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(54) **Titre : PROCÉDE POUR LA PRÉPARATION DE TRIHALOGENURES MONOALKYLES ET DE DIAHALOGENURES DIALYLES**
(54) **Title: PROCESS FOR THE PREPARATION OF MONOALKYL TIN TRIHALIDES AND DIALYL TIN DIHALIDES**

(57) **Abrégé/Abstract:**

The present invention relates to a process for the production of monoalkyltin trihalides of the formula $R\text{SnHal}_3$, in which R = alkyl or cycloalkyl and Hal = Cl, Br or I. Said process comprises contacting the corresponding alkene or cycloalkene, stannous halide SnHal_2 , hydrogen halide HHal and optionally Sn metal, in the presence of at least one transition metal-based catalyst, thereafter isolating the monoalkyltin trihalides from the medium. The present invention also relates to a process for the production of dialkyltin dihalides of the formula $R_2\text{SnHal}_2$ from monoalkyltin trihalides of the formula RsnHal_3 , in which R = alkyl or cycloalkyl and Hal = Cl, Br or I. Said process comprises contacting monoalkyltin trihalides RsnHal_3 and Sn metal, optionally thereafter isolating the dialkyltin dihalides $R_2\text{SnHal}_2$ from the medium.



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(54) Title: PROCESS FOR THE PREPARATION OF MONOALKYL TIN TRIHALIDES AND DIALKYL TIN DIHALIDES

(57) Abstract: The present invention relates to a process for the production of monoalkyltin trihalides of the formula $R\text{SnHal}_3$, in which R = alkyl or cycloalkyl and Hal = Cl, Br or I. Said process comprises contacting the corresponding alkene or cycloalkene, stannous halide SnHal_2 , hydrogen halide HHal and optionally Sn metal, in the presence of at least one transition metal-based catalyst, thereafter isolating the monoalkyltin trihalides from the medium. The present invention also relates to a process for the production of dialkyltin dihalides of the formula $R_2\text{SnHal}_2$ from monoalkyltin trihalides of the formula $R\text{SnHal}_3$, in which R = alkyl or cycloalkyl and Hal = Cl, Br or I. Said process comprises contacting monoalkyltin trihalides $R\text{SnHal}_3$ and Sn metal, optionally thereafter isolating the dialkyltin dihalides $R_2\text{SnHal}_2$ from the medium.



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PROCESS FOR THE PREPARATION OF MONOALKYL TIN TRIHALIDES AND DIALYL TIN DIHALIDES

[Field of the invention]

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Monoalkyltin trihalides, by way of example, monoalkyltin trichlorides $R\text{SnCl}_3$ (R being $\text{C}_n\text{H}_{2n+1}$), particularly methyl-, butyl- and octyltin trichloride, are industrially important as intermediates for PVC stabilisers, glass coating chemicals and catalysts. A new route to produce monoalkyltin trihalides with $n \geq$
10 2 has been discovered. The method utilizes the corresponding alkene, tin dihalide and hydrogen halide as raw materials and a transition metal complex as the catalyst. The reaction proceeds smoothly and selectively under mild conditions. The monoalkyltin trihalides either isolated from the reaction medium either coming from another source are reacted with tin metal to get a mixture of
15 tin dihalide and dialkyltin dihalides.

[The prior art and the technical problem]

Monoalkyltin trichlorides and dialkyltin dichlorides are currently prepared
20 through multistep processes. In these processes, the monoalkyltin trichlorides and dialkyltin dichlorides are formed as a mixture by disproportionation of the corresponding tetraalkyltin compound R_4Sn with SnCl_4 . The tetraalkyltin compound is prepared by reacting trialkylaluminium or alkyl-Grignard reagents with SnCl_4 . This route suffers from rather high raw material costs. Moreover, the
25 product composition depends on the length of the alkyl chain and reaction conditions, and is therefore hardly adjustable to the actual demand. Fractionation by distillation may be required but becomes practically impossible for higher alkylchains ($n = 8$ or longer). Therefore, alternative methods for the selective production of monoalkyltin trichlorides and dialkyltin dichlorides are
30 highly desirable.

Alternative methods to prepare dialkyltin dichlorides include the selective dialkylation of tin tetrahalide using alkylaluminium reagents (see GB Pat

923179, DE 1157617), or reaction of organic chloride with metallic tin. The latter reaction usually requires a catalyst, for example magnesium, copper (see US 3,085,102) or hexamethylphosphoric triamide (HMPT, see US 4,049,689, 4,044,035). The low yields for higher alkyl chlorides and large amounts of catalyst needed make these methods generally unattractive from a commercial point of view.

It is known that the reaction of SnCl_4 with trialkylaluminum etherate $\text{R}_3\text{Al}(\text{OR}'_2)$ / amide $\text{R}_3\text{Al}(\text{NR}'_3)$ compounds or alcoholates $\text{R}_2\text{Al}(\text{OR}')$ allows the formation of RSnCl_3 . Similarly, mixtures of monoalkyltin trichlorides and dialkyltin dichlorides have been prepared in one step from SnCl_4 using R_3Al and an excess of ether. This is described in the following patents US 3,894,066, US 3,994,944, and patent application US 2004/0133022A1. Drawback of these procedures is the excess of alkylaluminiums often required to achieve good yields.

EP 1 225 177 describes a process for the production of monoalkyltin trihalides of the formula RSnX_3 , wherein R = alkyl or cycloalkyl and X = Cl, Br or I, involving a redistribution reaction between tetraorganotins, triorganotin halides or diorganotin halides and tin tetrahalides, said process comprising contacting tetra- (R_4Sn), tri- (R_3SnX) or diorganotin halides (R_2SnX_2) with SnX_4 to afford said monoorganotin trihalides in the presence of at least one transition metal complex, said complex comprising at least one transition metal, M, selected from Group VIII of the periodic Table of elements, at least one monodentate ligand or bidentate ligand, L, L' or L'', and optionally one or more anions, X, of an organic or inorganic acid, as a catalyst or catalyst precursor. This reaction still requires the production of the initial tetraorganotins, triorganotin halides or diorganotin halides from tin tetrahalide and suffers from the formation of tin dihalide as byproduct.

An alternative route to monoalkyltin trichlorides is the reaction of the corresponding alkylhalide with SnCl_2 using a catalyst. Useful catalysts are phosphonium halides, amines or phosphines, disulfides, Se(II) or metal salts of group 1-3, (e.g. LiCl or MgCl_2), or Mg metal with I_2 . These reactions generally require high temperatures. This is described in the following patents US

3,519,667, US 3,340,283, CA 1069129, GB 1,146,435, US 4,046,791. Trialkylantimony compounds were found to be effective as catalysts in the case of alkyltin tribromides, but the lack of reactivity for the alkyltin trichlorides and the toxicity of the trialkylantimony catalysts renders this route less useful (E. J. Bulten, *J. Organomet. Chem.* 1975, 97, 167).

Reaction of α -olefins with stannane SnH_4 has been reported using a free radical catalyst (e.g. alkyl peroxides and cobalt naphthenate). The cryogenic conditions and low yields make this procedure unattractive from an industrial point of view. It has been described in GB 1,255,859. Addition of unactivated alkenes to HSnX_3 yielding RSnX_3 has been described to occur through a similar mechanism, but these produce the secondary substituted monoalkyltin trihalides in poor yields. It has been described in US 3,607,893. Hydrostannylations are known to occur when trialkyltin hydrides are reacted with substrates containing multiple bonds under radical conditions. Examples also exist where complexes of rhodium and palladium are successfully applied to catalyse the addition of trialkyltin hydrides to alkynes and alkenes to give mixed tetraorganotin compounds (M. Lautens, W. Klute, *Angew. Chem. Int. Ed. Engl.* 1996, 35, 442 and references therein).

The preparation of organotin compounds directly from SnCl_2 (or, alternatively, Sn metal), HCl and the corresponding alkene represents an attractive alternative route to monoalkyltin trichlorides. Its main advantages stem from the low raw material costs and ability to produce the desired alkyltin chloride selectively in one step. This reaction has been reported before for α,β -unsaturated carbonyl-containing substrates where it occurs without a catalyst under mild conditions. The carbonyl functionality acts as an activating group for the conversion in these substrates. Both monoorganotin trihalides and diorganotin dihalides or mixtures thereof have been produced. It has been described in US 4,105,684, EP 0,011,280, US 4,080,362, US 4,130,573, J. W. Burley, P. Hope, R. E. Hutton, C. J. Groenenboom, *J. Organomet. Chem.* 1979, 170, 21, US Pat 4,202,830, J. W. Burley, P. Hope, A. G. Mack, *J. Organomet. Chem.* 1984. However, unactivated alkenes are not reactive under these conditions. Reaction of 1-octene with $\text{HSnCl}_3(\text{Et}_2\text{O})_2$ reportedly only results in

trace amounts (< 1%) of *sec*-octyltin trichloride (277, 37, R. E. Hutton, J. W. Burley, *J. Organomet. Chem.* 1978, 156, 369). *n*-Octyltin trichloride was formed in up to 81 % yield when $[(\eta^5\text{-C}_5\text{H}_5)_2\text{Zr}(\text{H})\text{Cl}]$ and a stoichiometric amount of 1-octene were reacted with 0.5 equivalent of SnCl_4 at room temperature. Obviously, the need for large amounts of zirconium reagent makes this route industrially less attractive (V. G. Kumar Das, O. Ghee Chee, *J. Organomet. Chem.* 1987, 321, 335).

A novel process for the direct and selective preparation of monoalkyltin trihalides from the corresponding unactivated alkene (e.g. 1-octene), stannous halide (e.g. SnCl_2) and hydrogen halide (e.g. HCl) in one single reaction step in the presence of a transition metal complex as a catalyst has been found. The reaction proceeds selectively, the only significant side product being isomerised alkene. Dialkyltin dihalides are then produced from monoalkyltin trihalides.

15

[Brief description of the invention]

The present invention comprises a process for the production of monoalkyltin trihalides of the formula RSnHal_3 , in which R = alkyl or cycloalkyl and Hal = Cl, Br or I, said process comprising contacting alkene, stannous halide and hydrogen halide in the presence of at least one transition metal complex as a catalyst or catalyst precursor; optionally thereafter isolating the monoalkyltin trihalides from the medium. In a preferred embodiment of the invention said complex comprises at least one transition metal M, at least one monodentate ligand or bidentate ligand, L or L', and optionally one or more anions, X, being defined as (i) the conjugate base of an organic or inorganic acid, (ii) a hydride or (iii) a hydrocarbyl fragment. In another preferred embodiment of the invention said complex is a transition metal salt consisting of transition metal M, and optionally one or more anions, X, being defined as the conjugate base of an organic or inorganic acid, and optionally one or more alkalimetal cations.

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Advantageously M is selected from Group VIII of the periodic Table of elements. The reaction can be carried out with or without a solvent.

The reaction proceeds selectively, the only significant side product being alkene isomers resulting from isomerisation of the starting alkene. The alkene is currently applied in excess to the other reactants. The hydrogen halide acid may be employed as gas or in solution. The reaction proceeds smoothly at room temperature or above. A multitude of organic solvents can be used, in particular, solvents like alcohols, ethers and apolar aromatic and aliphatic solvents and mixtures thereof. Small amounts of water do not disturb the reaction.

The invention also comprises a process to make dialkyltin dihalides. The monoalkyltin trihalides (i) either isolated from the above reaction medium (ii) either coming from another source are reacted with tin metal to get a mixture of tin dihalide and dialkyltin dihalides. Optionally in option (i) the tin metal can be added during the reaction to monoalkyltin trihalide. In that way the tin dihalide formed can be consumed to produce monoalkyltin trihalide.

The invention also relates to the use of these monoalkyltin trihalides, dialkyltin dihalides and mixtures thereof made according to the process hereabove as intermediates for PVC stabilisers, glass coating chemicals and catalysts. The invention also relates to the PVC stabilisers, glass coating chemicals and catalysts having been made from the monoalkyltin trihalides and dialkyltin dihalides made by the process of the present invention.

[Detailed description of the invention]

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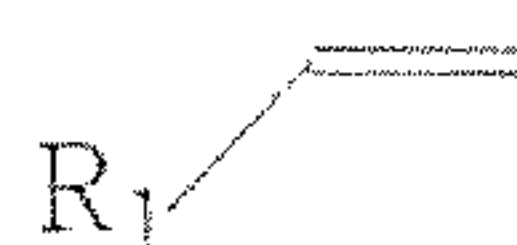
The present invention relates to a process for the production of monoalkyltin trihalides of the formula $R\text{SnHal}_3$, in which R = alkyl or cycloalkyl and Hal = Cl, Br or I. Said process comprises contacting the corresponding alkene or cycloalkene, stannous halide SnHal_2 , hydrogen halide HHal and optionally Sn metal, in the presence of at least one transition metal-based catalyst, thereafter isolating the monoalkyltin trihalides from the medium.

30

Advantageously, R is an alkyl, linear or branched, in the range C2-C20 and preferably selected among C2, C3, C4, C5, C6, C7 and C8.

5 **As regards the monoalkyltin trihalides**, in a specific embodiment Hal is chloride. This means that the stannous halide is SnCl₂ and hydrogen halide is HCl. In the formula RSnHal₃ the group R is preferably defined as an alkyl (linear or branched) or cycloalkyl having from 2 to 20 carbon atoms. Preferably *n*-butyl, butyl, *n*-hexyl, hexyl, *n*-octyl and octyl are used.

10 **As regards the alkene** (sometimes called olefin), it can be described, by way of example, as the following formula :



and the reaction route as follows (eq 1) :

15



(eq. 1)

in which R₁ is H or is defined as an alkyl (linear or branched or substituted), having from 1 to 18 carbon atoms.

20 The alkene, but also cycloalkene, has advantageously from 2 to 20 carbon atoms. In a specific embodiment the alkene also can be described as R₁(R₂)C=C(R₃)(R₄) with R₁-R₄ being any alkyl group (branched or linear or substituted) or hydrogen, R₁, R₂, R₃ and/or R₄ being optionally linked to any of the other R groups, for example R₁ or R₂ being linked to R₃ or R₄, or R₁ being
25 linked to R₂, and the number of carbon atoms in R₁-R₄ ranging from 0 to 18.

The olefin can contain functions and/or substituents. Advantageously this hydrocarbon has 4 to 8 carbon atoms. Especially 1-butene and 1-octene are relevant to produce industrially important organotins.

As regards stannous halide, it can be SnHal_2 or any precursor. Mention may be made, by way of examples, of Sn / SnHal_4 blends and HHal / Sn. The precursor also relates to SnHal_2 / Sn / SnHal_4 blends. The stannous halide is preferably anhydrous but also their aqua complexes can be used. The stannous halide SnHal_2 can be produced in situ. According to a specific embodiment, SnHal_2 can be partly or totally replaced by a Sn / SnHal_4 blend (1/1 ratio) producing SnHal_2 in situ.

As regards the hydrogen halide, it can be the hydrogen halide itself as gas or solution in a solvent or any precursor or any blend thereof. The precursor can be $[\text{HN}(\text{alkyl})_3]\text{Hal}$, another ammonium salt or other Lewis base adduct of hydrogen halide. When used as gas the hydrogen halide may be diluted with another gas. In a preferred embodiment of the invention the hydrogen halide can be HCl or $[\text{HN}(\text{C}_2\text{H}_5)_3]\text{Cl}$. In another preferred embodiment, Hal is chloride, the stannous halide is SnCl_2 and hydrogen halide is HCl .

As regards the catalyst, in its broadest form the catalyst is a transition metal-based catalyst.

According to a first embodiment of the invention, said transition metal-based catalyst can be a complex, said complex comprising at least one transition metal M, at least one monodentate ligand L or bidentate ligand L', and optionally one or more anions X, X being defined as (i) the conjugate base of an organic or inorganic acid, (ii) a hydride or (iii) a hydrocarbyl fragment.

Advantageously, the catalyst is a complex having the formula



wherein L' is a bidentate ligand, or



or



30 or



wherein L is a monodentate ligand.

Preferably, the complex is $M(PPh_3)_4$.

According to a second embodiment of the invention, the transition metal-based catalyst can be a transition metal salt consisting of transition metal M, and optionally one or more anions, X, being defined as the conjugate base of an organic or inorganic acid, and optionally one or more alkalimetal cations.

More preferably, the transition metal-based catalyst can be a salt, said salt consisting of transition metal M, one or more anions X, X being defined as the conjugate base of an organic or inorganic acid, and optionally one or more alkalimetal cations M', such as Li^+ , Na^+ or K^+ , and/or one or more protons.

Advantageously, the salt is chosen from the group consisting of MX_2 , M'_2MX_4 and H_2MX_4 . For example, $M(Hal)_2$ or K_2MX_4 can be employed.

According to a third embodiment of the invention, the transition metal-based catalyst can be a supported transition metal M in its zero valent oxidation state.

Preferably, said support is carbon.

Regardless of the type of the transition metal-based catalyst used within the framework of the present invention, i.e. a complex, a salt or a supported transition metal M, the transition metal M to be used is advantageously a Group VIII metal (also called columns 8-10), and preferred metals are Pt, Pd and/or Ni. The groups X may be anions of organic and/or inorganic nature, hydrogen or a hydrocarbyl fragment. In the catalyst species containing two X's (by way of example like $L_2M(R)Cl$) the two X's can be mutually different. It is preferred to use Cl, Br, I, acetate, triflate, tosylate, hydride or alkyl. In a preferred embodiment of the invention L in formula (II) or (III) is selected from phosphine, alkene, amine, pyridine, organic sulfide, nitrile and imidazoline-2-ylidene. L' is selected from phosphine containing ligand with additional O or N, diphosphine, dialkene, diamine and bis(imidazoline-2-ylidene) ligands. More in particular L is triphenylphosphine or $L' = N,N, N',N'$ - tetramethylethylenediamine (TMEDA), or

byridine (optionally substituted), M is Pd or Pt and for catalyst (I), X is Cl. In a specific embodiment catalysts are chosen among $\text{Pd}(\text{PPh}_3)_4$ and $\text{Pt}(\text{PPh}_3)_4$.

5 **As regards the solvent**, in general organic, aprotic or even protic solvents are preferred, especially aromatic solvents, chloroaromatic solvents, alkanes, ethers and alcohols. In particular tetrahydrofuran (THF), ethanol and 1,2-dimethoxyethane (DME) were found to be appropriate solvents.

10 **As regards the operating conditions and the proportions**, the reaction is made continuously or in batch. The batch process is preferred. Temperature can be, by way of example, from ambient to 200°C . A range from 20 to 130°C is advantageous. As regards the pressure, no pressure is necessary except to maintain the alkene, when it has a low boiling point, and hydrogen halide in the reaction medium. However, to speed up the reaction
15 higher pressures may be advantageous. Preferred reaction times range from a few seconds to 48 hours. The molar ratio of olefin to SnHal_2 falls within the range 0.1/1 to 200/1, more advantageously 1/1 to 100/1. The molar ratio of HHal to SnHal_2 falls within the range 0.01/1 to 100/1. The catalyst loading (molar percentage of M) based on the number of moles of SnHal_2 can be 0.001
20 to 5 %, more preferred 0.1 to 1.5%. Should a solvent be used, any proportion is convenient. The reaction is carried out in any usual apparatus. The reaction can be checked by taking samples and conventional analysis. The monoalkyltin trihalides can be separated from the reaction medium by any means such as, by way of examples, distillation, solvent extraction, crystallisation.

25 About the yield based on olefin:

a1 is the number of moles of olefin originally present at the beginning of the reaction,
a2 is the number of moles of olefin converted,
a3 is the number of moles of olefin converted to monoalkyltin trihalide,
30 the yield based on olefin is defined as the ratio a_3/a_1 and typically is in the range 1-80%. The selectivity based on olefin is defined as a_3/a_2 and is typically in the range 10-80%.

About the Sn yield :

b1 is the number of moles of Sn (present as Sn, SnHal₂ or SnHal₄) at the beginning of the reaction,

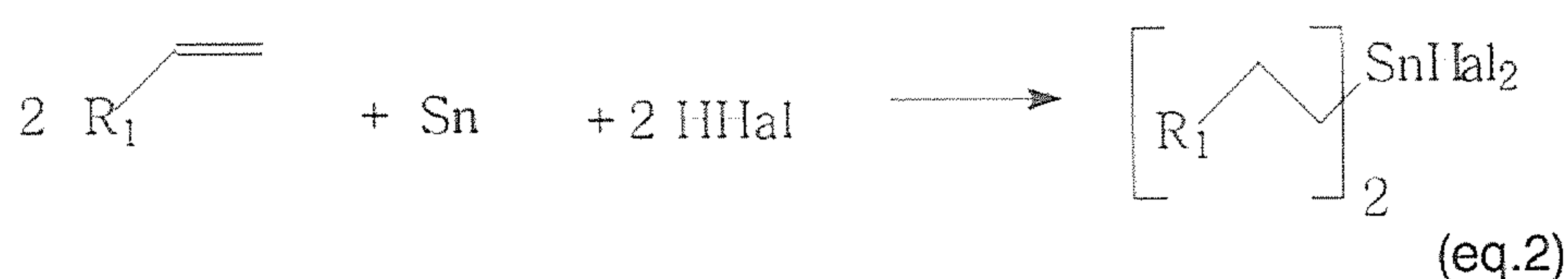
b2 is the total number of moles of Sn (present as Sn, SnHal₂ and SnHal₄) converted,

b3 is the number of moles of monoalkyltin trihalide produced.

The Sn selectivity is defined as the ratio b3/b2 and is in the range 95-100%.

The Sn yield is defined as b3/b1. The conversion is defined as b2/b1.

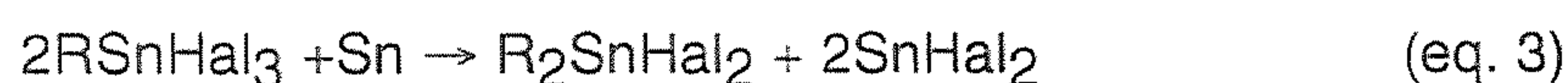
Also ratios Sn / SnHal₄ > 1 can be used. Optionally Sn can be added to the reaction mixture in the course of reaction. In this case the excess Sn metal gives rise to dialkyltin dihalide and SnHal₂ according to the following overall reaction stoichiometry:



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In eq 2 the alkene is only an example, it is clear that eq 2 concerns any alkene as described above.

20



The SnHal₂ is entering the reaction of eq. 1 affording another equivalent of RSnHal₃.

25

As regards the conversion, yields and selectivities :

a4 is the amount of olefin in moles converted to dialkyltin dihalide,

b4 is the number of moles of dialkyltin dihalide produced.

The conversion, yields and selectivities are now defined as follows :

The olefin yield is defined as (a3+a4)/a1.

The olefin selectivity is defined as $(a_3+a_4)/a_2$

The Sn yield is defined as $(b_3+b_4)/b_1$. The conversion is defined as above.

The Sn selectivity is defined as the ratio $(b_3+b_4)/b_2$.

Finally the two reactions of eq 1 and eq 3 can also be carried out as two
 5 consecutive reactions. In this case the monoalkyltin trihalide $RSnHal_3$ is first
 produced. The next step is then performed by adding Sn metal to the reaction
 mixture. The stannous halide that is left after isolation of the $RSnHal_3$ and
 R_2SnHal_2 products can be recycled to the first step. By choosing the Sn/ $RSnHal_3$
 stoichiometry any $R_2SnHal_2/RSnHal_3$ ratio in the product mixture can be
 10 chosen.

The present invention also relates to a process for the production of
 dialkyltin dihalides of the formula R_2SnHal_2 from monoalkyltin trihalides of the
 formula $RSnHal_3$, in which R = alkyl or cycloalkyl and Hal = Cl, Br or I, said
 15 process comprising contacting monoalkyltin trihalides $RSnHal_3$ and Sn metal,
 optionally thereafter isolating the dialkyltin dihalides R_2SnHal_2 from the medium.

Advantageously, R is an alkyl, linear or branched, in the range C1-C20
 and preferably selected among C2, C3, C4, C5, C6, C7 and C8.

In a preferred embodiment, the monoalkyltin trihalides $RSnHal_3$ are
 20 produced by the process above-described

**As regards the process to make dialkyltin dihalides from tin and
 monoalkyltin trihalides**, the monoalkyltin trihalides (i) either isolated from the
 above reaction medium (ii) either coming from another source are reacted with
 tin metal to get a mixture of tin dihalide and dialkyltin dihalides, according to the
 25 following reaction:



The reaction proceeds typically in the temperature range of 20 to 150°C
 with or without a catalyst and can be run with or without solvent. If solvent is
 applied, preferred solvents are organic apolar aliphatic or aromatic solvents or
 30 protic solvents or mixtures thereof. Water has a beneficiary effect on the

reaction. Advantageously, the SnCl_2 formed may be isolated and recycled, for example by extraction with water followed by drying, and applied as the starting material for the monoalkyltin trihalides production process as described above. By choosing the $\text{Sn}/\text{RSnHal}_3$ stoichiometry, any $\text{R}_2\text{SnHal}_2/\text{RSnHal}_3$ ratio in the product mixture can be chosen. In other words, by simply adjusting the amount of Sn, different mixtures of monoalkyltin trihalides and dialkyltin dihalides can be prepared.

Particularly, if an amount of Sn metal is added in deficiency, a partial conversion of the monoalkyltin trihalides RSnHal_3 occurs and a mixture that contains both monoalkyltin trihalides and dialkyltin dihalides is consequently obtained. In practice, such a "ready-to-go" mixture is currently used for making stabilizers.

Of course, the process of the present invention may further comprise a step of isolating the dialkyltin dihalides R_2SnHal_2 from the medium, in particular from the monoalkyltin trihalides and dialkyltin dihalides mixture.

[Examples]

20 Example 1

A reaction vessel equipped with magnetic stirring was brought under inert atmosphere and charged with 62 mg of $\text{Pt}(0)(\text{PPh}_3)_4$ and 138 mg of HNEt_3Cl (1.0 mmol). This mixture was then suspended by adding 0.5 mL of THF, followed by 1.0 mL of 1-octene and 0.5 mL of a 0.4 M solution of anhydrous SnCl_2 in THF (0.20 mmol). The vessel was placed in an oil bath and heated to 80°C and stirred for 16 hours.

After cooling down to room temperature, the liquid phase was ethylated with excess EtMgCl , and analysed by GLC using an internal standard. The yield is 10.5 mg (0.031 mmol ; $b_3/b_1 = 16\%$) of mono-octyltin trichloride

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Example 2

A reaction vessel equipped with magnetic stirring was brought under inert atmosphere and charged with 5.0 mg of Pd(PPh₃)₄. Next, 1.0 mL of a 0.8 M solution of anhydrous SnCl₂ in THF (0.80 mmol) was added, followed by 2.0 mL of 1-octene (12.5 mmol). The vessel was placed in an oil bath and heated to 60°C. Subsequently, 1.5 mL of a 0.25 M HCl solution in THF (0.375 mmol) was slowly added and the resulting pale yellow solution was stirred for 1 hr. at 60°C. After the reaction, the solvent and excess 1-octene were removed *in vacuo* to yield an orange/red residue. This residue was suspended in 3.0 mL of toluene and the resulting suspension stirred vigorously for several minutes. The liquid phase was analysed by GLC after ethylation with excess EtMgCl. The yield is 112 mg (0.33 mmol ; b₃/b₁ = 41 %) of mono-octyltin trichloride.

Example 3

A reaction vessel equipped with magnetic stirring was brought under inert atmosphere and charged with 9.5 mg of Pd(PPh₃)₄ and 172 mg SnCl₂ (0.91 mmol). Next, 4 mL of THF were added. The vessel was placed in an oil bath and heated to 50°C, while propylene was bubbled through the solution. Subsequently, 4.0 mL of a 0.20 M HCl solution in THF (0.80 mmol) was slowly added and the resulting pale yellow solution was stirred for 1.5 hr. at 50°C with propylene bubbling through the solution.

After the reaction, propylene bubbling was stopped and the solvent was removed *in vacuo* to yield an orange/red residue. This residue was suspended in 3.0 mL of toluene and the resulting suspension stirred vigorously for several minutes. The liquid phase was analysed by GLC, using an internal standard, after ethylation with excess EtMgCl. The yield is 12.6 mg (0.047 mmol ; b₃/b₁ = 6 %) of mono-propyltin trichloride.

Example 4

In a pressure vessel equipped with an inlet to enable dinitrogen purge and a stirring bar, 15.0 mg of Pd(PPh₃)₄ was weighed in. The tube was brought under inert atmosphere and subsequently cooled to -10 °C. Next, 4 mL of liquid 1-

butene was added, followed by 1.0 mL of a 0.8 M SnCl₂ solution in THF and dropwise addition of 3.0 mL of a 0.25 M HCl solution in THF. The vessel was then sealed and the cooling bath removed. When the vessel had reached room temperature, the vent was opened for a few seconds to remove the excess
5 pressure that had built up. The mixture was subsequently stirred at room temperature for 64 hrs.

After the reaction, the slightly turbid yellow reaction mixture was transferred to a second flask. The resulting residue was worked-up, ethylated and analysed by
10 GLC as described for Example 2. The analysis showed the formation of 45 mg of butyltin trichloride (0.16 mmol; b3/b1 = 20%).

Example 5

A reaction vessel equipped with magnetic stirring was brought under inert atmosphere and charged with 15.0 mg of Pd(PPh₃)₄ and 38 mg SnCl₂. THF (1
15 mL) was added, followed by the addition of 3.0 mL of cyclohexene. Finally, 0.8 mL of a 0.20 M solution of HCl in THF was added dropwise by means of a syringe. After the addition was completed, the resulting mixture was heated to 60°C and stirred for 24 hr. at this temperature.

After cooling down to room temperature, the volatiles were evaporated under
20 reduced pressure. The resulting residue was worked-up, ethylated and analysed by GLC as described for Example 2. The reaction yield was determined to be 4.0 mg (0.013 mmol; b3/b1 = 5%) of monocyclohexyltin trichloride.

25 Example 6

A reaction vessel equipped with magnetic stirring was brought under inert atmosphere and charged with 1 mL of a THF solution containing 4.5 mg of Pd(PPh₃)₄ and 75.1 mg SnCl₂ (0.40 mmol). The reaction vessel was heated to 50°C, after which 1.5 mL of styrene (13.1 mmol) was added. Subsequently, 2.0
30 mL of a 0.20 M HCl solution in THF (0.40 mmol) was slowly added and the resulting pale yellow solution was stirred for 16 hr. at 50°C.

After the reaction, the solvent and excess alkene were removed *in vacuo* to yield an orange/red residu. This residu was suspended in 3.0 mL of toluene and the resulting suspension stirred vigorously for several minutes. The liquid phase was analysed by GLC, using an internal standard, after ethylation with excess
5 EtMgCl. The yield is 5.9 mg (0.018 mmol; b3/b1 = 5 %) of mono(phenylethyl)tin trichloride.

Example 7

A reaction vessel equipped with magnetic stirring was brought under inert
10 atmosphere and charged with 1.7 mg PdCl₂ and 634 mg SnCl₂. Ethanol (2 mL) was added, followed by the addition of 4.4 ml of 1-octene. The mixture was heated to 50°C and 0.91 mL of a 2.75 M solution of HCl in ethanol were added by means of a syringe. After the addition was completed, the reaction mixture was stirred for 44 h at 50 °C.

15 After cooling down to room temperature, the volatiles were evaporated under reduced pressure. The resulting residue was worked-up, ethylated and analysed by GLC as described for Example 2. The reaction yield was determined to be 500 mg (1.48 mmol; b3/b1 = 44%) of monooctyltin trichloride.

20 Example 8

A reaction vessel equipped with a magnetic stirring bar was charged with 10.8 mg Pd on activated carbon (10 % Pd) and brought under inert atmosphere. The catalyst was then suspended by adding 2.0 mL of acetone. The mixture was heated up to 50 °C and 4.7 mL of 1-octene were added. In a separate reaction
25 vessel, a mixture of 671 mg SnCl₂, 0.66 mL of a 4 M solution of HCl in water (2.65 mmol) and 10.5 mL acetone was prepared, which was added by means of a syringe to the initial reaction mixture. The resulting mixture was stirred for 20 h at 50 °C.

After cooling down to room temperature, the volatiles were evaporated under
30 reduced pressure. The resulting residue was treated as described for Example 2. A yield of 98 mg (0.29 mmol; b3/b1 = 8 %) of monooctyltin trichloride was calculated from the results of the GLC measurements.

Example 9

A reaction vessel equipped with magnetic stirring was charged with 1.00 g Sn powder (8.42 mmol) and inertised. Next, 5.0 mL of toluene was added, followed
5 by 2.55 g of monobutyltin trichloride (9.04 mmol). This mixture was stirred at 105 °C for 24 hrs.

After the reaction, the resulting light-grey suspension was cooled to room temperature and filtered. The remaining solids were extracted with 3 times 5 mL of toluene, and the combined organic fractions were evaporated to dryness.
10 This resulted in 1.31 g white crystalline material as the product. Identification by ¹H and ¹¹⁹Sn NMR, GLC (after ethylation with EtMgCl) and mp confirm the product to be > 98% pure dibutyltin dichloride (4.31 mmol).

Example 10

15 A reaction vessel equipped with magnetic stirring was charged with 485 mg of Sn powder and brought under inert atmosphere. Next, 4.0 mL of toluene were added, followed by 1.41 g of octyltin trichloride. This mixture was stirred at 105 °C for 24 hrs.

After the reaction, the resulting off-white suspension was cooled to room
20 temperature and filtered. The remaining solids were extracted with toluene, and the combined organic fractions were evaporated to dryness. This resulted in 0.80 g (1.92 mmol; (b3+b4)/b1 = 47%) of dioctyltin dichloride.

Example 11

25 A reaction vessel equipped with magnetic stirring was brought under inert atmosphere and charged with 15 mg of Pd(PPh₃)₄. Next, 238 mg of Sn powder was added, followed by 3 mL of THF and 5.0 mL of 1-octene. The vessel was placed in an oil bath and heated to 50°C. Subsequently, 3 mL of a 0.3 M HCl solution in THF were added slowly and the resulting pale yellow solution was
30 stirred for 40 hrs under gentle reflux.

The solvent and the excess of 1-octene were removed *in vacuo* to yield an orange/red residue. This residue was suspended in 3.0 mL of toluene and the

resulting suspension was stirred vigorously for several minutes. The liquid phase was analysed by GLC after ethylation with excess EtMgCl. The yield was 50 mg (0.12 mmol; $(b_3+b_4)/b_1 = 6\%$) of dioctyltin dichloride.

- 5 The monoalkyltin trihalides, dialkyltin dihalides and mixtures thereof made according to the processes hereabove described are currently used as intermediates for PVC stabilisers, glass coating chemicals and catalysts.

CLAIMS

1. Process for the production of monoalkyltin trihalides of the formula $R\text{SnHal}_3$, in which R = alkyl or cycloalkyl and Hal = Cl, Br or I, said process comprising contacting the corresponding alkenes or cycloalkene, stannous halide SnHal_2 , hydrogen halide HHal and optionally Sn metal, in the presence of at least one transition metal-based catalyst, thereafter isolating the monoalkyltin trihalides from the medium.
2. The process according to claim 1 wherein said at least one transition metal-based catalyst is a complex, said complex comprising at least one transition metal M, at least one monodentate ligand L or bidentate ligand L', and optionally one or more anions X, X being defined as (i) the conjugate base of an organic or inorganic acid, (ii) a hydride or (iii) a hydrocarbyl fragment.
3. The process according to claim 2 wherein the complex is selected from the group consisting of L_2MX_2 , and $[\text{LMX}_2]_2$.
4. The process according to claim 2 wherein the complex is $\text{M}(\text{PPh}_3)_4$.
5. The process according to claim 1 wherein said at least one transition metal-based catalyst is a salt, said salt consisting of transition metal M, one or more anions X, X being defined as the conjugate base of an organic acid or inorganic acid, and optionally one or more alkalimetal cations M'.
6. The process according to claim 5 wherein the salt is selected from the group consisting of MX_2 , and $\text{M}'_2\text{MX}_4$.
7. The process according to claim 6 wherein the salt is $\text{M}(\text{Hal})_2$.
8. The process according to claim 1 wherein said at least one transition metal-based catalyst is a supported transition metal M in its zero valent oxidation state.
9. The process according to claim 8 wherein the support is carbon.
10. The process according to any one of claims 1 to 9 wherein the transition metal is a Group VIII metal.

11. The process according to any one of claims 1 to 10 wherein the stannous halide SnHal_2 is produced in situ.

12. The process according to claim 11 wherein stannous halide SnHal_2 is partly or totally replaced by a blend of Sn and SnHal_4 .

13. The process according to any one of claims 1 to 12 wherein R is an alkyl, linear or branched, in the range C2-C20.

14. The process according to any one of claims 1 to 13 wherein the reaction is carried out in a solvent.

15. The process according to claim 14 wherein the solvent is selected from the aromatic solvents, chloroaromatics, alkanes, ethers and alcohols.

16. The process according to any one of claims 1 to 15 wherein Hal is chloride, the stannous halide is SnCl_2 and hydrogen halide is HCl.

17. A process for the production of dialkyltin dihalides of the formula R_2SnHal_2 , from monoalkyltin trihalides of the formula RSnHal_3 , comprising preparing said monoalkyltin trihalides RSnHal_3 by the process according to any one of claims 1 to 16, in which R = alkyl or cycloalkyl and Hal = Cl, Br or I; and contacting said monoalkyltin trihalides RSnHal_3 and Sn metal, optionally thereafter isolating the dialkyltin dihalides R_2SnHal_2 .

18. The process according to claim 17 wherein R is an alkyl, linear or branched, in the range C1-C20.

19. The process according claim 18 wherein R is selected from C2, C3, C4, C5, C6, C7, and C8 alkyls.

20. The process according to any one of claims 17 to 19 wherein the amount of Sn metal is added in deficiency, said process further comprising an optional step of isolating the dialkyltin dihalides R_2SnHal_2 from the medium.