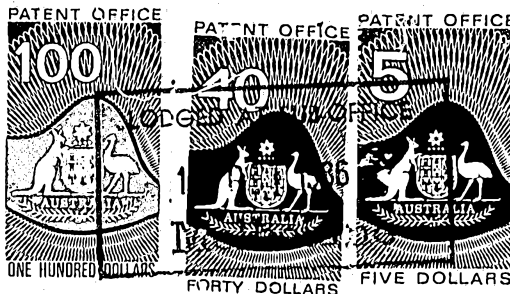


(CONVENTION. By one or more persons and/c

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CONVENTION APPLICATION FOR A PATENT

FEE STAMP TO VALUE OF
\$ 645 ATTACHED
MAIL OFFICER: *[Signature]*

(1) Here insert (in full) Name of Applicant or Applicants, followed by Address (es).

k (1) STUDIENGESELLSCHAFT KOHLE mbH,
We
of Kaiser-Wilhelm-Platz 1, D. 4330 Mulheim/Ruhr,
Federal Republic of Germany

(2) Here insert Title of Invention.

hereby apply for the grant of a Patent for an invention entitled: (2)
PROCESS FOR PREPARING HALOGEN MAGNESIUM ALANATE AND USE
THEREOF

(3) Here insert number(s) of basic application(s)

which is described in the accompanying complete specification. This application is a
Convention application and is based on the application numbered (3)
P35 36 797.0

(4) Here insert Name of basic Country or Countries, and basic date or dates

for a patent or similar protection made in (4) Federal Republic of Germany
on 16th October 1985

1. AMENDMENTS ACCEPTED AND AMENDMENTS

14 - 8 - 90

My
Our address for service is Messrs. Edwd. Waters & Sons, Patent Attorneys,
50 Queen Street, Melbourne, Victoria, Australia.

DATED this 14th day of October 19 86

(5) Signature (s) of Applicant (s) or Seal of Company and Signatures of its Officers as prescribed by its Articles of Association.

LOGGED AT SUB-OFFICE
15 OCT 1986
Melbourne

STUDIENGESELLSCHAFT KOHLE
MBH

[Signature]
Wayne McMaster

Registered Patent Attorney

To:

(12) PATENT ABRIDGMENT (11) Document No. AU-B-63936/86
(19) AUSTRALIAN PATENT OFFICE (10) Acceptance No. 603067

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PREPARATION OF HALOGEN MAGNESIUM ALANATE AND USE THEREOF
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- (74) Attorney or Agent
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3122
- (56) Prior Art Documents
EP 3564
- (57) Claim

1. A process for preparing halogen magnesium alanates XMgAlH_4 ($\text{X} = \text{Cl}, \text{Br}, \text{I}$) from aluminum halide and magnesium hydride, characterised in that an aluminum halide AlX_3 ($\text{X} = \text{Cl}, \text{Br}, \text{I}$) is reacted with a magnesium hydride in a solvent, said magnesium hydride having been prepared from magnesium and hydrogen in the same or a different solvent in the presence of homogeneous catalysts consisting of a halide of a metal of the subgroups IV to VIII of the Periodic Table and a magnesium hydride and in the presence of a polycyclic aromatic or a tertiary amine and a magnesium halide MgX_2 ($\text{X} = \text{Cl}, \text{Br}, \text{I}$).

2. The process according to claim 1, characterised in that as the solvents there are used aprotic organic solvents.

3. The process according to claim 2, characterised in that the aprotic organic solvents are open-chain and cyclic mono- and polyethers.

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(10) 603067

-2-

4. The process according to claim 3, characterised in that the open-chain and cyclic mono- and polyethers are selected from tetrahydrofuran (THF) and glycoldimethylether.

9. The process according to any one of the preceding claims characterised in that the polycyclic aromatic is selected from anthracene, tetracene and benzanthracene.

10. The process according to any one of claims 1 to 8, characterised in that the tertiary amine has the fomula NR_3 , wherein R = alkyl or cycloalkyl.

COMPLETE SPECIFICATION

(ORIGINAL)

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Lodged:

Class

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Priority:

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Related Art:

Name of Applicant:

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Complete Specification for the invention entitled:

PROCESS FOR PREPARING HALOGEN MAGNESIUM ALANATE AND USE THEREOF

The following statement is a full description of this invention, including the best method of performing it known to:

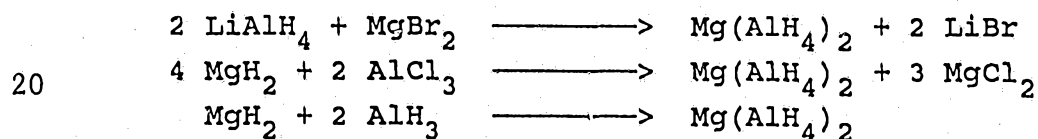
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PROCESS FOR PREPARING HALOGEN MAGNESIUM ALANATE
AND USE THEREOF

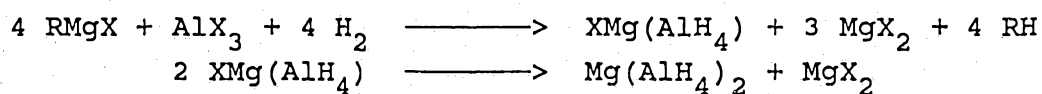
The invention relates to a process for an easy preparation of halogen magnesium alanate XMgAlH_4 (X = Cl, Br, I) and the use thereof.

5 Reductions using complex metal hydrides are standard reactions in organic chemistry (cf., e.g., N. G. Gaylord, "Reduction with Complex Metal Hydrides", Interscience Publishers, Inc., New York 1956). In these reactions the ether-soluble LiAlH_4 is most frequently used. In principle the substitution of the expensive
10 lithium by the less expensive magnesium should result in a cost reduction.

Therefore, many attempts have been made at synthesizing $\text{Mg}(\text{AlH}_4)_2$. Contradictory statements are found in the literature with respect to the properties of
15 said substance. An ether-soluble $\text{Mg}(\text{AlH}_4)_2$ was first described by Wiberg and Bauer (Z. Naturforsch. 5B, 397 (1950); Z. Naturforsch. 7B, 131 (1952), German Patent 845 338):



The MgH_2 to be employed in these reactions was obtained by the thermolysis of Grignard or diorganomagnesium compounds, respectively. In this reaction in addition to magnesium halide also alkenes are formed as 5 undesired by-products. However, a synthesis starting from the lithium alanate is inappropriate. According to A. Hertwig (German Patent 921 986 (1954); C.A. 52, 11371 d)) the reaction of Grignard compounds with Al halides and hydrogen results in the formation of chloro- 10 magnesium alanate, $ClMgAlH_4$, which may be converted into magnesium alanate by thermolysis.



15 The reaction of a mixture of MgH_2 and aluminum with aluminum chloride gives $Mg(AlH_4)_2$ (BP 785 348). The reaction of MgH_2 with aluminum and hydrogen under drastic reaction conditions (J.C. Snyder, U.S. Patent Specification No. 3,387,948 (1962)) provides $Mg(AlH_4)_2$ in insatis- 20 factory yields. All of the described processes do not satisfy the requirements for commercial procedures.

The $Mg(AlH_4)_2$ synthesized later (J. Plesek, S. Hermanek, Coll. Czech. Chem. Comm. 31, 3060 (1966)) from 25 magnesium halide and sodium alanate, in contrast to earlier descriptions, had an extremely poor solubility in ethers. According to Ashby *et al.* ((Inorg. Chem. 9, 325 (1970)) in the reactions of lithium alanate with magnesium bromide or magnesium hydride with aluminum chloride 30 a soluble halogenomagnesium alanate, $XMg(AlH_4)$, is formed as a product which is also obtainable from hydride magnesium chloride and alane ((Inorg. Chem. 16, 2941 (1977)). Thus, the true constitution of the reaction product has not been recognized by Wiberg, Hertwig and Snyder.

The substitution of the expensive lithium alanate with the less expensive soluble halogen magnesium alanate still appears to be desirable. The realization of this concept has so far failed due to the lack of an efficient synthesis for the inexpensive starting material magnesium hydride.

According to the European Patent No. 0 003 564 metallic magnesium may be hydrogenated by means of homogeneous transition metal catalysts under mild conditions to give magnesium hydride which, contrary to the magnesium hydride produced in accordance with conventional processes (high temperature hydrogenation) has a high reactivity. This method for preparing hydrides of magnesium by using hydrogen and transition metal catalysts is characterized in that magnesium is reacted with hydrogen in the presence of a catalyst consisting of a halide of a metal of the Subgroups IV to VIII of the Periodic Table and an organomagnesium compound or a magnesium hydride, and optionally in the presence of a polycyclic aromatic or a tertiary amine and optionally in the presence of magnesium halide MgX_2 wherein $X = Cl, Br, I$.

In the subclaims of the European Patent Specification No. 0 003 564 preferred embodiments have been claimed, namely that the reaction is carried out in a solvent, preferably in tetrahydrofuran, that pressures of from 1 to 300 bar and temperatures of from 0 °C to 200 °C are employed, that the ratio of Mg : transition metal is selected to be from 10^4 to 10 : 1, and the ratio of transition metal : organomagnesium compound or magnesium hydride is selected to be from 0.1 : 1 to 10 : 1, chromium, titanium and iron halides are employed as the transition metal halides, magnesium anthracene is used as the organomagnesium compound, anthracene, tetracene and

benzanthracene are employed as the polycyclic aromatics, and tertiary amines NR_3 are used wherein R = alkyl or cycloalkyl groups and that optionally, when the magnesium is allowed to react, its halides MgX_2 wherein X = Cl, Br, I, are added in the ratio of Mg : MgX_2 = 1 : 1.

It has now been found that the highly active magnesium hydride which is now readily available due to said process is excellently suitable for the production of halogen magnesium alanates from aluminum halides.

Accordingly, the present invention relates to a process for preparing halogen magnesium alanates $XMgAlH_4$ (X = Cl, Br, I) from aluminum halide and magnesium hydride, which process is characterized in that an aluminum halide AlX_3 (X = Cl, Br, I) is reacted with a magnesium hydride in a solvent, said magnesium hydride having been prepared from magnesium and hydrogen in a solvent in the presence of homogeneous catalysts consisting of a halide of a metal of the Subgroups IV to VIII of the Periodic System and of an organomagnesium compound or a magnesium hydride and in the presence of a polycyclic aromatic or of a tertiary amine and optionally in the presence of a magnesium halide MgX_2 (X = Cl, Br, I).

The reaction proceeds in aprotic organic solvents, and preferably cyclic or linear ethers or polyethers such as tetrahydrofuran (THF) or Glycol dimethyl ether, already at below 0 °C and gives halogen magnesium alanates in high yields. THF is particularly preferred.

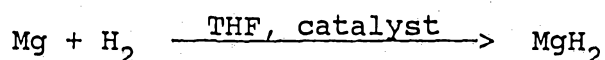
The reaction of the aluminum halide with the magnesium hydride is preferably carried out in the

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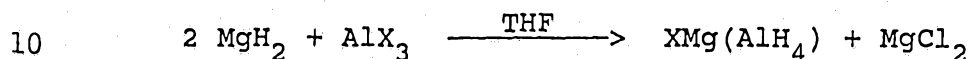


temperature range of from -80 °C to 150 °C, the range of from -10°C to 60°C being particularly preferred.

The combination of the two processes enables a two-step synthesis of halogen magnesium alanates to be effected using the inexpensive raw materials magnesium, hydrogen and aluminum halide as exemplified hereinbelow:



Catalyst: 1 mole percent of anthracene,
1 mole percent of CrCl_3 or TiCl_4



X = Cl, Br, I

Alternatively, there is the possibility of isolating the MgH_2 prepared according to the European Patent No. 0 003 564 in the solid state and then to use the compound in a different suitable solvent for the reaction with aluminum halides.

According to own investigations, $\text{ClMg}(\text{AlH}_4)$ cannot be successfully prepared by using commercially available MgH_2 synthesized from the elements at high temperatures. Even upon activation by grinding in a glass ball mill such a magnesium hydride does not yield reduction products in the reaction with unsaturated substrates, as will be apparent from the Comparative Example.

The chloromagnesium alanate prepared according to the present invention may be employed for reduction purposes directly as a solution or, upon removal of the

solvent, as a solid. The $MgCl_2$ formed as a by-product does not interfere with the subsequent reactions; in the case of the isolated material the pyrophoricity of the materials is even lowered. If, however, it is desired to
5 remove the produced $MgCl_2$, this is possible by the addition of dioxane.

The $ClMg(AlH_4)$ as readily accessible from MgH_2 and $AlCl_3$ is a very good reducing agent for functional
10 organic groups. It has been shown (cf. EXAMPLES) that aldehydes, esters, ketones, alkyl halides, carboxylic acids and anhydrides are reduced in very good yields. A change of the solvents for the reductions is possible.

The obtained yields are often better than those attained by Wiberg and Bauer (Chem. Ber. 85, 593 (1952)).
15 The reduction power of $ClMg(AlH_4)$ is comparable to that of $LiAlH_4$, and replacing the expensive lithium with the inexpensive magnesium is feasible and desirable. A further advantage of this method is that the hydrogenation of magnesium and subsequent reduction of functional organic
20 compounds may be carried out in a single-vessel reaction, e.g. in THF as reaction medium.

The invention is illustrated in greater detail by the following EXAMPLES. All experiments were run in absolute solvents under argon as protective gas.
25

EXAMPLE 1

48 ml of a 4.12 molar MgH_2 suspension (prepared according to the European Patent No. 0 003 564 with a chromium catalyst; $Mg : anthracene : CrCl_3 = 100 : 1 : 1$) were charged into 250 ml three-necked flask equipped with
30

dropping funnel, reflux condenser and inner thermometer. To this well agitated suspension there were dropwise added 8.85 g (66 mmol) of AlCl_3 , dissolved in 60 ml of THF within a period of 30 min so that the inside temperature did not exceed 30 °C (external cooling). Then 25.3 ml (239 mmol) of 3-pentanone were immediately added dropwise within 20 min (exothermal reaction, external cooling). The mixture was allowed to after-react at room temperature for 1 h; then the volatile reaction products were removed under the vacuum of an oil pump. The residue was suspended in 60 ml of toluene and decomposed with H_2O and HCl . The organic phase was separated, and the aqueous phase was twice extracted with toluene. The united organic phases were distilled at from 20 °C to 120°C/0.1 mbar.

An aliquot was admixed with n-octane and subjected to gas chromatographical analysis. Yield: 19.98 g of 3-pentanol (95 % of the theoretical value).

20 EXAMPLE 2

The experiment was carried out as in EXAMPLE 1, but using 60 ml of a 3.42 molar MgH_2 suspension, 6.63 g of AlCl_3 (50 mmol) in 59 ml of THF and 17.2 ml (169 mmol) of benzaldehyde.

Yield: 16.96 g (157 mmol) of benzyl alcohol (93 % of the theoretical value).

30 EXAMPLE 3

The experiment was carried out as in EXAMPLE 1, but using 50 ml of a 4.12 molar MgH_2 suspension, 8.02 g of AlCl_3 (60 mmol) in 60 ml of THF and 15.5 ml (108 mmol) of benzoic acid ethyl ester.

Yield: 11.67 g (108 mmol) of benzyl alcohol
(100 % of the theoretical value).

EXAMPLE 4

5 The experiment was carried out as in EXAMPLE 1,
but using 70 ml of a 2.94 molar MgH_2 suspension, 8.5 g
of $AlCl_3$ (64 mmol) in 60 ml of THF and 34 ml (216 mmol)
of 1-bromoheptane.

10 Yield: 19.34 g (193 mmol) of n-heptane (89 % of
the theoretical value).

EXAMPLE 5

15 The experiment was carried out as in EXAMPLE 1,
but using 30 ml of a 6.33 molar MgH_2 suspension, 4.08 g
of $AlCl_3$ (30.6 mmol) in 48 ml of THF and 8.5 ml
(104 mmol) of crotonaldehyde.

Yield: 6.79 g (94.2 mmol) of crotyl alcohol
(91 % of the theoretical value).

EXAMPLE 6

20 The experiment was carried out as in EXAMPLE 1,
but using 70 ml of a 3.01 molar MgH_2 suspension, 9.28 g
of $AlCl_3$ (70 mmol) in 74 ml of THF and 9.4 ml (59.3 mmol)
of octanoic acid.

Yield: 7.15 g (54.9 mmol) of 1-octanol (93 % of
the theoretical value).

25 EXAMPLE 7

The experiment was carried out as in EXAMPLE 1,
but using 42 ml of a 5.88 molar MgH_2 suspension, 11.0 g

of AlCl_3 (82.6 mmol) in 100 ml of THF and 6.0 ml (46.8 mmol) of propionic acid anhydride.

Yield: 5.371 g (89.4 mmol) of 1-propanol (95 % of the theoretical value).

5 EXAMPLE 8

The experiment was carried out as in EXAMPLE 1, but using 40 ml of a 2.7 molar MgH_2 suspension, 4.77 g of AlCl_3 (36 mmol) in 44 ml of THF and 10.4 ml (102 mmol) of benzaldehyde at 65 °C.

10 Yield: 8.87 g (82.0 mmol) of benzyl alcohol (80 % of the theoretical value).

EXAMPLE 9

15 The experiment was carried out as in EXAMPLE 1, but using 2.40 g (91.1 mmol) of isolated and dried MgH_2 , 3.92 g of AlCl_3 (29.4 mmol) in 66 ml of THF and 10.1 ml (100 mmol) of benzaldehyde.

Yield: 8.61 g (79.6 mmol) of benzyl alcohol (80 % of the theoretical value).

EXAMPLE 10

20 The experiment was carried out as in EXAMPLE 1, but using 2.40 g (91.1 mmol) of isolated and dried MgH_2 prepared using a titanium catalyst, 3.92 g of AlCl_3 (29.4 mmol) in 66 ml of THF and 10.1 ml (100 mmol) of benzaldehyde.

25 Yield: 8.61 g (79.6 mmol) of benzyl alcohol (80 % of the theoretical value).

COMPARATIVE EXAMPLE

The experiment was carried out using 6.11 g (197 mmol) of 85 % commercially available MgH_2 which had been activated by grinding in a glass ball mill for 2 h, 6.74 g of $AlCl_3$ (50.5 mmol) in 60 ml of THF and 13.0 ml (90.5 mmol) of benzoic acid ethyl ester in the same manner as in EXAMPLE 1. Besides the starting compound no benzyl alcohol was detectable by gas chromatography.

THE CLAIMS DEFINING THE INVENTION ARE AS FOLLOWS:

1. A process for preparing halogen magnesium alanates XMgAlH_4 ($\text{X} = \text{Cl}, \text{Br}, \text{I}$) from aluminum halide and magnesium hydride, characterised in that an aluminum halide AlX_3 ($\text{X} = \text{Cl}, \text{Br}, \text{I}$) is reacted with a magnesium hydride in a solvent, said magnesium hydride having been prepared from magnesium and hydrogen in the same or a different solvent in the presence of homogeneous catalysts consisting of a halide of a metal of the subgroups IV to VIII of the Periodic Table and a magnesium hydride and in the presence of a polycyclic aromatic or a tertiary amine and a magnesium halide MgX_2 ($\text{X} = \text{Cl}, \text{Br}, \text{I}$).

2. The process according to claim 1, characterised in that as the solvents there are used aprotic organic solvents.

3. The process according to claim 2, characterised in that the aprotic organic solvents are open-chain and cyclic mono- and polyethers.

4. The process according to claim 3, characterised in that the open-chain and cyclic mono- and polyethers are selected from tetrahydrofuran (THF) and glycoldimethylether.

5. The process according to any one of claims 1 to 4, characterised in that the reaction of the aluminum halide with the magnesium hydride is carried out in the temperature range of from -80°C to 150°C .



6. The process according to claim 5, characterised in that the reaction of aluminum halide with the magnesium hydride is carried out in the temperature range of from -10°C to 60°C .

7. The process according to any one of claims 1 to 6, characterised in that it is carried out in two steps, the magnesium hydride being prepared in the first step and then said magnesium hydride being reacted with the aluminum halide in the same solvent.

8. The process according to claim 7, characterised in that the solvent is THF.

9. The process according to any one of the preceding claims characterised in that the polycyclic aromatic is selected from anthracene, tetracene and benzanthracene.

10. The process according to any one of claims 1 to 8, characterised in that the tertiary amine has the formula NR_3 , wherein R = alkyl or cycloalkyl.

DATED this 27th day of July, 1990

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