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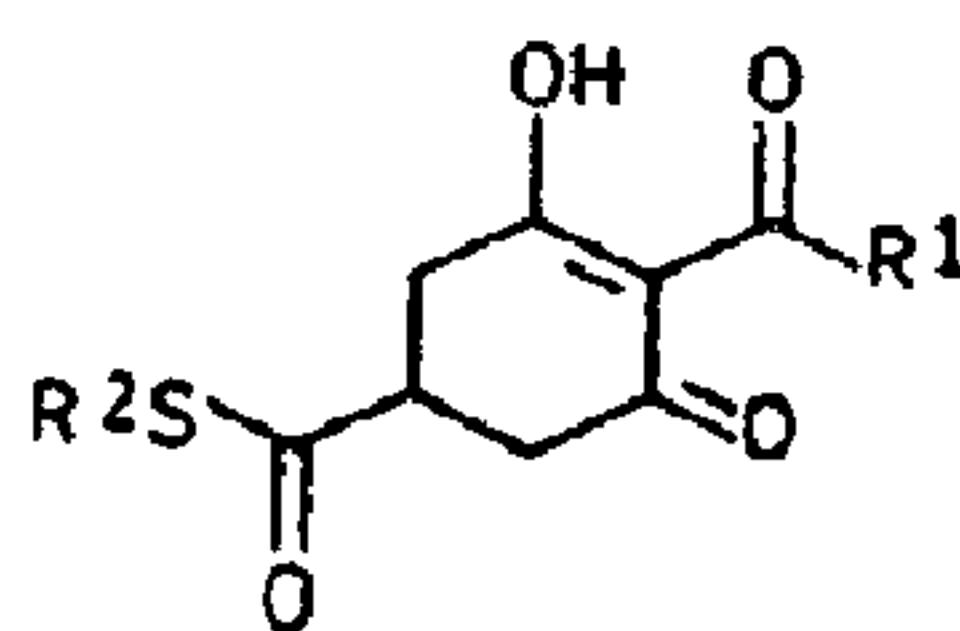
(72) Inventeurs/Inventors:
Schubert, Juergen, DE;
Kaczmarek, Reinhard, DE;
KAST, JUERGEN, DE

(73) Propriétaire/Owner:
BASF AKTIENGESELLSCHAFT, DE

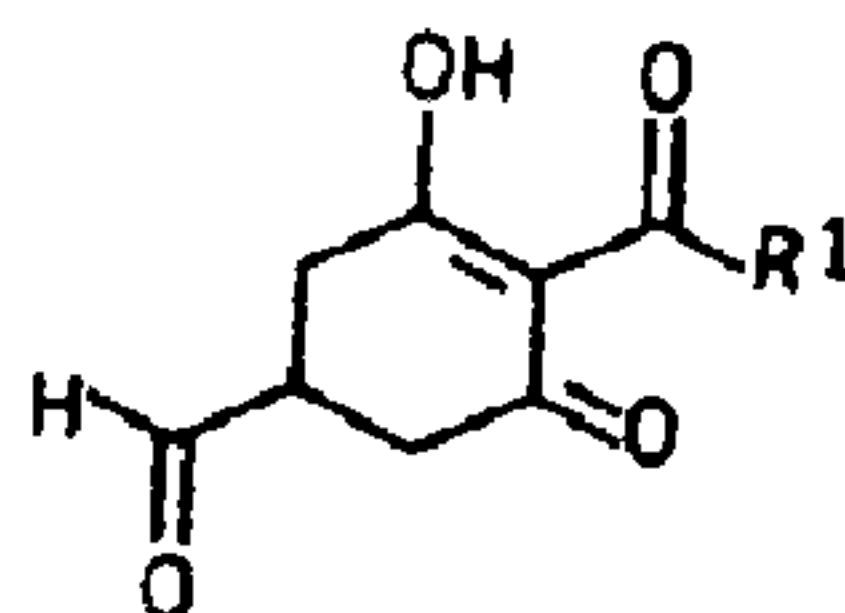
(74) Agent: ROBIC

(54) Titre : PREPARATION DE -ESTERS ACYLCYCLOHEXADIONETHIOCARBOXYLIQUES ET NOUVEAUX
INTERMEDIAIRES

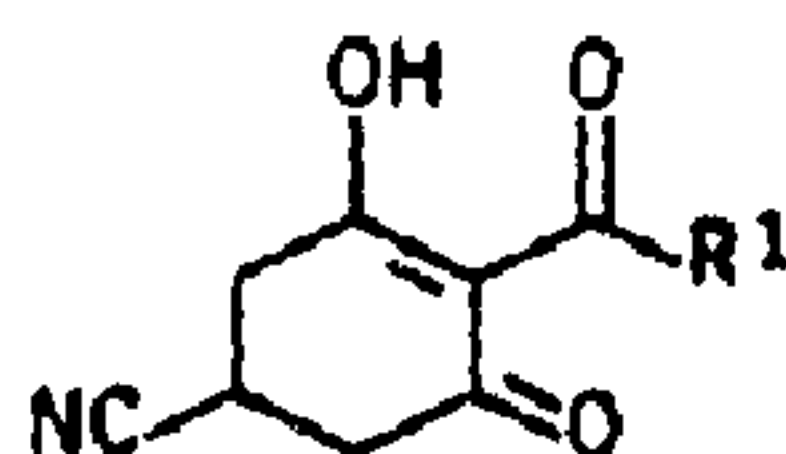
(54) Title: PREPARATION OF ACYLCYCLOHEXADIONETHIOCARBOXYLIC S-ESTERS AND NOVEL
INTERMEDIATES



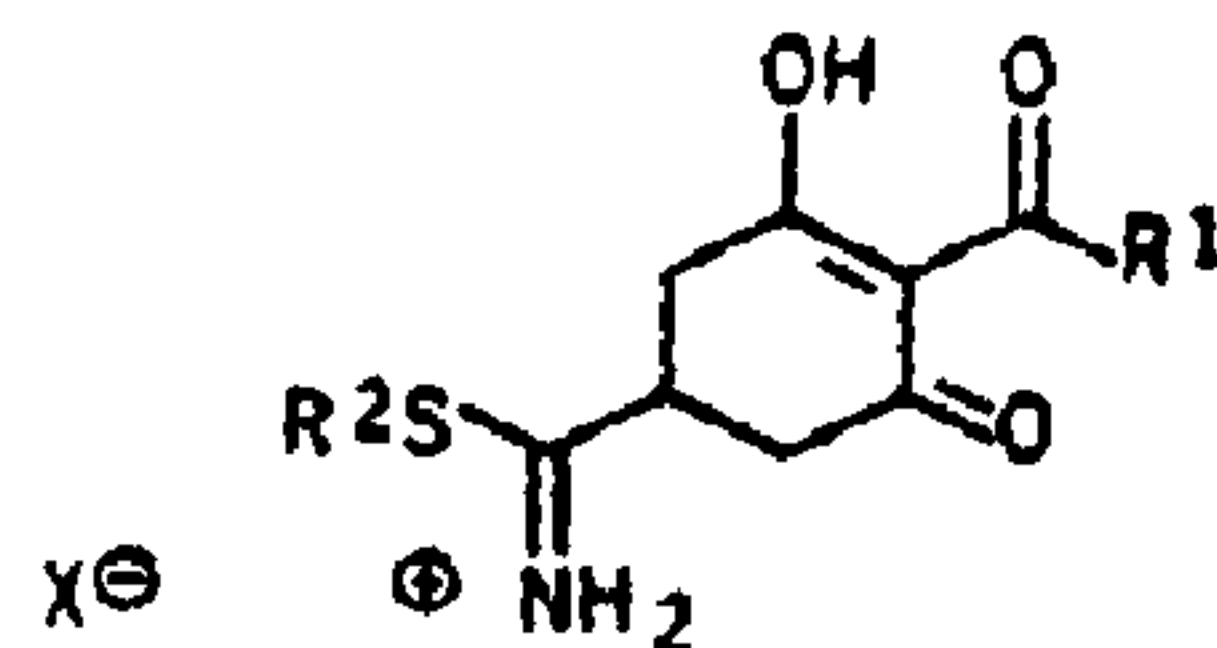
I



II



III



V

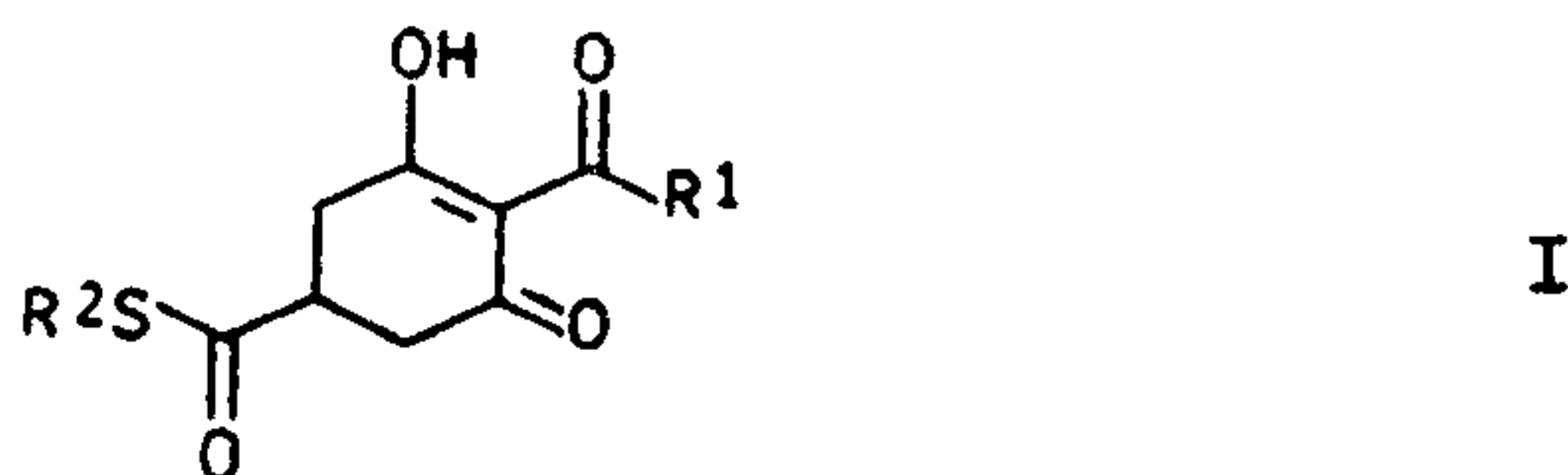
(57) Abrégé/Abstract:

An acylcyclohexadionethiocarboxylic S-ester of the formula (see formula I) where R¹ and R² are substituted or unsubstituted alkyl, alkenyl, alkynyl, cycloalkyl, benzyl or phenyl, and R² is additionally hydrogen, are prepared by reacting an

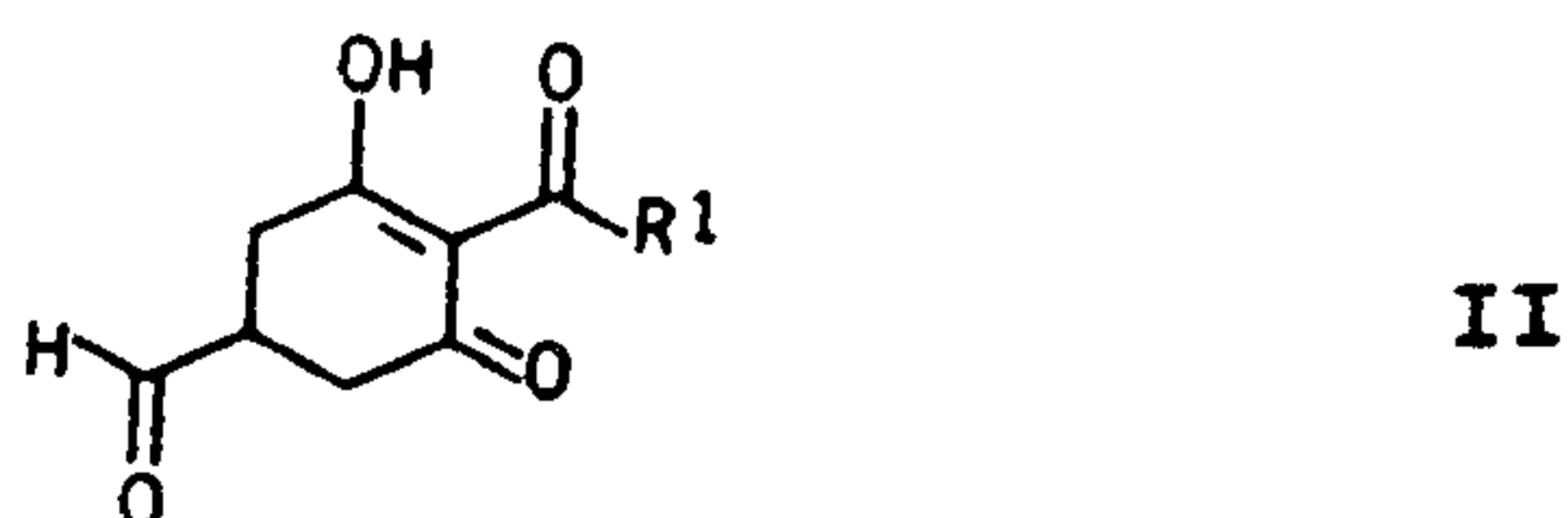
(57) **Abrégé(suite)/Abstract(continued):**

acylcyclohexadione II (see formula II) with hydroxylamine or hydroxylamine-O-sulfonic acid in an inert solvent at from 0 to 150°C, to give an acylcyclohexadione compound III (see formula III) and then reacting the compound III with a mercaptan IV R^2-SH IV in the presence of an anhydrous acid HX to give an acylcyclohexadionethiocarboximidic S-ester salt V (see formula V) where X is the anion of the acid, and hydrolyzing the compounds V to the acylcyclohexadionethiocarboxylic S-ester I.

Abstract of the Disclosure: An acylcyclohexadionethiocarboxylic S-ester of the formula



where R^1 and R^2 are substituted or unsubstituted alkyl, alkenyl, alkynyl, cycloalkyl, benzyl or phenyl, and R^2 is additionally hydrogen, are prepared by reacting an acylcyclohexadione II



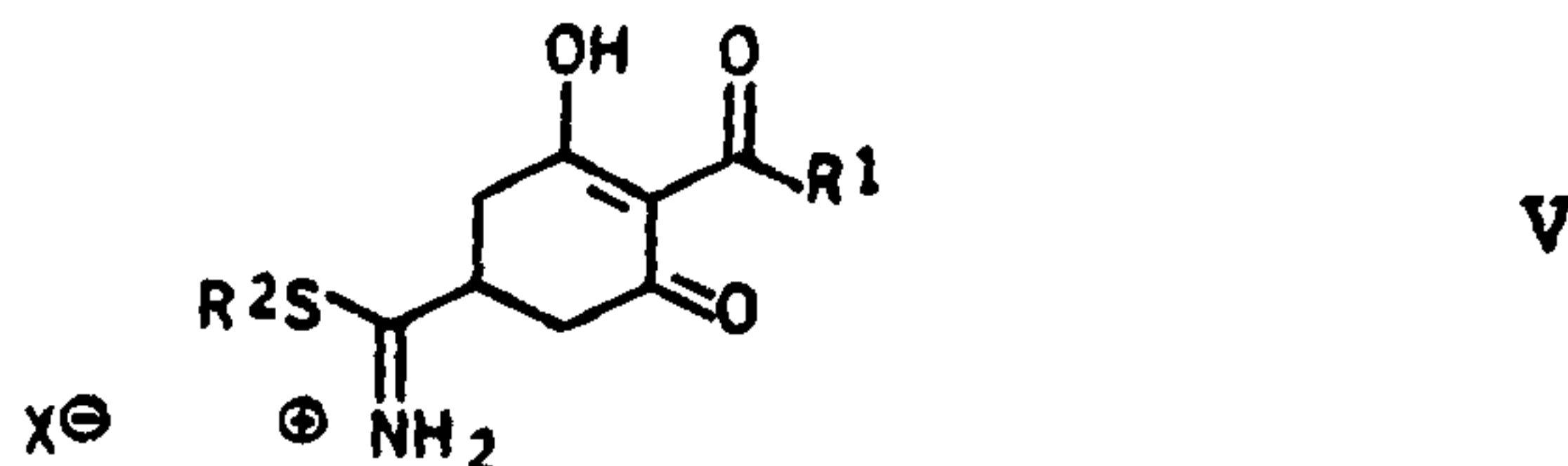
with hydroxylamine or hydroxylamine-O-sulfonic acid in an inert solvent at from 0 to 150°C, to give an acylcyclohexadione compound III



and then reacting the compound III with a mercaptan IV



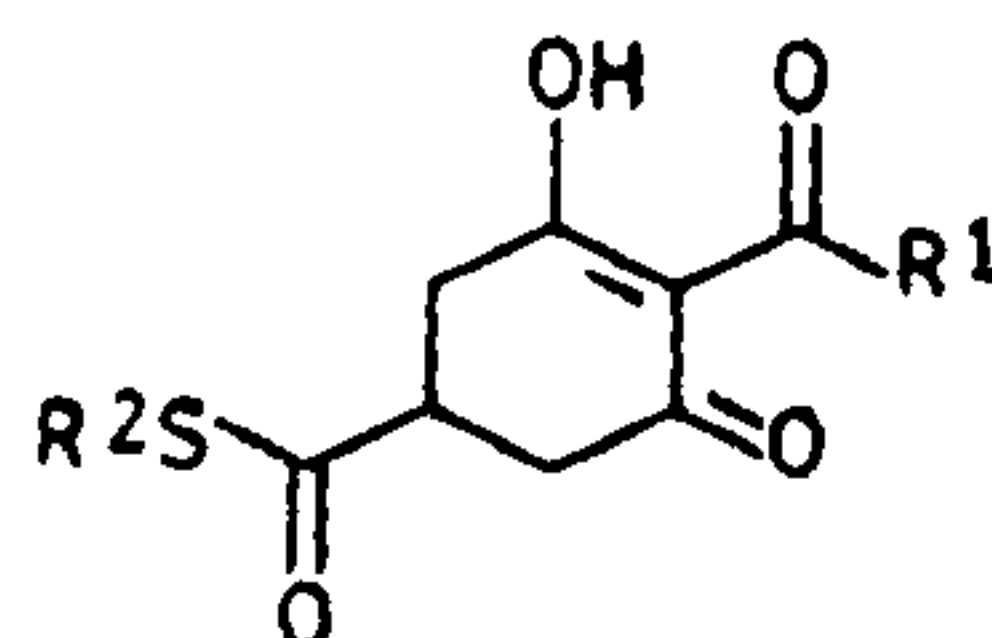
in the presence of an anhydrous acid HX to give an acylcyclohexadionethiocarboximidic S-ester salt V



where X is the anion of the acid, and hydrolyzing the compounds V to the acylcyclohexadionethiocarboxylic S-ester I.

The preparation of acylcyclohexadionethiocarboxylic
S-esters and novel intermediates

The present invention relates to the preparation
of acylcyclohexadionethiocarboxylic S-esters of the
formula I



I

where

R^1 is C_1 - C_{20} -alkyl, C_2 - C_{20} -alkenyl, C_2 - C_{20} -alkynyl or C_3 - C_6 -cycloalkyl, each of which is unsubstituted or substituted
by halogen, C_1 - C_4 -alkoxy or C_1 - C_4 -alkylthio, or is benzyl
or phenyl, each of which is unsubstituted or substituted
by halogen, cyano, C_1 - C_4 -alkyl, C_1 - C_4 -alkoxy, C_1 - C_4 -halo-
alkyl or nitro, and

R^2 is hydrogen, C_1 - C_6 -alkyl, C_2 - C_6 -alkenyl, C_2 - C_6 -alkynyl or
 C_3 - C_6 -cycloalkyl, each of which is unsubstituted or
substituted by C_1 - C_4 -alkoxy, C_1 - C_4 -alkylthio, C_1 - C_4 -di-
alkylamino, hydroxyl or halogen; benzyl or phenyl, each
of which is unsubstituted or substituted by halogen,
cyano, C_1 - C_4 -alkyl, C_1 - C_4 -alkoxy or nitro.

Furthermore, novel intermediates are made avail-
able by the present invention.

Acylcyclohexadionethiocarboxylic S-esters I are
highly active bioregulators, as is disclosed in EP-A
293 817. There are various possibilities for the prepara-
tion of S-esters. Some methods are described below.

Route A:

From activated carboxylic acids with thiols.
Examples of suitable activating reagents are diphenyl-
phosphinic chloride (Monatsh. Chem. 110, (1979) 759),
diethyl cyanophosphate (Tetrahedron Lett. 1973, 1595),
carbonyl-bis-imidazolidine and carbonyl-bis-triazolidine
(Angew. Chem. 89 (1977) 251; J. Am. Chem. Soc. 93 (1971)
1419).

Route B:

From carbonyl halides or carboxylic anhydrides or esters with thiols or thiolates in the presence or absence of a base (Houben-Weyl, Methoden der organischen Chemie, Vol. 9, pages 753-760, 1955).

Route C:

By free-radical substitution on aldehydes with organic disulfides catalyzed by UV light or with free radical initiators such as azobisisobutyronitrile (Bull. Chem. Soc. Jpn. 53, (1980), 1982).

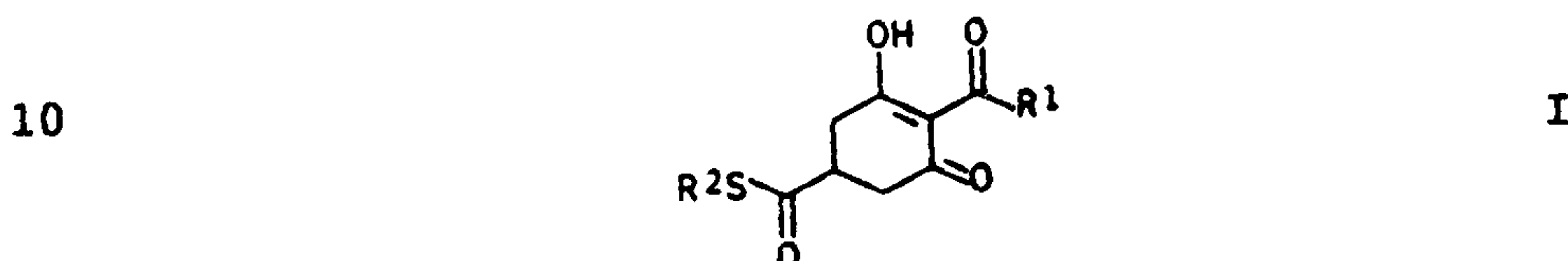
All of these processes have one or more serious disadvantages. The activating reagents used in route A are costly or difficult to obtain, which rules out commercial utilization. The aldehyde component is used in large excess or as solvent in route C, which makes the process uneconomic for costly aldehydes.

Route B, the reaction with acid halides or anhydrides, is a standard method for preparing S-esters. However, there is a risk with the cyclohexadiones that the conventional halogenating agents such as thionyl chloride, phosphorus oxychloride, sulfuryl chloride, oxalyl chloride or phosgene will also replace the vinylic OH group by halogen, eg. chlorine or bromine.

It is also known from the literature that adducts are formed between mercaptans and nitriles in the presence of hydrogen chloride. The resulting thiocarboximidic S-esters can be hydrolyzed to thiocarboxylic S-esters (A. Pinner, Die Iminoether, p. 80 Verlag R. Oppenheim, Berlin 1892). However, because of the competing hydrolysis to carboxamides and carboxylic acids, in general, yields of only about 10 to 25% are obtained (see, for example, US 2,458,075 (1946) Philipps Petrol Co., inventor: Ch. M. Himel, CA 43 (1949) 3444 or Ber. Dt. Chem. Ges. 69 (1936) 2352), for which reason this sequence of reactions is not regarded as being of preparative significance (Houben-Weyl, Methoden der organischen Chemie, E5/I p. 876, 1985).

It is an object of the present invention to find a process for preparing the acylcyclohexadionethiocarboxylic S-esters I, which are defined in the first paragraph, which is straightforward and can be carried out on the industrial scale, gives good yields of the desired product I and requires few process stages.

We have found that this object is achieved by a process for preparing acylcyclohexadionethiocarboxylic S-esters of the formula I

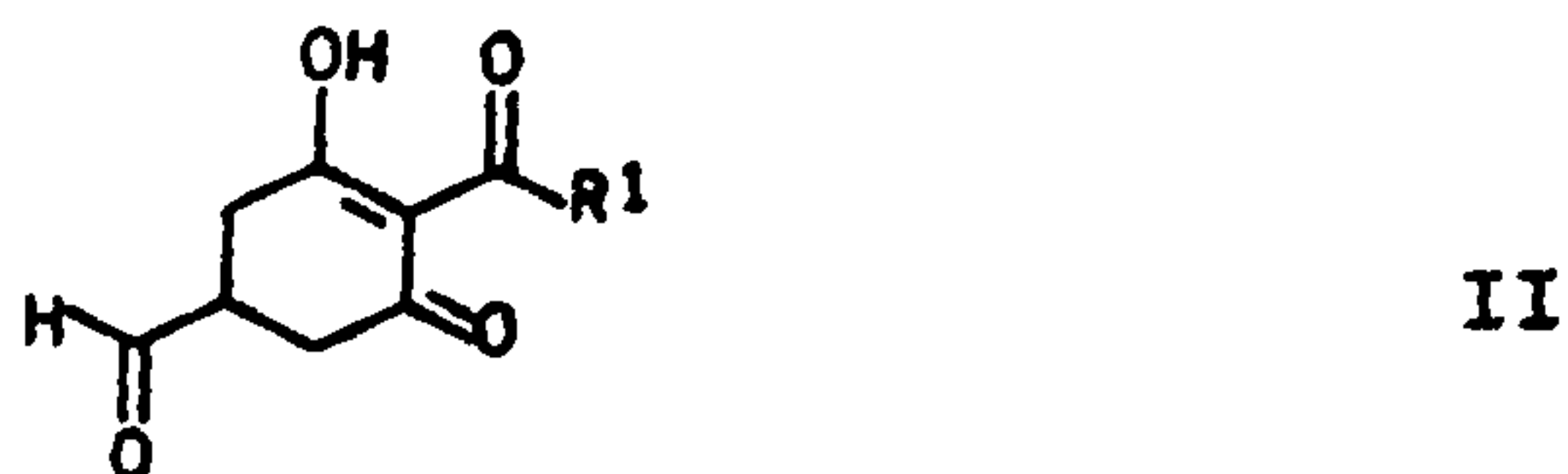


where

R^1 is C_1 - C_{20} -alkyl, C_2 - C_{20} -alkenyl, C_2 - C_{20} -alkynyl or C_3 - C_8 -cycloalkyl, each of which is unsubstituted or substituted by halogen, C_1 - C_4 -alkoxy or C_1 - C_4 -alkylthio, or is benzyl or phenyl, each of which is unsubstituted or substituted by halogen, cyano, C_1 - C_4 -alkyl, C_1 - C_4 -alkoxy, C_1 - C_4 -haloalkyl or nitro, and

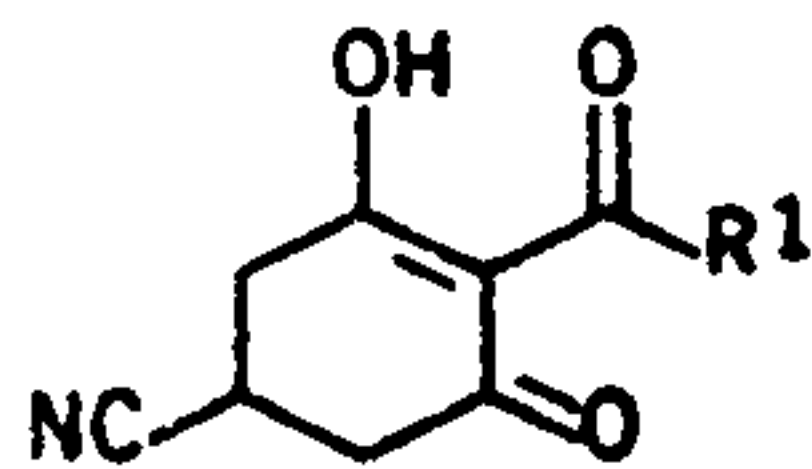
R^2 is hydrogen, C_1 - C_8 -alkyl, C_2 - C_8 -alkenyl, C_2 - C_8 -alkynyl or C_3 - C_8 -cycloalkyl, each of which is unsubstituted or substituted by C_1 - C_4 -alkoxy, C_1 - C_4 -alkylthio, C_1 - C_4 -di-alkylamino, hydroxyl or halogen; benzyl or phenyl, each of which is unsubstituted or substituted by halogen, cyano, C_1 - C_4 -alkyl, C_1 - C_4 -alkoxy or nitro,

which comprises reacting, in a first stage, a compound of the formula II



where R^1 has the abovementioned meaning, with hydroxylamine or hydroxylamine-O-sulfonic acid in an inert solvent at from 0 to 150°C to give a compound of the

formula III



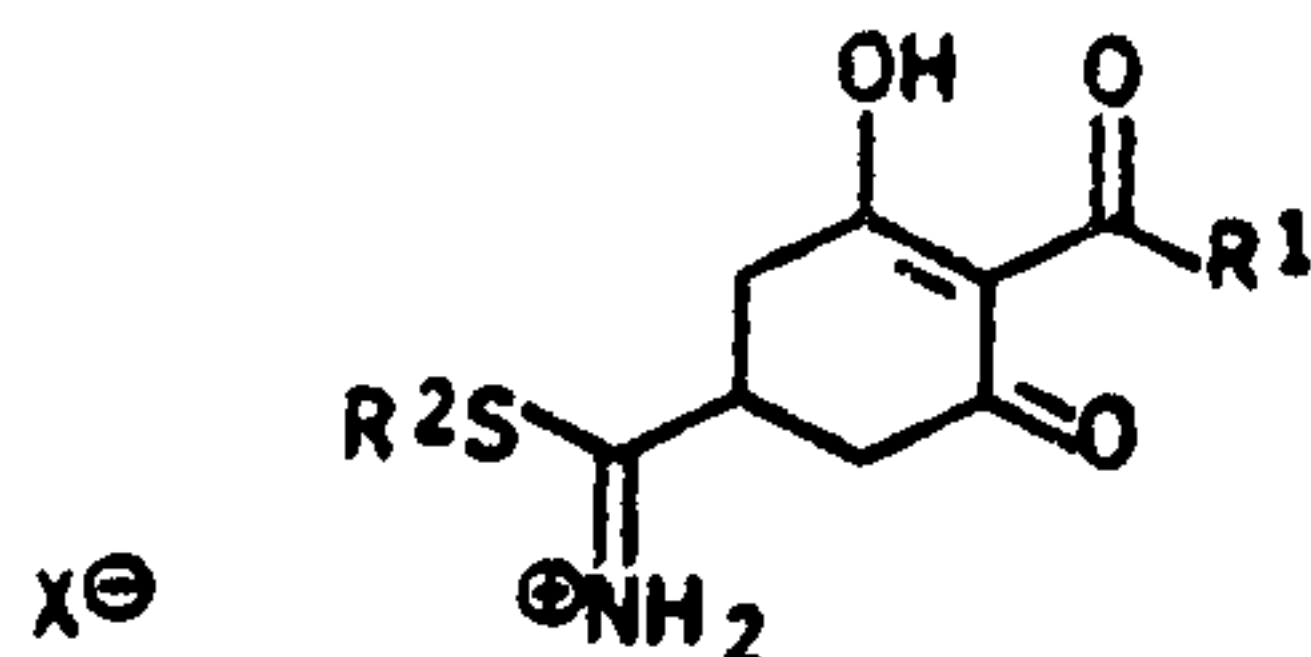
III

where R^1 has the abovementioned meaning,
and then, in a second stage, reacting this cyano compound
5 of the formula III with a mercaptan of the formula IV



IV

where R^2 has the abovementioned meaning, in the presence
of an acid HX, to give a compound of the formula V

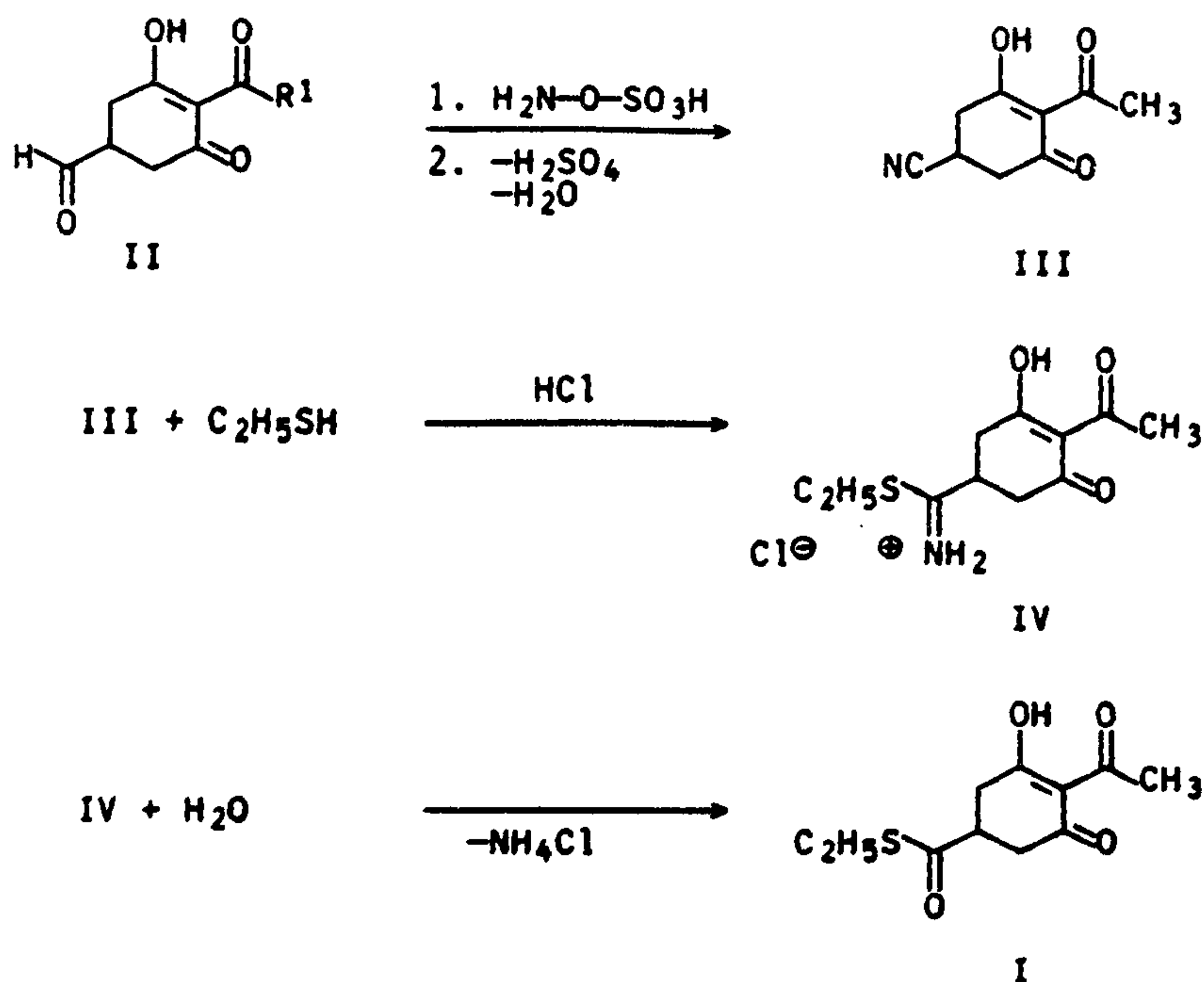


V

10 where R^1 and R^2 have the abovementioned meanings, and X is
the anion of an acid, and,
in a third stage, hydrolyzing the compound of the formula
V to give the compound of the formula I.

15 The reaction sequence in the process according to
the invention is shown in the scheme below, where R^1 is
methyl, R^2 is ethyl and the acid used in the second stage
is hydrogen chloride.

Reaction scheme:



In the first stage, the formyl compound II, which can be obtained as described in DE-A-233,568, is reacted with hydroxylamine-O-sulfonic acid or hydroxylamine under condensation conditions in an inert solvent at from 0 to 150°C, in particular 20 to 80°C. It has proven particularly beneficial to carry out the reaction with hydroxylamine-O-sulfonic acid in water, eg. in from 1 to 100 parts by weight of water based on the formyl compound II.

The reaction can be carried out in homogeneous or heterogeneous aqueous phase, with or without the addition of a buffer, the pH generally being from 1 to 9, in particular from 3 to 8.

The procedure is expediently such that the formyl compound II is suspended or induced to dissolve, by adding a water-miscible organic solvent, eg. methanol or ethanol, in water. It is also possible to dissolve the starting material II in water-immiscible solvents such as ethers, eg. diethyl ether, chlorohydrocarbons such as methylene chloride, chloroform or dichloroethane, esters

such as ethyl acetate, or aromatic compounds such as benzene, toluene or xylenes. The hydroxylamine-O-sulfonic acid is added in solid form or as aqueous solution to the mixture of solvent and starting material II.

5 If the reaction is carried out in heterogeneous phase, it is advantageous to ensure that the phases are thoroughly mixed.

10 In order to achieve complete conversion into the cyano compound III, it is advisable to employ the reactants in equimolar amounts. It may be advisable, for technical reasons, to employ the formyl compound II or the hydroxylamine-O-sulfonic acid in an excess of, for example, from 1 to 100 mol %. It is preferable to use the hydroxylamine-O-sulfonic acid in an excess of from 10 to 15 20 mol %.

As a rule, the reaction goes to completion at up to 60°C, in particular from 20 to 40°C.

It may be advantageous in some cases to increase the reaction rate by adding catalytic amounts of a base.

20 Examples of suitable bases are alkali metal hydroxides such as NaOH or KOH, ammonium hydroxide, alkaline earth metal hydroxides such as magnesium hydroxide or calcium hydroxide, alkali metal carbonates or bicarbonates such as potassium carbonate or sodium bicarbonate. It is normally possible to use, based on the 25 starting material II, from 0 to 3 equivalents of base.

The reaction can be carried out under atmospheric pressure or elevated or reduced pressure, continuously or batchwise, using the conventional techniques.

30 The cyanocyclohexenone compound III can be isolated from the crude reaction mixture in a conventional manner, eg. by extraction or filtration.

It is also possible to react the starting material II with hydroxylamine in place of hydroxylamine-O-sulfonic acid, and then to eliminate water in a conventional manner, eg. by heating with acetic anhydride or 35 thionyl chloride at from about 80 to 150°C.

In the second stage, the acylcyclohexadione III is reacted with a mercaptan R^2-SH IV in the presence of anhydrous acid and with exclusion of water. Examples of such acids are hydrogen chloride, hydrogen bromide, 5 sulfuric acid, perchloric acid or tetrafluoroboric acid or strong carboxylic acids such as trifluoroacetic acid. Particular preference is given to hydrogen bromide and, in particular, hydrogen chloride.

10 In order to achieve complete conversion, it is advisable to employ the mercaptan IV and the cyano compound III in equimolar amounts. It may be advantageous, for technical reasons, to employ one of the two components in excess. The mercaptan is preferably used in an excess of from 0 to 200 mol %, preferably from 5 to 15 100 mol %.

Preferred R^2 radicals in the mercaptan are: methyl, ethyl, propyl, i-propyl, t-butyl, n-hexyl, allyl, butenyl, methoxyethyl, 3-chloropropyl, 2-dimethylamino-ethyl, 2-hydroxyethyl, cyclohexyl, benzyl, 4-methyl- 20 benzyl, 4-chlorobenzyl, phenyl, p-tolyl, 4-chlorophenyl, 4-methoxyphenyl, 3-nitrophenyl.

The reaction of the cyanocyclohexadione compound III with the mercaptan IV is expediently carried out in an aprotic organic diluent. Suitable examples are ethers 25 such as diethyl ether, tetrahydrofuran and dioxane, hydrocarbons such as pentane, hexane, cyclohexane, petroleum ether benzene and toluene, halohydrocarbons such as methylene chloride, chloroform, tetrachloro-methane and 1,2-dichloroethane.

30 The reaction can be carried out at from $-20^{\circ}C$ to $100^{\circ}C$, preferably from $0^{\circ}C$ to $+40^{\circ}C$, under atmospheric pressure or elevated or reduced pressure, using the conventional techniques.

35 The reaction is expediently carried out in such a way that the cyanocyclohexadione compound III is introduced together with the mercaptan IV into the diluent, substantially excluding water, and the acid is

added dropwise or passed in as gas at low temperature, eg. 0°C. It is then possible, to complete the reaction, to warm to from 20 to 40°C, for example.

5 The carboximidic S-ester salt V, which generally separates out as crystals or an oil, can be isolated in a conventional manner, eg. by filtration or extraction. If there is no interest in isolating the intermediates V, these can be converted by aqueous extraction, with simultaneous hydrolysis, into the final products I.

10 The intermediates V can be hydrolyzed in water, preferably in the presence of an acid or, in particular, in dilute aqueous mineral acid, eg. hydrochloric, sulfuric or phosphoric acid, or dilute carboxylic acids such as acetic or formic acid.

15 The amount of acid is not particularly critical and is generally from 0 to 100 parts by weight of acid based on V. The acid concentration is from 0 to 20% by weight, and aqueous solutions containing from 0 to 10% by weight of acid are preferably used. The pH of the reaction mixture is preferably from 1 to 7, in particular below 2.

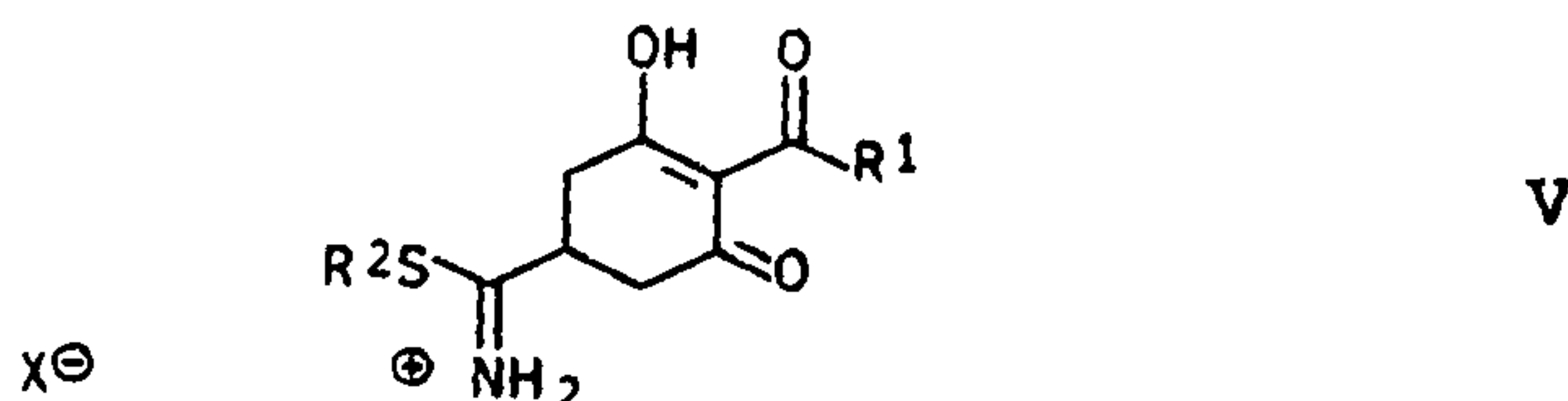
The reaction temperatures are likewise not critical and are usually from 0 to 100°C, in particular from 10 to 40°C.

25 Because the S-esters of the formula I are not soluble in water (solubility 100 mg/l), they are produced in the hydrolysis of V as an oil or solid. The hydrolysis can take place in a two-phase system by adding a water-immiscible solvent such as an ether, eg. diethyl ether, ester, eg. ethyl acetate, chlorohydrocarbon, eg. methyl-
30 ene chloride, chloroform, tetrachloromethane or dichloroethane, aromatic hydrocarbon, eg. benzene, toluene or xylene, which has the advantageous result that the reaction product I can be isolated directly from the organic phase. It is, of course, also possible to add the
35 organic solvent only after the hydrolysis has taken place, in order to isolate I.

Otherwise, the process, which can also be carried out as a one-pot process without isolation of the intermediates III and V described, involves no special technical procedures.

5 The invention provides novel intermediates V.

 The acylcyclohexadionecarboximidic S-ester salts V have the following formula



where

- 10 R^1 is C_1 - C_{20} -alkyl, C_2 - C_{20} -alkenyl, C_2 - C_{20} -alkynyl or C_3 - C_6 -cycloalkyl, each of which is unsubstituted or substituted by halogen, C_1 - C_4 -alkoxy or C_1 - C_4 -alkylthio, or is benzyl or phenyl, each of which is unsubstituted or substituted by halogen, cyano, C_1 - C_4 -alkyl, C_1 - C_4 -alkoxy, C_1 - C_4 -haloalkyl or nitro;
- 15 R^2 is hydrogen, C_1 - C_6 -alkyl, C_2 - C_6 -alkenyl, C_2 - C_6 -alkynyl or C_3 - C_6 -cycloalkyl, each of which is unsubstituted or substituted by C_1 - C_4 -alkoxy, C_1 - C_4 -alkylthio, C_1 - C_4 -dialkylamino, hydroxyl or halogen; benzyl or
- 20 phenyl, each of which is unsubstituted or substituted by halogen, cyano, C_1 - C_4 -alkyl, C_1 - C_4 -alkoxy or nitro, and
- X is a chloride, bromide, sulfate, phosphate, tetrafluoroborate, perchlorate or trifluoroacetate ion.

25 With a view to the biological activity of the final products I, R^1 , R^2 and X in the formula V have the following preferred meanings:

- 30 R^1 - C_1 - C_6 -alkyl such as methyl, ethyl, propyl, isopropyl, n-butyl, iso-butyl, s-butyl, t-butyl, n-pentyl, n-hexyl
- C_3 - C_6 -cycloalkyl such as cyclopropyl, cyclopentyl, cyclohexyl
- C_2 - C_6 -alkoxyalkyl eg. C_1 - C_4 -alkoxy- C_1 - C_4 -alkyl such

as methoxymethyl, ethoxymethyl, propyloxymethyl,
2-methoxyethyl, 2-ethoxyethyl, 2-propyloxyethyl,
methoxypropyl, ethoxypropyl,

- C₂-C₆-alkylthioalkyl, eg. methylthiomethyl,
ethylthiomethyl, methylthioethyl, ethylthioethyl,
methylthiopropyl, ethylthiopropyl,

- benzyl or phenyl, it being possible for the
aromatic nuclei to be substituted from once to
three times by halogen such as chlorine, bromine
or fluorine, by cyano, nitro, C₁-C₄-alkyl such as
methyl, ethyl, propyl or butyl, C₁-C₄-alkoxy such
as methoxy, ethoxy, propoxy or butoxy, C₁-C₄-
haloalkyl such as trifluoromethyl, difluoro-
chloromethyl, difluoromethyl, trichloromethyl or
tetrafluoroethyl,

R² - C₁-C₆-alkyl such as methyl, ethyl, propyl, iso-
propyl, n-butyl, iso-butyl, sec.-butyl, n-pentyl
or n-hexyl,

- C₃-C₅-alkenyl such as allyl, 2-butenyl, 3-butenyl
or 2-pentenyl,

- C₃-C₄-alkynyl such as propargyl, 2-butyne or 3-
butyne,

- C₃-C₆-cycloalkyl as specified for R¹,

- C₂-C₆-alkoxyalkyl or alkylthioalkyl, in each case
as specified for R¹,

- phenyl or benzyl, it being possible for the
aromatic nuclei to be substituted as specified
for R¹,

X - chloride or bromide.

It is particularly preferred for R¹ to be C₁-C₄-
alkyl, C₃-C₆-cycloalkyl or phenyl, R² to be C₁-C₆-alkyl,
C₃-C₄-alkenyl, C₃-C₄-alkynyl, C₂-C₆-alkoxyalkyl or benzyl,
and X to be chloride.

EXAMPLE 1.1

3,5-Dioxo-4-acetylcyclohexanecarbonitrile

19.3 g (0.11 mol) of 5-formyl-2-acetylcyclohexane-1,3-dione were introduced into 200 ml of distilled water and, at room temperature, 14.7 g (0.13 mol) of hydroxylamine-O-sulfonic acid were added. The mixture was then stirred at room temperature for 17 h. The precipitate was filtered off with suction, washed with water and dried. 11.5 g (61% of theory) of 3,5-dioxo-4-acetylcyclohexanecarbonitrile were obtained (melting point 94 to 97°C).

EXAMPLE 1.2

3,5-Dioxo-4-propionylcyclohexanecarbonitrile

30.7 g (0.16 mol) of 5-formyl-2-propionylcyclohexane-1,3-dione were introduced into 150 ml of distilled water and, at room temperature, 21.0 g (0.19 mol) of hydroxylamine-O-sulfonic acid were added. The mixture was then stirred at room temperature overnight. The precipitate was filtered off with suction, washed with water and dried. 23.8 g (71% of theory) of 3,5-dioxo-4-propionylcyclohexanecarbonitrile were obtained (melting point 70 to 74°C).

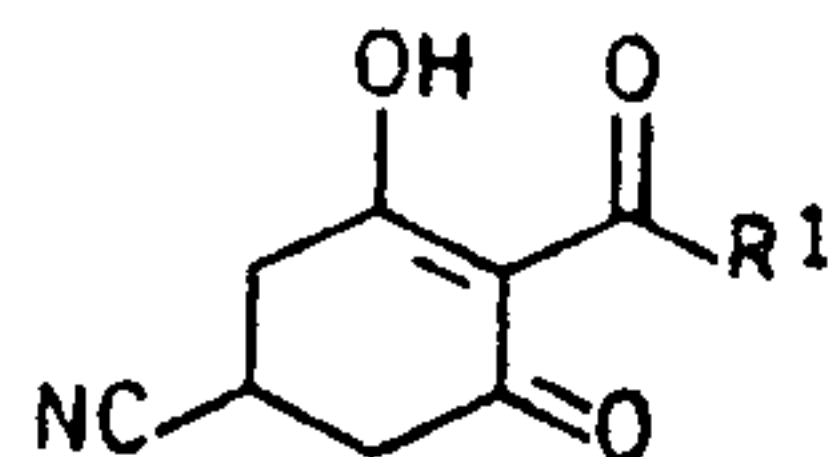
EXAMPLE 1.5

3,5-Dioxo-4-palmitoylcyclohexanecarbonitrile

43 g (0.12 mol) of 5-formyl-2-palmitoylcyclohexane-1,3-dione were suspended in 150 ml of distilled water. To this were added 15.7 g (0.14 mol) of hydroxylamine-O-sulfonic acid dissolved in 50 ml of water. The heterogeneous reaction mixture was stirred at room temperature overnight. The resulting solid was filtered off with suction, washed with water and dried. 37.7 g (86% of theory) of 3,5-dioxo-4-palmitoylcyclohexanecarbonitrile were isolated (melting point 66 to 69°C).

The cyclohexenone compounds III shown in Table 1 can be prepared in a similar manner.

TABLE 1:
Cyclohexenone compounds III



III

No.	R ¹	phys. data	
		m.p. [°C]	¹ H-NMR [δ in ppm]
5	1.1	methy	94 to 97
	1.2	ethyl	70 to 74
	1.3	propyl	47 to 50
	1.4	butyl	58 to 59
	1.5	pentadecanyl	66 to 69
10	1.6	cyclopropyl	1.2(m); 1.35(m); 3.0(m); 3.3(m)
	1.7	cyclohexyl	
	1.8	phenyl	
	1.9	4-Cl, 2-NO ₂ -C ₆ H ₃	184 to 187 (decomposition)

15 EXAMPLE 2.1

S-Methyl 3,5-dioxo-4-propionylcyclohexanethiocarboximide hydrochloride

20 5.0 g (0.026 mol) of 3,5-dioxo-4-propionylcyclohexanecarbonitrile and 1.37 g (0.028 mol) of methyl mercaptan were dissolved in 100 ml of dry diethyl ether. The solution was cooled to 0°C and then a vigorous stream of dry hydrogen chloride was passed through it. After 0.5 h the gas stream was turned off, and the reaction mixture was slowly warmed to room temperature. It was again cooled to 0°C, hydrogen chloride was passed in (0.5 h) and then the cooling was removed and the mixture was left to stand overnight. The crystals which formed were filtered off with suction and dried in vacuo: 5.4 g (74% of theory) of compound 2.1 [melting point 161°C (decomposition)].

30

EXAMPLE 2.2

S-Ethyl 3,5-dioxo-4-propionylcyclohexanethiocarboximide hydrochloride

19.3 g (0.1 mol) of 3,5-dioxo-4-propionylcyclo-

hexanecarbonitrile and 6.5 g (0.105 mol) of ethyl mercap-
tan were dissolved in 800 ml of dry diethyl ether and
reacted with hydrogen chloride as described in Example
2.1: 20.7 g (71% of theory) of compound 2.2 [melting
point 180-185°C (decomposition)].

EXAMPLE 2.3

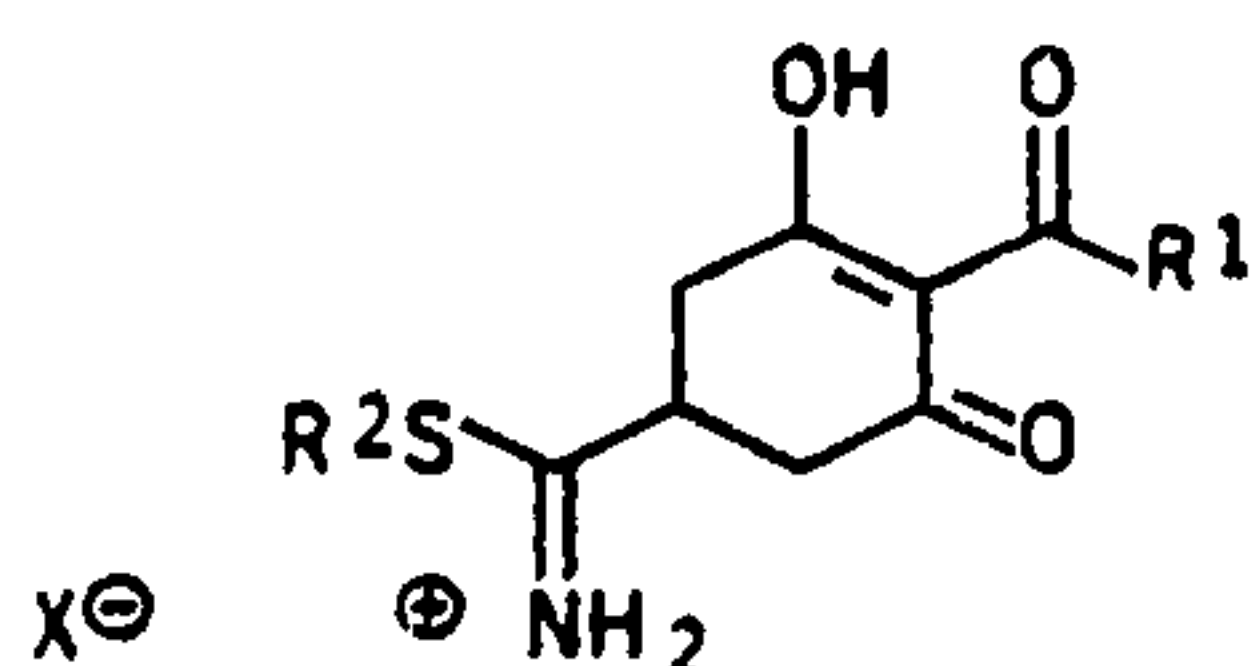
S-Ethyl 3,5-dioxo-4-palmitoylcyclohexanethiocarboximide
hydrochloride

7.5 g (0.02 mol) of 3,5-dioxo-4-palmitoylcyclo-
hexanecarbonitrile and 1.86 g (0.03 mol) of ethyl-
mercaptan were suspended in 150 ml of dry diethyl ether.
The suspension was cooled to 0°C and then a vigorous
stream of dry (concentrated sulfuric acid) hydrogen
chloride was passed through it. After 0.5 h the stream of
gas was turned off, and the reaction mixture was slowly
warmed to room temperature. It was again cooled to 0°C,
hydrogen chloride was passed in, the cooling was removed
and, after a total of 6 h, the solid was filtered off,
washed with ether and dried: 7.3 g (77% of theory) of
compound 2.3 [melting point 65-68°C (decomposition)].

The carboximidic S-esters V listed in Table 2 can
be prepared in a similar manner.

TABLE 2:

Acylcyclohexadionethiocarboximidic S-esters V



V

No.	R ¹	R ²	X	phys. data m.p. (°C)
2.1	ethyl	methyl	Cl	161 (decomp.)
2.2	ethyl	ethyl	Cl	180 to 185 (decomp.)
2.3	palmitoyl	ethyl	Cl	65-68
2.4	methyl	ethyl	Cl	160 to 165 (decomp.)
2.5	ethyl	2-methoxyethyl	Cl	oil
2.6	cyclo- propyl	2-meth- oxyethy	Cl	oil

EXAMPLE 3.1

S-Methyl-3,5-dioxo-4-propionylcyclohexanethiocarboxylate
2.8 g (0.01 mol) of compound 2.1 were dissolved
in 50 ml of 10% strength hydrochloric acid and stirred at
room temperature overnight. The white precipitate was
filtered off, washed with water and dried under reduced
pressure: 1.95 g (80% of theory) of compound 3.1 (melting
point 81°C).

EXAMPLE 3.2

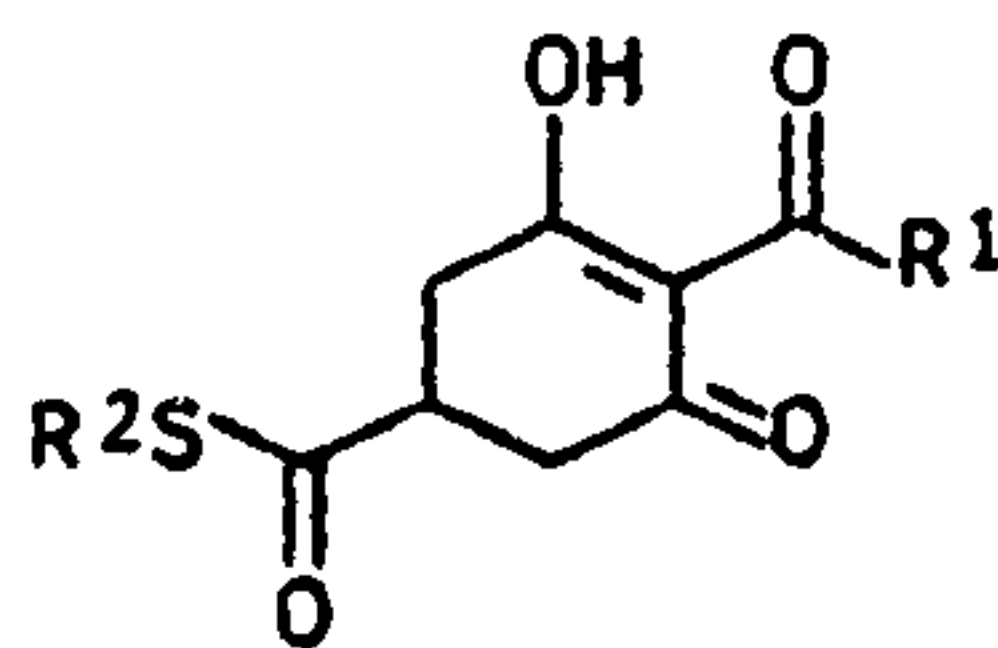
S-Ethyl 3,5-dioxo-4-propionylcyclohexanethiocarboxylate
5.8 g (0.02 mol) of compound 2.2 were dissolved
in 100 ml of 10% strength hydrochloric acid and stirred
at room temperature overnight. The white precipitate was
filtered off, washed with water and dried under reduced
pressure: 4.1 g (80% of theory) of compound 3.2 (melting
point 70°C).

EXAMPLE 3.3

S-Ethyl 3,5-dioxo-4-palmitoylcyclohexanethiocarboxylate
3.0 g (6.3 mmol) of compound 2.3 were suspended
in 50 ml of water and stirred vigorously at room tempera-
ture overnight. The solid was filtered off, washed with
water and dried under reduced pressure: 2.4 g (86% of
theory) of compound 3.3 (melting point 56-58°C).

The compounds I listed in Table 3 which follows
were prepared in a similar manner.

TABLE 3:
Cyclohexanethiocarboxylic S-esters I

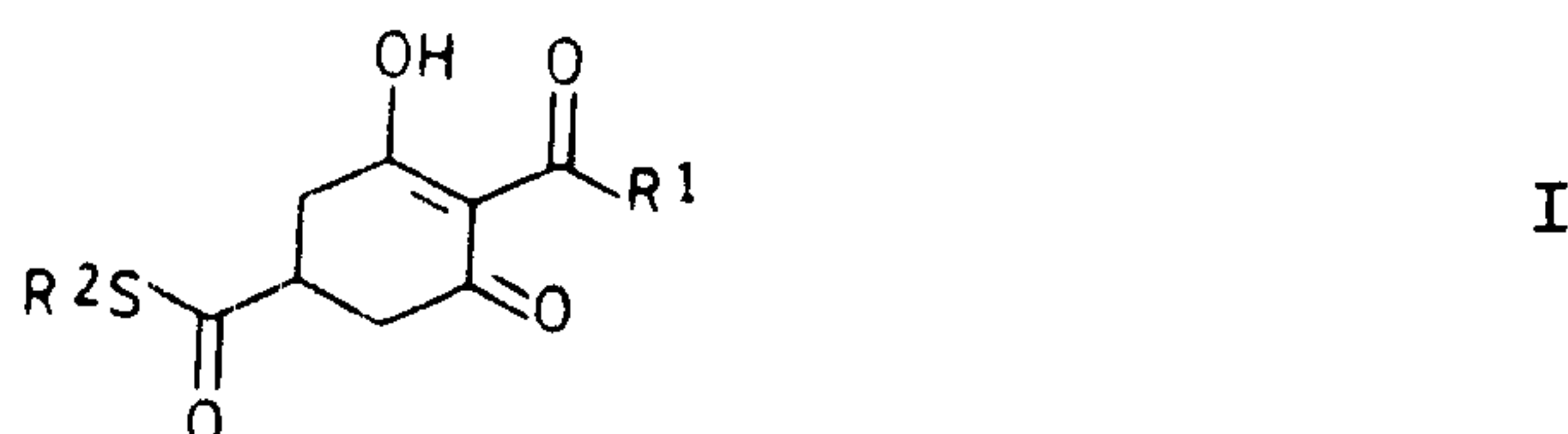


I

No.	R ¹	R ²	phys. data, m.p. (°C)
3.1	ethyl	methyl	81
3.2	ethyl	ethyl	70
3.3	palmitoyl	ethyl	56 to 58
5 3.4	methyl	ethyl	
3.5	ethyl	2-methoxyethyl	oil
3.6	cyclopropyl	ethyl	oil
3.7	cyclopropyl	2-methoxyethyl	oil
3.8	4-Cl, 2-NO ₂ -C ₆ H ₃	Ethyl	oil

CLAIMS

1. A process for preparing an acylcyclohexadione-thiocarboxylic S-ester of the formula I

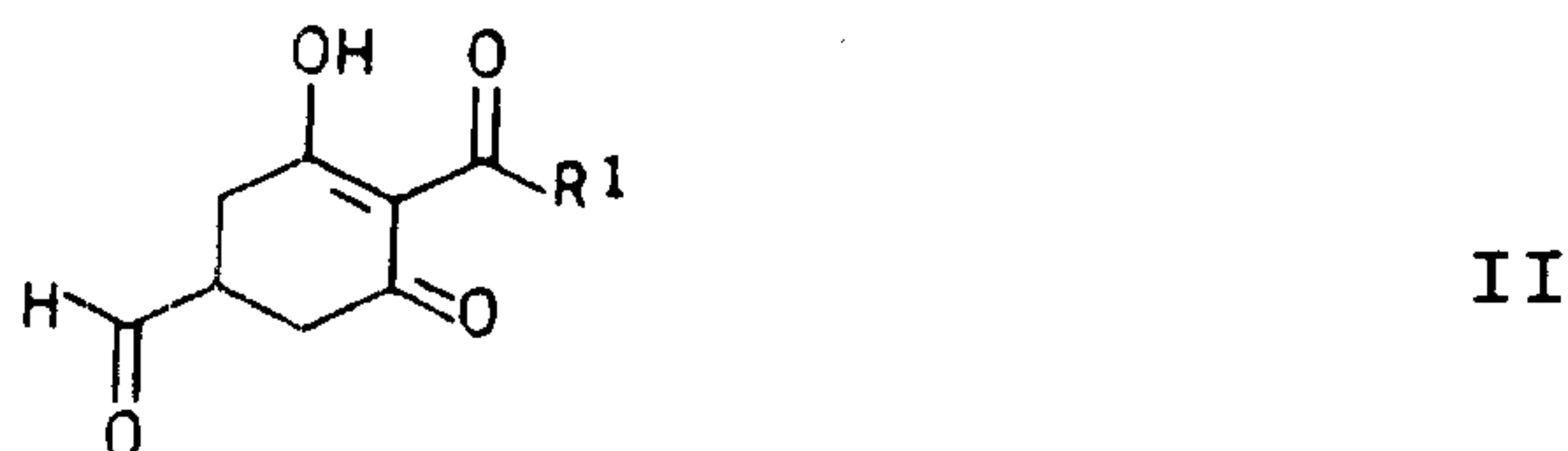


where

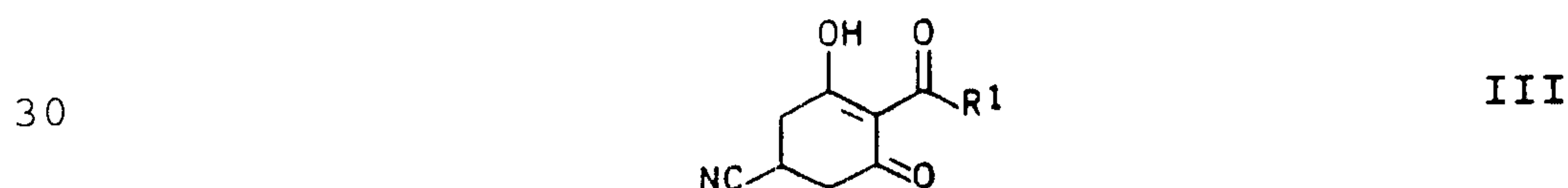
10 R^1 is C_1 - C_{20} -alkyl, C_2 - C_{20} -alkenyl, C_2 - C_{20} -alkynyl or C_3 - C_6 -cycloalkyl, each of which is unsubstituted or substituted by halogen, C_1 - C_4 -alkoxy or C_1 - C_4 -alkylthio, or is benzyl or phenyl, each of which is unsubstituted or substituted by halogen, cyano, C_1 - C_4 -alkyl, C_1 - C_4 -alkoxy, C_1 - C_4 -halo-alkyl or nitro, and

R^2 is hydrogen, C_1 - C_6 -alkyl, C_2 - C_6 -alkenyl, C_2 - C_6 -alkynyl or C_3 - C_6 -cycloalkyl, each of which is unsubstituted or substituted by C_1 - C_4 -alkoxy, C_1 - C_4 -alkylthio, C_1 - C_4 -di-alkylamino, hydroxyl or halogen; benzyl or phenyl, each of which is unsubstituted or substituted by halogen, cyano, C_1 - C_4 -alkyl, C_1 - C_4 -alkoxy or nitro,

20 which comprises reacting, in a first stage, a compound of the formula II



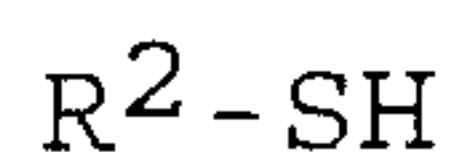
where R^1 has the abovementioned meaning, with hydroxylamine or hydroxylamine-O-sulfonic acid in an inert solvent at from 0 to 150°C to give a compound of the formula III



30 where R^1 has the abovementioned meaning,

17

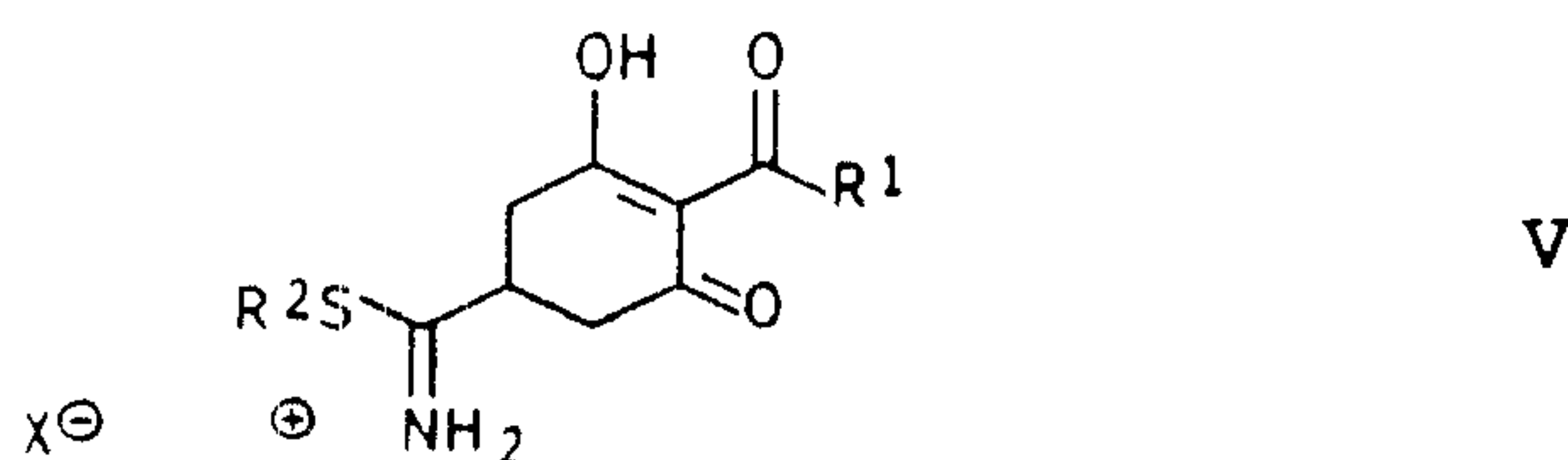
and then, in a second stage, reacting this cyano compound of the formula III with a mercaptan of the formula IV:



IV

where R^2 has the abovementioned meaning, in the presence of an anhydrous acid HX and substantially excluding water, to give a compound of the formula V:

10



V

where R^1 and R^2 have the abovementioned meanings, and X is the anion of the acid HX, and,

in a third stage, hydrolyzing the compound of the formula V to give the compound of the formula I.

2. A process as claimed in claim 1, in the first stage of which the compound of the formula II is reacted with hydroxylamine-O-sulfonic acid in homogeneous or heterogeneous aqueous phase at a pH of from 1 to 9.

3. A process as claimed in claim 1 or 2, wherein the reaction with hydroxylamine-O-sulfonic acid is carried out at a pH of from 3 to 8.

4. A process as claimed in any one of claims 1 to 3, wherein the reaction in the first stage is carried out at from 20 to 80°C.

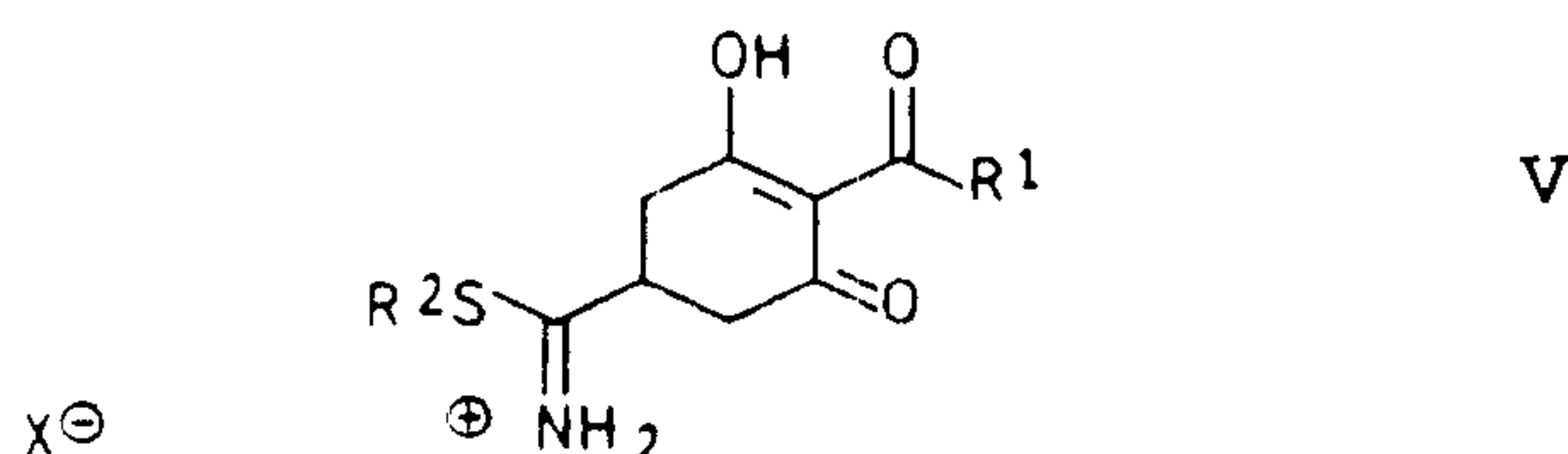
5. A process as claimed in claim 1, wherein the acid used in the second stage is hydrogen chloride or hydrogen bromide.

6. A process as claimed in claim 1 or 5, wherein the reaction in the second stage is carried out at from -20 to 100°C.

7. A process as claimed in claim 1, wherein the hydrolysis of compound V is carried out at a pH of from 1 to 7 and at from 0 to 100°C.

8. A process as claimed in any one of claims 1 to 7, wherein stages 1 to 3 are carried out without isolation of
10 the intermediates III and V.

9. An acylcyclohexadione of the formula V



where

R^1 is C_1 - C_{20} -alkyl, C_2 - C_{20} -alkenyl, C_2 - C_{20} -alkynyl or C_3 - C_6 -cycloalkyl, each of which is unsubstituted or substituted by halogen, C_1 - C_4 -alkoxy or C_1 - C_4 -alkylthio, or is benzyl or phenyl, each of which is
20 unsubstituted or substituted by halogen, cyano, C_1 - C_4 -alkyl, C_1 - C_4 -alkoxy, C_1 - C_4 -haloalkyl or nitro;

R^2 is hydrogen, C_1 - C_6 -alkyl, C_2 - C_6 -alkenyl, C_2 - C_6 -alkynyl or C_3 - C_6 -cycloalkyl, each of which is unsubstituted or substituted by C_1 - C_4 -alkoxy, C_1 - C_4 -alkylthio, C_1 - C_4 -dialkylamino, hydroxyl or halogen; benzyl or phenyl, each of which is unsubstituted or substituted by halogen, cyano, C_1 - C_4 -alkyl, C_1 - C_4 -alkoxy or nitro, and

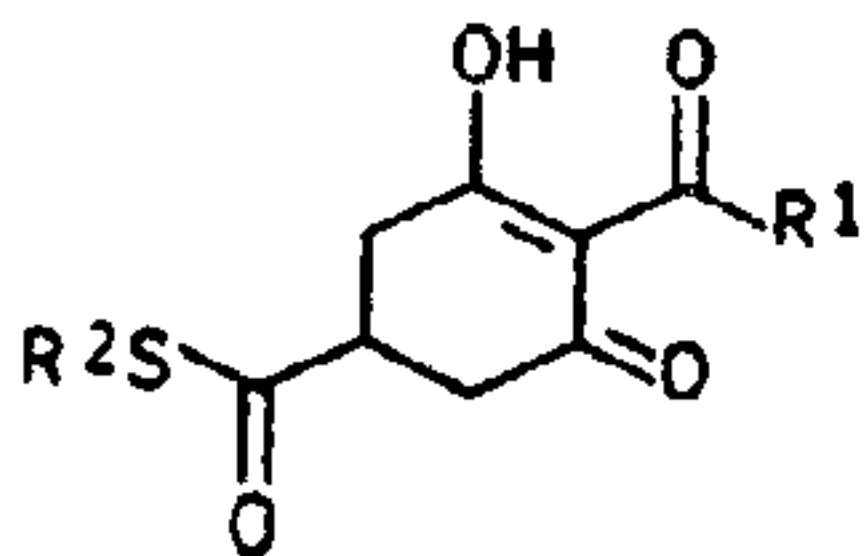
X is a chloride, bromide, sulfate, phosphate, tetrafluoroborate, perchlorate or trifluoroacetate ion.

10. An acylcyclohexadione of the formula V as claimed in claim 9, where

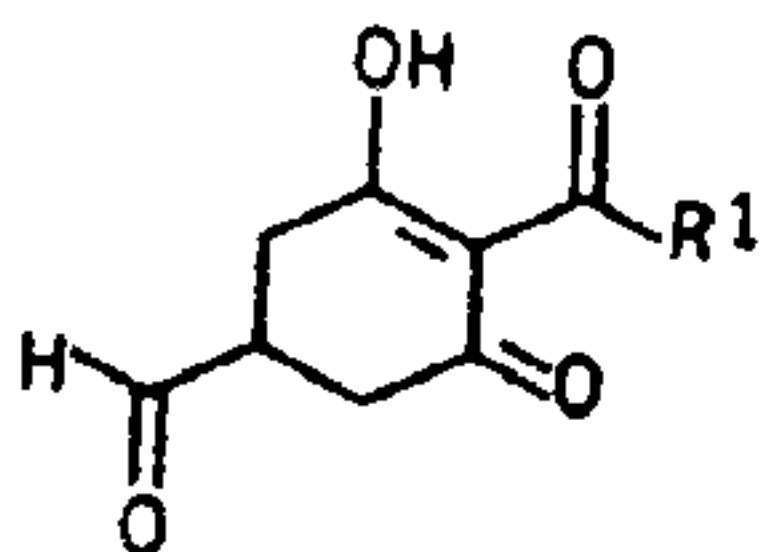
R¹ is C₁-C₄-alkyl, C₃-C₆-cycloalkyl, C₂-C₆-alkoxyalkyl, C₂-C₆-alkylthioalkyl, benzyl or phenyl unsubstituted or substituted once to three times by halogen, cyano, C₁-C₄-alkyl, C₁-C₄-alkoxy, C₁-C₄-haloalkyl or nitro;

R² is C₁-C₆-alkyl, C₃-C₅-alkenyl, C₃-C₄-alkynyl, C₃-C₆-cycloalkyl, C₂-C₆-alkoxyalkyl, C₂-C₆-alkylthioalkyl, benzyl or phenyl unsubstituted or substituted once to three times by halogen, cyano, C₁-C₄-alkyl, C₁-C₄-alkoxy or nitro, and

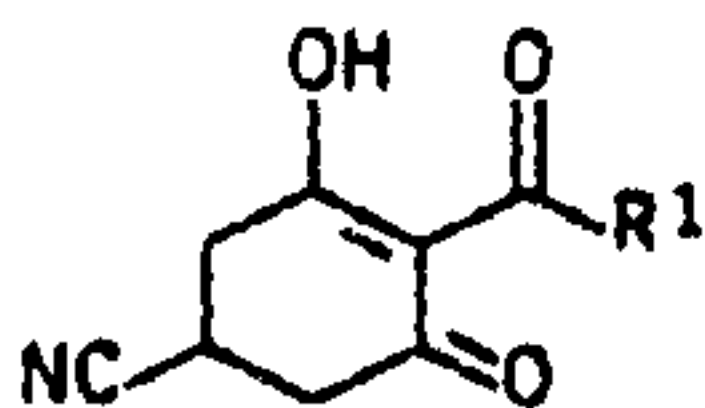
X is chloride or bromide.



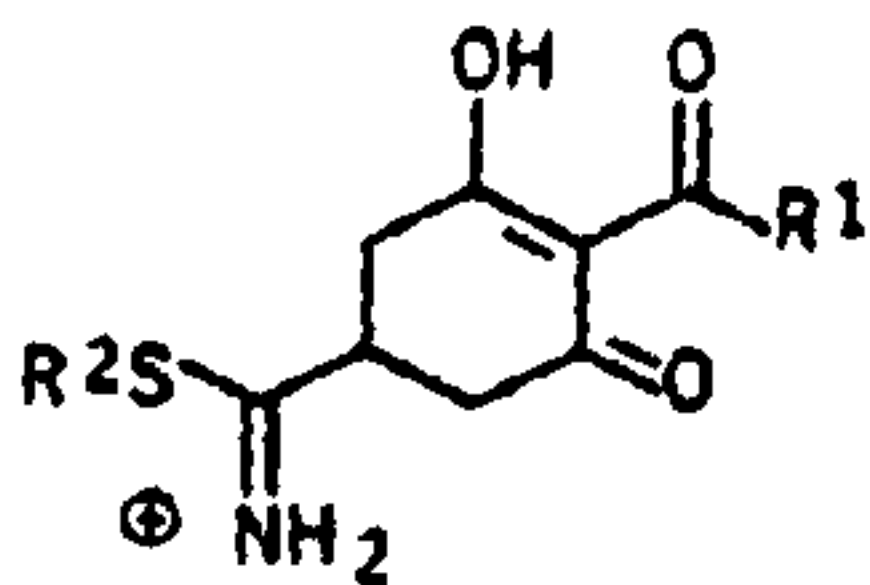
I



II



III



V

X[⊖]

⊕ NH₂