preparation of 5-fluoro-1,3-dimethyl-N-[2-(1,3-dimethyl)-but-2-ol-yl]-1H-pyrazole-4-carboxamide

To the mixture obtained in the above step 6 in octanol, activated 5 % Pd/C catalyst was added and stirred at 185°C in a hydrogen atmosphere (20 bars). Octanol was removed by azeotropic distillation with water. The resulting suspension was dissolved with MTBE. The organic phase was dried with MgSO₄. Thus obtained 5-fluoro-1,3-dimethyl-N-[2-(1,3-dimethylbutyl)phenyl]-1H-pyrazole-4-carboxamide as a white solid (95 %, 246 mg, yield 81%).

¹H NMR (400 MHz, CDCl₃, δ ppm): 5-fluoro-1,3-dimethyl-N-[2-(1,3-dimethyl)-butyl]-1H-pyrazole-4-carboxamide: 7.79 (1H, dd, J=8Hz, J=1Hz), 7.27 (1H, s), 7.25 (1H, m), 7.18 (1H, m), 7.16 (1H, m), 3.74 (3H, d, J=1Hz), 2.97 (1H, m), 2.48 (3H, s), 1.54 (2H, m), 1.42 (1H, m), 1.21 (3H, d, J=7Hz), 0.85 (6H, d, J=6Hz).

CLAIMS

1. A process for the preparation of a carboxamide derivative of general formula (I) or a salt thereof



in which:

R^1 represents a methyl group, an ethyl group or a C_1 - C_4 -haloalkyl group substituted with 1 to 9 halogen atoms chosen from fluorine, chlorine and bromine;

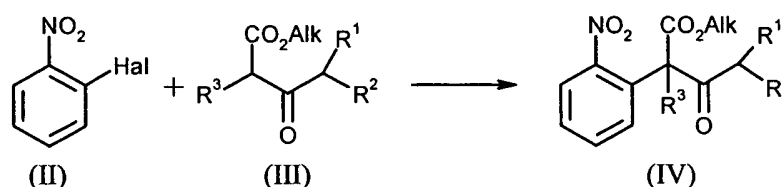
R^2 represents a halogen atom, a C_1 - C_4 -alkyl group or a C_1 - C_4 -haloalkyl group substituted with 1 to 9 halogen atoms chosen from fluorine, chlorine and bromine; and

A represents an optionally substituted 5-, 6- or 7-membered non-fused heterocycle with one, two or three heteroatoms which may be the same or different, the heterocycle being linked by a carbon atom;

said process comprising:

- (A) a first step according to reaction Scheme 1:

Scheme 1



in which:

R^1 and R^2 are as defined above; and

R^3 represents a hydrogen atom or a methyl group;

Hal represents a halogen atom; and

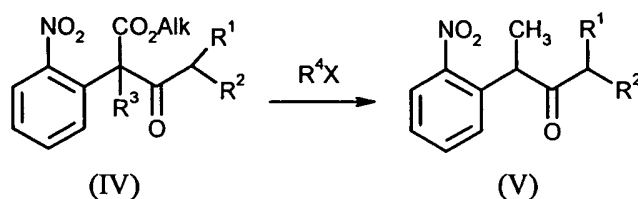
Alk represents a C_1 - C_{10} alkyl group;

comprising the reaction of a nitrobenzene derivative of general formula (II) with a ketoester derivative of general formula (III), in a compound (III) / compound (II) molar ratio of from 1 to 10, in a solvent and in the presence of a base, the base / compound (II) molar ratio being of from 0.5 to 5;

to provide a nitrophenyl ketoester derivative of general formula (IV);

(B) a second step according to reaction Scheme 2:

Scheme 2



in which:

R^1 and R^2 are as defined above; and

5 R^3 represents a hydrogen atom or a methyl group;

Alk represents a C_1 - C_{10} alkyl group;

R^4 represents a hydrogen atom or a metal specie; and

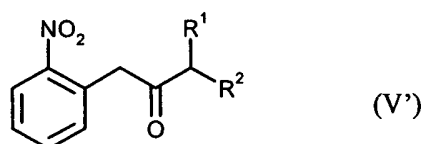
X represents a halogen atom;

comprising:

10 a) in the case R^3 is a methyl group, the decarboxylation reaction of a nitrophenyl keto-
ester derivative of formula (IV) obtained in step one in the presence of an agent R^4X ,
in a (R^4X) / compound (IV) molar ratio of from 0.1 to 50; in a solvent and at a
temperature of from 20°C to 180°C; or

b) in the case R^3 is a hydrogen atom,
15 1/ the decarboxylation of a nitrophenyl ketoester derivative of formula (IV)
obtained in step one in the presence of an agent R^4X , in a (R^4X) / compound
(III) molar ratio of from 0.1 to 50; in a solvent and at a temperature of from
20°C to 180°C;

20 which is then completed by the methylation of the intermediate of general
formula (V') previously obtained



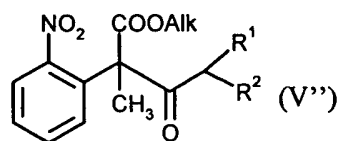
by adding methylating agent, in a methylating agent / compound (V') molar
ratio of from 0.5 to 2; in a solvent and in the presence of a base, in a base /
compound (V') molar ratio of from 0.5 to 2;

25 to provide a nitrophenyl ketone derivative of general formula (V);

or

2/ the methylation of a nitrophenyl ketoester derivative of formula (IV) obtain-
ed in step one by adding methylating agent, in a methylating agent /
compound (IV) molar ratio of from 0.5 to 2; in a solvent and in the presence
30 of a base, in a base / compound (IV) molar ratio of from 0.5 to 2;

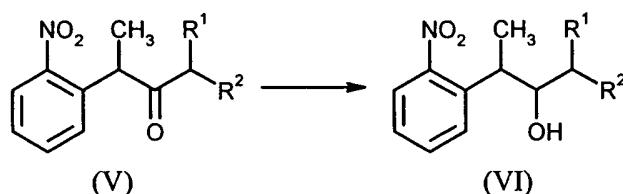
which is then completed by the decarboxylation of the intermediate of general formula (V'') previously obtained



5 in the presence of an agent R^4X , in a (R^4X) / compound (V'') molar ratio of from 0.1 to 50; in a solvent and at a temperature of from 20°C to 180°C; to provide a nitrophenyl ketone derivative of general formula (V);

(C) a third step according to reaction Scheme 3:

Scheme 3

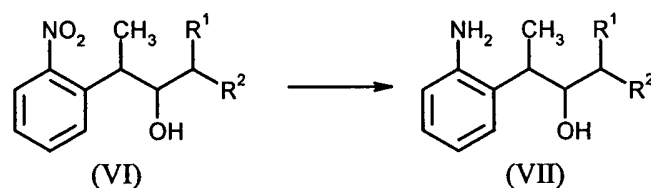


10 in which R^1 and R^2 are as defined above; comprising the reduction of a nitrophenyl ketone of general formula (V) obtained in step two by adding to it from 0.5 to 10 molar equivalent of a reduction agent, in a polar protic solvent and at a temperature of from -20°C to 80°C; to provide a nitrophenyl alcohol derivative of general formula (VI);

15

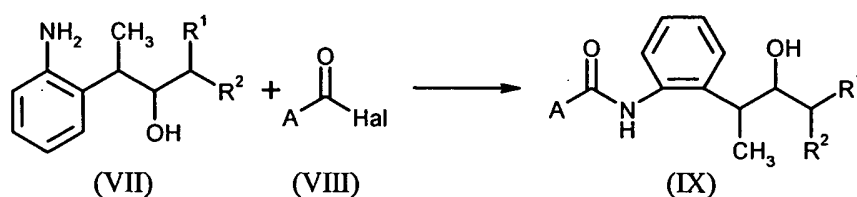
(D) a fourth step according to reaction Scheme 4:

Scheme 4



20 in which R^1 and R^2 are as defined above; comprising the reduction by H_2 of a nitrophenyl alcohol of general formula (VI) obtained in step three in the presence of a metal catalyst, in a solvent and under a pressure of from 1 to 10 bar; to provide an aminophenyl alcohol derivative of general formula (VII);

(E) a fifth step according to reaction Scheme 5:

Scheme 5

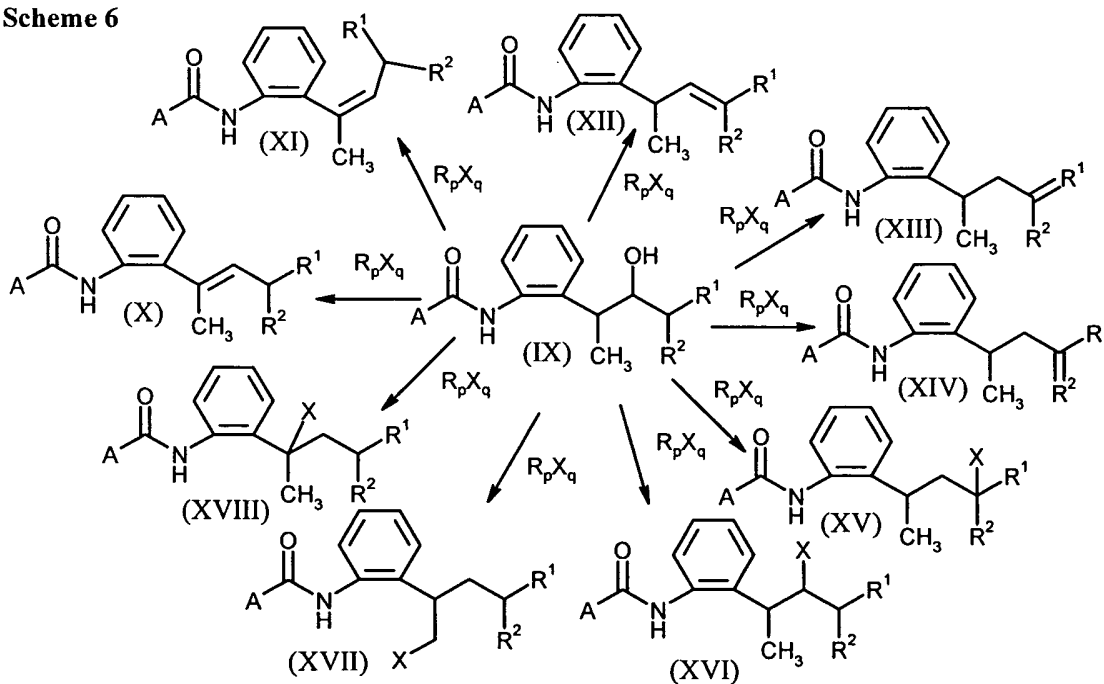
in which:

A, R¹ and R² are as defined above; and

Hal represents a halogen atom;

- 5 comprising the coupling reaction of an aminophenyl alcohol derivative of general formula (VII) obtained in step four with an acyl halide derivative of general formula (VIII), in a solvent and in the presence of a base in a base / compound (VII) molar ratio of 0.5 to 3; to provide a hydroxycarboxamide derivative of general formula (IX);

- 10 (F) a sixth step according to reaction Scheme 6:

Scheme 6

in which:

A, R¹ and R² are as defined above;

p and q are independently chosen as being 1, 2 or 3;

- 15 R represents a phosphorous atom, -P=O, -S=O, a mesyl group or a tosyl group;

X represents a halogen atom;

comprising the reaction of a hydroxycarboxamide derivative of general formula (IX) obtained in step five with a compound of formula R_pX_q at a temperature of from 0°C to 100°C ; to provide a carboxamide derivative of general formula (X), (XI), (XII), (XIII), (XIV), (XV), (XVI), (XVII) or (XVIII), or a mixture thereof;

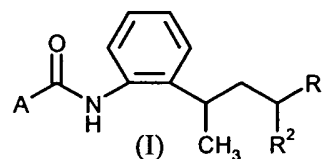
20

(G) a seventh step according to reaction Scheme 7:

Scheme 7

Mixture of carboxamide
derivatives of formula
(X) to (XVIII)

Reduction



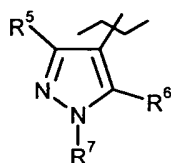
in which A, R¹ and R² are as defined above;

5 comprising the reduction by H₂ of all carboxamide derivatives of general formula (X) to (XVIII) obtained in step six, in the presence of a metal catalyst, in a solvent, at a temperature of from 10°C to 250°C and under a pressure of from 1 to 50 Bar;
to provide a carboxamide derivative of general formula (I).

10 2. A process according to claim 1, characterised in that R¹ is chosen as being methyl, ethyl, trifluoromethyl, difluoromethyl, fluoromethyl, trichloromethyl, dichloromethyl, chloromethyl, chlorofluoromethyl, fluorodichloromethyl, difluorochloromethyl, pentafluoroethyl, 1-fluoroethyl, 2-fluoroethyl, 2,2-difluoroethyl, 2,2,2-trifluoroethyl, 2-chloro-2-fluoroethyl, 2-chloro-2,2-difluoroethyl, 2-chloro-2,2-difluoroethyl, 2,2-dichloro-2-fluoroethyl, 2,2,2-trichloroethyl, 1-chlorobutyl, heptafluoro-n-propyl or heptafluoroisopropyl.

3. A process according to claim 1 or 2, characterised in that R² is chosen as being methyl, ethyl, fluorine, chlorine, bromine, trifluoromethyl, difluoromethyl, fluoromethyl, trichloromethyl, dichloromethyl, chloromethyl, chlorofluoromethyl, fluorodichloromethyl, difluorochloromethyl, pentafluoroethyl, 1-fluoroethyl, 2-fluoroethyl, 2,2-difluoroethyl, 2,2,2-trifluoroethyl, 2-chloro-2-fluoroethyl, 2-chloro-2,2-difluoroethyl, 2-chloro-2,2-difluoroethyl, 2,2-dichloro-2-fluoroethyl, 2,2,2-trichloroethyl, 1-chlorobutyl, heptafluoro-n-propyl or heptafluoroisopropyl.

25 4. A process according to any of the claims 1 to 3, characterised in that A represents a heterocycle of general formula (A1)



(A1), in which:

30 R⁵ represents hydrogen, cyano, halogen, nitro, C₁-C₄-alkyl, C₁-C₄-alkoxy, C₁-C₄-alkylthio, C₃-C₆-cycloalkyl, C₁-C₄-halogenoalkyl, C₁-C₄-halogenoalkoxy or C₁-C₄-halogenoalkylthio having in each case 1 to 5 halogen atoms, aminocarbonyl or aminocarbonyl-C₁-C₄-alkyl;

R^6 represents hydrogen, halogen, cyano, C_1 - C_4 -alkyl, C_1 - C_4 -alkoxy or C_1 - C_4 -alkylthio; and

R^7 represents hydrogen, C_1 - C_4 -alkyl, hydroxy- C_1 - C_4 -alkyl, C_2 - C_6 -alkenyl, C_3 - C_6 -cycloalkyl, C_1 - C_4 -alkylthio- C_1 - C_4 -alkyl, C_1 - C_4 -alkoxy- C_1 - C_4 -alkyl, C_1 - C_4 -halogenoalkyl, C_1 - C_4 -halogenoalkylthio- C_1 - C_4 -alkyl, C_1 - C_4 -halogenoalkoxy- C_1 - C_4 -alkyl having in each case 1 to 5 halogen atoms, or phenyl.

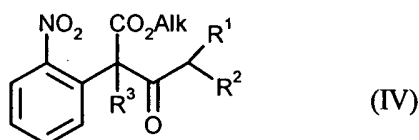
5. A process according to any of the claims 1 to 4, characterised in that step A is conducted at a temperature of from 0°C to 140°C .

6. A process according to any of the claims 1 to 5, characterised in that step A is conducted in the presence of a phase transfer agent.

7. A process according to any of the claims 1 to 6, characterised in that step F is conducted in the presence of a solvent.

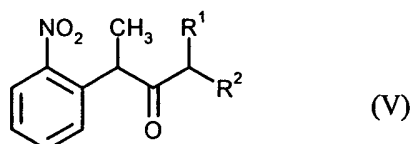
8. A process according to any of the claims 1 to 7, characterised in that step F is conducted in the presence of an acid.

9. A compound of formula (IV)



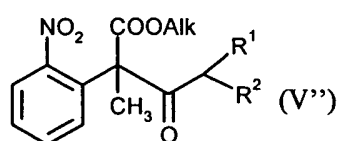
in which: R^1 , R^2 , R^3 are as in claim 1; and Alk represents a C_1 - C_{10} alkyl group.

10. A compound of formula (V)



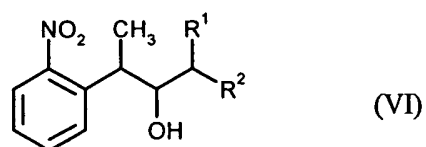
in which: R^1 and R^2 are as defined in claim 1; and Alk represents a C_1 - C_{10} alkyl group.

11. A compound of formula (V'')



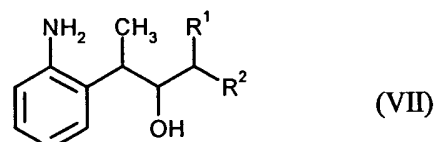
in which: R^1 and R^2 are as defined in claim 1; and Alk represents a C_1 - C_{10} alkyl group.

12. A compound of formula (VI)



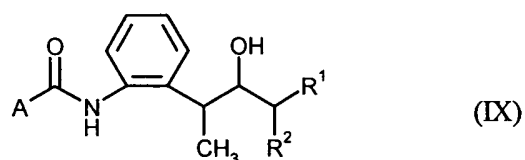
in which R¹ and R² are as defined in claim 1.

- 5 13. A compound of formula (VII)



in which R¹ and R² are as defined in claim 1.

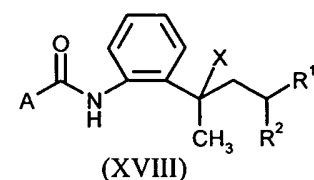
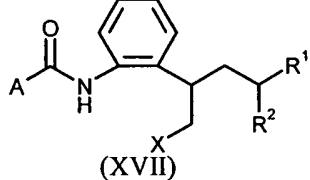
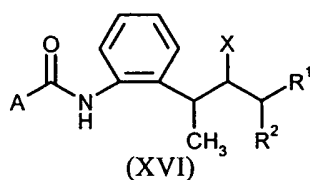
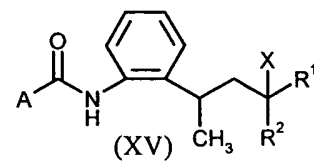
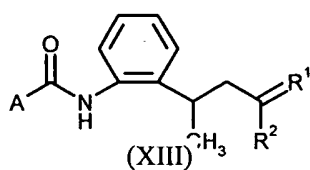
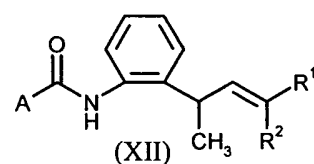
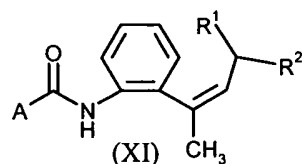
14. A compound of formula (IX)



10

in which A, R¹ and R² are as defined in claim 1.

15. Compounds of formulae (XI), (XII), (XIII), (XV), (XVI), (XVII) and (XVIII)



15

in which A, X, R¹ and R² are as defined in claim 1.

INTERNATIONAL SEARCH REPORT

International application No

PCT/EP2006/004566

A. CLASSIFICATION OF SUBJECT MATTER

INV. C07D231/14 C07C205/06 C07C211/44

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

C07D C07C

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal, CHEM ABS Data, WPI Data, BEILSTEIN Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	EP 0 824 099 A (MITSUI CHEMICALS, INC) 18 February 1998 (1998-02-18) cited in the application	15
A	examples 2,8	1-14
X	WO 2004/072023 A (BAYER CROPSOURCE AKTIENGESELLSCHAFT; DUNKEL, RALF; ELBE, HANS-LUDWIG;) 26 August 2004 (2004-08-26)	15
A	page 28, line 1 - page 28, line 21	1-14
X	WO 2004/103975 A (BAYER CROPSOURCE AKTIENGESELLSCHAFT; DUNKEL, RALF; ELBE, HANS-LUDWIG;) 2 December 2004 (2004-12-02)	15
A	page 25, line 21 - page 26, line 7	1-14



Further documents are listed in the continuation of Box C.



See patent family annex.

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O document referring to an oral disclosure, use, exhibition or other means

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Date of the actual completion of the international search

25 July 2006

Date of mailing of the international search report

31/07/2006

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INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/EP2006/004566

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