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- (54) Benævnelse: **FREMGANGSMÅDE TIL FREMSTILLING AF 2,2-DIFLUORETHYLAMIN-DERIVATER VED HJÆLP AF ALKYLERING AF 2,2-DIFLUORETHYLAMIN**
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**WO-A1-2007/115644**



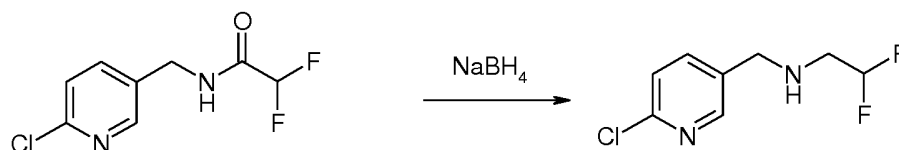
### Description

The present invention relates to a method (process) for preparing certain 2,2-difluoroethylamine derivatives starting from 2,2-difluoroethylamine.

2,2-Difluoroethylamine derivatives are useful intermediates for preparing active agrochemical ingredients (see WO 2007/115644). Various methods for preparing 2,2-difluoroethylamine derivatives known.

WO 2009/036900, for example, describes a method for preparing 2,2-difluoroethylamine derivatives by amide hydrogenation of N-[(6-chloropyridin-3-yl)methyl]-2,2-difluoroacetamide (scheme 1).

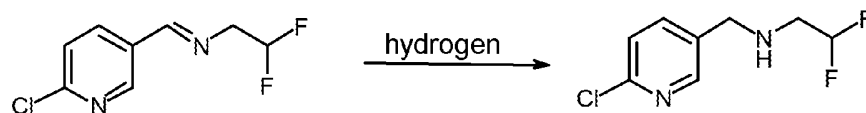
#### Scheme 1:



This method is unfavourable due to the use of complex hydrides such as sodium borohydride, since hydrides are expensive to use and raise safety concerns.

WO 2009/036901 describes the reduction of N-(6-chloropyridin-3-yl)methylene-2,2-difluoroethanamine by hydrogen (scheme 2).

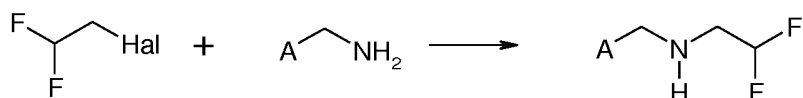
#### Scheme 2:



This method is unfavourable due to the use of hydrogen, since the use of hydrogen raises considerable safety concerns here to.

WO 2011/157650 describes the preparation of 2,2-difluoroethanamine derivatives starting from 2,2-difluoro-1-haloethanes with primary amines in the presence of organic  
 5 bases (scheme 3).

Scheme 3:



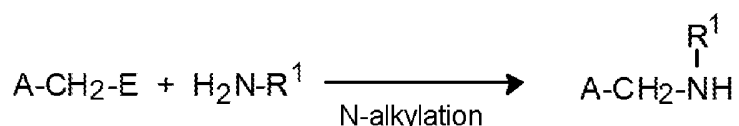
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The disadvantage of this method is that the reaction must be carried out in a high-pressure apparatus (autoclave).

The patent publication WO 2007/115644, which is concerned with  
 15 the preparation of insecticidally active 4-aminobut-2-enolide compounds, describes the preparation of compounds of the general formula  $\text{A}-\text{CH}_2-\text{NH}-\text{R}^1$ , in which A represents specific heterocycles and  $\text{R}^1$  is haloalkyl, by alkylation of the nitrogen (scheme 4).

20

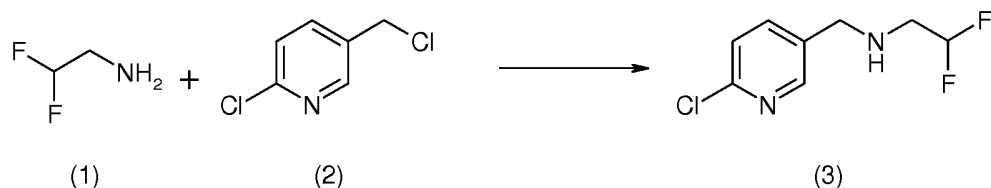
Scheme 4:



E = Hal, e.g. chlorine, bromine, iodine; O-tosyl, O-mesyl,

25 WO2007/115644 specifically describes the preparation of N-[(6-chloropyridin-3-yl)methyl]-2,2-difluoroethan-1-amine (compound (3), which is synthesized starting from 2-chloro-5-chloromethylpyridine (compound (2)) and 2,2-difluoroethan-1-amine (compound 1)) in the presence of triethylamine (see  
 30 scheme 5)). In this case, the compounds (1), (2) and triethylamine are used in equimolar amounts. The desired product is obtained in a yield of 53%.

Scheme 5:



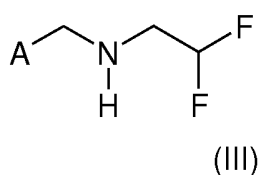
- 5 The method described in WO 2007/116544 for preparing compounds of the formula  $\text{A-CH}_2\text{-NH-R}^1$ , in which A represents specific heterocycles and  $\text{R}^1$  is haloalkyl, is disadvantageous since polyalkylation of the nitrogen can occur during the reaction. This leads to a loss of yield, which can be seen also in the
- 10 yield of the specifically cited example. The yield was only 53%. These polyalkylations can only be reduced by the use of a large excess of amine. The distillative recovery of the costly amine, however, is generally laborious and not without loss.
- 15 Due to the significance of 2,2-difluoroethylamine derivatives as building blocks for synthesizing active agrochemical ingredients, it is, however, necessary to find a method which can be used economically on an industrial scale. It is also desirable to obtain the specific 2,2-difluoroethylamine
- 20 derivatives with high yield and high purity, such that the target compound preferably does not have to be subjected to any further potentially complex purification.

A method has now been found for preparing certain 2,2-difluoroethylamine derivatives which avoids the disadvantages of the known methods and moreover is simple and economic to

25 carry out, such that it can be used industrially.

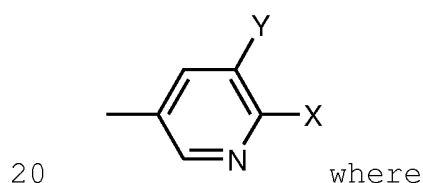
The present invention therefore relates to a method for

30 preparing certain 2,2-difluoroethylamine derivatives of the general formula (III)



where

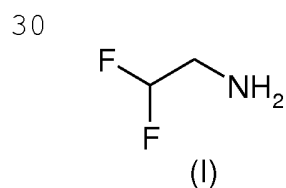
A is a pyrid-2-yl, pyrid-4-yl or pyrid-3-yl radical which  
 5 may respectively be substituted in the 6-position by fluorine,  
 chlorine, bromine, methyl, trifluoromethyl or trifluoromethoxy  
 or is pyridazin-3-yl which may be substituted in the 6-  
 position by chlorine or methyl, or is a pyrazin-3-yl, 2-  
 chloropyrazin-5-yl or 1,3-thiazol-5-yl radical which may  
 10 respectively be substituted in the 2-position by chlorine or  
 methyl, or is a pyrimidinyl, pyrazolyl, thiophenyl, oxazolyl,  
 isoxazolyl, 1,2,4-oxadiazolyl, isothiazolyl, 1,2,4-triazolyl  
 or 1,2,5-thiadiazolyl radical which may be substituted by  
 fluorine, chlorine, bromine, cyano, nitro, C<sub>1</sub>-C<sub>4</sub>-alkyl  
 15 optionally substituted by fluorine and/or chlorine, C<sub>1</sub>-C<sub>3</sub>-  
 alkylthio optionally substituted by fluorine and/or chlorine,  
 C<sub>1</sub>-C<sub>3</sub>-alkylsulphonyl optionally substituted by fluorine and/or  
 chlorine, or is a pyrid-3-yl of the following formula



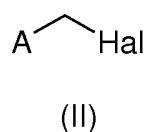
X is halogen, C<sub>1</sub>-C<sub>12</sub>-alkyl (preferably C<sub>1</sub>-C<sub>6</sub>-alkyl) or C<sub>1</sub>-C<sub>12</sub>-  
 haloalkyl (preferably C<sub>1</sub>-C<sub>6</sub>-haloalkyl) and

25 Y is halogen, C<sub>1</sub>-C<sub>12</sub>-alkyl (preferably C<sub>1</sub>-C<sub>6</sub>-alkyl), C<sub>1</sub>-C<sub>12</sub>-  
 haloalkyl (preferably C<sub>1</sub>-C<sub>6</sub>-haloalkyl), C<sub>1</sub>-C<sub>12</sub>-haloalkoxy  
 (preferably C<sub>1</sub>-C<sub>6</sub>-haloalkoxy), azido or cyano,

in which 2,2-difluoroethylamine of the formula (I)



is reacted with a halide of the general formula (II)

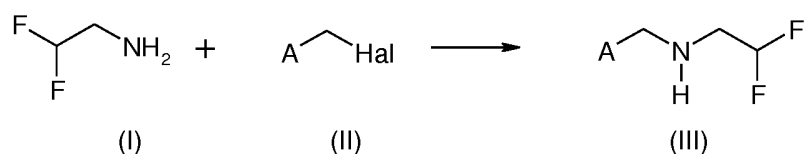


where Hal is Cl, Br or I,

in the presence of diisopropylethylamine.

The reaction according to the invention is shown in scheme 6.

Scheme 6:



The desired 2,2-difluoroethylamine derivatives of the general formula (III) are obtained in good yields and with high purity by the method according to the invention. The desired compounds are obtained in a purity which generally does not require an extensive work-up of the reaction product.

With the method according to the invention, significantly better yields can be achieved than with the method described in WO2007/115644, in which triethylamine is used as tertiary nitrogen base.

In the scope of the present invention, a derivative refers to a structure similar to a substance derived from the organic base skeleton (building block) indicated, i.e. a 2,2-difluoroethylamine derivative is understood to mean in particular a compound which comprises a 2,2-difluoroethylamine building block.

Preferably, a compound of the general formula (II) in which Hal is chlorine and bromine is used. Particular preference is given to the compound of the formula (II) in which Hal is

chlorine.

Furthermore, compounds of the formula (II) which are preferably used in the method according to the invention are those in which the radical A is selected from a group consisting of 6-fluoropyrid-3-yl, 6-chloropyrid-3-yl, 6-bromopyrid-3-yl, 6-methylpyrid-3-yl, 6-trifluoromethylpyrid-3-yl, 6-trifluoromethoxypyrid-3-yl, 6-chloro-1,4-pyridazin-3-yl, 6-methyl-1,4-pyridazin-3-yl, 2-chloro-1,3-thiazol-5-yl or 2-methyl-1,3-thiazol-5-yl, 2-chloropyrimidin-5-yl, 2-trifluoromethylpyrimidin-5-yl, 5,6-difluoropyrid-3-yl, 5-chloro-6-fluoropyrid-3-yl, 5-bromo-6-fluoropyrid-3-yl, 5-iodo-6-fluoropyrid-3-yl, 5-fluoro-6-chloropyrid-3-yl, 5,6-dichloropyrid-3-yl, 5-bromo-6-chloropyrid-3-yl, 5-iodo-6-chloropyrid-3-yl, 5-fluoro-6-bromopyrid-3-yl, 5-chloro-6-bromopyrid-3-yl, 5,6-dibromopyrid-3-yl, 5-fluoro-6-iodopyrid-3-yl, 5-chloro-6-iodopyrid-3-yl, 5-bromo-6-iodopyrid-3-yl, 5-methyl-6-fluoropyrid-3-yl, 5-methyl-6-chloropyrid-3-yl, 5-methyl-6-bromopyrid-3-yl, 5-methyl-6-iodopyrid-3-yl, 5-difluoromethyl-6-fluoropyrid-3-yl, 5-difluoromethyl-6-chloropyrid-3-yl, 5-difluoromethyl-6-bromopyrid-3-yl and 5-difluoromethyl-6-iodopyrid-3-yl.

Preferred radicals A are 6-fluoropyrid-3-yl, 6-chloropyrid-3-yl, 6-bromopyrid-3-yl, 6-chloro-1,4-pyridazin-3-yl, 2-chloro-1,3-thiazol-5-yl, 2-chloropyrimidin-5-yl, 5-fluoro-6-chloropyrid-3-yl, 5,6-dichloropyrid-3-yl, 5-bromo-6-chloropyrid-3-yl, 5-fluoro-6-bromopyrid-3-yl, 5-chloro-6-bromopyrid-3-yl, 5,6-dibromopyrid-3-yl, 5-methyl-6-chloropyrid-3-yl, 5-chloro-6-iodopyrid-3-yl and 5-difluoromethyl-6-chloropyrid-3-yl.

Particularly preferred radicals A are 6-chloropyrid-3-yl, 6-bromopyrid-3-yl, 6-chloro-1,4-pyridazin-3-yl, 2-chloro-1,3-thiazol-5-yl, 5-fluoro-6-chloropyrid-3-yl and 5-fluoro-6-bromopyrid-3-yl.

2-Chloro-(5-chloromethyl)pyridine is preferably used as the



compound of the formula (II), such that N-[(6-chloropyridin-3-yl)methyl]-2,2-difluoroethan-1-amine is obtained.

5 The method according to the invention is carried out in the presence of the tertiary nitrogen base diisopropylethylamine.

The method is carried out in the presence of a tertiary nitrogen base (i.e. one or more tertiary nitrogen bases). Suitable tertiary amines here are diisopropylethylamine, 10 tricyclohexylamine or C<sub>1</sub>-C<sub>12</sub>-alkylimidazoles (e.g. methylimidazole and butylimidazole), and diisopropylethylamine is used according to the invention. The use of the base in the reaction according to the invention has the advantage that the reaction solution remains homogeneous after the conversion is 15 carried out and that the unused 2,2-difluoroethylamine (I) can thus be readily and virtually completely distilled off and fed again into the method. The method therefore can be carried out in a particularly resource-sparing and economic manner.

20 Use of diisopropylethylamine as tertiary nitrogen base allows very much higher yields to be achieved than with other tertiary amines. This is also apparent from the examples.

Use of C<sub>1</sub>-C<sub>12</sub>-alkylimidazoles as tertiary nitrogen base 25 likewise allows higher yields to be achieved than use of triethylamine (WO-A-2007/115644). Accordingly, this alternative method variant is also a subject of the invention.

The molar ratio of the tertiary nitrogen base 30 (diisopropylethylamine) to the halide of the formula (II) used can be, for example, in the range from approximately 10 to approximately 0.5. The ratio is preferably in the range from approximately 8 to approximately 1, particularly preferably in the range from approximately 6 to approximately 1.1. The use 35 of larger amounts of tertiary nitrogen base is possible in principle but uneconomical.

In the method according to the invention, 2,2-difluoroamine is

used in excess. The molar ratio of halide of the general formula (II) to the 2,2-difluoroethylamine used is generally in the range from approximately 1: 1.5 to approximately 1 : 20. The ratio is preferably in the range from approximately 1: 2 to approximately 1 : 10, particularly preferably from approximately 1 : 2.5 to approximately 1 : 5.

Since the reactants are liquid, the method according to the invention can be carried out without an additional solvent for the reaction. The reaction can of course also be carried out in the presence of a solvent.

The reaction according to the invention can be carried out in a wide temperature range (e.g. in the range from 20°C to 100°C). The reaction is preferably carried out in a temperature range from 35° to 60°C.

The reaction is generally carried out at atmospheric pressure.

The reaction time of the reaction is short and is in the range from approximately 0.5 to approximately 5 hours. A longer reaction time is possible, but is not economically worthwhile.

For the work-up of the reaction mixture, the excesses of 2,2-difluoroethylamine used and of the tertiary nitrogen base (diisopropylethylamine) are removed by distillation and are available for a further reaction, i.e. they can be used for the next batch. After the distillation, the reaction mixture is normally dissolved with an inert solvent such as toluene or butyronitrile and admixed with water. After adjusting the pH of the solution to 5.5-6, the phases are separated. The 2,2-difluoroethylamine derivative of the formula (III) can subsequently be isolated at atmospheric pressure or under reduced pressure, preferably by distillation. Alternatively, the organic phase, in which the desired amine of the formula (III) is present, can be used directly for a further reaction.

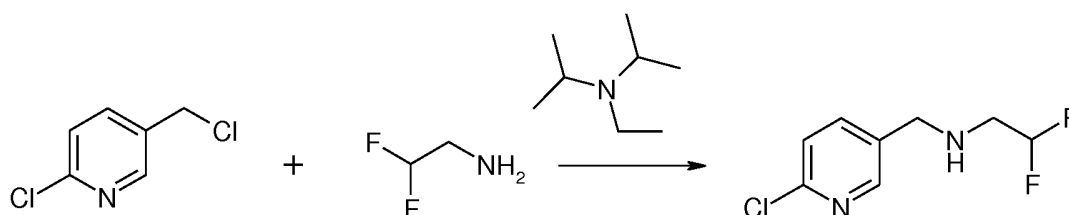
The tertiary amine, i.e. the tertiary nitrogen base

(diisopropylethylamine), can be liberated from its salts via its hydrochloride by reaction with an inorganic base, and be used again. An inorganic base is, for example, NaOH.

5 **Examples:**

The present invention is illustrated in more detail by the examples below, without limiting the invention thereto.

10 **Example 1 (inventive)**



74.4 g (0.90 mol) of 2,2-difluoroethylamine (content: 98%) and  
15 62.6 g (0.48 mol) of N, N-diisopropylethylamine (content: 99%)  
are heated to 55°C. To this mixture are added dropwise 49.5 g  
(0.30 mol) of 2-chloro-(5-chloromethyl)pyridine (content: 98%)  
over a period of 2.5 hours at this temperature. The yellow  
solution is allowed to stir for a further 2 hours at this  
20 temperature and subsequently 72.6 g of a mixture of 2,2-  
difluoroethylamine and N, N-diisopropylethylamine is distilled  
off.

According to GC methods using external standard, the recovery  
25 of excess 2,2-difluoroethylamine corresponds to 0.559 mol  
(95%) and the recovery of excess N, N-diisopropylethylamine  
corresponds to 0.17 mol (93%).

The residue is admixed with 237 g of toluene and 55 g of  
30 water, cooled to 20°C and adjusted to pH 6 with 32% strength  
aqueous sodium hydroxide solution. The lower aqueous phase is  
removed and the solvent from the organic phase is removed by  
distillation.

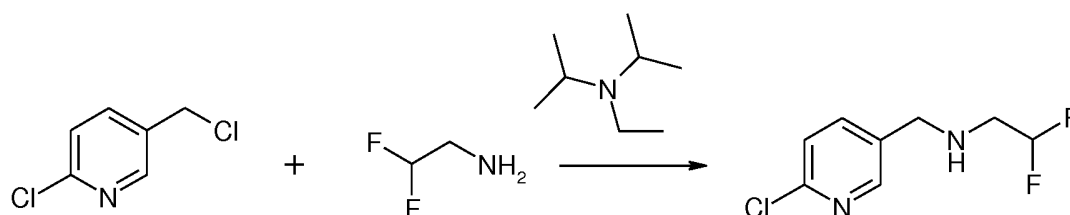
According to HPLC methods using external standard, a chemical yield of 90% of N-[(6-chloropyridin-3-yl)methyl]-2,2-difluoroethan-1-amine is obtained, based on 2-chloro-(5-chloromethyl)pyridine used.

5

NMR  $^1\text{H}$  (  $\text{CDCl}_3$  ) : 5.5 - 5.9 (m, 1H), 2.94 - 3.1 (m, 2 H), 1.26 (br m,  $\text{NH}_2$ ).

#### Example 2 (inventive)

10



74.4 g (0.90 mol) of 2,2-difluoroethylamine (content: 98%) and 62.6 g (0.48 mol) of N, N-diisopropylethylamine (content: 99%) are heated to 55°C. To this mixture are added dropwise 49.5 g (0.30 mol) of 2-chloro(5-chloromethyl)pyridine (content: 98%) over a period of 2.5 hours at this temperature. The yellow solution is allowed to stir for a further 2 hours at this temperature and subsequently 72.6 g of a mixture of 2,2-difluoroethylamine and N, N-diisopropylethylamine are distilled off.

According to GC methods using external standard, the recovery of excess 2,2-difluoroethylamine corresponds to 0.559 mol (93%) and the recovery of excess N, N-diisopropylethylamine corresponds to 0.17 mol (94%).

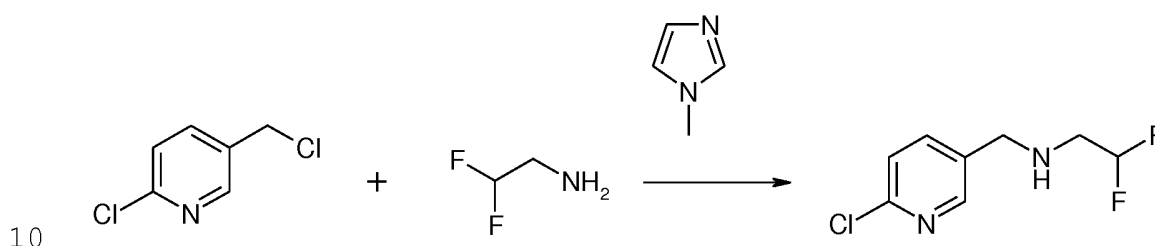
The residue is admixed with 218 g of toluene and 55 g of water, cooled to 20°C and adjusted to pH 6 with 32% strength aqueous sodium hydroxide solution. The lower aqueous phase is removed and the solvent from the organic phase is removed by distillation.

According to HPLC methods using external standard, a chemical

yield of 89% of N-[(6-chloropyridin-3-yl)methyl]-2,2-difluoroethan-1-amine is obtained, based on 2-chloro-(5-chloromethyl)pyridine used.

5 NMR  $^1\text{H}$  (  $\text{CDCl}_3$  ) : 5.5 - 5.9 (m, 1H), 2.94 - 3.1 (m, 2 H), 1.26 (br m,  $\text{NH}_2$ ).

Example 3 (alternative)



74.4 g (0.90 mol) of 2,2-difluoroethylamine (content: 98%) and 39.8 g (0.48 mol) of 1-methyl-1H-imidazole (content: 99%) are heated to 55°C. To this mixture are added dropwise 49.5 g  
15 (0.30 mol) of 2-chloro(5-chloromethyl)pyridine (content: 98%) over a period of 2.5 hours at this temperature. The yellow solution is allowed to stir for a further 2 hours at this temperature and subsequently 48.4 g of 2,2-difluoroethylamine are distilled off.

20 According to GC methods using external standard, the recovery of excess 2,2-difluoroethylamine corresponds to 95.6% of the excess used.

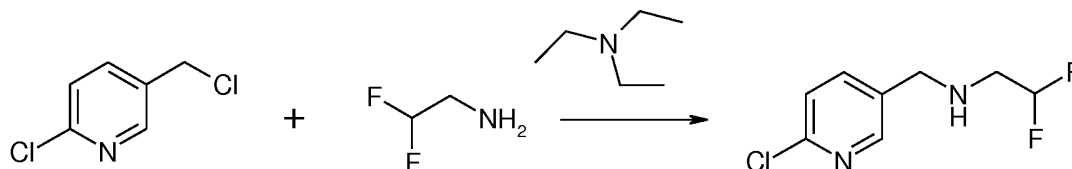
25 The residue is admixed with 217 g of butyronitrile and 55 g of water, cooled to 20°C and adjusted to pH 6 with 20% strength hydrochloric acid. The lower aqueous phase is removed and the solvent from the organic phase is removed by distillation.

30 According to HPLC methods using external standard, a chemical yield of 71% of N-[(6-chloropyridin-3-yl)methyl]-2,2-difluoroethan-1-amine is obtained, based on the 2-chloro-(5-chloromethyl)pyridine used.

NMR  $^1\text{H}$  (  $\text{CDCl}_3$  ) : 5.5 - 5.9 (m, 1H), 2.94 - 3.1 (m, 2 H), 1.26 (br m,  $\text{NH}_2$ ).

Example 4 (according to WO-A-2007/115644)

5



74.4 g (0.90 mol) of 2,2-difluoroethylamine (content: 98%) and 48.5 g (0.48 mol) of triethylamine (content: 99%) are heated to 55°C. To this mixture are added dropwise 49.5 g (0.30 mol) of 2-chloro(5-chloromethyl)pyridine (content: 98%) over a period of 2.5 hours at this temperature. The yellow solution is allowed to stir for a further 2 hours at this temperature and subsequently 74.0 g of a mixture of 2,2-difluoroethylamine and triethylamine are distilled off.

10

15

According to GC methods using external standard, the recovery of excess 2,2-difluoroethylamine corresponds to 0.50 mol (83%) and the recovery of excess triethylamine corresponds to 0.11 mol (60%).

20

The residue is admixed with 217 g of toluene and 55 g of water, cooled to 20°C and adjusted to pH 6 with 20% strength hydrochloric acid. The lower aqueous phase is removed and the solvent from the organic phase is removed by distillation.

25

According to HPLC methods using external standard, a chemical yield of 62% of N-[(6-chloropyridin-3-yl)methyl]-2,2-difluoroethan-1-amine is obtained, based on 2-chloro-(5-chloromethyl)pyridine used.

30

NMR  $^1\text{H}$  (  $\text{CDCl}_3$  ) : 5.5 - 5.9 (m, 1H), 2.94 - 3.1 (m, 2 H), 1.26 (br m,  $\text{NH}_2$ ).

35 Result:

Use of diisopropylethylamine as tertiary nitrogen base in the method according to the invention achieves very high yields of 90 % or 89% (examples 1 and 2).

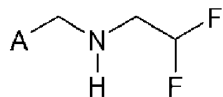
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In contrast, use of triethylamine as tertiary nitrogen base in the method according to the prior art (WO-A-2007/115644) achieves considerably lower yields of only 62% (example 4).

10 Use of C<sub>1</sub>-C<sub>12</sub>-alkylimidazoles as another tertiary nitrogen base achieves yields of 71% (example 3 using 1-methyl-1H-imidazole).

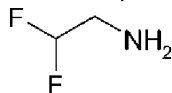
## Patentkrav

1. Fremgangsmåde til fremstilling af en 2,2-difluorethylamin med formel (III)



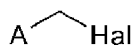
(III)

hvor 2,2-difluorethylamin med formel (I)



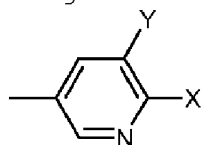
(I)

omsættes med et halogenid med formel (II)



(II)

hvor Hal står for chlor, brom eller iod, i nærvær af diisopropylethylamin, idet i formel (II) og (III) A står for en gruppe pyrid-2-yl, pyrid-4-yl eller pyrid-3-yl, som hver især i 6. position kan være substitueret med fluor, chlor, brom, methyl, trifluormethyl eller trifluormethoxy, eller for pyridazin-3-yl, som i 6. position kan være substitueret med chlor eller methyl, eller for en gruppe pyrazin-3-yl, 2-chlor-pyrazin-5-yl eller 1,3-thiazol-5-yl, som hver især i 2. position kan være substitueret med chlor eller methyl, eller for en gruppe pyrimidinyl, pyrazolyl, thiophenyl, oxazolyl, isoxazolyl, 1,2,4-oxadiazolyl, isothiazolyl, 1,2,4-triazolyl eller 1,2,5-thiadiazolyl, som kan være substitueret med fluor, chlor, brom, cyano, nitro, i givet fald med fluor og/eller chlor substitueret C<sub>1</sub>-C<sub>4</sub>-alkyl, i givet fald med fluor og/eller chlor substitueret C<sub>1</sub>-C<sub>3</sub>-alkylthio eller i givet fald med fluor og/eller chlor substitueret C<sub>1</sub>-C<sub>3</sub>-alkylsulfonyl, eller for en pyrid-3-yl med følgende formel



hvor

X står for fluor, chlor, brom, iod, C<sub>1</sub>-C<sub>6</sub>-alkyl eller C<sub>1</sub>-C<sub>6</sub>-halogenalkyl, og



Y står for fluor, chlor, brom, iod, C<sub>1</sub>-C<sub>6</sub>-alkyl, C<sub>1</sub>-C<sub>6</sub>-halogenalkyl, C<sub>1</sub>-C<sub>6</sub>-halogenalkoxy, azido eller cyano.

2. Fremgangsmåde ifølge krav 1, hvor det molære forhold  
5 mellem diisopropylethylamin og det anvendte halogenid med formel (II) ligger i området fra 10 til 0,5.

3. Fremgangsmåde ifølge krav 1 eller 2, hvor det molære forhold mellem halogenid med formel (II) og den anvendte 2,2-  
10 difluorethylamin ligger i området fra ca. 1 : 1,5 til ca. 1 : 20.

4. Fremgangsmåde ifølge et af kravene 1 til 3, hvor der efter afslutningen af fremgangsmåden fraskilles  
15 diisopropylethylamin og det i overskud eksisterende 2,2-difluorethylamin og igen tilsættes til fremgangsmåden.

5. Fremgangsmåde ifølge et af kravene 1 til 4, hvormed der fremstilles N-[(6-chlorpyridin-3-yl)methyl]-2,2-difluorethan-  
20 1-amin med formel (III), hvor 2-chlor-(5-chlormethyl)pyridin anvendes som halogenid med formel (II).