

Description

Monohalomaleic esters and monohalofumaric esters are useful in the preparation of pyridine-2,3-dicarboxylic esters which are key intermediates in the production of a class of highly potent herbicidal agents, 2-(imidazolin-2-yl)nicotinic acids, esters and salts. Monohalomaleic esters and monohalofumaric esters are also useful in the preparation of anilnofumarate which is an important intermediate in the manufacture of 2-(2-imidazolin-2-yl)quinoline-3-carboxylic acid herbicidal agents. Descriptions of the use of these important halomaleate and halofumarate compounds in the manufacture of imidazolinyl herbicidal agents may be found in U.S. patent 4,904,816.

Representative of the methods used to prepare halomaleic or halofumaric esters from dihalosuccinic esters are those which entail high reaction temperatures, excess quantities of organic solvent and long reaction times such as described in Japan 76 16,406 and Japan 68 29,571.

It is an object of this invention to provide an improved method for the manufacture of monohalomaleic and monohalofumaric esters from dihalosuccinic esters which employs milder reaction conditions and shorter reaction times.

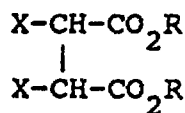
SUMMARY OF THE INVENTION

There is provided a process for the manufacture of a compound of formula I



I

wherein X is halogen and R is C₁-C₈alkyl, which comprises reacting a compound of formula II



II

wherein X and R are as described for formula I, with at least one molar equivalent of a base in the presence of a phase transfer catalyst and water.

The process of the invention is an improved process with effectively lower reaction temperatures, significantly shorter reaction times and minimum organic solvent requirements.

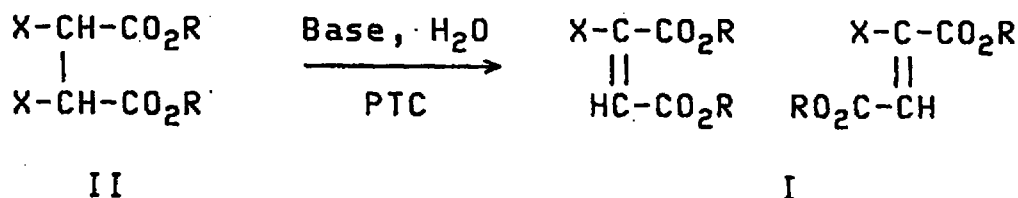
DESCRIPTION OF THE INVENTION

The present invention relates to an improved process for the manufacture of monohalomaleate and monohalofumarate compounds via the appropriate dihalosuccinate precursor. Monohalomaleate and monohalofumarate compounds are important intermediates in the preparation of a new class of highly potent 2-(imidazolin-2-yl)nicotinate and -quinoline-3-carboxylate herbicidal agents.

It has now been found, that dialkyl monohalomaleates and monohalofumarates of formula I may be prepared efficiently and effectively from dialkyl dihalosuccinates of formula II by reacting the formula I compounds with at least one molar equivalent of an alkali metal base in the presence of a phase transfer catalyst (PTC) and water, optionally at an

elevated temperature. The reaction is shown in flow Diagram I wherein X is halogen and R is C₁-C₆alkyl.

Flow Diagram I



The term halogen, as used in the specification and claims, designates Cl, Br and I. Bases suitable for use in the inventive process are alkali metal hydroxides such as NaOH or KOH, alkali metal carbonates such as Na₂CO₃, K₂CO₃ and the like and alkali metal bicarbonates such as NaHCO₃, KHCO₃ and the like. Alkali metal carbonates such as Na₂CO₃ are preferred. Phase transfer catalysts suitable for use in the process of the invention include tetraalkylated ammonium salts such as tetra-n-butylammonium bromide, tricaprylmethylammonium hydrogen sulfate, benzyltriethylammonium chloride, tributylmethylammonium chloride and the like.

In accordance with the method of invention a dihalosuccinnic ester of formula II is reacted with 1.0 to 1.5 molar equivalents of an alkali metal base, preferably an alkali metal carbonate, in the presence of a phase transfer catalyst, preferably a tetraalkylated ammonium salt, optionally at an elevated temperature of 45°-75°C, preferably 50°-60°C to form the formula I monohalomaleic and monohalofumaric ester product.

Advantageously, the rate of formation of the formula I product is greatly enhanced by the presence of a phase transfer catalyst and is further increased by increased temperature. Therefore, effective reaction rates may be accomplished by increasing the reaction temperature to a range of 45°-75°C.

The product may be isolated by separating the reaction mixture phases and optionally distilling the organic phase. Phase separation may be enhanced by the addition of a suitable organic solvent such as toluene, benzene, xylene, mono or dichlorobenzene, methylene chloride, carbon tetrachloride, methyl isobutylketone, and the like.

The process of the present invention is further illustrated by the following examples which are solely demonstrative thereof and not limited thereby.

Unless otherwise noted, all parts are parts by weight. The term HPLC designates high performance liquid chromatography and the term HRGC designates high resolution gas chromatography.

EXAMPLE 1

Preparation of diethyl chlorofumarate and diethyl chloromaleate from diethyl dichlorosuccinate

A stirred mixture of anhydrous sodium carbonate (9.8g, 0.093 mole) and tetra-n-butylammonium bromide (0.9g, 0.0028 mole) in 35g water is treated with diethyl dichlorosuccinate (15.0g, 0.062 mole) and heated at 55°C for 2 hours, until reaction is complete by HPLC analysis. The reaction mixture is cooled to room temperature and extracted with toluene. The extracts are combined and distilled to give the title product in 95% yield as a 6:1 mixture of diethyl chlorofumarate and diethyl chloromaleate, respectively, identified by HRGC analysis.

EXAMPLE 2

Kinetic study of the process of the invention. (Presence of a phase transfer catalyst)

A stirred mixture of anhydrous sodium carbonate (16.0g, 0.15 mole) and tetra-n-butylammonium bromide (2.2g, 0.0068 mole) is treated with diethyl dichlorosuccinate (53.1g, 0.22 mole). The reaction mixture is heated to 60°C and held at that temperature until the reaction is complete. Periodically, samples are removed and analyzed by gas chromatography. The results are shown in Table I below.

When the reaction is complete, methylene chloride is added to the reaction mixture and the phases are separated. The organic phase is distilled to give the title product, 45.1g, (97.4% pure) in 96.6% yield consisting of 83.3% diethyl chlorofumarate and 14.1% diethyl chloromaleate, identified by HRGC analysis.

Table I

Rate Of Formation Of Chlorofumarate And Chloromaleate In The Presence Of a Phase Transfer Catalyst			
Reaction Time (Minutes)	% DEDCS ¹	% DECF ²	% DECM ³
0	91.6	0	0
30	8.2	75.9	9.5
50	5.5	81.2	11.2
90	0	83.7	13.8

1 Diethyl dichlorosuccinate

2 Diethyl chlorofumarate

3 Diethyl chloromaleate

As can be seen in Table I, the reaction is essentially complete in about 1 hour at 60°C and the overall yield is essentially quantitative.

EXAMPLE 3

Comparative kinetic study. (Absence of a phase transfer catalyst)

A stirred mixture of anhydrous sodium carbonate (5.3g, 0.05 mole) in water is treated with diethyl dichlorosuccinate (17.7g, 0.065 mole). The reaction mixture is heated to 60°C and held at that temperature until the reaction is spent. Samples are removed periodically and analyzed as described in Example 2. The results are shown in Table II below. The measurement taken at reaction time equal to zero was taken after starting to heat to 60°C.

Table II

Rate Of Formation Of Chlorofumarate And Chloromaleate In The Absence Of A Phase Transfer Catalyst			
Reaction Time (Minutes)	% DEDCS ¹	% DECF ²	% DECM ³
0	94.2	3.5	0
80	48.0	44.3	5.3
130	37.8	53.1	6.7
190	29.2	60.5	7.8
240	23.3	65.5	8.8
280	19.6	68.0	9.3
355	15.7	72.0	9.9

1 Diethyl dichlorosuccinate

2 Diethyl chlorofumarate

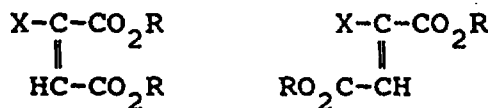
3 Diethyl chloromaleate

As can be seen in Table II, the reaction is still incomplete after 6 hours at 60°C.



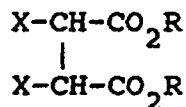
Claims

1. A process for the manufacture of a compound of formula I



I

wherein X is halogen and R is C₁-C₆alkyl, which comprises reacting a compound of formula II



II

wherein X and R are as described for formula I, with at least one molar equivalent of a base in the presence of a phase transfer catalyst and water.

2. The process according to claim 1 wherein the base is present in the amount of 1.0 to 1.5 molar equivalents.
3. The process according to claim 1 wherein the base is an alkali metal hydroxide, carbonate or bicarbonate.
4. The process according to claim 3 wherein the base is an alkali metal carbonate.
5. The process according to claim 1 wherein the phase transfer catalyst is a tetraalkylated ammonium salt.
6. The process according to claim 5 wherein the phase transfer catalyst is tetra-n-butylammonium bromide.
7. The process according to claim 1 wherein the reaction is run at an elevated temperature.
8. The process according to claim 7 wherein the temperature is 45°-75°C.
9. The process according to claim 8 wherein the temperature is 50°-60°C.
10. The process according to claim 1 wherein X is Cl and R is methyl or ethyl.



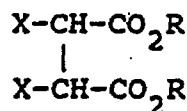
Patentansprüche

1. Verfahren zur Herstellung einer Verbindung der Formel I



I

wobei X Halogen ist und R C₁-C₆-Alkyl ist, das umfaßt eine Umsetzung einer Verbindung der Formel II



II

wobei X und R wie für Formel I beschrieben sind, mit mindestens einem molaren Äquivalent einer Base in Gegenwart eines Phasentransferkatalysators und Wasser.

2. Verfahren gemäß Anspruch 1, wobei die Base in einer Menge von 1,0 bis 1,5 molaren Äquivalenten vorliegt.
3. Verfahren gemäß Anspruch 1, wobei die Base ein Alkalimetallhydroxid, Carbonat oder Bicarbonat ist.
4. Verfahren gemäß Anspruch 3, wobei die Base ein Alkalimetallcarbonat ist.
5. Verfahren gemäß Anspruch 1, wobei der Phasentransferkatalysator ein tetraalkyliertes Ammoniumsalz ist.
6. Verfahren gemäß Anspruch 5, wobei der Phasentransferkatalysator Tetra-n-butylammoniumbromid ist.
7. Verfahren gemäß Anspruch 1, wobei die Reaktion bei einer erhöhten Temperatur geführt wird.
8. Verfahren gemäß Anspruch 7, wobei die Temperatur 45° bis 75°C ist.
9. Verfahren gemäß Anspruch 8, wobei die Temperatur 50° bis 60°C ist.
10. Verfahren gemäß Anspruch 1, wobei X Cl ist und R Methyl oder Ethyl ist.

Revendications

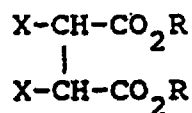
1. Un procédé pour la fabrication d'un composé de formule I



I

où X est un atome d'halogène et R est un groupe alkyle en C₁-C₆, qui comprend la réaction d'un composé de formule

II



II

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où X et R sont tels que définis pour la formule I, avec au moins un équivalent molaire d'une base en présence d'un catalyseur de transfert entre phases et d'eau.

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2. Le procédé selon la revendication 1, dans lequel la base est présente en une quantité de 1,0 à 1,5 équivalent molaire.

3. Le procédé selon la revendication 1, dans lequel la base est un hydroxyde, carbonate ou bicarbonate de métal alcalin.

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4. Le procédé selon la revendication 3, dans lequel la base est un carbonate de métal alcalin.

5. Le procédé selon la revendication 1, dans lequel le catalyseur de transfert entre phases est un sel d'ammonium tétra-alkylé.

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6. Le procédé selon la revendication 5, dans lequel le catalyseur de transfert entre phases est le bromure de tétra-*n*-butylammonium.

7. Le procédé selon la revendication 1, dans lequel la réaction est conduite à une température élevée.

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8. Le procédé selon la revendication 7, dans lequel la température est de 45° à 75°C.

9. Le procédé selon la revendication 8, dans lequel la température est de 50° à 60°C.

10. Le procédé selon la revendication 1, dans lequel X est Cl et R est un groupe méthyle ou éthyle.

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