

(19) World Intellectual Property Organization
International Bureau(43) International Publication Date
9 February 2006 (09.02.2006)

PCT

(10) International Publication Number
WO 2006/013060 A1

(51) International Patent Classification:

C08G 77/28 (2006.01) *A61K 9/14* (2006.01)
C08G 77/50 (2006.01)

(21) International Application Number:

PCT/EP2005/008189

(22) International Filing Date:

26 July 2005 (26.07.2005)

(25) Filing Language:

English

(26) Publication Language:

English

(30) Priority Data:

0417345.6 4 August 2004 (04.08.2004) GB
 0426622.7 4 December 2004 (04.12.2004) GB

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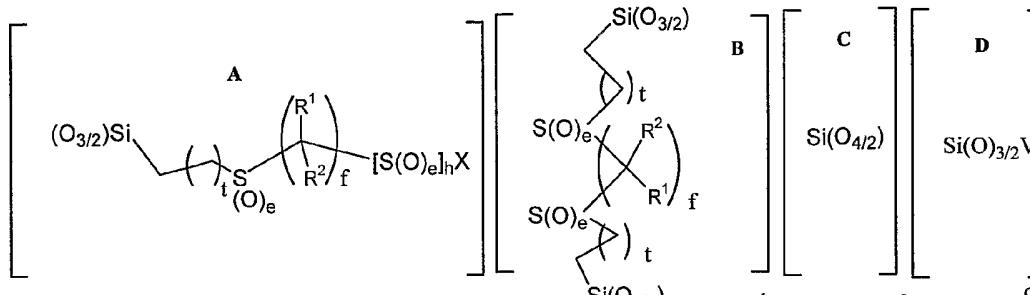
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(81) **Designated States** (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BW, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KM, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NA, NG, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, SM, SY, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, YU, ZA, ZM, ZW.

(84) **Designated States** (unless otherwise indicated, for every kind of regional protection available): ARIPO (BW, GH, GM, KE, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HU, IE, IS, IT, LT, LU, LV, MC, NL, PL, PT,

[Continued on next page]

(54) Title: SUBSTITUTED ORGANOPOLYSILOXANES AND USE THEREOF



(I)

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(57) **Abstract:** The invention relates to new compounds of Formula (1) wherein X is selected from R^1 , a group $-\text{[C}_0\text{O}_2(\text{CH}_2)_n\text{CO}_2\text{]}_n$ linking two moieties A¹, A¹ being moiety A without X and n being 2 to 4, C(=W)R₆¹ (CR₆²Z₇¹)_iCHR₆³Z₇², OH, O(M^{4+g})_{1/g} OC(=W)R₆⁶R₇⁷ or NNR₆⁶R₇⁷ and Z is selected from OR₆, NR₆⁶R₇⁷ or SR₆⁶ and R is R₁, R₂, R₃, R₄, R₅, R₆⁶, R₇⁷ and R¹ and R⁷ are each hydrogen, an optionally substituted linear or branched alkyl, alkenyl or alkynyl group, an aryl or alkylaryl group. M is a metal ion derived from a lanthanide, actinide, main group or transition metal. V is an optionally substituted alkyl, alkenyl or alkynyl group or an aryl group or alkylaryl group; e is an integer from 0 to 2; f is an integer from 0 to 100, g is an integer from 1 to 4, i is an integer from 0 to 6, t is an integer from 1 to 20, preferably 1 to 3, and h is 0 or 1. The free valences of the silicate oxygen atoms are saturated by one or more of silicon atoms of other groups of Formula (1), hydrogen, a linear or branched alkyl groups or by end groups, cross-linking bridge members or by polymer chains containing silicon, aluminium, titanium or other known oxo metal bridging systems. The integers a, b, c and d are such that i) when b is 0 the ratio of a:c is from 0.00001 to 100,000 and in the formula A_aB_bC_cD_d both A and C are always present and ii) when b is 1 or more that the ratio of a:b is from 0.00001 to 100,000 and in the formula A_aB_bC_cD_d both A and B are always present. The ratio of an end group and/or cross linker and/or polymer chain to a+b+c+d is from 0 to 999:1. The compounds are useful as scavengers for the removal of unwanted organic and inorganic compounds, for solid phase extraction, for solid phase synthesis, for acid and metal mediated heterogeneous catalysis, for metal ion abstraction and for the immobilisation of bio-molecules.



RO, SE, SI, SK, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

Published:

- *with international search report*
- *before the expiration of the time limit for amending the claims and to be republished in the event of receipt of amendments*

Substituted organopolysiloxanes and use thereof

The invention relates to new organopolysiloxanes and their use for example as heterogeneous catalysts, catalyst supports, cation and anion exchangers, organic and inorganic compound scavengers, solid phase purification or extraction materials, immobilisation materials for bio-5 molecules, anti-microbial agents, hydrophilicity modifiers, flameproofing agents, antistatic agents; coatings for biomedical devices, water repellent films and coatings, solid phase synthesis materials and chromatography materials. The invention also relates to precursors of these new products and processes for their production.

10 The use of functionalised solids is growing rapidly for many different applications such as solution phase synthesis, solid phase synthesis, solid phase extraction, catalysis, catalyst supports, product purification and the immobilisation of bio-molecules. In these applications the advantages of functionalised solids are ease of manipulation, simple separation from the rest of the medium by filtration and regeneration and reuse. Key requirements for these functionalised solids are excellent 15 physical and chemical stability over a wide range of operating conditions, broad solvent applicability, fast kinetics - fast and easy access to the functional groups and functional groups with high intrinsic activity for the desired application. In addition the preparation of these functionalised materials has to be simple from readily available reagents. Finally it is highly advantageous if the functional groups can be readily transformed into different functionalised materials that can be used for other 20 applications.

As a consequence of stricter environmental regulations there is a growing requirement for more effective systems for the removal and recovery of toxic and hazardous chemicals from many sources including a wide spectrum of contaminated products, active pharmaceutical ingredients (API), 25 solvents, potable water and aqueous based wastes and from contaminated waters. For example the electronics industry has a particular need for ultra pure water with very low levels of both cations and anions. Other industries such as the nuclear industry and the electroplating industry generate substantial quantities of water-based effluent that are heavily contaminated with undesirable metal ions. In the pharmaceutical industry metal catalysts are increasing being used in the manufacture of 30 APIs or their intermediates. Given the toxicity of these metals very low residual levels have to be achieved in the API. In the preparation of compound libraries for biological evaluation simple and quick processes are required to purify reaction mixtures in order to screen thousands of compounds to identify leads for optimisation and development programmes.

35 Substituted polystyrene derivatives are an important class of materials being used for a range of applications. The chemical and physical properties of a variety of such polystyrene based systems are

described in the Bio-Rad Life Science Research Products catalogue 1998/99, pages 56–64. However the physical and chemical properties of these polystyrene resins may possess disadvantages, for example poor chemical stability and thermal stability, believed to be due to the organic polymeric backbone. Additional problems for example swelling and shrinking in organic solvents as well as the 5 production of highly coloured unwanted side products may also be encountered. Generally, due to their poor thermal stability, these polystyrene resins cannot be used for any length of time above 80°C, thus limiting their general applicability. In addition a range of chemical functionality cannot be readily attached to these organic polymers due to the physical limitations of these polymers and the range of chemistry that can be used to attaché functional groups onto the aromatic rings.

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Inorganic polymer systems such as silica, aluminium oxide and titanium oxide have also been disclosed as functionalised materials. Active functional groups or metals can be attached by a variety of means to these systems. However a number of problems may be encountered where the functional groups are only physically adsorbed for example low functional group loading along with limitations 15 in the range of solvents that can be used and removal of the functional groups on use or on standing. This is believed to be due to the rather weak attachment between the functional group and the surface atoms on the support. Building the functional group into the framework may provide a more robust material and may also permit higher functional group loadings. However in this approach there is a significant lack of readily available starting materials as well as precursors for preparing such starting 20 materials. In addition there are limited synthetic methodologies for the preparation of suitable starting materials from available precursors. A need exists to provide new synthetic methods as well as starting compounds in order to make such functionalised materials.

Functionalised solid materials are used in solution phase organic synthesis to aid rapid purification 25 and workup. These materials, also known as scavengers, may remove excess reagents and side products. Typically, a scavenger is added to a solution to quench and selectively react with excess or unreacted reagents and reaction side products. The unwanted chemicals now attached to the functionalised materials are removed by simple filtration. This simple process circumvents the standard purification methodologies of liquid-liquid extraction, chromatography and crystallisation. 30 Substituted polystyrene derivatives are known for use as scavengers but have a number of limitations such as lack of thermal stability, swelling and shrinking in organic solvents and a limited range of functional groups.

In solid phase synthesis substituted polystyrene derivatives are the main class of materials being used 35 and likewise these materials suffer the same limitations as described above. The use of functionalised silica materials for this application is limited by the availability of suitable functionalised materials.

Due to their toxicity there is a growing requirement for more effective systems for the removal and recovery of cations and anions including a wide spectrum of contaminated products, active pharmaceutical ingredients (API), solvents, potable water and aqueous based wastes and from contaminated waters. Polymers having an organic, partly cross-linked polystyrene backbone with 5 sulfonate groups attached to some of the phenyl rings are known for use as cation exchangers for removing metal ions from solution. The physical and chemical stability and other properties of these materials for example due to the organic nature of the polymeric backbone, may adversely affect their use in cation exchange applications. Organophosphonic acid cation exchangers have also been reported in US 5,281,631 and US 5,449,462. The feedstock in the manufacture of these materials 10 may be expensive and they have limited applicability due to their physical and chemical properties.

Strong acidic cation exchangers based on sulfonic acid groups attached to a organopolysiloxane backbone have been described in US 4,552,700 and US 5,354,831. The reported materials have a 15 general formula of $(O_{3/2}Si—R^1—SO_3)_xM^x$ where R^1 is an alkyl or cycloalkyl fragment, M is hydrogen or a mono to tetravalent metal ion and where the free valences of the oxygen atoms being saturated by silicon atoms of other groups of this formula and/or by cross-linking bridge members such as $SiO_{4/2}$, $R^1SiO_{3/2}$, $TiO_{4/2}$, $AlO_{3/2}$, etc. Whilst these materials can act as cation exchangers it is generally recognised that sulfonic acid groups are limited in their effectiveness to complex with a 20 range of metals and in comparison to other functional groups. In addition the sulfonate group is also limited by the fact that it is a mono anion and thus more of these functional groups are needed to bind to di and multivalent metal ions compared to other functional groups. These materials are also expensive to prepare. In our earlier patent application PCT/GB 0200069 we reported on 25 organopolysiloxanes containing phosphonic groups. These materials demonstrate high intrinsic activity for the removal of metal ions. A range of other functionalised materials is needed particularly to separate specific metal ions from various environments.

Anions such as arsenates, chromates, permanganates, borates and perchlorates pose many significant problems to the environment and health. For example arsenates, chromates and permanganates are 30 highly toxic and so their concentrations in water or other medium has to be very carefully controlled. New materials with very high affinity for such anions are needed in order to achieve very low acceptable limits.

Precious metal mediated reactions enable the organic chemist to conduct a wide range of reactions used in the manufacture of products for a number of industries. Typical reactions include Suzuki, 35 Heck, oxidations and reductions and metals and their complexes such as platinum, palladium and rhodium are extensively used. A major problem encountered with the use of these systems is the significant loss of these expensive and highly toxic metals. Furthermore in the production of active

pharmaceutical agents (APIs) using such metal mediated reactions, it is found that the metal invariably complexes to the desired API and residual metal contents in the range of 600–1000 ppm are not uncommon. The current target for palladium, platinum, rhodium and nickel is less than 5 ppm. Various methods have been tried to reduce the residual palladium content, most unsuccessfully.

5 Selective re-crystallisation leads to only a slight lowering of metal content. A lower yield of the API is a significant unwanted side effect of this process. Attempts to reposition the precious metal catalysed reaction from the final to an earlier step leads also to a slight but not significant lowering of metal content. Attempts to pass a solution of the API through a medium containing a metal exchanger such as a functionalised polystyrene resin have also been largely unsuccessful. Alternative 10 and more costly processes have been tried – washing with an aqueous solution of a suitable metal chelator. A number of such reagents have been used with only limited success. Thus there is a need to design new functionalised materials that have very high affinity for precious metals and can readily remove them from tightly bound complexes. Furthermore given the structural diversity of APIs it is necessary to have a range of functionalised materials with different structures and high affinity in 15 order to provide an effective solution.

Catalysts are utilised in the chemical and biochemical industry to conduct a wide range of chemical transformations. A range of homogenous and heterogeneous catalysts are used some of which require high temperatures to be effective and some produce considerable amount of bi-products and waste. 20 These unwanted products and waste have to be treated and destroyed. The drive for more environmentally friendly processes – Green Chemistry - highlights the need for reusable, more effective and selective catalysts. Examples of such reagents currently used extensively across manufacturing industries include mineral acids – sulphuric acid, hydrochloric acid, hydrogen fluoride, phosphoric acid – Lewis acids – aluminium trichloride, boron trifluoride and zinc chloride – and 25 oxidation reagents – permanganate, manganese dioxide and chromium (VI). This need has led to investigations into the design of new solid phase materials that can catalyse a variety of chemical transformations. Key requirements for such new catalysts are very good thermal stability, high insensitivity to chemical attack, high and tailored functional group loading, fixed and rigid structures, optimum functional groups so as to avoid rearrangements and side products, limited swelling 30 capability, insolubility in organic solvents, ease of purification and high reusability, high ageing resistance and ease of access to the functional group which conducts the chemical transformation. A particular requirement for acid catalysed reactions is to have suitable functional groups attached to an inert support that possess the right level of acidity to catalyse the desired reaction without producing a range of side products and highly discoloured products. For example, whilst both sulfuric acid and 35 heterogeneous sulfonic acids are effective acid catalysts they also invariably produce a range of highly coloured unwanted side products that have to be removed. Further requirements are for

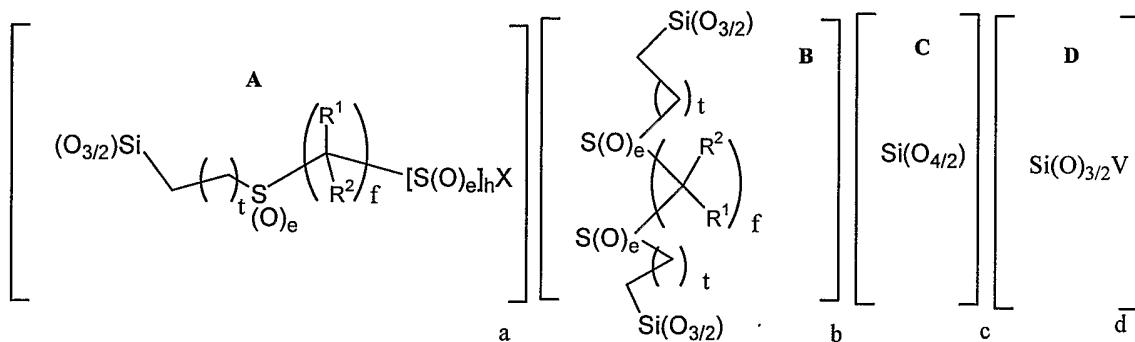
heterogeneous oxidation catalysts as well as for carbon carbon bond formation that do not leach the metal ions into the products or waste streams.

The inventors have discovered a class of compounds which have a desirable combination of 5 characteristics and make them suitable for use in a range of applications including acting as scavengers for inorganic and organic compounds, solid phase purification or extraction materials, ion exchange materials, catalysts, catalyst immobilisation supports, immobilisation materials for biomolecules, anti-microbial agents, hydrophilicity modifiers, flameproofing agents, antistatic agents, solid phase synthesis materials and chromatography materials, or which are precursors for these.

10

In a first aspect of the present invention, there is provided a compound of General Formula 1:

Formula 1



wherein X is selected from R¹, a group -[CO₂(CH₂)_nCO₂]- linking two moieties A¹, A¹ being moiety 15 A without X and n being 2 to 4, C(=W)R, (CR³Z)_iCHR³Z, OH, O(M⁺)_{1/g} and OC(=W)R where W is selected from oxygen, sulfur, NR⁴ and NNR⁴R⁵, Z is selected from OR⁶, NR⁶R⁷ and SR⁶, R is selected from R⁶, OR⁶, O(M⁺)_{1/g}, NR⁶R⁷, NHNR⁶R⁷ and SR⁶ and R¹, R², R³, R⁴, R⁵, R⁶ and R⁷ are each selected from hydrogen, an optionally substituted linear or branched C₁₋₄₀-alkyl, C₂₋₄₀-alkenyl or 20 C₂₋₄₀-alkynyl group, an aryl and a C₁₋₄₀-alkylaryl group; M is a metal ion derived from a lanthanide, actinide, main group or transition metal and V is an optionally substituted C₁₋₄₀-alkyl, C₂₋₄₀-alkenyl or C₂₋₄₀-alkynyl group or an aryl group or C₁₋₄₀-alkylaryl sulfide, sulfoxide, sulfone, amine or a polyalkyl amine or phosphine or other phosphorous containing group; e is an integer from 0 to 2; f is an integer from 0 to 100, preferably 1 to 100, g is an integer from 1 to 4, i is an integer from 0 to 6, t is an integer from 1 to 20, preferably 1 to 3; and h is 0 or 1:

25 the free valences of the silicate oxygen atoms are saturated by one or more of: silicon atoms of other groups of Formula 1, hydrogen, a linear or branched C₁₋₁₂-alkyl group or by end groups R⁸₃M¹O_{1/2} or by cross-linking bridge members or by polymer chains R⁸_qM¹(OR⁹)_mO_{k/2} or Al(OR⁹)_{3-p}O_{p/2} or R⁸Al(OR⁹)_{2-r}O_{r/2}; where M¹ is Si or Ti;

R⁹ is a linear or branched C₁₋₄₀, an aryl or C₁₋₄₀-alkylaryl group; and R⁸ is a linear or branched 30 C₁₋₄₀-alkyl group or an aryl or C₁₋₄₀-alkylaryl group;

k is an integer from 1 to 3 and q is an integer from 1 to 2 and m is an integer from 0 to 2; such that m + k + q = 4;

p is an integer from 1 to 3; and r is an integer from 1 to 2;

or other known oxo metal bridging systems where the metal is zirconium, boron, magnesium, iron, nickel or a lanthanide and the integers a, b, c and d are such that i) when b is 0 the ratio of a:c is from 0.00001 to 100,000 and in the formula $A_aB_bC_cD_d$ both A and C are always present, and ii) when b is 1 or more the ratio of a:b is from 0.00001 to 100,000 and in the formula $A_aB_bC_cD_d$ both A and B are always present.

10 Where an end group and/or cross linker and/or polymer chain is used, it is preferred that the ratio of end group, cross linker or polymer chains to $a+b+c+d$ is from 0 to 999:1 and preferably 0.001 to 999:1.

Advantages of the new scavengers for inorganic and organic compounds, solid phase extraction or 15 purification materials, catalysts, catalyst immobilisation supports, bio-molecule immobilisation supports, anti-microbial agents, hydrophilicity modifiers, flameproofing agents, antistatic agents, solid phase synthesis materials and chromatography materials, and ion exchanger materials based on compounds of Formula 1 include high intrinsic activity of particular functional groups for specific 20 applications and that the functional group or groups can be tuned to have either a high or low level of loading according to the requirements of the user. Other advantages include high thermal stability, fixed and rigid structures, good stability to a wide range of chemical conditions, insolubility in organic solvents, high resistance to ageing, easily purified and high reusability. In addition the processes for the preparation of compounds of Formula 1 are very flexible, allowing a wide range of functionalised materials to be made from a small number of common intermediates and also the 25 porosity of the materials can be varied from micro to macro porous and the loading of the functional groups as well as the other substituents in the fragment V to be varied as needed. Compounds of Formula 1 have the added advantage of their respective functional groups being firmly attached to a very stable and inert medium. Furthermore compounds of Formula 1 have the added advantages of a very high affinity for both cations and anions coupled with fast kinetics thus enabling very rapid 30 removal of toxic compounds or impurities to very low levels. In addition compounds of Formula 1 can be used as heterogeneous catalysts to conduct a number of chemical transformations and posses the key advantages of being easily separated from the reaction mixture by filtration and also of being recycled and reused.

35 The optionally substituted linear or branched group selected from C_{1-40} -alkyl, C_{2-40} -alkenyl, C_{2-40} -alkynyl group, an aryl and C_{1-40} -alkylaryl group, R^{1-7} groups may independently be linear or branched and/or may be substituted with one or more substituents but preferably contain only hydrogen and

carbon atoms. If a substituent is present, it may be selected from nitro, chloro, fluoro, bromo, nitrile, hydroxyl, carboxylic acid carboxylic esters, sulfides, sulfoxides, sulfones, C₁₋₆-alkoxy, a C₁₋₄₀-alkyl or aryl di substituted phosphine, amino, amino C₁₋₄₀-alkyl or amino di (C₁₋₄₀-alkyl) or C₁₋₄₀-alkyl phosphinic or phosphonic group.

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Preferably, the optionally substituted linear or branched group selected from C₁₋₄₀-alkyl, C₂₋₄₀-alkenyl, C₂₋₄₀-alkynyl group, an aryl and C₁₋₄₀-alkylaryl group, R¹⁻⁷ are independently selected from linear or branched C₁₋₂₂ and desirably C₁₋₁₂-alkyl, C₂₋₂₂- and desirably C₂₋₁₂-alkenyl, aryl and a C₁₋₂₂-alkylaryl group and it is especially preferred that these groups are independently selected from a linear or branched C₁₋₈-alkyl, C₂₋₈-alkenyl, aryl and a C₁₋₈-alkylaryl group.

10

Suitably groups R¹⁻⁷ are independently a C₁₋₆-alkyl group for example methyl or ethyl, or a phenyl group. Preferably q is from 0 to 2, k is from 1 to 3 and m is 0 provided that m+k+q =4.

15

Examples of suitable alkyl groups include methyl, ethyl, isopropyl, *n*-propyl, butyl, *tert*-butyl, *n*-hexyl, *n*-decyl, *n*-dodecyl, cyclohexyl, octyl, *iso*-octyl, hexadecyl, octadecyl, *iso*-octadecyl and docosyl. Examples of suitable alkenyl groups include ethenyl, 2-propenyl, cyclohexenyl, octenyl, *iso*-octenyl, hexadecenyl, octadecenyl, *iso*-octadecenyl and docosenyl.

20

C₁₋₆-alkoxy refers to a straight or branched hydrocarbon chain having from one to six carbon atoms and attached to an oxygen atom. Examples include methoxy, ethoxy, propoxy, *tert*-butoxy and *n*-butoxy.

25

The term aryl refers to a five or six membered cyclic, 8-10 membered bicyclic or 10-13 membered tricyclic group with aromatic character and includes systems which contain one or more heteroatoms, for example, N, O or S. Examples of suitable aryl groups include phenyl, pyridinyl and furanyl. Where the term "alkylaryl" is employed herein, the immediately preceding carbon atom range refers to the alkyl substituent only and does not include any aryl carbon atoms. Examples of suitable alkaryl groups include benzyl, phenylethyl and pyridylmethyl.

30

Compounds in which wherein X is independently selected from R¹, C(=W)R or (CR³Z)_iCHR³Z or OH or O(M⁺g)_{1/g} or OC(=W)R where W is oxygen and Z is OR⁶, NR⁶R⁷ or SR⁶ and R is R⁶, OR⁶, O(M⁺g)_{1/g}, NR⁶R⁷, NHNR⁶R⁷ or SR⁶ and R¹, R², R³, R⁴, R⁵, R⁶ and R⁷ are each hydrogen, an optionally substituted linear or branched C₁₋₂₂-alkyl, C₂₋₂₂-alkenyl or C₂₋₂₂-alkynyl group, an aryl or C₁₋₂₂-alkylaryl group; M is a metal ion derived from a lanthanide, actinide, main group or transition metal and V is an optionally substituted C₁₋₂₂-alkyl, C₂₋₂₂-alkenyl or C₂₋₂₂-alkynyl group or an aryl

group; e is an integer from 0 to 2; f is an integer from 1 to 10; g is an integer from 1 to 4; i is an integer from 0 to 6; t is an integer from 1 to 3; and h is 0 or 1, are preferred.

By way of example, some particularly preferred species for moiety A include $O_{3/2}SiCH_2CH_2SR^1$,

5 $O_{3/2}SiCH_2CH_2SC_6H_4SO_3H$ and, $O_{3/2}SiCH_2CH_2SCH_2C_6H_4SO_3H$ as acid catalysts, $O_{3/2}SiCH_2CH_2SC_6H_4SO_2Cl$ for removing amines and alcohols from a process stream, $O_{3/2}SiCH_2CH_2SCH_2C_6H_4SO_3M^+$ for cation exchange, $O_{3/2}SiCH_2CH_2SH_2CH_2NR^6R^7$, and $O_{3/2}SiCH_2CH_2SCH_2CH_2OCH_2(CF_2)n'CHF_2$ where n' is 0 to 6.

10 Compounds of Formula 1 in which the free valences of the silicate oxygen atoms are saturated by one or more of silicon atoms of other groups of Formula 1, hydrogen, a linear or branched C_{1-12} -alkyl group or by end groups $R^8_3M^1O_{1/2}$ or by cross-linking bridge members or by polymer chains $R^8_qM^1(OR^9)_mO_{k/2}$ or $Al(OR^9)_{3-p}O_{p/2}$ or $R^8Al(OR^9)_{2-r}O_{r/2}$; where M^1 is Si or Ti in which R^9 is a linear or branched C_{1-12} , an aryl or C_{1-12} -alkylaryl group; and R^8 is a linear or branched C_{1-12} -alkyl group or 15 an aryl or C_{1-12} -alkylaryl group; k is an integer from 1 to 3 and q is an integer from 1 to 2 and m is an integer from 0 to 2; such that $m + k + q = 4$; p is an integer from 1 to 3; and r is an integer from 1 to 2; are preferred.

20 Where an end group and/or cross linker and or polymer chain is used, it is preferred that the ratio of end groups or cross linker or polymer chains to $a+b+c+d$ varies from 0 to 99:1, preferably 0.01 to 99:1. Particularly suitable cross linkers or polymer chains are derived from titanium alkoxides, aluminium trialkoxides and alkyl alkoxy silanes. Examples of cross linkers include aluminium triethoxide, aluminium tributoxide and titanium isopropoxide and for polymer chains alkyl alkoxy silanes. The end group, cross linking bridge or polymer chain member is preferably $R^8_3M^1O_{1/2}$, 25 $R^8_2SiO R^9O_{1/2}$, $(R^8)_2SiO_{2/2}$, $TiO_{4/2}$, $R^8TiO_{3/2}$, $(R^8)_2TiO_{2/2}$, $AlO_{3/2}$ or $R^8AlO_{2/2}$. R^8 and R^9 are preferably C_{1-4} -alkyl, especially methyl or ethyl.

30 The preparation of compounds of Formula 1 will now be discussed in greater detail. The general procedure used for the production of the compounds of Formula 1 comprises first forming the compounds $(R^9O)_3SiCH_2(CH_2)_tS(CR^1R^2)_fX$ and depending on the reagents and reaction conditions $(R^9O)_3SiCH_2(CH_2)_tS(CR^1R^2)_fS(CH_2)_tCH_2Si(OR^9)_3$ as well and then combining the former and the latter if present with tetraalkyl orthosilicate and with other compounds such as $(R^5O)_3SiV$, titanium alkoxides, aluminium trialkoxides and alkyl alkoxy silanes, in the desired ratios, in solvent with either dilute acid or base. Alternatively the surfaces of materials such as silica, aluminium oxide or carbon 35 can be treated with $(R^9O)_3SiCH_2(CH_2)_tS(CR^1R^2)_fX$ or mixtures of $(R^9O)_3SiCH_2(CH_2)_tS(CR^1R^2)_fX$ and $(R^9O)_3SiCH_2(CH_2)_tS(CR^1R^2)_fS(CH_2)_tCH_2Si(OR^9)_3$ and if necessary with other compounds such as

$(R^5O)_3SiV$, titanium alkoxides, aluminium trialkoxides and alkyl alkoxy silanes to give compounds of Formula 1. These materials can then be subsequently transformed using known chemistry.

There is a lack of simple and effective synthetic methodology for the preparation of functionalised 5 organic or inorganic polymers or materials. For example there is a lack of simple and effective synthetic methodology for the preparation of readily transformed carbonyl, carboxy, thio or hydroxy functionalised organic or inorganic polymers or materials. Given the advantages of inorganic materials such as high thermal stability, fast kinetics and greater solvent compatibility there is a particular need for new simple synthetic methodologies for the preparation of functionalised 10 inorganic materials.

An important desired property of functionalised materials is to be able to transform the functional group, attached to the surface via a stable bond, into different groups using known chemistry. These new functionalised materials can then be used for other applications or to optimise existing 15 applications. A further advantage is that a wide range of different functionalised materials can be made from a limited number of intermediates. However a number of problems are encountered in the chemical transformation of surface attached functional groups. For example very long reaction times are often needed to conduct such chemical transformations of surface attached functional groups. These prolonged reaction conditions often result in the functional group being removed from the 20 surface. In addition those reactions that do proceed very often do not go to completion leading to a mixture of products that cannot be separated. To circumvent these difficulties the inventors designed new functionalised materials with specific additional functionality to enhance the chemical reactivity of these materials. In addition the inventors believed that this design would enhance the properties of the materials for a number of desired applications. The design involved the use of a 25 neighbouring group to enhance the reactivity of the second functional group.

It is known that free radical reactions involving alkenes may not proceed in high yield or selectivity as, depending on the particular starting materials unwanted dimers and higher tellomers may 30 undesirably be produced for example as disclosed in *Org. Reactions*, Vol.13, page 218 – 222 and the references provided therein. In the original 1950's work mono substituted products and not mixtures were the desired target for use as fine chemicals. As a consequence of these side reactions interest in this area of chemistry waned. It has been reported that sulfides can be prepared through the free radical addition of thiols to double bonds. This is described in *Org. Reactions*, Vol.13, 164 - 196. The majority of this work concerns the addition of thiols to simple alkyl substituted olefins. For 35 silicon containing olefins there are a small number of examples that include the photochemical catalysed reaction of methyl thioglycolate with trimethoxy vinylsilane reported in *J. Gen. Chem.*, 1976, **46**, 1013 to give $(RO)_3Si(CH_2)_2SCH_2CO_2R$. These compounds were investigated for

pharmacological activity in a programme on atrane derivatives. Also it has been reported in the *Russ. J. Appl. Chem.*, 1999, **72**, 610-612 that the radical catalysed reaction of thioglycolic acid, $\text{HSCH}_2\text{CO}_2\text{H}$, to trimethoxy vinylsilane gives a complex mixture which on either acid or neutral treatment does not lead to a polymeric material. Strong base treatment followed by acidification was 5 reported to give a polymeric material described as $[\text{O}_{1.5}\text{Si}(\text{CH}_2)_2\text{SCH}_2\text{CO}_2\text{H}]_n$. The sodium salts of this polymer are capable of removing both silver and gold ions but are ineffective for other metal ions.

Thus it was decided to explore the free radical addition of substituted thiols to vinyl trialkoxy silane 10 to produce functionalised organopolysiloxanes with the desired physical and chemical properties for applications such as scavengers for the removal of unwanted chemical, as materials for solid phase synthesis, as materials for cation and anion recovery and removal, for solid phase purification and extraction, as catalysts and catalyst supports, as chromatography materials and for the immobilisation of bio-molecules.

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Compounds such as $(\text{R}^9\text{O})_3\text{SiCH}_2\text{CH}_2\text{S}(\text{CR}^1\text{R}^2)_f\text{X}$ were synthesised *via* a free radical promoted addition of a thiol $\text{HS}(\text{CR}^1\text{R}^2)_f\text{X}$ to vinyl trialkoxy silane. R^9 is a linear or branched C_{1-40} -alkyl, C_{2-40} -alkenyl or C_{2-40} -alkynyl group, aryl or C_{1-40} -alkylaryl group. A wide range of free radical initiators can be used for this reaction and preferred are the peroxides and in particular the alkyl peroxides.

20

Addition of a very small amount of the initiator every few hours improves the overall yield. Reaction temperatures between 20-170°C can be used, though a reaction temperature of between 20-120°C is preferred. Di-*tert*-butyl peroxide is the preferred free radical initiator. Reaction times of between 5 minutes to 48 hours have been used with 1/2 to 2 hours preferred.

25

Known sol-gel technology was used to produce the organopolysiloxanes of Formula 1. The state of the arts of sol-gel technology and the hydrolysis of silicon esters are described by M.A.Brook in *Silicon in Organic, Organometallic and Polymer Chemistry* Chapter 10, page 318, John Wiley & Sons, Inc., 2000, G.A. Scherer in *Sol-gel science: the physics and chemistry of sol-gel processing*, Boston: Academic Press, 1990, and J.D. Wright in *Sol-gel materials: chemistry and applications*,

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Amsterdam: Gordon & Breach Science Publishers, 2001 and the references contained within. Acids and bases were used to catalyse the hydrolysis of the silicon esters of $(\text{R}^9\text{O})_3\text{SiCH}_2\text{CH}_2\text{S}(\text{CR}^1\text{R}^2)_f\text{X}$ or mixtures of $(\text{R}^9\text{O})_3\text{SiCH}_2\text{CH}_2\text{S}(\text{CR}^1\text{R}^2)_f\text{X}$ and $(\text{R}^9\text{O})_3\text{SiCH}_2\text{CH}_2\text{S}(\text{CR}^1\text{R}^2)_f\text{SCH}_2\text{CH}_2\text{Si}(\text{OR}^9)_3$ and if necessary with other compounds such as $(\text{R}^9\text{O})_3\text{SiV}$, and tetraalkyl orthosilicate to produce the organopolysiloxanes of Formula 1.

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A range of solvents, well known to those skilled in the art of organic chemistry, can be used to conduct this reaction. Alcohols are the preferred solvents particularly methanol and ethanol. After

standing for a period of time the solution can be warmed to speed up the formation of the glass. Ratios, by weight, of the alcohol solvent to the combined weight of the reagents from 100 to 0.01 can be used, with ranges from 2-10 being preferred. A range of acids can be used to aid hydrolysis with hydrochloric acid in concentrations ranging from 0.1 to 4 M being preferred. Hydrochloric acid, 1 molar, was routinely used. Ratios, from 0.000001 to 10, of hydrochloric acid, 1 molar, to the combined weight of the reagents can be used, with ranges from 0.0001 to 1 being preferred. In general the reaction mixture was left to stand at temperatures ranging from 0°C-120°C to aid hydrolysis and the formation of the Si-O-Si bonds. Temperatures between 20°C-90°C are preferred and warming is continued until all the solvent has evaporated and a clear glass is obtained.

10

In addition to the groups A, B, C and D, end groups, cross-linking bridge members or polymer chains such as $(R^8)_3SiO_{1/2}$ or $R^8SiO_{3/2}$ or $(R^8)_2SiO_{2/2}$ or $TiO_{4/2}$ or $R^2TiO_{3/2}$ or $(R^8)_2TiO_{2/2}$ or $AlO_{3/2}$ or $R^8AlO_{2/2}$, where R^8 is as defined above, but is preferably methyl or ethyl, or other oxo metals can be added in varying ratios to produce the desired compound of Formula 1. These end groups, cross linking bridge or polymer chain precursors are added at the same time as compounds $(R^9O)_3SiCH_2CH_2S(CR^1R^2)_fX$, or mixtures of $(R^9O)_3SiCH_2CH_2S(CR^1R^2)_fX$ and $(R^9O)_3SiCH_2CH_2S(CR^1R^2)_fSCH_2CH_2Si(OR^9)_3$ and tetraalkyl orthosilicate and $(R^9O)_3SiV$.

Compounds of Formula 1 can also be prepared by treating a preformed material such as silica or 20 aluminium oxide or carbon with $(R^9O)_3SiCH_2CH_2S(CR^1R^2)_fX$ or a mixture of $(R^9O)_3SiCH_2CH_2S(CR^1R^2)_fX$ and $(R^9O)_3SiCH_2CH_2S(CR^1R^2)_fSCH_2CH_2Si(OR^9)_3$, and with $(R^9O)_3SiV$ if required, and with other end groups, cross linkers or polymers chains if required, in varying ratios in a solvent. At the end of the reaction the solid is filtered off and washed extensively with solvents such as water or alcohols to remove any remaining starting materials.

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A further advantage of the processes is that based on a small number of intermediates a wide range of compounds of Formula 1 can be prepared. For example the esters $(R^9O)_3SiCH_2CH_2S(CH_2)_fC(O)OMe$ are important intermediates leading via simple processes to a wide range of different structures for different applications. This common intermediate is prepared in a simple process involving a free 30 radical reaction between vinyl trialkoxysilane and readily available thiol esters such as methyl thioglycolate or methyl 3-thiopropionate to give $(CH_3O)_3SiCH_2CH_2S(CH_2)_fC(O)OMe$. The next step involves either a sol gel process between these esters and tetraethyl orthosilicate or coating the surface of preformed materials such as silica to give compounds of Formula 1 where W is oxygen and R is methoxy. These ester compounds of Formula 1 can be readily transformed into a wide range of 35 derivatives. Acid or base hydrolysis of these ester of Formula 1 affords the corresponding acid $[O_{3/2}SiCH_2CH_2S(CH_2)_fC(O)OH]_a[O_{4/2}Si]_c$ where the ratio of a to c depends on the relative concentrations of $(CH_3O)_3SiCH_2CH_2S(CH_2)_fC(O)OMe$ and tetraethyl orthosilicate in the sol gel step

or silica in the coating process. Metal salts of Formula 1, useful for heterogeneous metal mediated catalysis, can be readily prepared via standard synthetic methodologies from these carboxylic acids. Other derivatives such as amides, hydrazides and other esters can similarly be prepared by treatment of this ester of Formula 1 with the corresponding amines, hydrazines or alcohols in a solvent. At the 5 end of the reaction the new derivative of Formula 1 can be easily purified through simple filtration from the reaction medium. As a consequence of the presence of the second functional group, sulfur, close to the carbonyl group these reactions proceed to completion with short reaction times usually one to two hours. Without this neighbouring group effect these reactions do not go to completion even after prolonged reaction times.

10

In this way the hydrazide of Formula 1 where W is oxygen and R is NHNH_2 as well as amides and polyamine derivatives of Formula 1 where W is oxygen and R is $\text{NH}(\text{CH}_2)_3\text{N}(\text{CH}_3)_2$ or R $\text{NH}(\text{CH}_2)_2\text{N}(\text{CH}_2)_2\text{NH}_2$ or $\text{NH}(\text{CH}_2)_2(\text{N}(\text{CH}_2)_2\text{NH})_l\text{H}$ where l is an integer between 2 and 40, or the esters of Formula 1 where W is oxygen and R is $\text{O}(\text{CH}_2)_2\text{OH}$ or $\text{O}(\text{CH}_2)_2\text{O}(\text{CH}_2\text{CH}_2\text{O})_j\text{H}$ where j is an 15 integer between 2 and 20,000 were prepared.

Compounds of Formula 1 where X is CHR^3Z or $(\text{CR}^3\text{Z})_i\text{CHR}^3\text{Z}$ where Z is OR^6 , NR^6R^7 or SR^6 and R³, R⁶ and R⁷ are each independently hydrogen, a linear or branched C₁₋₄₀-alkyl, C₂₋₄₀-alkenyl or C₂₋₄₀-alkynyl group, an aryl or C₁₋₄₀-alkylaryl group; and i is an integer from 1 to 6 are similarly prepared 20 by a two step process. The first step is a free radical reaction between a thiol and trimethoxy vinyl silane followed either by a sol gel or coating process described above. For example a free radical reaction involving thioglycerol and trimethoxy vinyl silane gives $(\text{CH}_3\text{O})_3\text{SiCH}_2\text{CH}_2\text{SCH}_2\text{CHOHCH}_2\text{OH}$ which on sol gel with tetraethyl orthosilicate gave compounds of Formula 1 where i = 1, R³ = H and Z = OH. Another example is the free radical 25 reaction between 2-mercptoethanol and trimethoxyvinyl silane to give $(\text{CH}_3\text{O})_3\text{SiCH}_2\text{CH}_2\text{SCH}_2\text{CH}_2\text{OH}$ which on sol gel with tetraethyl orthosilicate gave compounds of Formula 1 where i = 1, R³ = H and Z = OH. Alternatively a preformed material such as silica or aluminium oxide can be treated with $(\text{CH}_3\text{O})_3\text{SiCH}_2\text{CH}_2\text{SCH}_2\text{CHOHCH}_2\text{OH}$ or $(\text{CH}_3\text{O})_3\text{SiCH}_2\text{CH}_2\text{SCH}_2\text{CH}_2\text{OH}$ in a solvent such as toluene, xylene or other aromatic or water. At 30 the end of the reaction the solid is filtered off and washed extensively with solvents such as water or alcohols to remove any remaining starting materials.

Substituted ether derivatives of Formula 1 where h is zero, R³ = H and X is OR^6 can readily be prepared from the corresponding hydroxy compound of Formula 1 where X is OH, an alcohol and a 35 homogeneous acid catalyst. For example treatment of the hydroxy compound of Formula 1 where e, i, h, b, d is zero, R³ = H; f is 2; X is OH with 1- butanol or octafluoro-pentan-1-ol in the presence of an acid catalyst gave the corresponding ether where R⁶ is butyl or C₅F₈H₃ in quantitative yield.

Compounds of Formula 1 where B is present involve the use of the bisthiol $\text{HS}(\text{CR}^1\text{R}^2)_\text{f}\text{SH}$. The mixture of $(\text{R}^9\text{O})_3\text{SiCH}_2\text{CH}_2\text{S}(\text{CRR}^1)_\text{f}\text{SH}$ and $(\text{R}^9\text{O})_3\text{SiCH}_2\text{CH}_2\text{S}(\text{CRR}^1)_\text{f}\text{SCH}_2\text{CH}_2\text{Si}(\text{OR}^9)_3$ was synthesised *via* a free radical promoted addition of a thiol $\text{HS}(\text{CR}^1\text{R}^2)_\text{f}\text{SH}$ to vinyl trialkoxy silane.

5 For example compounds $(\text{CH}_3\text{O})_3\text{SiCH}_2\text{CH}_2\text{S}(\text{CH}_2)_3\text{SCH}_2\text{CH}_2\text{Si}(\text{OCH}_3)_3$ and $(\text{CH}_3\text{O})_3\text{SiCH}_2\text{CH}_2\text{S}(\text{CH}_2)_3\text{SH}$ were synthesised *via* a free radical promoted addition of $\text{HS}(\text{CH}_2)_3\text{SH}$ to vinyl trimethoxy silane. The ratio of the products follows from the ratio of the reactants. ^1H and ^{13}C nmr spectroscopy was used to identify both compounds in the mixture. In the ^1H spectrum run in CDCl_3 signals at δ 0.92, 1.77 and 2.55 correspond to the SiCH_2 , CCH_2C and CH_2SCH_2 protons of $(\text{CH}_3\text{O})_3\text{SiCH}_2\text{CH}_2\text{S}(\text{CH}_2)_3\text{SH}$ whilst signals at δ 0.93, 1.81 and 2.58 correspond to the SiCH_2 , CCH_2C and CH_2SCH_2 protons of $(\text{CH}_3\text{O})_3\text{SiCH}_2\text{CH}_2\text{S}(\text{CH}_2)_3\text{SCH}_2\text{CH}_2\text{Si}(\text{OCH}_3)_3$. Sol gel or coating processes 10 described above involving $(\text{R}^9\text{O})_3\text{SiCH}_2\text{CH}_2\text{S}(\text{CRR}^1)_\text{f}\text{SH}$ and $(\text{R}^9\text{O})_3\text{SiCH}_2\text{CH}_2\text{S}(\text{CRR}^1)_\text{f}\text{SCH}_2\text{CH}_2\text{Si}(\text{OR}^9)_3$ give the corresponding materials of Formula 1 where A, B and C are present, e is 0 and h is 1 and X is H.

15

Substituted phenyl sulfonic acid catalysts of Formula 1 can be prepared in a simple three-step process. The first step involves the formation of $(\text{R}^9\text{O})_3\text{SiCH}_2\text{CH}_2\text{SR}$ via reaction of the corresponding thiol RSH with vinyl trialkoxy silane. Sol gel or coating processes using $(\text{R}^9\text{O})_3\text{SiCH}_2\text{CH}_2\text{SR}$ then affords compounds of Formula 1 where e and h are zero. Treatment of 20 these products where R is phenyl or benzyl with concentrated sulphuric acid gave the corresponding phenyl sulfonic acid.

Sulfonic acid compounds of Formula 1 where e is 2 and h is 1 and X is OH can be prepared via oxidation of compounds of Formula 1 where e is 0, h is 1 and X is H.

25

Templates to aid the preparation of pores with particular sizes and distributions in compounds of Formula 1 can be added at the sol gel stage. On preparation of the solid organopolysiloxane of Formula 1 these templates can be washed out using known methods.

30 Compounds of Formula 1 may be linked to a metal complex, for example as a ligand. A further aspect of the invention provides a Compound of Formula 1 further comprising a metal complex $\text{M}(\text{L})_\text{j}$ where M is derived from a lanthanide, actinide, main group or transition metal with oxidation states ranging from zero to four and L is one or more optionally substituted ligands selected from halide, nitrate, acetate, carboxylate, cyanide, sulfate, carbonyl, imine, alkoxy, triaryl or trialkylphosphine and 35 phenoxy and j is an integer from 0 to 8 and where the compound of Formula 1 is linked to the said metal complex .

Suitably, M is derived from cobalt, manganese, iron, nickel, palladium, platinum, rhodium, with oxidation states ranging from zero to four and L is one or more optionally substituted ligands selected from halide, nitrate, acetate, carboxylate, cyanide, sulfate, carbonyl, imine, alkoxy, triaryl or trialkylphosphine and phenoxy and j is an integer from 0 to 4.

5

Compounds of Formula 1 have a wide range of uses. The present invention provides a process for treating a feed material comprising contacting a compound of Formula 1 with a feed material:

- i) to effect a chemical reaction by catalytic transformation of a component of the feed material to produce a desired product;
- 10 ii) to remove a component of the feed material so as to produce a material depleted in the removed component; or
- 15 iii) to remove an ionic species in the feed material in an ion exchange process.

The feed material may be a continuous stream for example a continuous process reaction feedstock, or may be in the form of a batch of material for discrete treatment. The feed material, for example a waste water or waste process stream, may be treated to selectively remove a components of the feed. The removed component may be an undesirable material in the feed and the process acts to provide a desired composition for the feed material that has been depleted in the selectively removed component after contact with compounds of Formula 1. This process may be used for example in removing unwanted species from a feed material in a pharmaceutical manufacturing or formulation process to improve the purity level of the pharmaceutical product as regards the removed material, for example metal species.

The process may be employed to remove desired species from a feed material for subsequent processing or analysis, for example a biological molecule such as an enzyme, peptide, protein and nucleic acid may be removed from a feed material to enable further processing or analysis of the removed components.

As a consequence of stricter environmental regulations there is a growing requirement for more effective systems for the removal and recovery of cations and anions from a wide spectrum of contaminated solvents, aqueous based wastes and from contaminated waters and contaminated products and pharmaceuticals. Compounds of Formula 1 are very effective at abstracting a wide range of cations and anions from various environments. For cations these include the lanthanides, actinides, main group and transition metals. Anions include arsenates, borates, chromates, 35 permanganates and perchlorates.

Compounds of Formula 1 were designed to have very high affinity for ions and thus be able to remove them from various environments. Such high affinity is required when metal ions are tightly bound to particular functional groups for example in highly polar active pharmaceutical ingredients. The design of compounds of Formula 1 for these applications involves the presence of two or more 5 different ligands to bind strongly to the ion. Depending on the ion to be removed the ligands are designed to be either soft or hard or a combination of both in order to optimise the affinity of the functionalised material for the ion. Furthermore the compounds of Formula 1 have been designed with easily modified functional groups in order to simply find the optimum combination of ligands for specific ion impurities.

10

For example the products from Examples 13, 17, 19, 22-26, 30-32, and 43 are very effective for the removal of cupric (II) ions from various solutions. Ferrous and ferric ions present in hydro-processing streams are readily removed using the products from Examples 13 and 43.

15

Compounds of Formula 1 can also remove precious metals such as palladium, platinum and rhodium ion as well as nickel (0) and nickel (II) from various different solutions and also bound to functional groups commonly found in active pharmaceutical ingredients such as amides, amines and carboxylic acids. For example treatment of a palladium acetate solution in tetrahydrofuran or dichloromethane with any of the products from Examples 13, 17, 19, 22-26, 30-32, and 41, 45, 47, 49 and 51-54 results 20 in the complete removal of the palladium ions from solution. For solutions containing bis(triphenylphosphine) palladium chloride or acetate, the products from Examples 13, 17, 19, 22-26, 30-32, and 41, 45, 47, 49 and 51-54 are equally effective for its removal. The products from Examples 13, 17, 19, 22-26, 30-32, and 41, 45, 47, 49 and 51-54 are effective for the removal of 25 chlorotris(triphenylphosphine) rhodium(I) from various solutions. The products from Examples 13, 17, 19, 22-26, 30-32, and 41, 45, 47, 49 and 51-54 are effective for the removal of platinum chloride from various solutions. Rhodium (III) is readily removed from various solutions using any of the products from Examples 13, 17, 19, 22-26, 30-32, and 41, 45, 47, 49 and 51-54.

30

Given their respective catalytic cycles the precious metals are often present in waste streams, solutions or bound to products in more than one oxidation state. Compounds of Formula 1, such as the amides formed in Examples 17, 25, 26 and 31-32 and the sulfides formed in Examples 41, 45, 47, 49 and 51-54 can scavenge these precious metals in their different oxidation states.

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Compounds of Formula 1 can be used, as scavengers, to remove excess inorganic or organic reagents and side products from reactions mixtures or from impure chemical products. In these applications impurities are removed by matching functionality contained in these impurities with specific functionalised materials. For example the sulfonic acid or carboxylic acid materials prepared in

Example 65 and 12 respectively can readily remove amines and hydrazines as well as other basic reagents including hydrides from reaction mixtures. The hydrazide and amine prepared in Examples 18 and 17 respectively can remove acids, isocyanates, acid chlorides, aldehydes, sulfonyl halides and chloroformates. The diol prepared in Example 8 can scavenge boronic acids as well as aldehydes and 5 ketones. The following examples illustrate the scavenging of unwanted organic and inorganic compounds by compounds of Formula 1 but are not intended to limit the scope of their capability. Treatment of solutions containing amines such as benzylamine, hexylamine and 3-methoxypropylamine with 2 to 4 equivalents of an organopolysiloxane carboxylic acid of Formula 1 at room temperature for 1 hour led to the complete removal of the amine. Excess borohydrides such 10 as sodium borohydride can be removed on treatment with the organopolysiloxane carboxylic acid of Formula 1. Toluene sulfonyl chloride, benzoyl chloride and phenyl isocyanate are readily removed using the amides from Examples 17, 25, 26 and 31 and 32.

Unlike the polystyrene based scavengers, organopolysiloxane compounds of Formula 1 can work in 15 all solvents and are not limited in their application to reaction temperatures below 80°C. In addition compounds of Formula 1 do not suffer from swelling and possess the significant advantage of very fast kinetics compared to organic polymers.

Compounds of Formula 1 where i) b, e and h are zero and X is a substituted phenyl sulfonic acid and 20 ii) h is 1 and X is OH are especially beneficial in catalysing a wide range of acid promoted reactions. For examples these compounds readily catalyse the condensation between aldehydes and aldehydes, aldehydes and ketones and ketones with ketones, reactions known as the Aldol condensation and the Claisen-Schmidt reaction. In addition these compounds catalyse esterification, trans-esterification, acylation, alkylation, cyclisation, etherification, dehydration and rearrangement reactions as well as a 25 variety of protection and de-protection reactions. In addition these compounds of Formula 1 possess good thermal and chemical stability and reactions can be catalysed at much higher temperatures than functionalised polystyrene materials. One of the advantages of these catalysts is that on completion of the reaction they can be simply filtered off and reused. No apparent loss of activity was observed. Following filtration and washing with solvents such as acetone, alcohols, water and others well 30 known to those skilled in the art of organic chemistry and drying at temperatures ranging from 20°C-120°C under reduced pressure the compounds of Formula 1 can be used to catalyse other reaction types without apparent loss of activity.

The following examples illustrate the catalytic activity of compounds of Formula 1 but are not 35 intended to limit the scope of their capability to catalyse a wide range of reactions. Compounds of Formula 1, where i) b, e and h are zero and X is a substituted phenyl sulfonic acid and ii) h is 1 and X is OH, catalyse the esterification of carboxylic acids. For example treatment of oleic acid in refluxing

ethanol with such compounds of Formula 1 gave the ester, ethyl oleate, in quantitative yield. These compounds also catalyse the trans-esterification of carboxylate esters. For example treatment of ethyl oleate in butanol at temperatures between 60-140°C with these catalysts gives colourless butyl oleate. Utilising known reaction conditions compounds of Formula 1, particularly where i) b, e and h are 5 zero and X is a substituted phenyl sulfonic acid and ii) h is 1 and X is OH, readily catalyse the ketalisation of ketones in very high yields and purity.

Metal salt/complexes of Formula 1 can catalyse a wide range of reactions well known to practitioners of organic and inorganic chemistry. Examples include but not limited to oxidations, reductions, 10 alkylations, carbon-carbon bond formation, polymerisations, hydroformylations, arylations, acylations, isomerisations, alkylations, carboxylations, carbonylations, esterifications, trans-esterifications and rearrangements. These organopolysiloxane compounds of Formula 1 have many advantages for example they possess good thermal and chemical stability and broad solvent compatibility. One of the advantages of these catalysts is that on completion of the reaction they can 15 be simply filtered off and reused. No apparent loss of activity was observed. Thus an important application of the metal derivatives of Formula 1 is their use as heterogeneous catalysts.

Compounds of Formula 1 where i) X is independently selected from R^1 , $C(=W)R$ or $(CR^3Z)CHR^3Z$ where W is selected from oxygen, sulfur, NR^4 or NNR^4R^5 and Z is selected from OR^6 , NR^6R^7 or SR^6 20 and R is R^6 , OR^6 , $O(M^{+g})_{1/g}$, NR^6R^7 , $NHNR^6R^7$ or SR^6 where R^{1-7} are as designed above and M is a metal ion derived from a lanthanide, actinide, main group or transition metal, or ii) metal complexes $M(L)_j$ of i) are especially beneficial in catalysing a wide range of metal promoted reactions. For example palladium (II) complexes of compounds of Formula 1 where i) e and h are zero, X is $C(=W)R$ where R is O⁻ or NR^6R^7 and W is oxygen or sulfur, or ii) e and h are zero, X is H catalyse a 25 wide range of carbon-carbon bond formation reactions such as Suzuki and Heck reactions. At the end of these reactions these catalysts can be filtered easily from the reaction mixture and reused.

Compounds of Formula 1 can also be used for solid phase synthesis through first attachment of the starting material to groups such as X or Z. A number of chemical reactions can then be conducted 30 and in each step purification is facile through simple filtration. At the end of the sequence the desired material is released from the solid phase. For example 4-hydroxybenzaldehyde was attached to the diol prepared in Example 8. Alkylation of the free hydroxyl group using standard methodologies gave an aryl, alkyl ether. The product was then released from the material to give pure 4-alkoxybenzaldehyde.

35

In addition compounds of Formula 1 can be used as materials for solid phase extraction where a desired product is purified through selective retention on the functionalised materials whilst the

impurities are removed. The desired material is then subsequently released using a different solvent system. For example amines can be retained on the acids prepared in Example 12 or 65 and the impurities are then washed out. Treatment of the material with a methanol solution containing ammonia releases the amine and after concentration the pure amine is obtained.

5

Compounds of Formula 1 can also be used for the separation or removal of gases, including the removal of malodorous volatile organic compounds. For example the removal of malodorous amines can be achieved with acids prepared in Examples 65 or 12.

10 Further applications of compounds of Formula 1 include the use as materials for chromatographic separations. For example the materials of Formula 1 can be used in the separation of amines, including optically active amines. Primary amines can be selectively separated from secondary amines using compounds of Formula 1.

15 Compounds of Formula 1, containing optically active groups such as in the products formed in Examples 28 and 29, can be used as materials for chiral separation.

Compounds of Formula 1 can be used as materials for gel filtration and high speed size-exclusion chromatography as well as for high pressure liquid chromatography and solid phase extraction.

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Compounds of Formula 1 can be used both to immobilise biological molecules such as enzymes, polypeptides, proteins and nucleic acids as well as for their separation and purification. In addition nucleic acids immobilised on compounds of Formula 1 can be used for conducting high volume nucleic acid hybridization assays.

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Compounds of Formula 1 can be used as anti-microbial agents. The invention also provides an antimicrobial composition comprising a compound of Formula 1 and a carrier.

Compounds of Formula 1 can be applied as thin films onto a variety of surfaces.

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The invention will now be described in detail with reference to illustrative examples of the invention.

Example 1

A mixture containing trimethoxyvinylsilane (156 ml, 1.02 mol), methyl thioglycolate (87 ml, 0.97 mol) and di-*tert* butyl peroxide (10 drops) was stirred at room temperature and then warmed to 115 °C under an atmosphere of nitrogen. The mixture was maintained at this temperature for 1 h during which di-*tert* butyl peroxide (10 drops) was added every 20 min. The solution was then cooled to

room temperature to give methyl (2-trimethoxysilyl ethyl) thioglycolate. ^1H NMR CDCl_3 , δ_{H} 3.66 (3H, s, COCH_3), 3.50 (9H, s, SiOCH_3), 3.18 (2H, s, CH_2C), 2.66 (2H, bm, CH_2S) and 0.96 (2H, bm, CH_2Si).

5 **Example 2**

A mixture of the product from Example 1 (38.1 g, 0.15 mol) and tetraethyl orthosilicate (62.4 g, 0.3 mol) was dissolved in methanol (200 ml) and 1 M HCl (36 ml) was added with stirring. The mixture was then warmed at 80 °C until the methanol had evaporated and a glass had formed. The glass was crushed and then stirred in refluxing methanol. The material was then dried under reduced pressure of 0.1 mm Hg at 80 °C for 2 h to give a methyl ester of Formula 1, where R^1 and R^2 are hydrogen, $\text{X} = \text{CO}_2\text{Me}$ and B, D, h, e=0 and f=1 , as a white powder. ^1H NMR $\text{D}_2\text{O}/\text{NaOD}$ 3.18 (3H, s, OCH_3), 3.08 (2H, s, COCH_2S), 2.55 (2H, bm) and 0.6 (2H, bm).

Example 3

15 A mixture of the product from Example 1 (25.4 g, 0.1 mol) and tetraethyl orthosilicate (223 ml, 1.0 mol) was dissolved in methanol (400 ml) and 1 M HCl (90 ml) was added with stirring. The mixture was then warmed at 80 °C until the methanol had evaporated and a glass had formed. The glass was crushed and then stirred in refluxing methanol. The material was then dried under reduced pressure of 0.1 mm Hg at 80 °C for 2 h to give a methyl ester as a white powder.

20

Example 4

A mixture containing trimethoxyvinylsilane (14.8 g, 0.10 mol), ethyl thioglycolate (12.0 g, 0.1 mol) and di-*tert* butyl peroxide (10 drops) was stirred at room temperature and then warmed to 115 °C under an atmosphere of nitrogen. The mixture was maintained at this temperature for 6 h during 25 which di-*tert* butyl peroxide (10 drops) was added every 20 min. The solution was then cooled to room temperature and added to a mixture of silica (80 g) in toluene (200 ml). This mixture was stirred under gentle reflux for 2 h. Triethylene tetra amine (19.6 g) dissolved in toluene (40 ml) was added and the mixture was stirred and refluxed for a further 2 h. The white solid was filtered, washed well with distilled water and then dried under reduced pressure of 0.1 mm Hg at 80 °C for 2 h to give 30 the triethyleneamine ethyl amide (47.8 g) of Formula 1 where R^1 and R^2 are hydrogen, $\text{X} = \text{CONH}(\text{CH}_2)_2\text{NH}(\text{CH}_2)_2\text{NH}_2$ and B, D, h, e=0 and f=1 , as a white powder.

Example 5

A mixture containing trimethoxyvinylsilane (29.6 g, 0.20 mol), ethyl 3-mercaptopropionate (26.8 g, 35 0.20 mol) and di-*tert* butyl peroxide (10 drops) was stirred at room temperature and then warmed to 115 °C under an atmosphere of nitrogen. The mixture was maintained at this temperature for 6 h during which di-*tert* butyl peroxide (10 drops) was added every 20 min. The solution was then

cooled to room temperature to give ethyl 3-(2-trimethoxysilylethylmercapto) propionate. ^1H NMR CDCl_3 , δ_{H} 3.60 (2H, bq), 3.46 (9H, bs), 2.7 (2H, m), 2.53 (4H, m), 1.1 (3H, bm) and 0.88 (2H, m).

Example 6

5 A mixture of the product from Example 5 (28.2 g, 0.1 mol) and tetraethyl orthosilicate (223 ml, 1.0 mol) was dissolved in methanol (400 ml) and 1 M HCl (90 ml) was added with stirring. The mixture was then left at 80 °C until the methanol had evaporated and a glass had formed. The glass was crushed and then stirred in refluxing methanol. The material was then dried under reduced pressure of 0.1 mm Hg at 80 °C for 2 h to give an ethyl ester of Formula 1, where R^1 and R^2 are hydrogen, $\text{X} =$
10 CO_2Et and $\text{B, D, h, e=0 and f=2}$, as a white powder.

Example 7

A mixture containing trimethoxyvinylsilane (15 ml, 0.10 mol), thioglycerol (10.8 g, 0.10 mol) and di-*tert* butyl peroxide (10 drops) was stirred at room temperature and then warmed to 115 °C under an 15 atmosphere of nitrogen. The mixture was maintained at this temperature for 2 h during which di-*tert* butyl peroxide (10 drops) was added every 20 min. The solution was then cooled to room temperature. ^1H NMR CDCl_3 , 3.53 (9H, s, SiOCH_3), 3.9-3.5 (3H, bm), 2.65-2.5 (4H, bm) and 0.97 (2H, bm, CH_2Si).

20 **Example 8**

A mixture of the product from Example 7 (6 g, 0.023 mol) and tetraethyl orthosilicate (25.6 ml, 0.115 mol) was dissolved in methanol (80 ml) and 1 M HCl (12 ml) was added with stirring. The mixture was then warmed at 80 °C until the methanol had evaporated and a glass had formed. The glass was crushed and then stirred in refluxing methanol. The material was then dried under reduced pressure 25 of 0.1 mm Hg at 80 °C for 2 h to give a diol of Formula 1 where R^1 and R^2 are hydrogen, $\text{X} =$ CHOHCH_2OH and $\text{B, D, h, e=0 and f=1}$, as a white powder.

Example 9

A mixture of the product from Example 1 (25 g,) and silica (70 g, 28 – 200 mesh) in toluene (200 ml) 30 was refluxed for 3 h. After cooling the mixture was filtered and washed with methanol and then dried to give a methyl ester of Formula 1, where R^1 and R^2 are hydrogen, $\text{X} = \text{CO}_2\text{Me}$, $\text{B, D, h, e=0 and f=1}$, as a white powder.

Example 10

A mixture of the product from Example 1 (19.1 g) and tetraethyl orthosilicate (41.3 g) and dimethoxy 35 dimethyl silane (4.4 g) was dissolved in methanol (160 ml) and 1 M HCl (22 ml) was added with stirring. The mixture was then left at 80 °C until the methanol had evaporated and a glass had formed. The glass was crushed and then stirred in refluxing methanol. The material was then dried

under reduced pressure of 0.1 mm Hg at 80 °C for 2 h to give to give a methyl ester of Formula 1, where R¹ and R² are hydrogen, X = CO₂Me, B, D, h, e=0 and f=1, and with (CH₃)₂SiO_{2/2} as a cross linker, as a white powder.

5 **Example 11**

A mixture of the product from Example 1 (18.9 g) and tetraethyl orthosilicate (41.3 g) and trimethoxy methyl silane (3.1 g) was dissolved in methanol (160 ml) and 1 M HCl (21 ml) was added with stirring. The mixture was then left at 80 °C until the methanol had evaporated and a glass had formed. The glass was crushed and then stirred in refluxing methanol. The material was then dried 10 under reduced pressure of 0.1 mm Hg at 90 °C for 2 h to give a methyl ester of Formula 1, where R¹ and R² are hydrogen, X = CO₂Me, B, h, e=0 and f=1, and V is methyl, as a white powder.

Example 12

A mixture of the product from Example 3 (3.14 g) and potassium hydroxide (1.68 g) in water (30 ml) 15 was gently refluxed for 2 h and then cooled to room temperature. The mixture was then acidified with hydrochloric acid and left to stand for 6 h. The white solid was filtered, washed well with distilled water and finally with methanol. The material was then dried under reduced pressure of 0.1 mm Hg at 80 °C for 2 h to give a carboxylic acid of Formula 1 where R¹ and R² are hydrogen, X = CO₂H and B, D, h, e=0 and f=1, as a white powder (2.9 g). ¹H NMR NaOD/D₂O, δ_H 2.52 (2H, bm, 20 CH₂S) and 0.58 (2H, bm, CH₂Si).

Example 13

A mixture of the product from Example 12(1.0 g) in water (30 ml) was treated with an aqueous 25 solution of sodium hydroxide until the pH was 7. The white solid was filtered, washed well with distilled water and finally with methanol. The material was then dried under reduced pressure of 0.1 mm Hg at 80 °C for 2 h to give the sodium carboxylate salt of Example 12 as a white powder (0.9 g).

Example 14

A mixture of the product from Example 13 (0.5 g) in water (30 ml) was treated with an aqueous 30 solution of copper nitrate. The mixture was stirred for 1 h and then filtered. The blue solid was filtered, washed well with distilled water and finally with methanol. The material was dried under reduced pressure of 0.1 mm Hg at 80 °C for 2 h to give the copper salt as a blue powder (0.46 g).

Example 15

A mixture of the product from Example 3 (1.03 g), ethylene glycol (1 ml) and methanesulfonic acid 35 (6 drops) in toluene (5 ml) was stirred under gentle reflux for 12 h. The white solid was filtered and washed well with distilled water. The solid was then stirred in aqueous methanol (2:1, 20 ml) at 40°C for 6 h and filtered and washed well with distilled water and methanol. The material was then dried

under reduced pressure of 0.1 mm Hg at 80 °C for 2 h to give the 2-hydroxyethyl ester of Formula 1 where R¹ and R² are hydrogen, X = CO₂CH₂CH₂OH and B, D, h, e=0 and f=1, as a white powder (1.1 g). ¹H NMR NaOD/D₂O, δ_H 3.55 (2H, bs, CH₂O) 3.47 (2H, bs, CH₂O), 2.52 (2H, bm, CH₂S) and 0.58 (2H, bm, CH₂Si).

5

Example 16

A mixture of the product from Example 3 (1.03 g) and 3-methoxypropylamine (1 ml) in toluene (5 ml) was stirred under gentle reflux for 2 h. The white solid was filtered and washed well with distilled water. The solid was then stirred in aqueous methanol (2:1, 20 ml) at 40°C for 6 h and 10 filtered and washed well with distilled water and methanol. The material was then dried under reduced pressure of 0.1 mm Hg at 80 °C for 2 h to give the 3-methoxypropylamide (1.17 g) of Formula 1 where R¹ and R² are hydrogen, X = CONH(CH₂)₃OMe and B, D, h, e=0 and f=1. ¹H NMR NaOD/D₂O, δ_H 3.42 (2H, bm), 3.25 (3H, bs, OCH₃), 3.19 (2H, bm), 2.61 (2H, bm, CH₂S), 1.73 (2H, bm, CCH₂C) and 0.66 (2H, bm, CH₂Si).

15

Example 17

A mixture of the product from Example 3 (1.05 g), diethylenetriamine (1.2 ml) in toluene (5 ml) was stirred under gentle reflux for 20 h. The white solid was filtered and washed well with distilled water. The solid was then stirred in aqueous methanol (2:1, 20 ml) at 40°C for 6 h and filtered and washed 20 well with distilled water and methanol. The material was then dried at 0.1 mm Hg at 80 °C for 2 h to give the amide (1.11 g) of Formula 1 where R¹ and R² are hydrogen, X = CONH(CH₂)₂NH(CH₂)₂NH₂ and B, D, h, e=0 and f=1, as a white powder. ¹H NMR NaOD/D₂O, δ_H 3.23 (2H, bm, CONHCH₂), 2.80-2.52 (8H, bm) and 0.67 (2H, bm, CH₂Si).

25

Example 18

A mixture of the product from Example 3 (3.05 g), hydrazine hydrate (3 ml) in toluene (20ml) was stirred at 40°C for 20 h. The white solid was filtered and washed well with distilled water. The solid was then stirred in aqueous methanol (2:1, 20 ml) at 40°C for 6 h and filtered and washed well with distilled water and methanol. The material was then dried under reduced pressure of 0.1 mm Hg at 80 °C for 2 h to give the hydrazide (3.11 g) of Formula 1 where R¹ and R² are hydrogen, X = CONHNH₂ and B, D, h, e=0 and f=1, as a white powder. ¹H NMR NaOD/D₂O, δ_H 2.61 (2H, bm, CH₂S) and 0.66 (2H, bm, CH₂Si).

Example 19

A mixture of the product from Example 3 (1.05 g), 3-dimethylaminopropylamine (1.2 ml) in toluene 35 (5 ml) was stirred under gentle reflux for 12 h. The white solid was filtered and washed well with distilled water. The solid was then stirred in aqueous methanol (2:1, 20 ml) at 40°C for 6 h and filtered and washed well with distilled water and methanol. The material was then dried under

reduced pressure of 0.1 mm Hg at 80 °C for 2 h to give the 3-dimethylaminopropyl amide (1.16 g) of Formula 1 where R¹ and R² are hydrogen, X = CONH(CH₂)₃N(CH₃)₂ and B, D, h, e=0 and f=1, as a white powder. ¹H NMR NaOD/D₂O, δ_H 3.16 (2H, m), 2.63 (2H, bm), 2.28 (2H, bm), 2.09 (6H, s), 1.61 (2H, bm, CCH₂C) and 0.71 (2H, bm, CH₂Si).

5

Example 20

A mixture containing trimethoxyvinylsilane (32.13 ml, 0.21 mol), 2-mercaptop ethanol (14 ml, 0.2 mol) and di-*tert* butyl peroxide (10 drops) was warmed to 115 °C under an atmosphere of nitrogen and maintained at this temperature for 1 h. The solution was then cooled to room temperature to give 10 2-hydroxyethyl, 2-trimethoxysilylethyl sulfide. ¹H NMR, CDCl₃ 3.49 (2H, t, OCH₂) and 2.63 (4H, bm, OCCH₂SCH₂).

Example 21

A mixture of 2-hydroxyethyl, 2-trimethoxysilylethyl sulfide (14.69 g, 0.065 mol), silica (Merck 7734, 15 39.81 g) and toluene (160 ml) were stirred under gentle reflux for 2 h. The mixture was cooled and then filtered and the white solid was washed well with water and then methanol to give 2-hydroxyethyl sulfide ethyl silica (45 g) of Formula 1 where R¹ and R² are hydrogen, X = OH and B, D, h, e=0 and f=2, as a white powder. ¹H NMR, NaOD/D₂O, δ_H 3.5 (2H, bm, CH₂O) 2.74 – 2.52 (4H, bm, CH₂SCH₂) and 0.58 (2H, bm, CH₂Si).

20

Example 22

A mixture of the ester formed in Example 3 (15 g) and *N* - (2-hydroxyethyl)-ethylenediamine (4.7 g) in toluene (45 ml) was stirred under gentle reflux for 2 h. The white solid was filtered and washed well with distilled water. The material was then dried under reduced pressure of 0.1 mm Hg at 80 °C 25 for 2 h to give the *N* - (2-hydroxyethyl)-aminoethyl amide (17.8 g) of Formula 1 where R¹ and R² are hydrogen, X = CONH(CH₂)NH(CH₂)OH and B, D, h, e=0 and f=1, as a white powder.

Example 23

A mixture of the ester formed in Example 9 (30 g) and 1-(3-aminopropyl) imidazole (7.4 g) in toluene 30 (200 ml) was stirred under gentle reflux for 2 h. The white solid was filtered and washed well with distilled water. The material was then dried under reduced pressure of 0.1 mm Hg at 80 °C for 2 h to give the 3-imidazole 1-propyl amide (35 g) of Formula 1 where X = C(O)R and R = 3-(1-imidazoyl) propylamine, R¹ and R² = H, f = 1 and B, D, h, e=0.

35

Example 24

A mixture of the ester formed in Example 9 (7 g) and 1-methyl piperazine (2.1 g) in toluene (30 ml) was stirred under gentle reflux for 2 h. The white solid was filtered and washed well with distilled

water. The material was then dried under reduced pressure of 0.1 mm Hg at 80 °C for 2 h to give the 4-methyl piperazine amide (8.3 g) of Formula 1 where X = C(O)R and R = 4-methyl piperazyl, R¹ and R² = H, f = 1 and B, D, h, e = 0.

5 **Example 25**

A mixture of methyl 2-trimethoxysilylethyl thioacetate (from Example 1, 17.02 g) and silica (40 g) in toluene (150 ml) was stirred under gentle reflux for 2 h. Triethylene tetra amine (19.6 g) dissolved in toluene (40 ml) was added and the mixture was stirred and refluxed for a further 2 h. The white solid was filtered, washed well with distilled water and then dried to give the triethyleneamine ethyl amide 10 (47.8 g) of Formula 1 where R¹ and R² are hydrogen, X = CONH(CH₂)₂NH(CH₂)₂NH(CH₂)₂NH₂ and B, D, h, e = 0 and f = 1, as a white powder.

Example 26

A mixture of methyl 2-trimethoxysilylethyl thioacetate (from Example 1, 17.2 g) and silica (41 g) in 15 toluene (200 ml) was stirred under gentle reflux for 2 h. Tetraethylene penta amine (19.6 g) was added and the mixture stirred and refluxed for a further 2 h. The white solid was filtered, washed well with distilled water and then dried to give the tetraethyleneamine ethyl amide (48.8 g) of Formula 1.

20 **Example 27**

A mixture of the ester formed in Example 9 (10 g) and 1-(2-aminoethyl) piperazine (3.3 g) in toluene (45 ml) was stirred under gentle reflux for 2 h. The white solid was filtered and washed well with distilled water. The material was then dried to give an amide (11 g) of Formula 1 where X = C(O)R and R = 2-(piperazine) ethylamine, R¹ and R² = H, f = 1 and B, D, h and e = 0.

25

Example 28

A mixture of the ester formed in Example 3 (4.2 g) and (+) α methylbenzylamine (0.7 g) in acetonitrile (10 ml) was stirred under gentle reflux for 8 h. The white solid was filtered and washed well with methanol. The material was then dried to give a chiral amide (4.6 g) of Formula 1 where X 30 = C(O)R and R = (+) α methylbenzylamine, R¹ and R² = H, f = 1 and B, D, h and e = 0.

Example 29

A mixture of the ester formed in Example 3 (4.0 g) and (-) 2-amino-1-propanol (0.6 g) in acetonitrile (10 ml) was stirred under gentle reflux for 8 h. The white solid was filtered and washed well with 35 methanol. The material was then dried to give a chiral amide (4.4 g) of Formula 1 where X = C(O)R and R = (-) 2-amino-1-propanol, R¹ and R² = H, f = 1 and B, D, h and e = 0.

Example 30

A mixture of methyl 2-trimethoxysilylethyl thioacetate (from Example 1, 17.2 g) and silica (42 g) in toluene (200 ml) was stirred under gentle reflux for 2 h. 3-Aminomethylpyridine (14.6 g) was added and the mixture stirred and refluxed for a further 2 h. The white solid was filtered, washed well with 5 distilled water and then dried to give the pyridyl methyl amide (48.6 g) of Formula 1 where X = C(O)R and R = 3-aminomethylpyridine, R¹ and R² = H, f = 1 and B, D, h and e = 0.

Example 31

10 A mixture of methyl 2-trimethoxysilylethyl thioacetate (from Example 1, 13.7 g), alumina (40.6 g) and toluene (150 ml) were stirred under gentle reflux for 5 h. The mixture was cooled and then filtered and the white solid was washed well with water and then methanol to give a methyl ester of Formula 1, where R¹ and R² are hydrogen, X = CO₂Me and B, C, D, h and e=0 and f=1, as a white powder (46 g).

15 **Example 32**

A mixture of the ester formed in Example 31 (6.1 g) and triethylene tetra amine (2.2 g) in toluene (20 ml) was stirred under gentle reflux for 4 h. The white solid was filtered and washed well with distilled water. The material was then dried to give to give the corresponding tetraethyleneamine ethyl amide (6.6 g) of Formula 1.

20

Example 33

A mixture of the product from Example 12 and thionyl chloride (5 ml) was stirred under gentle reflux for 2 h and then the excess thionyl chloride was evaporated to give the corresponding acid chloride of Formula 1, where R¹ and R² are hydrogen, X = COCl and B, D, h and e=0 and f=1.

25

Example 34

A solution of palladium acetate (0.24g, 1.188 mmol) in THF (50 ml) was added to the sodium salt of the carboxylic acid (Example 13, 2.0 g, 1.24 mmol) and the mixture was stirred overnight. The yellow solid was filtered and washed well with THF and then dried. Weight – 2.04 g, Surface area 30 340 m²/g

Example 35

A mixture of 2-hydroxyethyl sulfide ethyl silica (1 g) and *para* toluenesulfonic acid (0.05 g) in butanol (5 ml) was stirred under gentle reflux for 4 h and then filtered. The white solid was filtered 35 and washed well with distilled water. The material was then dried to give 2-butoxyethyl sulfide ethyl silica (1.2 g) of Formula 1 where R¹ and R² are hydrogen, X = Obutyl and B, D, h and e=0 and f=2.

Example 36

A mixture of 2-hydroxyethyl sulfide ethyl silica (1 g) and *para* toluenesulfonic acid (0.05 g) in octafluoropentanol (5 ml) was stirred under gentle reflux for 4 h and then filtered. The white solid was filtered and washed well with distilled water. The material was then dried to give (2-octafluoropentyl)ethyl sulfide ethyl silica (1.2 g) of Formula 1 where R¹ and R² are hydrogen, X = OC₅F₈H₃ and B, D, h and e=0 and f=2.

Example 37

A mixture of 2-hydroxyethyl sulfide ethyl silica (1.1 g), 1-methylpiperazine (0.8 g) and *para* toluenesulfonic acid (0.5 g) in toluene (10 ml) was stirred under gentle reflux for 10 h and then filtered. The white solid was filtered and washed well with distilled water. The material was then dried to give 2-piperazine ethyl sulfide ethyl silica (1.2 g) of Formula 1.

Example 38

To sodium silicate (197.1 g, 0.929 mol) dissolved in water (500 ml) was added the methyl ester from Example 2 (36.15 g, 0.115 mol). The mixture was stirred until a solution was obtained. After acidification with conc. hydrochloric acid the solution was placed in a large Pyrex dish and warmed at 80 °C until a glass was obtained. The glass was crushed to give the carboxylic acid as a white solid (85 g, 92% yield) where R¹ and R² are hydrogen, X = CO₂H and B, D, h and e=0 and f=2.

20

Example 39

A mixture containing trimethoxyvinylsilane (12.28 ml, 0.081 mol), 1,3 dimercapto propane (6.23 g, 0.057 mol) and di-*tert* butyl peroxide (10 drops) was stirred at room temperature for 1 h then warmed to 100 °C under an atmosphere of nitrogen for 2 h. The solution was cooled to room temperature to give a mixture (3:2 ratio) of 3-mercaptopropyl, 2-trimethoxysilylethyl sulfide 270 MHz, δ_H (CDCl₃) 3.53 (9H, s), 2.55 (4H, m), 1.77 (2H, m) and 0.92 (2H, m) and 1,3 di (2-trimethoxysilylethylsulfyl) propane, 270 MHz, δ_H (CDCl₃) 3.53 (18H, s), 2.58 (8H, m), 1.81 (2H, m) and 0.93 (4H, m).

Example 40

A mixture of the product from Example 39 (7.05 g, 0.0296 mol) and tetraethyl orthosilicate (13 ml, 0.059 mol) was dissolved in methanol (50 ml) and 1 M HCl (7 ml) was added with stirring. The mixture was then warmed at 80 °C until the methanol had evaporated and a glass had formed. The glass was crushed and then stirred in refluxing methanol. The material was then dried under reduced pressure of 0.1 mm Hg at 80 °C for 2 h to give a compound of Formula 1 where R¹ and R² are hydrogen, X is hydrogen, D and e are 0, h is 1, f is 3, and a is 3, b is 2 and c is 10 as a white powder, 270 MHz, δ_H (D₂O/NaOD) 2.45 (4H, m), 2.27 (2H, m), 1.55 (2H, m) and 0.52 (2H, m); 67.8 MHz δ_C (D₂O/NaOD) 36.25, 30.69, 27.83, 24.99 and 16.46 for the fragment O_{3/2}SiCH₂CH₂S(CH₂)₃SH; 270

MHz, δ_H ($D_2O/NaOD$) 2.52 (8H, m), 1.73 (2H, q, J 6.6Hz) and 0.58 (4H, m); 67.8MHz δ_C ($D_2O/NaOD$) 29.89, 28.78, 28.18 and 16.67 for the fragment $O_{3/2}SiCH_2CH_2S(CH_2)_3SCH_2CH_2SiO_{3/2}$.

Example 41

5 A mixture of the product from Example 39 (2.54 g, 0.0083mol) and tetraethyl orthosilicate (18.6 ml, 0.083 mol) was dissolved in methanol (100 ml) and 1 M HCl (8.9 ml) was added with stirring. The mixture was then warmed at 80 °C until the methanol had evaporated and a glass had formed. The glass was crushed and then stirred in refluxing methanol. The material was then dried under reduced pressure of 0.1 mm Hg at 80 °C for 2 h to give a compound of Formula 1 where R^1 and R^2 are 10 hydrogen, X is hydrogen, D and e are 0, h is 1, f is 3, and a is 3, b is 2 and c is 50 as a white powder.

Example 42

A mixture containing trimethoxyvinylsilane (13 ml, 0.0851 mol), 1,3 dimercapto propane (7.66 g, 0.071 mol) and di-*tert* butyl peroxide (10 drops) was stirred at room temperature for 1 h then warmed 15 to 100 °C under an atmosphere of nitrogen. The mixture was maintained at this temperature for 1 h. The solution was then cooled to room temperature to give a mixture (4:1 ratio) of $(CH_3O)_3SiCH_2CH_2S(CH_2)_3SH$ and $(CH_3O)_3SiCH_2CH_2S(CH_2)_3SCH_2CH_2Si(OCH_3)_3$.

Example 43

20 A mixture of the product from Example 42 (3.12 g, 0.01155 mol) and tetraethyl orthosilicate (25.7 ml, 0.1155 mol) was dissolved in methanol (150 ml) and 1 M HCl (12 ml) was added with stirring. The mixture was then warmed at 80 °C until the methanol had evaporated and a glass had formed. The glass was crushed and then stirred in refluxing methanol. The material was then dried under reduced pressure of 0.1 mm Hg at 80 °C for 2 h to give a compound of Formula 1 where R^1 and R^2 25 are hydrogen, X is hydrogen, D and e are 0, h is 1, f is 3, and a is 4, b is 1 and c is 50 as a white powder.

Example 44

A mixture containing trimethoxyvinylsilane (10.4 ml, 0.0688 mol), 1,3 dimercapto propane (4.66 g, 30 0.043 mol) and di-*tert* butyl peroxide (10 drops) was stirred at room temperature for 1 h then warmed to 100 °C under an atmosphere of nitrogen. The mixture was maintained at this temperature for 1 h. The solution was then cooled to room temperature to give a mixture (2:3 ratio) of $(CH_3O)_3SiCH_2CH_2S(CH_2)_3SH$ and $(CH_3O)_3SiCH_2CH_2S(CH_2)_3SCH_2CH_2Si(OCH_3)_3$.

35 Example 45

A mixture of the product from Example 44 (2.33 g, 0.0068mol) and tetraethyl orthosilicate (15 ml, 0.068 mol) was dissolved in methanol (100 ml) and 1 M HCl (8 ml) was added with stirring. The

mixture was then warmed at 80 °C until the methanol had evaporated and a glass had formed. The glass was crushed and then stirred in refluxing methanol. The material was then dried under reduced pressure of 0.1 mm Hg at 80 °C for 2 h to give a compound of Formula 1 where R¹ and R² are hydrogen, X is hydrogen, D and e are 0, h is 1, f is 3, and a is 2, b is 3 and c is 50 as a white powder.

5

Example 46

A mixture containing trimethoxyvinylsilane (9.13 ml, 0.06 mol), 1,3 dimercapto propane (3.24 g, 0.03 mol) and di-*tert* butyl peroxide (10 drops) was stirred at room temperature for 1 h then warmed to 100 °C under an atmosphere of nitrogen. The mixture was maintained at this temperature for 1 h 10 and then cooled to room temperature to give (CH₃O)₃SiCH₂CH₂S(CH₂)₃SCH₂CH₂Si(OCH₃)₃ and a trace of (CH₃O)₃SiCH₂CH₂S(CH₂)₃SH. 270 MHz, δ_H (CDCl₃) 3.53 (18H, s), 2.58 (8H, m), 1.81 (2H, m) and 0.93 (4H, m); MHz δ_C (CDCl₃) 50.60, 30.77, 29.14, 26.07 and 10.57.

Example 47

15 The product from Example 46 (4.02 g, 0.01 mol) was dissolved in methanol (50 ml) and 1 M HCl (2 ml) was added with stirring. The mixture was then warmed at 80 °C until the methanol had evaporated and a glass had formed. The glass was crushed and then stirred in refluxing methanol. The material was then dried under reduced pressure to give a white powder.

Example 48

A mixture containing trimethoxyvinylsilane (50.8 ml, 0.333 mol), 1,2 dimercapto ethane (20 ml, 0.238 mol) and di-*tert* butyl peroxide (10 drops) was stirred at room temperature for 1 h then warmed to 100 °C under an atmosphere of nitrogen for 1 h. The solution was then cooled to room temperature to give a mixture (3:2 ratio) of 2-mercaptopethyl, 2-trimethoxysilylethyl sulfide 270 MHz, δ_H (CDCl₃) 25. 3.53 (9H, s), 2.58 (4H, m) and 0.88 (2H, m); MHz δ_C (CDCl₃) 50.53, 35.96, 31.82, 29.14, 25.98 and 10.57. and 1,2 di (2-trimethoxysilylethylsulfyl) ethane, 270 MHz, δ_H (CDCl₃) 3.48 (18H, s), 2.66 (4H, bs), 2.56 (4H, bm) and 0.92 (4H, m); MHz δ_C (CDCl₃) 50.53, 31.85, 26.15 and 10.61.

Example 49

30 A mixture of the product from Example 48 (8.32 g, 0.0276 mol) and tetraethyl orthosilicate (61.5 ml, 0.276 mol) was dissolved in methanol (200 ml) and ammonia (0.88, 51 ml) was added with stirring. The mixture was then warmed at 80 °C until the methanol had evaporated and a glass had formed. The glass was crushed and then stirred in refluxing methanol. The material was then dried under reduced pressure to give a compound of Formula 1 where R¹ and R² are hydrogen, X is hydrogen, D and e are 0, h is 1, f is 2, and a is 3, b is 2 and c is 50 as a white powder.

Example 50

A mixture containing trimethoxyvinylsilane (29 ml, 0.190 mol), 1,2 dimercapto ethane (10 ml, 0.119 mol) and di-*tert* butyl peroxide (10 drops) was stirred at room temperature for 1 h then warmed to 100 °C under an atmosphere of nitrogen. The mixture was maintained at this temperature for 1 h. The solution was then cooled to room temperature to give a mixture (2:3 ratio) of 5 (CH₃O)₃SiCH₂CH₂S(CH₂)₂SH and (CH₃O)₃SiCH₂CH₂S(CH₂)₂SCH₂CH₂Si(OCH₃)₃.

Example 51

A mixture of the product from Example 50 (8.66 g, 0.0262 mol) and tetraethyl orthosilicate (54.42 ml, 0.262 mol) was dissolved in methanol (200 ml) and 1 M HCl (51 ml) was added with stirring. 10 The mixture was then warmed at 80 °C until the methanol had evaporated and a glass had formed. The glass was crushed and then stirred in refluxing methanol. The material was then dried under reduced pressure to give a compound of Formula 1 where R¹ and R² are hydrogen, X is hydrogen, D and e are 0, h is 1, f is 2, and a is 2, b is 3 and c is 50 as a white powder.

Example 52

A mixture of the product from Example 39 (5 g) and silica (20 g, 28–200 mesh) in toluene (70 ml) was stirred and refluxed for 12 h. After cooling the mixture was filtered, washed with methanol and then dried.

Example 53

A mixture of the product from Example 44 (6 g) and silica (20 g) in toluene (70 ml) was stirred and refluxed for 12 h. After cooling the mixture was filtered, washed with methanol and then dried.

Example 54

25 A mixture of the product from Example 48 (5 g) and silica (20 g, 400 – 200 mesh) in toluene (70 ml) was stirred and refluxed for 12 h. After cooling the mixture was filtered, washed with methanol and then dried.

Example 55

30 A mixture of the product from Example 43 (2 g) and hydrogen peroxide (30%, 25 ml) in water (10 ml) was stirred at room temperature for 12 h. The mixture was filtered and washed with methanol and then dried to give a compound of Formula 1 where R¹ and R² are hydrogen, D is 0, h is 1, X is OH, the integers e and f are respectively 2 and 3, and a is 4, b is 1 and c is 50 as a white powder.

Example 56

A mixture of the product from Example 39 (0.05 mol) and tetraethyl orthosilicate (41.6 g, 0.2 mol) and dimethoxy dimethyl silane (2.4 g, 0.02 m) was dissolved in methanol (160 ml) and 1 M HCl (22

ml) was added with stirring. The mixture was then left at 80 °C until the methanol had evaporated and a glass had formed. The glass was crushed and then stirred in refluxing methanol. The material was then dried under reduced pressure to give a compound of Formula 1 where R¹ and R² are hydrogen, X is hydrogen, D is 0, h is 1, the integers e and f are respectively 0 and 3, and a is 3, b is 2
5 and c is 20 with the dimethyl silyl cross linker as a white powder.

Example 57

A mixture of the product from Example 39 (0.05 mol) and tetraethyl orthosilicate (41.6 g, 0.2 mol) and trimethoxy methyl silane (2.72 g, 0.02 mol) was dissolved in methanol (160 ml) and 1 M HCl (21
10 ml) was added with stirring. The mixture was then left at 80 °C until the methanol had evaporated and a glass had formed. The glass was crushed and then stirred in refluxing methanol. The material was then dried under reduced pressure to give a compound of Formula 1 where R¹ and R² are hydrogen, X is hydrogen, V is methyl, h is 1, the integers e and f are respectively 0 and 3, and a is 3,
b is 2, c is 20 and d is 1 as a white powder.

15

Example 58

To ethylene glycol bis thioglycolate (7.34 g, 0.0349 mol) was added vinyltrimethoxysilane (11.42 g,
11.8 ml, 0.077 mol). The solution was left to stir at room temperature for 1 hour and then 12 drops of
di-*tert*-butyl peroxide was added and the solution was heated at 100°C with stirring for one hour.

20

Example 59

A solution containing the product from Example 58 (2.39 g, 4.72 mmol), tetraethyl orthosilicate (5.88
g, 6.3 ml, 28.2 mmol), methanol (25 ml) and 1M HCl (4 ml) was left overnight at 90°C. The glass
was crushed and then stirred in refluxing methanol. The material was then dried to give a compound
25 of Formula 1 where R¹ and R² are hydrogen, X is-[CO₂(CH₂)_nCO₂]- linking two moieties A¹, A¹
being moiety A without X and n is 2, B, D, h and e is 0, as a white powder.

Example 60

A mixture containing the product from Example 58 (4.30 g), silica (18.04 g) and toluene (100 ml)
30 was refluxed for 5 hours with stirring. It was allowed to cool, filtered then washed with methanol.

Example 61

A mixture containing trimethoxyvinylsilane (15.6 ml, 0.102 mol), thioacetic acid (0.097 mol) and di-*tert* butyl peroxide (10 drops) was stirred at room temperature and then warmed to 115 °C for 1 h
35 during which di-*tert* butyl peroxide (10 drops) was added every 20 min. The solution was then
cooled to room temperature to give (CH₃O)₃SiCH₂CH₂SC(O)CH₃.

Example 62

A mixture containing the product from Example 61 (4.10 g), silica (20 g) and toluene (100 ml) was refluxed for 5 hours with stirring. It was allowed to cool, filtered then washed with methanol to give a compound of Formula 1 where B, D, e, f and h are 0 and X is $\text{C}(\text{O})\text{CH}_3$.

5

Example 63

A mixture containing trimethoxyvinylsilane (15.6 ml, 0.102 mol), thiophenol (0.097 mol) and *di-tert* butyl peroxide (10 drops) was stirred at room temperature and then warmed to 115 °C. The mixture was maintained at this temperature for 6 h during which *di-tert* butyl peroxide (10 drops) was added 10 every 20 min. The solution was cooled to room temperature to give $(\text{CH}_3\text{O})_3\text{SiCH}_2\text{CH}_2\text{Sphenyl}$.

Example 64

A mixture containing trimethoxyvinylsilane (15.6 ml, 0.102 mol), benzylmercaptan (0.097 mol) and *di-tert* butyl peroxide (10 drops) was stirred at room temperature and then warmed to 115 °C. The 15 mixture was maintained at this temperature for 1 h. The solution was cooled to give $(\text{CH}_3\text{O})_3\text{SiCH}_2\text{CH}_2\text{SCH}_2\text{phenyl}$.

Example 65

A mixture of the product from Example 63 (16 g) and silica (70 g, 28 – 200 mesh) in toluene (200 ml) 20 was refluxed for 3 h. After cooling the mixture was filtered and washed with methanol and then dried to give a compound of Formula 1, where X = phenyl, B, D, h, f and e=0 as a white powder.

Example 66

A mixture of the product from Example 65 (5 g) and concentrated sulphuric acid (40 ml) was stirred 25 at 50°C for 4 hours. After cooling the solid was filtered and washed well with water to give a compound of Formula 1 where X = $\text{C}_6\text{H}_4\text{SO}_3\text{H}$, B, D, h, f and e=0 as a white powder.

Example 67

A mixture of the product from Example 64 (18 g) and silica (70 g, 28 – 200 mesh) in toluene (200 ml) 30 was refluxed for 3 h. After cooling the mixture was filtered and washed with methanol and then dried to give a compound of Formula 1, where X = CH_2phenyl , B, D, h, f and e=0 as a white powder.

Example 68

A mixture of the product from Example 67 (5 g) and concentrated sulphuric acid (40 ml) was stirred 35 at 50°C for 4 hours. After cooling the solid was filtered and washed well with water to give a compound of Formula 1 where X = $\text{CH}_2\text{C}_6\text{H}_4\text{SO}_3\text{H}$, B, D, h, f and e=0 as a white powder.

Example 69

A mixture of the product from Example 3 (2 g) and hydrogen peroxide (30%, 25 ml) in water (10 ml) was stirred at room temperature for 12 h. The mixture was filtered and washed with methanol and then dried to give a methyl ester of Formula 1, where R¹ and R² are hydrogen, X = CO₂Me and e=2 and f=1, as a white powder. ¹H NMR, D₂O/NaOD δ_H 3.16 (3H, s OCH₃), 2.82 (2H, bm, CH₂SO₂) and 5 0.65 (2H, bm, CH₂Si)

Example 70

The product from Example 40 (0.06 g) was added to a sample (1 ml) of a 1000 ppm orange coloured solution of palladium acetate in THF. The solution went completely colourless in less than 5 minutes. 10 The mixture was then filtered. Analysis of the filtrate showed that the palladium had been removed. Examples 3, 4, 8, 13, 17, 19, 21, 22, 23, 26-27, 32, 41, 43, 45, 47, 49, 51-54, 59 and 60 (0.06 g) were equally effective in the above test.

Example 71

15 The product from Example 40 (0.08 g) was added to a sample (1 ml) of a 250 ppm yellow coloured solution of bis(triphenylphosphine) palladium chloride in THF. The solution went completely colourless in less than 10 minutes. The mixture was stirred for a further 30 minutes at room temperature and then filtered. Analysis of the filtrate showed that the palladium had been removed. Examples 17, 19, 22, 26, 27, 41, 43, 45, 47, 49 and 51-54 were equally effective in the above test.

20

Example 72

25 The product from Example 40 (0.09 g) was added to a sample (1 ml) of a 250 ppm yellow coloured solution chlorotris(triphenylphosphine)rhodium(I) in THF. The solution went completely colourless in less than 10 minutes. The mixture was stirred for a further 30 minutes at room temperature and then filtered. Analysis of the filtrate showed that the rhodium catalyst had been removed. Examples 17, 19, 22, 26, 27, 41, 43, 45, 47, 49 and 51-54 were equally effective in the above test.

Example 73

30 The product from Example 40 (0.09 g) was added to a sample (1 ml) of a yellow solution of potassium platinum chloride (0.02 g) in water (25 ml). The mixture was stirred for 30 minutes at room temperature and then filtered. Analysis of the filtrate showed that the platinum catalyst had been removed. Examples 17, 19, 22, 26, 27, 41, 43, 45, 47, 49 and 51-54 were equally effective in the above test.

35

Example 74

The product from Example 40 (0.12 g) was added to a sample (2 ml) of a deep yellow solution of tetra(triphenylphosphine) palladium(0) (0.02 g) in THF (25 ml). The mixture was stirred for 10 min

at room temperature and then filtered. Analysis of the filtrate showed that the palladium had been removed. Examples 17, 19, 22, 26, 27, 41, 43, 45, 47, 49 and 51-54 were equally effective in the above test.

5 **Example 75**

The product from Example 13 (0.12 g) was added to a sample (2 ml) of an aqueous solution of silver (I) nitrate (0.1 M) in water. The mixture was stirred for 10 min at room temperature and then filtered. Analysis of the filtrate showed that silver ions had been removed. Examples 17, 19, 22, 26, 27, 41, 43, 45, 47, 49 and 51-54 were equally effective in the above test.

10

Example 76

The product from Example 40 (0.12 g) was added to a sample (2 ml) of a solution of rhodium (III) chloride (0.02 g) in water (25 ml). The mixture was stirred for 1 h at room temperature and then filtered. Analysis of the filtrate showed that the rhodium catalyst had been removed. Examples 17, 15 19, 22, 26, 27, 41, 43, 45, 47, 49 and 51-54 were equally effective in the above test.

Example 77

The product from Example 17 (0.12 g) was added to a sample (2 ml) of a solution of cupric (II) chloride (1000 ppm) in THF. The mixture was stirred for 1 h at room temperature and then filtered. 20 Analysis of the filtrate showed that cupric chloride had been removed.

Example 78

The product from Example 40 (0.12 g) was added to a sample (2 ml) of a solution of ferric (III) chloride (1000 ppm) in water. The mixture was stirred for 1 h at room temperature and then filtered. 25 Analysis of the filtrate showed that ferric chloride had been removed.

Example 79

A mixture of anisole (0.035 g, 0.33 mmol) as a marker, benzylamine (0.041 g, .038 mmol) and the product from Example 12 (0.65 g, 1.2 mmol) was stirred in CDCl_3 (2.5 cm^3) at room temperature for 30 1 h. The mixture was then centrifuged and a ^1H NMR spectrum of the chloroform solution showed that the benzylamine was completely removed.

A mixture of anisole (0.02860 g, 0.26 mmol), hexylamine (0.02504 g, 0.25 mmol) and the product from Example 16 (0.5 g, 1.0 mmol) was stirred in CDCl_3 (2.5 cm^3) at room temperature for 1 h. The mixture was then centrifuged and a ^1H NMR spectrum of the chloroform solution showed that the 35 hexylamine was completely removed.

Example 80

A mixture of anisole (0.031 g, 0.28 mmol), ethyl chloroformate (0.027 g, 0.25 mmol) and the product from Example 17 (0.59 g, 1.11 mmol) was stirred in CDCl_3 (2.5 cm^3) at room temperature for 1.5 h. The mixture was then centrifuged and a ^1H NMR spectrum of the chloroform solution showed that 5 the ethyl chloroformate was completely removed.

Example 81

A mixture of anisole (0.031 g, 0.29 mmol), benzaldehyde (0.031 g, 0.3 mmol) and the product from Example 18 (0.47 g, 1.19 mmol) was stirred in CDCl_3 (2.5 cm^3) for 1.5 h. The mixture was then 10 centrifuged and a ^1H NMR spectrum of the solution showed that the benzaldehyde was completely removed.

Example 82

A mixture of dimethoxyethane (0.03304 g, 0.37 mmol), benzoyl chloride (0.046 g, 0.33 mmol) and 15 the product from Example 17 (0.52, 1.3 mmol) was stirred in CDCl_3 (2.5 cm^3) at room temperature for 1.5 h. The mixture was then centrifuged and a ^1H NMR spectrum of the chloroform solution showed that the benzoyl chloride was completely removed.

Example 82

20 A mixture of dimethoxyethane (0.022 g, 0.25 mmol), phenyl isocyanate (0.029 g, 0.24 mmol) and the product from Example 17 (0.45 g, 0.97 mmol) was stirred in CDCl_3 (2.5 cm^3) at room temperature for 1.5 h. The mixture was then centrifuged and a ^1H NMR spectrum of the chloroform solution showed that the phenyl isocyanate was completely removed.

Example 83

A mixture containing *para* toluenesulfonic acid (0.0265 g, 0.14 mmol) and the product from Example 19 (0.44 g, 0.11 mmol) in ether (10 ml) was stirred at room temperature for 1 h and then filtered. The filtrate was concentrated and the residue weighted. Greater than 95% of the *para* toluenesulfonic acid was removed.

Example 84

A mixture containing *para* toluenesulfonic acid (0.019 g, 0.1 mmol) and the product from Example 27 (0.54 g, 0.10 mmol) in ether (10 ml) was stirred at room temperature for 1 h and then filtered. The filtrate was concentrated and the residue weighted. Greater than 95% of the *para* toluenesulfonic acid was removed.

35

Example 85

A mixture of acetophenone (6 g, 50 mmol), ethylene glycol (6 ml) and the product from Example 55 or 66 or 68 (0.2 g) in toluene (40 ml) was refluxed under a Dean and Stark condenser for 4h. The reaction mixture was cooled, filtered and washed with water (3 x 50 ml) and then dried over magnesium sulphate. On concentration 1-methyl-1-phenyl 1,3 dioxolane was obtained in 95% yield.

5 M.p. 61°C; lit. 61-62°C

Example 86

A mixture of 1-phenyl-1-propanol (2 mmol) and the product from Example 55 or 66 or 68 (30 mg) in toluene (2ml) was stirred and heated at 75°C for 10 h under nitrogen. Ether (20 ml) was added and 10 the mixture was filtered to remove the catalyst. The organic washings were concentrated under reduced pressure at room temperature to afford β - methyl styrene as a colourless oil (95%).

Example 87

A mixture containing the product from Example 55 or 66 or 68 (0.05 g) and oleic acid (1.41 g, 15 5mmol) and ethanol (10 ml) was refluxed with stirring for 4 h. On cooling ether (30 ml) was added and the catalyst was filtered off. The organic washings were combined and concentrated to give ethyl oleate (90% yield).

Example 88

20 The product from Example 26 (0.12 g) was added to a sample (2 ml) of a deep yellow solution of bis(triphenylphosphine)-dicarbonyl nickel(0) (0.02 g) in THF (25 ml). The mixture was stirred for 10 min at room temperature and then filtered. Analysis of the filtrate showed that the nickel had been removed. Examples 13, 27, 40, 41, 43, 47, 49 and 51-54 were equally effective in the above test.

25 **Example 89**

A mixture of the palladium catalyst formed in Example 34 (50 mg), 4-bromotoluene (1.6 mmol), phenyl boronic acid (1.6 mmol) and potassium carbonate (2.4 mmol) in xylene (10 ml) was warmed at 110°C with stirring for 1 hour. The mixture was filtered and the solid washed with ether. The combined organic extracts were washed with water, dried and then concentrated to give 4-methyl biphenyl in 99% yield.

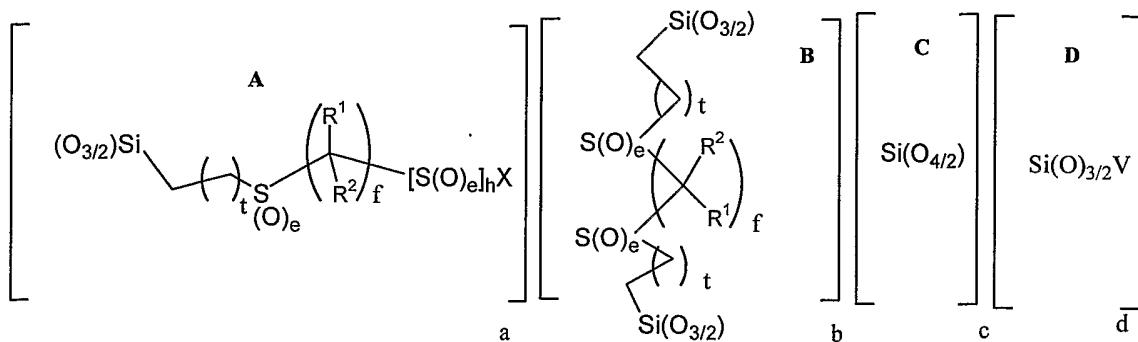
The filtered solid was returned to the reaction flask and further 4-bromotoluene (1.6 mmol), phenyl boronic acid (1.6 mmol) and potassium carbonate (2.4 mmol) in xylene (10 ml) was added and the process repeated to give 4-methyl biphenyl in 99% yield.

30 The above was repeated with 4-bromo anisole, 4-iodo chlorobenzene or 4-bromobenzene in place of 4-bromotoluene. The yield of the corresponding biphenyl product was greater than 95% in each case.

CLAIMS

1. A compound of Formula 1:

Formula 1



5 wherein X is selected from R^1 , a group $-\text{[CO}_2(\text{CH}_2)_n\text{CO}_2\text{-}$ linking two moieties A^1 , A^1 being moiety A without X and n being 2 to 4, $\text{C}(\text{=W})\text{R}$, $(\text{CR}^3\text{Z})_i\text{CHR}^3\text{Z}$, OH , $\text{O}(\text{M}^{+g})_{1/g}$ and $\text{OC}(\text{=W})\text{R}$ where W is selected from oxygen, sulfur, NR^4 and NNR^4R^5 , Z is selected from OR^6 , NR^6R^7 and SR^6 , R is selected from R^6 , OR^6 , $\text{O}(\text{M}^{+g})_{1/g}$, NR^6R^7 , NHNR^6R^7 and SR^6 and $R^1, R^2, R^3, R^4, R^5, R^6$ and R^7 are each selected from hydrogen, an optionally substituted linear or branched C_{1-40} -alkyl, C_{2-40} -alkenyl, 10 C_{2-40} -alkynyl group, an aryl and C_{1-40} -alkylaryl group; M is a metal ion derived from a lanthanide, actinide, main group or transition metal and V is an optionally substituted C_{1-40} -alkyl, C_{2-40} -alkenyl or C_{2-40} -alkynyl group or an aryl group and C_{1-40} -alkylaryl sulfide, sulfoxide, sulfone, amine or a polyalkyl amine or phosphine or other phosphorous containing group; e is an integer from 0 to 2; f is an integer from 0 to 100, g is an integer from 1 to 4, i is an integer from 0 to 6, t is an integer from 1 to 20; and h is 0 or 1:

the free valences of the silicate oxygen atoms are saturated by one or more of:

silicon atoms of other groups of Formula 1, hydrogen, a linear or branched C_{1-12} -alkyl group or by end groups $\text{R}^8\text{M}^1\text{O}_{1/2}$ or by cross-linking bridge members or by chains $\text{R}^8\text{qM}^1(\text{OR}^9)_m\text{O}_{k/2}$ or $\text{Al}(\text{OR}^9)_{3-p}\text{O}_{p/2}$ or $\text{R}^8\text{Al}(\text{OR}^9)_{2-r}\text{O}_{r/2}$; where M^1 is Si or Ti;

20 R^9 is a linear or branched C_{1-40} alkyl group an aryl or C_{1-40} -alkylaryl group; and R^8 is a linear or branched C_{1-40} -alkyl group or an aryl or C_{1-40} -alkylaryl group;

k is an integer from 1 to 3 and q is an integer from 1 to 2 and m is an integer from 0 to 2;

such that $\text{m} + \text{k} + \text{q} = 4$;

p is an integer from 1 to 3; and r is an integer from 1 to 2;

25 or other known oxo metal bridging systems where the metal is zirconium, boron, magnesium, iron, nickel or a lanthanide;

a, b, c and d are integers such that i) when b is 0 the ratio of a:c varies from 0.00001 to 100,000 and in the formula $\text{A}_a\text{B}_b\text{C}_c\text{D}_d$ both A and C are always present, and ii) when b is 1 or more the ratio of a:b varies from 0.00001 to 100,000 and in the formula $\text{A}_a\text{B}_b\text{C}_c\text{D}_d$ both A and B are always present.

2. A compound as claimed in claim 1 which includes an end group and/or cross linking bridge member and/or polymer chain and wherein the ratio of an end group and/or cross linker and/or polymer chain to a+b+c+d varies from 0 to 999:1.

5 3. A compound as claimed in claim 1 or claim 2 that includes an end group derived from a trialkyl or triaryl alkoxy silane or a cross linking bridge member derived from an orthosilicate, a titanium alkoxide or an aluminium trialkoxide or a polymer chain derived from a mono alkyl or mono aryl trialkoxysilane or a di alkyl or di aryl dialkoxy silane.

10 4. A compound as claimed in claim 3 wherein the one or more end groups or cross linking bridges or polymer chains are selected from R^8_2SiO $R^9O_{1/2}$, $R^8_3SiO_{1/2}$ or $R^8_2SiO_{2/2}$ or $TiO_{4/2}$ or $R^8TiO_{3/2}$ or $R^8_2TiO_{2/2}$ or $AlO_{3/2}$ or $R^8AlO_{2/2}$, wherein R^8 and R^9 are as defined in claim 1.

15 5. A compound as claimed in claim 4 wherein R^8 is independently selected from linear or branched C_{1-22} -alkyl, aryl and a C_{1-22} -alkylaryl group.

6. A compound as claimed in claim 5 wherein R^8 is C_{1-6} -alkyl, C_{2-12} -alkenyl or aryl.

20 7. A compound as claimed in claims 1 to 6 comprising a metal complex $M(L)_j$ where M is derived from a lanthanide, actinide, main group or transition metal with oxidation states ranging from zero to four and L is one or more optionally substituted ligands selected from halide, nitrate, acetate, carboxylate, cyanide, sulfate, carbonyl, imine, alkoxy, triaryl or trialkylphosphine and phenoxy and j is an integer from 0 to 8 and where the compound of Formula 1 is linked to the said metal complex .

25 8. A compound as claimed in claims 1 to 7 comprising a metal complex $M(L)_j$ where M is derived from cobalt, manganese, iron, nickel, palladium, platinum, rhodium, with oxidation states ranging from zero to four and L is one or more optionally substituted ligands selected from halide, nitrate, acetate, carboxylate, cyanide, sulfate, carbonyl, imine, alkoxy, triaryl or trialkylphosphine and phenoxy and j is an integer from 0 to 4 and where the compound of Formula 1 is linked to the said metal complex .

30 9. A compound as claimed in any one of claims 1 to 8 wherein X is selected from R^1 , $C(=W)R$ or $(CR^3Z)_iCHR^3Z$ or OH or $O(M^{+g})_{1/g}$ where W is oxygen, Z is OR^6 , SR^6 or NR^6R^7 and R is R^6 , OR^6 , $O(M^{+g})_{1/g}$, NR^6R^7 , $NHNR^6R^7$ or SR^6 and R^1 , R^2 , R^3 , R^4 , R^5 , R^6 and R^7 are each hydrogen, an optionally substituted linear or branched C_{1-20} -alkyl, C_{2-20} -alkenyl or C_{2-20} -alkynyl group, an aryl or C_{1-20} -alkylaryl group, M is a metal ion derived from a lanthanide, actinide, main group or transition metal and V is an optionally substituted C_{1-20} -alkyl, C_{2-20} -alkenyl or C_{2-20} -alkynyl group or an aryl

group or C_{1-20} -alkylaryl sulfide, sulfoxide, sulfone, amine or a polyalkyl amine or phosphine or other phosphorous containing group, and e is an integer from 0 to 2; f is an integer from 1 to 20, g is an integer from 1 to 4, i is an integer from 0 to 6 and h is 0 to 1.

5 10 A compound as claimed in claim 9 wherein X is selected from R^1 , $C(=W)R$ or $(CR^3Z)_iCHR^3Z$ or OH where W is oxygen, Z is OR^6 , SR^6 or NR^6R^7 , and R is R^6 , OR^6 , $O(M^{+g})_{1/g}$, NR^6R^7 , $NHNR^6R^7$ or SR^6 and R^1 , R^2 , R^3 , R^4 , R^5 , R^6 and R^7 are each hydrogen, an optionally substituted linear or branched C_{1-12} -alkyl, C_{2-6} -alkenyl or C_{2-6} -alkynyl group, an aryl or C_{1-12} -alkylaryl group, M is a metal ion derived from a lanthanide, main group or transition metal and V is an 10 optionally substituted C_{1-6} -alkyl, C_{2-6} -alkenyl or C_{2-6} -alkynyl group or an aryl group, and e is an integer from 0 to 2; f is an integer from 1 to 6, g is an integer from 1 to 4, i is an integer from 0 to 2 and h is 0 to 1.

15 11. A compound as claimed in claim 10 wherein X is selected from $C(=W)R$ or $(CR^3Z)_iCHR^3Z$ where W is oxygen, Z is OR^6 and R is OR^6 , $O(M^{+g})_{1/g}$, NR^6R^7 or SR^6 and R^1 , R^2 , R^3 , R^4 , R^5 , R^6 and R^7 are each hydrogen, an optionally substituted linear or branched C_{1-12} -alkyl, C_{2-6} -alkenyl or C_{2-6} -alkynyl group, an aryl or C_{1-12} -alkylaryl group, M is a metal ion derived from a lanthanide, main group or transition metal and V is an optionally substituted C_{1-6} -alkyl, C_{2-6} -alkenyl or C_{2-6} -alkynyl group or an aryl group, and f is an integer from 1 to 6, g is an integer from 1 to 4, i is an integer from 20 0 to 2 and e and h are 0.

25 12. A compound as claimed in claim 11 containing a metal complex $M(L)_j$ where M is derived from cobalt, manganese, nickel, palladium, platinum, rhodium, with oxidation states ranging from zero to four and L is one or more optionally substituted ligands such as halide, nitrate, acetate, carboxylate, cyanide, sulfate, carbonyl, imine, alkoxy, triaryl or trialkylphosphine and phenoxy and j is an integer from 0 to 4.

30 13. A compound as claimed in claim 9 wherein X is R^1 and R^1 are each hydrogen, an optionally substituted linear or branched C_{1-12} -alkyl, C_{2-6} -alkenyl or C_{2-6} -alkynyl group, an aryl or C_{1-12} -alkylaryl group, V is an optionally substituted C_{1-6} -alkyl, C_{2-6} -alkenyl or C_{2-6} -alkynyl group or an aryl group, and e is an integer from 0 to 2; f is an integer from 1 to 6 and h is 0 to 1.

35 14. A compound as claimed in claim 13 wherein X is an aryl group containing one or more sulfonic acid groups, V is an optionally substituted C_{1-6} -alkyl, C_{2-6} -alkenyl or C_{2-6} -alkynyl group or an aryl group, and e is an integer from 0 to 2; f is an integer from 1 to 6 and h is 0.

15. A compound as claimed in claims 9 to 14 wherein the free valences of the silicate oxygen atoms are saturated by one or more of silicon atoms of other groups of Formula 1, hydrogen, a linear or branched C₁₋₆ alkyl group or by end groups R⁸₃SiO_{1/2} or by cross-linking bridge members or by polymer chains R⁸_qSiO_{k/2} where R⁸ is a linear or branched C₁₋₄ alkyl group; k is an integer from 2 to 3
5 and q is an integer from 1 to 2; such that k + q = 4; and a, b, c and d are integers such that i) when b is 0 the ratio of a:c varies from 0.00001 to 100,000 and in the formula A_aB_bC_cD_d both A and C are always present and ii) when b is 1 or more that the ratio of a:b varies from 0.00001 to 100,000 and in the formula A_aB_bC_cD_d both A and B are always present and the ratio of end groups and/or cross linkers and/or polymer chains to a+b+c+d varies from 0 to 999:1.

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16. A compound as claimed in claim 15 wherein a, b, c and d are integers such that i) when b is 0 the ratio of a:c varies from 0.01 to 100 and in the formula A_aB_bC_cD_d both A and C are always present and ii) when b is 1 or more that the ratio of a:b varies from 0.01 to 100 and in the formula A_aB_bC_cD_d both A and B are always present and the ratio of end groups and/or cross linkers and/or polymer chains to a+b+c+d varies from 0 to 99:1.

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17. A compound as claimed in claim 16 wherein a, b, c and d are integers such that i) when b is 0 the ratio of a:c is from 0.01 to 5 and in the formula A_aB_bC_cD_d both A and C are always present and ii) when b is 1 or more that the ratio of a:b is from 0.01 to 5 and in the formula A_aB_bC_cD_d both A and B are always present and the ratio of end groups and/or cross linkers and/or polymer chains to a+b+c+d is from 0 to 10:1.

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18. A process for treating a feedstock comprising contacting a compound as claimed in any one of claims 1 to 17 with a feed stream:

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i) to effect a chemical reaction by catalytic transformation of a component of the feed stream to produce a desired product;
ii) to remove a component of the feed stream from the stream; or
iii) to remove an ionic species in the feed stream in an ion exchange process.

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19. A process as claimed in claim 18 for conducting a carbon-carbon bond formation reaction, an oxidation, reduction, alkylation, polymerisation, hydroformylation, arylation, acylation, isomerisation, alkylation, carboxylation, carbonylation, esterification, trans-esterification or rearrangement reaction.

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20. Use of a compound as claimed in any one of claims 1 to 17 as a scavenger for the removal of or reducing the level of an unwanted organic or inorganic compound from a liquid substrate.

21. Use as claimed in claim 20 in which the unwanted compound is removed from a reaction mixture, waste stream or waste water or bound or attached to other organic compounds.
22. Use of a compound as claimed in any one of claims 1 to 17 as a scavenger for the removal of or 5 reducing the level of platinum, palladium, rhodium, rhenium or nickel metal or ions from reaction mixtures, waste streams or waste waters or bound or attached to other organic compounds.
23. Use of a compound as claimed in any one of claims 1 to 17 as an acid catalyst.
- 10 24. Use of a compound as claimed in any one of claims 1 to 17 as a heterogeneous catalyst for an oxidation, reduction, a carbon-carbon bond formation reaction, alkylation, polymerisation, hydroformylation, arylation, acylation, isomerisation, carboxylation, carbonylation, esterification, trans-esterification or rearrangement reaction.
- 15 25. Use of a compound as claimed in any one of claims 1 to 17 as a cation or anion exchanger.
26. Use of a compound as claimed in any one of claims 1 to 17 for the immobilisation of a biological molecule such as enzymes, peptides, proteins and nucleic acids.
- 20 27. An anti-microbial composition comprising a compound as claimed in any one of claims 1 to 17 and a carrier.
28. Use of a compound as claimed in any one of claims 1 to 17 and a composition as claimed in claim 27 as an anti-microbial agent.
- 25 29. Use of a compound as claimed in any one of claims 1 to 17 as a hydrophilicity modifier, a flameproofing agent, an antistatic agent, a coating for biomedical devices, a water repellent film and as a coating.
- 30 30. Use of a compound as claimed in any one of claims 1 to 17 for solid phase synthesis or for solid phase extraction and purification.
31. Use of a compound as claimed in any one of claims 1 to 17 as a heterogeneous catalyst support
- 35 32. Use of a compound as claimed in any one of claims 1 to 17 for the separation or purification of organic, biological or inorganic molecules from gaseous, liquid and solid environments.

33. Use of a compound as claimed in any one of claims 1 to 17 for chiral separation.
34. Use of a compound as claimed in any one of claims 1 to 17 as a gel filtration, size-exclusion or chromatography medium.
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35. Use as claimed in claim 34 for the purification and/or identification of an organic or biological compound.

INTERNATIONAL SEARCH REPORT

PCT/EP2005/008189

A. CLASSIFICATION OF SUBJECT MATTER		
C08G77/28 C08G77/50 A61K9/14		
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) C08G A61K		
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, WPI Data, PAJ		
C. DOCUMENTS CONSIDERED TO BE RELEVANT		
Category °	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 2003/199619 A1 (CRUSE RICHARD W) 23 October 2003 (2003-10-23) example 8	1-6, 9-11, 13-19, 27
A	US 5 739 238 A (PETTY ET AL) 14 April 1998 (1998-04-14) examples 1-19	1-35
A	US 2003/055139 A1 (CRUSE RICHARD W) 20 March 2003 (2003-03-20) paragraph '0105!; example 1	1-35
<input type="checkbox"/> Further documents are listed in the continuation of box C.		<input checked="" type="checkbox"/> Patent family members are listed in annex
<p>° Special categories of cited documents</p> <p>*A* document defining the general state of the art which is not considered to be of particular relevance</p> <p>*E* earlier document but published on or after the international filing date</p> <p>*L* document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</p> <p>*O* document referring to an oral disclosure, use, exhibition or other means</p> <p>*P* document published prior to the international filing date but later than the priority date claimed</p> <p>*T* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</p> <p>*X* document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone</p> <p>*Y* document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.</p> <p>*&* document member of the same patent family</p>		
Date of the actual completion of the international search		Date of mailing of the international search report
11 January 2006		20/01/2006
Name and mailing address of the ISA European Patent Office, P B 5818 Patentlaan 2 NL - 2280 HV Rijswijk Tel (+31-70) 340-2040, Tx 31 651 epo nl, Fax: (+31-70) 340-3016		Authorized officer Kolitz, R

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