

Complexes having optically active ligands, a process for their preparation and their use

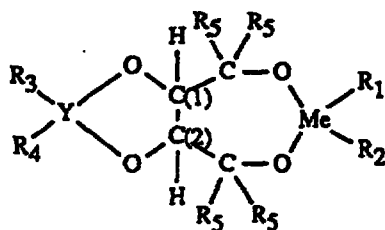
The invention relates to metal complexes having ligands of optically active 1,3-dioxolane-4,5-dimethanols, a radical which can be conferred to carbonyl groups or groups analogous to carbonyl and a cyclopentadienyl radical, to a process for their preparation and to their use as enantioselective reactants for aldehydes, ketones and N-substituted imines.

It is known from Helvetica Chimica Acta, volume 64, fasc. 7, No. 243, pages 2485-2488 (1981), Organometallics 3, pages 1716-1717 (1984) and Chem. Ber. 118, 3673-3682 (1985) that titanium compounds having a transferable group and a radical derived from a chiral monohydroxy or dihydroxy compound, for example 1,3-dioxolane-4,5-dimethanols, can be reacted with aldehydes to give secondary alcohols. Aliphatic chiral hydroxy compounds as ligands result in only moderate stereoselective conversions, whereas high optical yields can be achieved using chiral dinaphthol as the ligand. The chiral ligands used are difficult of access and expensive in industrial amounts.

EP-A 0,254,685 describes cyclopentadienyl-titanium complexes having optically active sugar ligands which produce chiral secondary alcohols at high enantioselective conversions in high yields when reacted with, for example, aldehydes. By virtue of the natural sugar ligands, it is, however, only possible to obtain one enantiomer of the alcohol.

There is a requirement for low-cost chiral organometallic reagents which are available in industrial quantities and have high stereoselective conversions when reacted with prochiral aldehydes, ketones and imines, in which the chiral ligand is derived from one of the pairs of enantiomers or diastereomers so that, for example when reacted with aldehydes, a secondary alcohol having the R-configuration or the S-configuration can be prepared in a controlled manner.

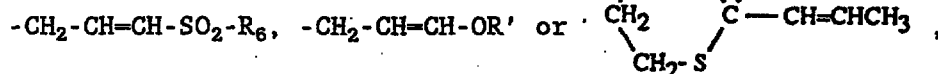
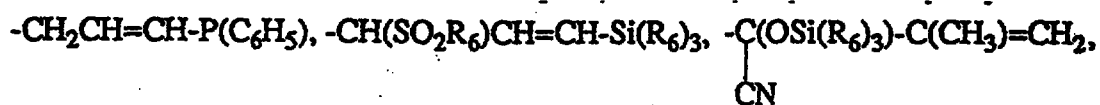
The invention relates to compounds of the formula I



(I).

in which

a) Me is tetravalent titanium and R_1 is allyl, 1-methylallyl, 2-methylallyl,



R_6 is phenyl, benzyl or C_1 - C_8 alkyl and R' is C_1 - C_8 -alkyl or $-\text{Si}(\text{R}_6)_3$, or R_1 is a radical of an enol, enamine or enhydrazine which has up to 20 C atoms and which is attached via the O atom or N atom; or

b) Me is tetravalent zirconium or hafnium and R_1 is linear or branched C_1 - C_{18} alkyl, C_2 - C_{12} alkenyl, C_2 - C_{12} alkynyl or C_3 - C_8 cycloalkyl or C_3 - C_8 cycloalkenyl each of which is unsubstituted or substituted by C_1 - C_4 alkyl, or is C_6 - C_{12} aryl, C_7 - C_{16} alkaryl, C_8 - C_{16} aralkyl, C_8 - C_{16} alkaralkyl, C_8 - C_{16} aralkenyl, C_9 - C_{16} alkaralkenyl, C_8 - C_{16} aralkynyl or C_9 - C_{16} alkaralkynyl each of which is unsubstituted or monosubstituted or polysubstituted by $(\text{C}_6\text{H}_5)_2\text{P}-$, $(\text{R}_6\text{O})_2\text{P}(\text{O})-$, $(\text{R}_6)_3\text{Si}-$, $(\text{R}_6)_3\text{SiO}-$, R_6SO_2- , $-\text{S}-\text{C}_2-\text{C}_4\text{alkylene}-\text{S}-$ or $-\text{O}-\text{C}_2-\text{C}_4\text{alkylene}-\text{O}-$ in which R_6 is phenyl, benzyl or C_1 - C_8 alkyl, cyano, F, nitro, C_1 - C_{12} alkylthio, C_1 - C_{12} alkoxy, $-\text{NR}_{18}\text{R}_{19}$ or $-\text{COR}_7$ in which R_7 is C_1 - C_{12} alkoxy, R_{18} and R_{19} are C_1 - C_{12} alkyl, cyclopentyl, cyclohexyl, phenyl, benzyl or $(\text{R}_6)_3\text{Si}$, or R_{18} and R_{19} together are C_3 - C_8 alkylene, 3-oxapentylene or $-\text{Si}(\text{R}_6)_2-\text{C}_2-\text{C}_3\text{alkylene}-\text{Si}(\text{R}_6)_2-$; or R_1 is a radical of an enol, enamine or enhydrazine which has up to 20 C atoms and which is attached via the O atom or N atom; R_2 is cyclopentadienyl or indenyl each of which is unsubstituted or substituted by C_1 - C_8 alkyl, C_2 - C_8 alkenyl, C_1 - C_8 alkoxy, C_5 - or C_6 cycloalkyl, C_6 - C_{12} aryl, C_7 - C_{13} aralkyl, tri- C_1 - C_6 -alkoxysilyl, tri- C_1 - C_6 alkylsilyl, R_6SO_2 - or halogen, Y is C, Si or $-\text{Si}-\text{O}-\text{SiR}_3\text{R}_4-$, R_3 and R_4 independently of one another are H, linear or branched C_1 - C_{18} alkyl or C_2 - C_{12} alkenyl or C_3 - C_8 cycloalkyl or

C₃-C₈cycloalkenyl each of which is unsubstituted or substituted by C₁-C₄alkyl, or are C₆-C₁₂aryl, C₇-C₁₆aralkyl, C₇-C₁₆alkaryl, C₈-C₁₆alkaralkyl, C₈-C₁₆aralkenyl or C₉-C₁₆alkaralkenyl, or R₃ and R₄ together are -C_nH_{2n}- in which n is 3 to 7 and which is unsubstituted or substituted by -CN, -F, -Cl, -Br, nitro, C₁-C₁₂alkylthio or C₁-C₁₂alkoxy, R₅ is C₆-C₁₀aryl, heteroaryl, benzyl naphthylmethyl or heteroarylalkyl each of which is unsubstituted or substituted by C₁-C₁₂alkyl, C₁-C₁₂alkoxy, C₁-C₁₂alkylthio, cyano, di-(C₁-C₄alkyl)-amino, di-(C₁-C₄alkyl)-aminocarbonyl, fluorine, C₆-C₁₀aryl, R₅SO₂-, C₁-C₁₂alkoxymethyl, C₁-C₁₂alkylthiomethyl, di-(C₁-C₄alkyl)-aminomethyl or di-(C₁-C₄alkyl)-aminocarbonylmethyl, the heteroaryl being 5- or 6-membered and containing a heteroatom from the group O, S and N; or is C₁-C₁₂alkyl, C₂-C₁₂alkenyl, C₂-C₁₂alkynyl, C₃-C₈cycloalkyl or C₃-C₈cycloalkenyl, and C(1) and C(2) are chiral C atoms, predominantly in the form of enantiomers or diastereomers.

If Y is a C atom, this can also be chiral, in which case diastereomers can be formed.

R₁ is a group which is transferable to carbonyl and imine compounds.

As alkyl, R₁ contains 1 to 18, especially 1 to 12 and particularly 1 to 6, C atoms. Examples are methyl, ethyl, and the isomers of propyl, butyl, pentyl, hexyl, heptyl, octyl, nonyl, decyl, undecyl, dodecyl, tridecyl, tetradecyl, pentadecyl, hexadecyl, heptadecyl and octadecyl.

As alkenyl, R₁ contains 2 to 12, especially 2 to 6, C atoms. It can be either alkenylalkyl of the formula (C_nH_{2n-1})-C_mH_{2m} in which n is a number from 2 to 12, preferably 2 to 6, and m is a number from 1 to 6, preferably 1 or 2, or alkylvinyl which preferably has 1 to 10 C atoms in the alkyl group. Examples are: allyl, 1-methylallyl, 2-methylallyl, but-2-en-4-yl, but-1-en-3-yl, pent-3-en-5-yl, pent-1-en-3-yl, hex-4-en-6-yl, hex-2-en-4-yl, hept-2-en-1-yl, hept-3-en-5-yl, oct-6-en-8-yl, oct-2-en-4-yl, non-2-en-2-yl, dec-8-en-10-yl, dodec-3-en-12-yl, vinyl, crotonyl, n-but-1-en-1-yl, but-2-en-3-yl, pent-1-en-2-yl and hex-1-en-1-yl, R₁ is preferably vinyl or allyl. It is particularly preferable for R₁ to be allyl.

As alkynyl, R_1 contains 2 to 12, especially 2 to 6, C atoms. The alkynyl group can either be located in the carbon chain or can be terminal.

Examples are: ethynyl, prop-2-yn-3-yl, pent-2-yn-4-yl, pent-1-yn-5-yl and hex-1-yn-6-yl. Ethynyl and propargyl are preferred.

As cycloalkyl or cycloalkenyl, R_1 contains 3 to 8, especially 3 to 6 and particularly 5 or 6, ring C atoms and these can be substituted by

C_1 - C_4 alkyl. Examples are cyclopropyl, cyclobutyl, cyclopentyl, cyclohexyl, cycloheptyl, cyclooctyl, cyclodecyl, cyclododecyl, cyclopropenyl, cyclobutenyl, cyclopent-1-en-3-yl, cyclopent-1-en-1-yl, cyclohex-1-en-3-yl, cyclohex-2-en-1-yl, cyclohept-1-en-3-yl, cyclooct-1-en-3-yl and 4-methylcyclohex-1-en-3-yl.

As aryl, R_1 contains 6 to 12 C atoms and is preferably naphthyl and especially phenyl.

As alkaryl, R_1 contains 7 to 16 C atoms. The aryl is preferably phenyl.

Examples are: methylphenyl, dimethylphenyl, ethylphenyl, n-propylphenyl, isopropylphenyl, n-, iso- and t-butylphenyl, di-t-butylphenyl, hexylphenyl, octylphenyl and decylphenyl.

As aralkyl, R_1 contains 7 to 16, especially 7 to 10, C atoms. The aryl in this is preferably phenyl. Examples are: benzyl, 1-phenylethyl, 2-phenylethyl, 1-phenylpropyl, 2-phenylpropyl, phenylbutyl, phenylpentyl and phenylhexyl. Benzyl and 1-phenylethyl or 2-phenylethyl are preferred.

As alkaralkyl, R_1 can contain 8 to 16 C atoms. The aryl in this is preferably phenyl. Examples are: methylbenzyl, ethylbenzyl, n-propylbenzyl, isopropylbenzyl, dimethylbenzyl, n-, iso- or t-butylbenzyl, hexylbenzyl, nonylbenzyl, 1-methylphenyleth-2-yl, 2-methylphenyleth-2-yl and 1-methylphenylprop-3-yl.

As aralkenyl, R_1 contains 8 to 16 C atoms. The aryl in this is preferably phenyl. Examples are: phenylvinyl, 1-phenylprop-1-en-3-yl, 2-phenylprop-2-en-1-yl, 3-phenylprop-1-en-3-yl, phenylbutenyl, phenylpentenyl or phenylhexenyl.

As alkaralkenyl, R_1 contains 9 to 16 C atoms. The aryl in this is preferably phenyl. Examples are: methylphenylvinyl, ethylphenylvinyl, dimethylphenylvinyl, 1-methylphenylprop-2-en-3-yl and 2-methylphenylprop-2-en-3-yl.

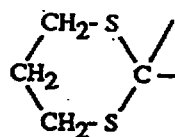
As aralkynyl, R_1 contains 8 to 16 C atoms. The aryl in this is preferably phenyl. Examples are: phenylethynyl, phenylpropynyl and 1-phenylbut-3-yn-4-yl.

As alkaralkynyl, R_1 contains 9 to 16 C atoms. The aryl in this is preferably phenyl. Examples are: methylphenylethynyl and methylphenylpropargyl.

Some examples of radicals R_1 are $-\text{CH}_2\text{P}(\text{O})(\text{OR}_6)_2$, methyl, ethyl, vinyl, allyl, crotyl and substituted allyl radicals, for example $-\text{CH}_2\text{CH}=\text{CH}-\text{P}(\text{C}_6\text{H}_5)_2$, $-\text{CH}(\text{SO}_2\text{R}_6)\text{CH}=\text{CH}-\text{Si}(\text{R}_6)_3$, $-\text{C}(\text{OSi}(\text{R}_6)_3)-\text{C}(\text{CH}_3)=\text{CH}_2-\text{CH}_2$,



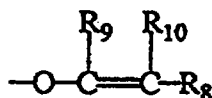
$-\text{CH}=\text{CH}-\text{SO}_2-\text{R}_6$, $-\text{CH}_2-\text{CH}=\text{CH}-\text{OR}'$ and



$-\text{CH}=\text{CHCH}_3$, R_6 can be as defined above. Examples of R' can be

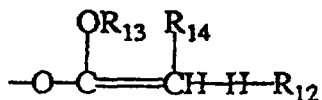
C_1-C_8 alkyl or $-\text{Si}(\text{R}_6)_3$.

The enol radical R_1 is attached to the metal Me via the enol oxygen atom. Linear or cyclic enols are possible. The enol radical R_1 contains up to 20, particularly 2 to 16, C atoms. The cyclic enols can contain 3 to 8, particularly 4 to 6, ring atoms, it being possible for the ring to be formed from atoms of the group comprising C, O, S and N. The enol radical R_1 can, for example, have the general formula

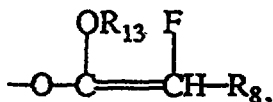


R_9 can, for example, be H or substituted or unsubstituted C_1-C_8 alkyl, C_1-C_8 alkoxy, C_1-C_8 alkylthio, cycloalkyl having 3 to 6 ring C atoms, phenyl, benzyl, phenoxy, phenylthio, benzyloxy, benzylthio, $\text{R}_{10}\text{R}_{11}\text{N}-$, $-\text{OB}(\text{OC}_1-\text{C}_8\text{-alkyl})_2$, $-\text{OSn}(\text{R}_{11})_3$ in which R_{11} is C_1-C_8 alkyl, phenyl or

benzyl, $-\text{OTi}(\text{R}_{11})_3$, $-\text{OLi}$ or $-\text{OSi}(\text{R}_6)_3$. R_{10} and R_8 independently can be H, F or substituted or unsubstituted $\text{C}_1\text{-C}_8$ alkyl, $\text{C}_1\text{-C}_8$ alkoxy, $\text{C}_1\text{-C}_8$ alkylthio, cycloalkyl having 3 to 6 ring C atoms, phenyl, benzyl, phenoxy, phenylthio, benzyloxy, benzylthio, $\text{R}_{18}\text{R}_{19}\text{N-}$ or $-\text{OSi}(\text{R}_6)_3$. Suitable substituents for R_9 are the substituents mentioned for R_1 . The secondary amino group can contain $\text{C}_1\text{-C}_8$ alkyl groups, phenyl, benzyl or $(\text{R}_6)_3\text{Si}$ groups. Secondary amino groups preferably containing 4 to 6 ring atoms from the group comprising C, O, S, Si and N are also possible. R_9 and R_{10} or R_{10} and R_8 , respectively, together with the C atoms to which they are attached, can form a 3-membered to 8-membered, preferably 4-membered to 6-membered, carbocyclic or heterocyclic ring, it being possible for the heterocyclic ring to contain atoms from the group comprising C, O, S and N. The rings can be substituted as defined above for R_1 . A preferred group is formed by ester-enolates in which R_9 is $\text{C}_1\text{-C}_8$ alkoxy. Another preferred group is formed by enols of glycine derivatives which, for example, have the formula



R_{13} can, for example, be benzyl, phenyl or $\text{C}_1\text{-C}_8$ alkyl, R_{14} and R_{12} can be $\text{C}_1\text{-C}_8$ alkyl, phenyl or benzyl, or they can, together with the N atom, form a heterocyclic structure which can contain further heteroatoms from the group comprising O, S or N. R_{13} and R_{14} together can also be methylene or ethylene. R_{14} and R_{12} can also be detachable protective groups, for example $(\text{R}_6)_3\text{Si-}$ or $-\text{Si}(\text{R}_6)_2\text{CH}_2\text{CH}_2\text{Si}(\text{R}_6)_2-$. R_{13} , R_{14} and R_{12} can be substituted as defined above for R_1 . Another preferred group is formed by enol radicals of the formula

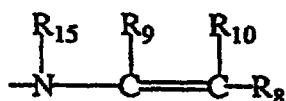


in which R_8 and R_{13} are as defined above.

R_1 can also be the radical of an enamine or enhydrazine each of which is attached to the metal Me via an N atom. Linear or cyclic enamines or enhydrazines containing up to 20, particularly 2 to 16, C atoms are possible. The cyclic enamines and enhydrazines can contain 3 to 8,

particularly 4 to 6, ring atoms, it being possible for the ring to be formed from atoms of the group comprising C, O, S and N. The N atom of the enamine group can be substituted, preferably by C₁-C₈alkyl, phenyl, benzyl or protective groups, for example (R₈)₃Si-.

The enamine radical or enhydrazine radical can, for example, have the formula



in which R₉, R₁₀ and R₈ are as defined above for the enol radical R₁, R₉ and R₁₅, together with the C-N- group, or R₁₀ and R₁₅, together with the -N-C=C- group, form a 3-membered to 8-membered, preferably 4-membered to 6-membered, heterocyclic structure which can contain further heteroatoms from the group comprising O, S and N, and R₁₅ is H, C₁-C₈alkyl, phenyl, benzyl, C₁-C₈alkoxy, phenoxy, benzyloxy, (R₈)₃Si- or -NR₁₆R₁₇ in which R₈ is as defined above and R₁₆ and R₁₇ are H, C₁-C₈alkyl, phenyl or benzyl. In a preferred group R₉ is H, C₁-C₈alkyl or phenyl and R₁₀ and R₈ are H. The enol, enamine and enhydrazine radicals are C-nucleophiles capable of aldol reactions.

As the radical of an enol, R₁ can also be a ketone-enolate containing, in particular, up to 16 C atoms, especially 4 to 16 C atoms. These enolates can be derived from β-ketoaldehydes, 1,3-diketones, β-ketocarboxylic acid esters and β-ketocarboxylic acid esters and β-ketocarboxamides. The ester group preferably contains radicals of aliphatic C₁-C₆alcohols. The N atom in the amide group can be monosubstituted or disubstituted, preferably by C₁-C₆ alkyl. The following are examples: β-ketobutyraldehyde, acetylacetone, benzoyl acetone, ethyl acetoacetate and acetoacetamide.

The radical R₁ can be monosubstituted or polysubstituted, preferably monosubstituted to trisubstituted and particularly monosubstituted or disubstituted. If the substituent is alkoxy or alkylthio, it preferably contains 1 to 6 C atoms. R₇ is preferably the radical of an aliphatic alcohol having 1 to 6 C atoms. Possible examples are radicals of aliphatic or cycloaliphatic alcohols. The following are examples:

methoxy, ethoxy, n-propoxy, isopropoxy, n-, iso- and t-butoxy, pentoxy, hexyloxy, cyclopentyloxy and cyclohexyloxy.

As alkyl, R_6 preferably contains 1 to 6 C atoms, particularly 1 to 4 C atoms. The alkoxy, alkylthio, $-S-C_2-C_4\text{alkylene}-S-$ and $-O-C_2-C_4\text{alkylene}-O-$ groups can be attached to a C atom; they are then acetal or ketal groups.

When it is a substituent, the secondary amino has the formula $-NR_{18}R_{19}$ in which R_{18} and R_{19} are $C_1-C_{12}\text{alkyl}$, preferably $C_1-C_6\text{alkyl}$, cyclopentyl, cyclohexyl, phenyl, benzyl or $(R_6)_3Si$, or R_{18} and R_{19} together are $C_3-C_6\text{alkylene}$, 3-oxapentylene or $-Si(R_6)_2-C_2-C_3\text{alkylene}-Si(R_6)_2-$ and R_6 is as defined above.

In a preferred subgroup R_1 is linear or branched $C_1-C_{12}\text{alkyl}$, $C_2-C_{12}\text{alkenyl}$, $C_2-C_{12}\text{alkynyl}$, cycloalkyl or cycloalkenyl each of which has 3 to 8 ring C atoms, $C_6-C_{12}\text{aryl}$, $C_7-C_{16}\text{alkaryl}$, $C_7-C_{16}\text{aralkyl}$, $C_8-C_{16}\text{alkaralkyl}$, $C_8-C_{16}\text{aralkenyl}$, $C_9-C_{16}\text{alkaralkenyl}$, $C_8-C_{16}\text{aralkynyl}$ or $C_9-C_{16}\text{alkaralkynyl}$ each of which is unsubstituted or monosubstituted or polysubstituted by $-NR_{18}R_{19}$, cyano, nitro, $C_1-C_6\text{alkylthio}$, $C_1-C_6\text{alkoxy}$ or $-COR_7$ in which R_7 is $C_1-C_{12}\text{alkoxy}$; or R_1 is a radical of an enol, enamine or enhydrazine which is attached via the enol oxygen atom or via the enamine nitrogen atom.

In another preferred subgroup R_1 is linear or branched $C_1-C_6\text{alkyl}$, $C_2-C_6\text{alkenyl}$, $C_2-C_6\text{alkynyl}$, cycloalkyl or cycloalkenyl each of which has 3 to 6 ring C atoms, phenyl, $(C_1-C_{10}\text{alkyl})\text{-phenyl}$, phenyl- $(C_1-C_2\text{alkyl})$, $(C_1-C_8\text{alkyl})\text{-phenyl}$, phenylvinyl, phenylethynyl or phenylpropargyl, $(C_1-C_8\text{alkyl})\text{-phenylvinyl}$, $(C_1-C_6\text{alkyl})\text{-phenylethynyl}$ or $(C_1-C_7\text{alkyl})\text{-phenylpropargyl}$ each of which is unsubstituted or monosubstituted or polysubstituted by $-NR_{18}R_{19}$, cyano, nitro, $C_1-C_6\text{alkoxy}$, $C_1-C_6\text{alkylthio}$ or $-COR_7$ in which R_7 is $C_1-C_{12}\text{alkoxy}$; or R_1 is a radical of an enol, enamine or enhydrazine which has up to 20 C atoms and which is attached via an enol oxygen atom or enamine nitrogen atom.

It is particularly preferable for R_1 to be methyl, ethyl, vinyl, allyl, crotonyl, ethynyl, propargyl, cyclopentyl, cyclohexyl, cyclopentenyl, cyclohexenyl, phenyl, methylphenyl, benzyl, 1-phenyleth-2-yl,

methylbenzyl, phenylvinyl, methylphenylvinyl, phenylethynyl, phenylpropargyl, methylphenylethynyl, dimethylphenylethynyl or dimethylphenylpropargyl each of which is unsubstituted or monosubstituted or polysubstituted by $-NR_{18}R_{19}$, cyano, nitro, C_1-C_6 alkoxy, C_1-C_6 alkylthio or $-COR_7$ in which R_7 is C_1-C_{12} alkoxy; or R_1 is a radical of an enol, enamine or enhydrazine which has 2 to 16 C atoms and which is attached via the enol oxygen atom or via the enamino nitrogen atom.

In particular R_1 is methyl, ethyl, allyl or the radical of an ester-enolate which can be substituted by secondary amino.

When R_2 is cyclopentadienyl or indenyl, it can be substituted, for example by 1 to 5, for example 1 or 2, substituents. Examples of suitable substituents are alkyl preferably having 1 to 6 C atoms, alkenyl preferably having 2 to 6 C atoms, alkoxy preferably having 1 to 6 C atoms, cycloalkyl preferably having 5 or 6 ring C atoms, aryl preferably having 6 to 12 C atoms, aralkyl preferably having 7 to 13 C atoms, trialkoxysilyl preferably having 1 to 6 C atoms in the alkoxy groups, trialkylsilyl preferably having 1 to 6 C atoms in the alkyl groups, halogen, preferably F, Cl or Br, or R_6-SO_2- in which R_6 is preferably phenyl, tolyl, benzyl or C_1-C_6 alkyl. Aryl is especially phenyl and aralkyl is especially benzyl.

If Me is titanium, R_2 as cyclopentadienyl or indenyl preferably contains no substituents or 1 to 5 substituents, particularly 1, 2 or 3. If Me is zirconium or hafnium, R_2 as cyclopentadienyl or indenyl preferably contains 3 to 5 substituents, particularly methyl or trialkylsilyl groups.

In a preferred embodiment R_2 is cyclopentadienyl or indenyl which is unsubstituted or substituted by C_1-C_6 alkyl, C_2-C_6 alkenyl, C_1-C_6 alkoxy, cycloalkyl having 5 or 6 ring C atoms, phenyl, benzyl, trialkoxysilyl having 1 to 6 C atoms in the alkoxy groups, trialkylsilyl having 1 to 6 C atoms in the alkyl groups, F, Cl, Br or R_6SO_2- .

In another preferred embodiment R_2 is cyclopentadienyl which is unsubstituted or substituted by C_1-C_6 alkyl or trimethylsilyl.

It is particularly preferable for R_2 to be cyclopentadienyl, pentamethylcyclopentadienyl, trimethylsilylcyclopentadienyl, bis-(trimethylsilyl)-cyclopentadienyl or tris-(trimethylsilyl)-cyclopentadienyl.

The same preferences as for R_1 apply to R_3 and R_4 when they are hydrocarbon radicals.

Examples of R_1 have been enumerated. As alkyl, R_3 and R_4 contain 1 to 18, especially 1 to 12 and particularly 1 to 6, C atoms. The following are examples: methyl, ethyl, n-propyl, isopropyl, n-, iso- or t-butyl, pentyl, hexyl, heptyl, octyl, nonyl, decyl, undecyl, dodecyl, tetradecyl, hexadecyl, octadecyl and eicosyl. Methyl, ethyl, propyl and butyl are particularly preferred. As cycloalkyl, R_3 and R_4 preferably contain 5 or 6 ring C atoms. Examples are cyclopentyl, cyclohexyl and methylcyclohexyl. When together as the group $-C_nH_{2n}-$, R_3 and R_4 are linear or branched alkylene having 3 to 7, preferably 4 to 6, C atoms in the alkylene group. Substituents for R_3 and R_4 which are particularly preferred are -F, -Cl, C_1 - C_6 alkylthio or C_1 - C_6 alkoxy.

In a preferred embodiment R_3 and R_4 independently of one another are H, C_1 - C_{12} alkyl, C_2 - C_{12} alkenyl, cycloalkyl or cycloalkenyl each of which has 5 or 6 ring C atoms and is unsubstituted or substituted by C_1 - C_4 alkyl, or are phenyl, naphthyl, benzyl, C_1 - C_6 alkylphenyl or C_1 - C_6 alkylbenzyl or R_3 and R_4 together are $-C_nH_{2n}-$ in which n is 4 to 6 and which is unsubstituted or substituted by -CN, -F, -Cl, nitro, C_1 - C_6 alkylthio or C_1 - C_6 alkoxy.

In another preferred embodiment R_3 and R_4 independently of one another are H, C_1 - C_6 alkyl, for example methyl, ethyl, propyl and butyl, cyclopentyl or cyclohexyl each of which is unsubstituted or substituted by C_1 - C_4 alkyl, or are phenyl, benzyl, C_1 - C_6 alkylphenyl or C_1 - C_6 alkylbenzyl or R_3 and R_4 together are pentamethylene or tetramethylene.

A preferred subgroup is formed by compounds in which R_3 is H and R_4 or R_3 and R_4 are one of the hydrocarbon radicals defined above.

Y in formula I is especially C. If this C atom is chiral, the compounds

of the formula I embrace diastereomers. R_3R_4Y can be R_3R_4Si in which R_3 and R_4 are preferably C_1-C_6 alkyl, especially C_1-C_4 alkyl. R_3R_4Y can also be $-SiR_3R_4-O-SiR_3R_4-$ in which R_3 and R_4 are preferably C_1-C_4 alkyl.

As aryl, R_5 is C_6-C_{10} aryl and is especially phenyl or naphthyl. As heteroaryl, R_5 is 5-membered or 6-membered heteroaryl having a heteroatom from the group comprising O, S and N. As aralkyl, R_5 is benzyl or naphthylmethyl and heteroarylmethyl in which the heteroaryl contains 5 or 6 ring members and heteroatoms from the group comprising O, S and N. Examples of heteroaryl are pyridyl, furyl, thiophenyl and pyrrolyl. The substituents alkyl, alkoxy and alkylthio preferably contain 1 to 6 C atoms.

As alkyl, alkenyl and alkynyl, R_5 can follow the preferences indicated for R_1 .

R_5 is preferably C_2-C_4 alkenyl, 2-furyl or C_6-C_{10} aryl each of which is unsubstituted or substituted by C_1-C_6 alkyl or F. Aryl is preferably methylphenyl, pentafluorophenyl, phenyl or naphthyl. R_5 is especially propenyl, phenyl, pentafluorophenyl, methylphenyl or furyl.

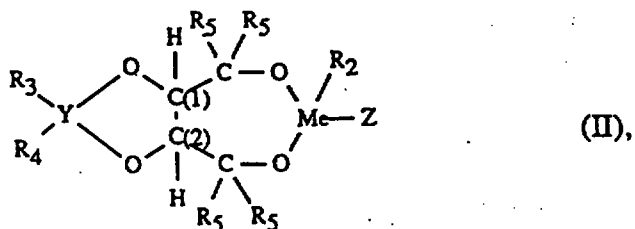
A preferred embodiment is constituted by compounds of the formula I in which R_1 is linear or branched C_1-C_4 alkyl, C_2-C_6 alkenyl or cycloalkyl or cycloalkenyl each of which has 3 to 6 ring C atoms and is unsubstituted or substituted by C_1-C_4 alkyl, or R_1 is phenyl, benzyl, C_1-C_6 alkylphenyl or C_1-C_6 alkylbenzyl each of which is unsubstituted or [lacuna] by secondary amino, cyano, nitro, C_1-C_6 alkoxy, C_1-C_6 alkylthio or $-COR_7$ in which R_7 is C_1-C_{12} alkoxy, or R_1 is a radical of an enol, enamine or enhydrazine which has up to 12 C atoms and which is attached via an enol oxygen atom or an enamino nitrogen atom, R_2 is cyclopentadienyl which is unsubstituted or substituted by C_1-C_4 alkyl or trimethylsilyl, Y is C, R_3 is H or is as defined for R_4 and R_4 is C_1-C_{12} alkyl, phenyl, benzyl, cyclopentyl or cyclohexyl or R_3 and R_4 together are tetramethylene or pentamethylene, R_5 is C_2-C_4 alkenyl, phenyl, pentafluorophenyl or furyl and Me is tetravalent titanium, zirconium or hafnium.

The C(1) and C(2) atoms in formula I preferably have the R, R-configuration or the S,S-configuration. If Y in formula I is a chiral

C atom, the C(1) and C(2) atoms can also have the R,S-configuration or the S,R-configuration.

A particularly preferred embodiment is constituted by compounds of the formula I in which R_1 is C_1 - C_4 alkyl, allyl or the radical of an ester-enolate which has 2 to 12 C atoms and can be substituted by secondary amino, R_2 is cyclopentadienyl which is unsubstituted or substituted by methyl or trimethylsilyl, R_3 is H or is as defined for R_4 and R_4 is C_1 - C_6 alkyl, R_5 is propenyl, phenyl, pentafluorophenyl or furyl and Me is tetravalent titanium, zirconium or hafnium and Y is C.

The compounds of the formula I can be prepared by reacting a compound of the formula II



with a compound of the formula III

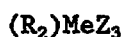


in the presence of an inert solvent and an inert protective gas, R_1 , R_2 , R_3 , R_4 , R_5 , Me and Y being as defined above, Z being an anion and $M^{\oplus}$ being $Li^{\oplus}$, $Na^{\oplus}$, $K^{\oplus}$, $MgX^{\oplus}$, $ZnX^{\oplus}$, $CdX^{\oplus}$, $HgX^{\oplus}$, $CuX^{\oplus}$ or quaternary ammonium, X being halogen.

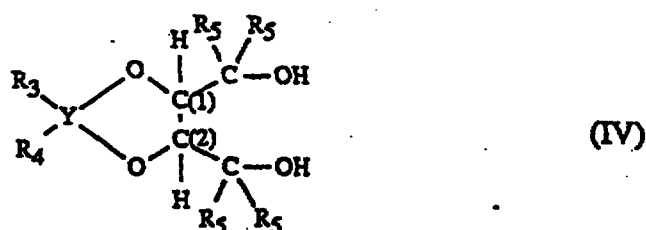
In the group $M^{\oplus}$ of the formula III X is preferably Cl, Br or I. $M^{\oplus}$ is preferably $Li^{\oplus}$, $MgCl^{\oplus}$, $MgBr^{\oplus}$, $ZnCl^{\oplus}$, $ZnBr^{\oplus}$, $CdCl^{\oplus}$, $CdBr^{\oplus}$ or tetraalkylammonium having 1 to 6 C atoms in the alkyl groups. It is particularly preferable for $M^{\oplus}$ to be $MgX^{\oplus}$ and $Li^{\oplus}$, in which X is Cl, Br or I.

Examples of suitable anions Z are $PF_6^{\ominus}$, $SbF_6^{\ominus}$, $BF_4^{\ominus}$, CF_3COO , sulfonate (for example tosylate) and particularly $Cl^{\ominus}$ or $Br^{\ominus}$.

The invention also relates to the compounds of the formula II. They are obtainable in a simple manner by reacting 1 mole of a salt of the formula



with 1 mole of a compound of the formula IV



The compounds of the formula IV can be prepared from correspondingly optically active tartaric acid esters protected with a group $R_3R_4Y<$ by means of Li-organic compounds or Grignard reagents, for example of the formula R_5Li or R_5MgX in which X is Cl, Br or I. The preparation is described by D. Seebach et al. in *Helv. Chim. Acta* 70, page 954 (1987).

The reaction can be carried out at temperatures from -78 to $+100^\circ C$, preferably -20 to $40^\circ C$, preferably in an inert solvent, for example hydrocarbons (toluene or xylene) or ethers (diethyl ether, tetrahydrofuran, dioxane or ethylene glycol dimethyl ether). The reaction is preferably carried out under an atmosphere of a protective gas, for example argon, and in the presence of a basic compound, in order to bind the HZ formed. Examples of suitable basic compounds are alkali metal carbonates, such as sodium carbonate and bicarbonate, and also amines, particularly tertiary amines, for example triethylamine. Other suitable bases are LiH, KH, NaH, lithium secondary amides (lithium diisopropylamide), methyllithium, ethyllithium, lithium hexamethyldisilazide, sodium hexamethyldisilazide, potassium hexamethyldisilazide, methylmagnesium chloride or diethylzinc. The reaction solution can be used for the next stage without further treatment. The compounds are isolated by filtering off the precipitated salt and removing the solvent. The crude products thus obtained can be used for the next stage without purification.

The preparation of the compounds of the formula I is preferably effected at temperatures from -78 to $+40^\circ C$, preferably -20 to $40^\circ C$, and in an

inert solvent. Suitable solvents are, in particular, ether. The reaction is carried out under a protective gas, for example argon. Precipitated salts can be filtered off. The resulting crude product, if appropriate after removal of the solvent, can be used for the next stage without further treatment.

The compounds according to the invention are excellently suitable for use as enantioselective reactants for reactions with prochiral aldehyde, keto and/or N-substituted imine groups. It is a particular advantage that, depending on the choice of the R,R- or S,S-configuration at the C atoms C(1) and C(2) in formula I, both enantiomers can be prepared. They are particularly suitable for the transfer of allyl groups, and also enol, enamine and enhydrazine groups, by the aldol reaction. The invention also relates to this use. The carbonyl compounds are preferably prochiral aldehydes and ketones. The reaction products obtained, in high yields, are chiral, secondary or tertiary alcohols or secondary amines or aminoacids, with a high excess of one enantiomer. The synthesis of chiral active compounds in the field of pharmaceuticals and agricultural chemicals has become of great importance. The compounds according to the invention are suitable for the preparation of corresponding intermediates for the synthesis of such active compounds or for the introduction of groups having chiral C atoms in the final stage of the synthesis of active compounds of this type. Thus it is possible, for example, to prepare, in high yields, pheromones for the control of insects. An example which may be mentioned is (+)-ipfenol or (-)-ipfenol, which can be prepared by the process described in EP-A 0,254,685 using a titanium complex according to the invention (See Example 17).

In addition, the compounds according to the invention can be prepared at a low cost from cheap starting materials. As derivatives of natural compounds they can be disposed of in a manner not harmful to the environment by means of biological methods of degradation, especially as titanium or titanium oxide is, as is known, physiologically acceptable.

The present invention also relates to a process for the preparation of, preferably chiral, secondary and tertiary alcohols and secondary amines, which comprises reacting, preferably prochiral, aldehydes, ketones or N-

substituted aldimines or ketimines with 1 mole of a compound of the formula I per mole of aldehyde, keto or imine group. The substituent in the imine can be the radicals previously mentioned, such as alkyl, alkenyl, cycloalkyl, aryl and aralkyl. If these radicals are substituted by carboxyl or carboxylic ester groups, the reaction products obtained are aminoacids or esters thereof, respectively. Examples of other suitable substituents are R_6SO_2 - and acyl which preferably has 1 to 8 C atoms and can be substituted by -F. Examples are acetyl, mono-, di- and tri-fluoroacetyl, benzoyl and fluorobenzoyl.

The reaction is advantageously carried out at temperatures from -80 to 30°C in the presence of an inert solvent and under a protective gas. The reaction product is preferably isolated by hydrolysis, extracting the product and purifying it in a customary manner. Examples of suitable inert solvents are ethers or hydrocarbons, such as pentane, hexane, cyclohexane, methylcyclohexane, benzene, toluene, xylene, diethyl ether, tetrahydrofuran or dioxane, nitriles, for example acetonitrile, or chlorinated hydrocarbons, for example methylene chloride, chloroform or chlorobenzene.

The following examples illustrate the invention. Cp stands for cyclopentadienyl.

A) Preparation Examples

Example 1:

a) [(4S,5S)-2-(t-Butyl)-1,3-dioxolane-4,5-bis-(diphenylmethoxy)]-cyclopentadienyltitanium chloride.

1.24 g (2.5 mmol) of (4S,5S)-2-(t-butyl)-4,5-[bis-(diphenylhydroxymethyl)]-1,3-dioxolane are added to a solution of 0.55 g (2.5 mmol) of cyclopentadienyltitanium trichloride in 50 ml of diethyl ether. A solution of 0.56 g (5.5 mmol) of triethylamine in 10 ml of diethyl ether is added dropwise in the course of 30 minutes and at room temperature (RT) to the reaction solution above. The pale yellow suspension is stirred for a further 12 hours at RT and the triethylamine hydrochloride formed is filtered off with suction under argon and washed with three times 10 ml of ether. The reaction solution thus obtained can

be used for the next stage without further treatment. The complex is isolated by removing the solvent by vacuum distillation. Two diastereomers are formed in a ratio of 4:1.

Main isomer.

^1H -NMR spectrum (CD_2Cl_2 , 400 MHz): 7.20-7.70 (m, 20H, Ph); 6.26 (s, 5H, Cp); 4.86 (d, $J = 6.5$ 1H, H-C(4) or H-C(5)); 4.79 (d, $J = 6.5$, 1H, H-(C5) or H-C(4)); 3.43 (s, 1H, H-C(2)); 0.84 (s, 9H, $\text{C}(\text{CH}_3)_3$).

^{13}C -NMR spectrum (CD_2Cl_2 , 100 MHz): 147.22 (s, Ph); 146.79 (s, Ph); 142.83 (s, Ph); 142.17 (s, Ph); 128.73 (d, Ph); 128.59 (d, Ph); 128.24 (d, Ph); 128.08 (d, Ph); 172.99 (d, Ph); 127.92 (d, Ph); 127.91 (d, Ph); 127.89 (d, Ph); 172.59 (d, Ph); 127.53 (d, Ph); 127.47 (d, Ph); 127.33 (d, Ph); 117.32 (d, Cp); 109.42 (d, C(2)); 97.88 (s, $\text{C}(\text{Ph})_2\text{O}$); 97.27 (s, $\text{C}(\text{Ph})_2\text{O}$); 83.83 (d, C(4) or C(5)); 80.30 (d, C(5) or C(4)); 35.51 (s, $\text{C}(\text{CH}_3)_3$); 24.74 (q, $\text{C}(\text{CH}_3)_3$).

Subsidiary isomer.

^1H -NMR spectrum (CD_2Cl_2 , 400 MHz): 7.20-7.70 (m, 20H, Ph); 6.56 (s, 5H, Cp); 5.03 (d, $J = 7.5$, 1H, H-C(4) or H-C(5)); 4.78 (d, $J = 7.5$, 1H, H-(C5) or H-C(4)); 3.44 (s, 1H, H-C(2)); 0.61 (s, 9H, $\text{C}(\text{CH}_3)_3$).

^{13}C -NMR spectrum (CD_2Cl_2 , 100 MHz): 146.49 (s, Ph); 146.45 (s, Ph); 142.53 (s, Ph); 142.06 (s, Ph); 129.25 (d, Ph); 128.84 (d, Ph); 128.63 (d, Ph); 128.53 (d, Ph); 128.16 (d, Ph); 128.07 (d, Ph); 127.99 (d, Ph); 127.92 (d, Ph); 127.88 (d, Ph); 127.55 (d, Ph); 127.46 (d, Ph); 127.17 (d, Ph); 117.80 (d, Cp); 109.85 (d, C(2)); 97.52 (s, $\text{C}(\text{Ph})_2\text{O}$); 97.40 (s, $\text{C}(\text{Ph})_2\text{O}$); 80.83 (d, C(4) or C(5)); 80.01 (d, C(5) or C(4)); 35.30 (s, $\text{C}(\text{CH}_3)_3$); 24.38 (q, $\text{C}(\text{CH}_3)_3$).

b) [(4S,5S)-2-(t-Butyl)-1,3-dioxolane-4,5-bis-(diphenylmethoxy)]-cyclopentadienylallyltitanium.

The reaction solution obtained in a) is cooled to 0°C and 1.8 ml (2.25 mmol) of allylmagnesium chloride (1.25-molar solution in tetrahydrofuran) are added dropwise in the course of 5 minutes. The yellow-brown suspension is stirred for 1 hour at 0°C . The reaction solution thus obtained is used for the next stage without further treatment.

Example 2:

a) [(4R,5R)-2,2-Dimethyl-1,3-dioxolane-4,5-bis-(diphenylmethoxy)]-cyclopentadienyltitanium chloride.

1.17 g (2.5 mmol) of (4R,5R)-2,2-dimethyl-4,5-[bis-(diphenylhydroxymethyl)]-1,3-dioxolane are added to a solution of 0.55 g (2.5 mmol) of cyclopentadienyltitanium trichloride in 50 ml of diethyl ether. A solution of 0.56 g (5.5 mmol) of triethylamine in 10 ml of diethyl ether is added dropwise in the course of 30 minutes and at room temperature (RT), to the above reaction solution. The pale yellow suspension is stirred at RT for a further 12 hours, and the triethylamine hydrochloride formed is filtered off with suction under argon and washed with three times 10 ml of ether. The reaction solution thus obtained is used for the next stage without further treatment.

$^1\text{H-NMR}$ spectrum (CD_2Cl_2 , 400 MHz): 7.65-7.27 (m, 20H, Ph); 6.43 (s, 5H, Cp); 5.16 (d, $J = 7.0$, 1H, H-C(4) or H-C(5)); 4.95 (d, $J = 7.0$, 1H, H-C(5) or H-C(4)); 0.94 (s, 3H, CH_3); 0.50 (s, 3H, CH_3).

$^{13}\text{C-NMR}$ spectrum (CD_2Cl_2 , 100 MHz): 148.87 (s, Ph); 146.72 (s, Ph); 142.86 (s, Ph) 142.72 (s, Ph); 129.75 (d, Ph); 129.08 (d, Ph); 128.60 (d, Ph); 128.36 (d, Ph); 127.99 (d, Ph); 127.92 (d, Ph); 127.73 (d, Ph); 127.68 (d, Ph); 127.59 (d, Ph); 127.57 (d, Ph); 127.55 (d, Ph); 127.49 (d, Ph); 117.48 (d, Cp); 111.71 (s, C(2)); 98.65 (s, $\text{C}(\text{Ph})_2\text{O}$); 98.06 (s, $\text{C}(\text{Ph})_2\text{O}$); 82.12 (d, C(4) or C(5)); 81.67 (d, C(5) or C(4)); 27.60 (q, CH_3); 27.00 (q, CH_3).

b) (4R,5R)-2,2-Dimethyl-1,3-dioxolane-4,5-bis-(diphenylmethoxy)]-cyclopentadienylallyltitanium.

The reaction solution obtained in a) is cooled to 2°C and 1.8 ml (2.25 mmol) of allylmagnesium chloride (1.25-molar solution in tetrahydrofuran) are added dropwise in the course of 5 minutes. The orange suspension is stirred for 1 hour at 2°C and filtered with suction under argon. The reaction solution thus obtained is used for the next stage without further treatment.

¹H-NMR spectrum (CD₂Cl₂, 250 MHz): 7.65-7.27 (m, 20H, Ph); 6.15 (s, 5H, Cp); 5.85 (quint. J=11.5, H-C(2')) 5.40 (d, J=7.0, 1H, H-C(4) or H-C(5)); 4.78 (d, J=7.0, 1H, H-C(5) or H-C(4)); 3.36 (d, J=11.5, 4H, H-C(1'), H-C(3')); 0.72 (s, 3H, CH₃); 0.58 (s, 3H, CH₃).

¹³C-NMR spectrum (CD₂Cl₂, 62.9 MHz): 148.48 (s, Ph); 147.86 (s, Ph); 143.85 (s, Ph); 143.35 (d, C(2')); 143.23 (s, Ph); 129.75 (d, Ph); 129.08 (d, Ph); 128.60 (d, Ph); 128.36 (d, Ph); 127.99 (d, Ph); 127.92 (d, Ph); 127.73 (d, Ph); 127.68 (d, Ph); 127.59 (d, Ph); 127.57 (d, Ph); 127.55 (d, Ph); 127.49 (d, Ph); 115.25 (d, Cp); 112.10 (s, C(2)); 94.95 (s, C(Ph)₂O); 88.03 (t, C(1'), C(3')); 82.30 (d, C(4) or C(5)); 82.25 (d, C(5) or C(4)); 27.67 (q, (CH₃); 27.64 (q, (CH₃).

Example 3

a) [(4S,5S)-2,2-Dimethyl-1,3-dioxolane-4,5-bis-(diphenylmethoxy)]-cyclopentadienyltitanium chloride is prepared as in Example 2a using (4S,5S)-2,2-dimethyl-4,5-[bis-(diphenylhydroxymethyl)]-dioxolane as a starting material.

b) (4S,5S)-2,2-Dimethyl-1,3-dioxolane-4,5-bis-(diphenylmethoxy)]-cyclopentadienylallyl titanium is prepared as in Example 2b, using as starting material [(4S,5S)-2,2-dimethyl-1,3-dioxolane-4,5-bis-(diphenylmethoxy)]-cyclopentadienyltitanium chloride.

Example 4

a) [(4R,5R)-2,2-Dimethyl-1,3-dioxolane-4,5-bis-(diphenylmethoxy)]-cyclopentadienyl-E-crotyltitanium

10 ml (10 mmol) of (crotyl)MgCl (1-molar solution in diethyl ether) are added at -10°C to 10 mmol of [(4R,5R)-2,2-dimethyl-1,3-dioxolane-4,5-bis-(diphenylmethoxy)]-cyclopentadienyltitanium chloride, prepared analogously to Example 2a, in 160 ml of diethyl ether. The rust-red suspension is stirred for 2 hours at this temperature and filtered under argon. The reaction solution thus obtained can be concentrated or used for the next stage without further treatment.

¹H-NMR spectrum (CD₂Cl₂, 250MHz): 7.65-7.15 (m, 20H, Ph); 6.08 (s, 5H,

Cp); 5.46 (dxtxq, J = 14.0, 8.5, 1.5, H-C(2')); 4.82 (dxq, J = 14.0, 6.5, H-C(3')); 5.11 (d, J=7.0, 1H, H-C(4) or H-C(5)); 4.47 (d, J=7.0, 1H, H-C(5) or H-C(4)); 2.26 (dxd, J=8.5, 8.5 H-C(1')); 2.17 (dxd, J=8.5, 8.5 H-C(1')); 1.67 (dxd, 3H, J=6.5, 1.5, H-C(4')); 0.68 (s, 3H, C(2)-CH₃); 0.58 (s, 3H, C(2)-CH₃).

Example 5:

a) (4R,5R)-2,2-Dimethyl-4,5-[bis-(dipentafluorophenylhydroxymethyl)]-1,3-dioxolane.

6.25 ml (10 mmol) of n-butyllLi in hexane are added dropwise, in the course of 45 minutes and at -78°C, to a solution of 1.25 ml (10 mmol) of bromopentafluorobenzene in 30 ml of diethyl ether, and the mixture is warmed to room temperature (RT), stirred and cooled to 0°C. 10 mmol of diethyl (4R,5R)-2,2-dimethyl-1,3-dioxolane-4,5-dicarboxylate, dissolved in 20 ml of diethyl ether, are added dropwise slowly to the above reaction solution, and the mixture is stirred for 12 hours at RT and hydrolysed by adding a saturated solution of NH₄Cl slowly. The emulsion is extracted with 3 × 80 ml of diethyl ether, and the extract is washed with a saturated solution of NaCl, dried over Na₂SO₄ and evaporated. The product is purified by flash chromatography (80 g of SiO₂, 1:5 ether/hexane). Yield: 4.63 g (56 %).

¹H-NMR-Spectrum (CDCl₃, 250 MHz): 5.43 (s, 2H); 4.95 (s, 2H); 1.40 (s, 6H).

b) [(4R,5R)-2,2-Dimethyl-1,3-dioxolane-4,5-bis-(dipentafluorophenylmethoxy)]-cyclopentadienyltitanium chloride.

Prepared analogously to Example 2a, but using (4R,5R)-2,2-dimethyl-4,5-[bis-(dipentafluorophenylhydroxymethyl)]-1,3-dioxolane as starting material.

c) [(4R,5R)-2,2-Dimethyl-1,3-dioxolane-4,5-bis-(dipentafluorophenylmethoxy)]-cyclopentadienylallyltitanium.

The reaction solution obtained in Example 5b is reacted analogously to Example 2b and can be used for the next stage without further processing.

Example 6:

a) (4R,5R)-2,2-Dimethyl-4,5-[bis-(di-2-furylhydroxymethyl)]-1,3-dioxolane.

A solution of 97 ml of n-butyllLi (155 mmol) in hexane is diluted with 100 ml of diethyl ether and cooled to -20°C, and 11.62 ml (160 mmol) of furane are added in the course of 10 minutes. The reaction solution is warmed slowly to RT and is then heated under reflux for 4 hours. 9.84 g (40 mmol) of diethyl

(4R-5R)-2,2-dimethyl-1,3-dioxolane-4,5-dicarboxylate, dissolved in 20 ml of ether, are added slowly with ice cooling to the above reaction solution, and the mixture is then stirred for 2 hours at RT and for 16 hours under reflux and hydrolysed by adding 300 ml of saturated NH₄Cl solution slowly. The emulsion is filtered through Hyflo and extracted with 3 × 200 ml of diethyl ether, and the extracts are washed with saturated NaCl solution, dried over Na₂SO₄ and evaporated. The product is purified by flash chromatography (800 g of SiO₂, 10:1 toluene/ether). Yield: 5.10 g (30 %).

¹H-NMR spectrum (CDCl₃, 250 MHz): 7.48-7.36 (m, 4H); 6.48-6.30 (m, 8H); 4.78 (s, 2H); 1.02 (s, 6H).

¹³C-NMR spectrum (CDCl₃, 62.9 MHz): 154.3 (s), 152.9 (s), 142.4 (d); 111.5 (s); 110.6 (d); 110.3 (d); 109.8 (d), 109.3 (d); 80.4 (d); 72.6 (s); 26.7 (q).

b) [(4R,5R)-2,2-Dimethyl-1,3-dioxolane-4,5-bis(di-2-furylmethoxy)]-cyclopentadienyltitanium chloride.

Prepared analogously to Example 2a, but using

(4R,5R)-2,2-dimethyl-4,5-[bis-(di-2-furylhydroxymethyl)]-1,3-dioxolane as starting material.

c) [(4R,5R)-2,2-Dimethyl-1,3-dioxolane-4,5-bis(di-2-furylmethoxy)]-cyclopentadienylallyltitanium.

The reaction solution obtained in Example 6b is reacted analogously to Example 2b and can be used for the next stage without further treatment.

Example 7:

a) (4R,5R)-2,2-Dimethyl-4,5-[bis-(di-2-propenylhydroxymethyl)]-1,3-dioxolane

13.8 g (575 mmol) of Mg turnings in 50 ml of tetrahydrofuran (THF) are initially taken and 43.7 ml (500 mmol) of 2-bromopropene are added dropwise in the course of 1.5 hours, and the mixture is heated under reflux for 1 hour and cooled to 40°C. 24.6 g (100 mmol) of diethyl (4R,5R)-2,2-dimethyl-1,3-dioxolane-4,5-dicarboxylate, dissolved in 50 ml of THF, are added dropwise to the reaction solution in the course of 1 hour. The mixture is then hydrolysed with 250 ml of 2N H₂SO₄, the phases are separated, the aqueous phase is extracted with 3x 200 ml of diethyl ether, and the combined ethereal phases are washed twice with saturated NaCl solution, dried over NaSO₄ [sic] and evaporated. The product is purified by flash chromatography (1 kg of SiO₂, 1:5 ether/hexane). Yield: 6.1 g (18.9 %).

¹H-NMR spectrum (CDCl₃, 250 MHz): 5.25 (dxq, J=1.5, 0.5, 2H); 5.19 (dxq, J=1.5, 0.5, 2H); 5.11 (dxq, J=1.5, 1.5, 2H); 5.00 (dxq, J=1.5, 1.5, 2H); 4.40 (s, 2H); 1.80 (dxd J=1.5, 0.5, 6H) 1.72 (dxd J=1.5, 0.5, 6H); 1.40 (s, 6H)

¹³C-NMR spectrum (CDCl₃, 62.9 MHz): 146.1(s); 145.7 (s); 114.3 (t); 113.7 (t); 98.4 (s); 80.2 (d); 79.1 (s); 27.2 (q); 21.0 (q); 19.4 (q).

b) [(4R,5R)-2,2-Dimethyl-1,3-dioxolane-4,5-bis-(di-2-propenyl-methoxy)]-cyclopentadienyl-titanium chloride.

Prepared analogous to Example 2a, using

(4R,5R)-2,2-dimethyl-4,5-[bis-(di-2-propenylhydroxymethyl)]-1,3-dioxolane as starting material.

c) [(4R,5R)-2,2-Dimethyl-1,3-dioxolane-4,5-bis-(di-2-propenyl-methoxy)]-cyclopentadienyltitanium.

The reaction solution obtained in Example 7b is reacted analogously to Example 2b and can be used for the next stage without further treatment.

Example 8

[(4R,5R)-2,2-Diphenyl-1,3-dioxolane-4,5-bis(diphenylmethoxy)]-
cyclopentadienyltitanium chloride

Prepared analogously to Example 2a, using

(4R,5R)-2,2-diphenyl-4,5-[bis-(diphenylhydroxymethyl)]-1,3-dioxolane as starting material.

¹H-NMR spectrum (CDCl₃, 250MHz): 7.70-6.40 (m, 30H, Ph); 6.29 (s, 5H, Cp); 5.33 (d, J=7.0, 1H, H-C(4) or H-C(5)); 5.20 (d, J=7.0, 1H, H-C(5) or H-C(4));

¹³C-NMR spectrum (CDCl₃, 62.89MHz): 146.4 (s, Ph); 146.3 (s, Ph); 144.0 (s, Ph); 143.4 (s, Ph); 141.3 (s, Ph); 140.2 (s, Ph); 128.6-126.3 (d, 16C, Ph); 125.4 (d, Ph); 125.2 (d, Ph); 116.8 (d, Cp); 112.2 (s, C(2)); 98.4 (s, C(Ph)₂O); 97.8 (s, C(Ph)₂O); 84.3 (d, C(4) or C(5)); 83.5 (d, C(5) or C(4)).

Example 9

a) [(4R,5R)-2,2-Dimethyl-1,3-dioxolane-4,5-bis(diphenylmethoxy)]-
pentamethylcyclopentadienylzirconium chloride

9.32 g (20 mmol) of (4R,5R)-2,2-dimethyl-4,5-[bis-(diphenylhydroxymethyl)]-1,3-dioxolane are added to a solution of 6.66 g (20 mmol) of pentamethylcyclopentadienylzirconium trichloride in 150 ml of diethyl ether. A solution of 6.1 ml (44 mmol) of triethylamine in 50 ml of diethyl ether is added dropwise, in the course of 30 minutes and at room temperature (RT), to the above reaction solution. The beige suspension is stirred at RT for a further 12 hours, and the triethylamine hydrochloride formed is filtered off with suction under argon and washed with three times approx. 20 ml of diethyl ether. The reaction solution thus obtained can be used in the next stage without further treatment.

¹H-NMR spectrum (CDCl₃, 250MHz): 7.55-7.18 (m, 20H, Ph); 5.12 (d, J=7.0, 1H, H-C(4) or H-C(5)); 4.92 (d, J=7.0, 1H, H-C(5) or H-C(4)); 1.95 (s, 15H, CP*); 0.46 (s, 3H, CH₃); 0.45 (s, 3H, CH₃).

¹³C-NMR spectrum (CDCl₃, 62.89MHz): 148.5 (s, Ph); 148.2 (s, Ph); 143.6 (s, Ph); 143.4 (s, Ph); 129.8 (d, Ph); 129.5 (d, Ph); 128.6-127.5 (d, 10C, Ph); 123.74 (s, Cp*); 111.62 (s, C(2)); 91.38 (s, C(Ph)₂O); 90.19 (s, C(Ph)₂O); 82.16 (d, C(4) or C(5)); 80.55 (d, C(5) or C(4)); 27.50 (q, CH₃); 27.40 (q, CH₃); 11.10 (q, Cp*).

Ph: phenyl

Cp*: cyclopentadienyl

b) [(4R,5R)-2,2-Dimethyl-1,3-dioxolane-4,5-

bis(diphenylmethoxy)]pentamethylcyclopentadienylmethylzirconium

A solution of 5 mmol of the zirconium compound of Example 9a in 60 ml of diethyl ether is cooled to -74°C, 1.5 ml of a 3-molar solution of CH₃MgBr in THF is added and the mixture is stirred for 2 hours at -74°C. The reaction solution thus obtained is used for the next stage without further treatment.

Example 10

a) [(4R,5R)-2,2-Dimethyl-1,3-dioxolane-4,5-

bis(diphenylmethoxy)]pentamethylcyclopentadienylhafnium chloride

Prepared analogously to Example 9a, but using pentamethylcyclopentadienylhafnium trichloride as starting material.

¹H-NMR spectrum (CDCl₃, 250MHz): 7.55-7.2 (m, 20H, Ph); 5.08 (d, J=7.0, 1H, H-C(4) or H-C(5)); 4.92 (d, J=7.0, 1H, H-C(5) or H-C(4)); 2.00 (s, 15H, Cp*); 0.46 (s, 3H, CH₃); 0.43 (s, 3H, CH₃).

¹³C-NMR spectrum (CDCl₃, 62.89MHz): 148.63(s, Ph); 148.18 (s, Ph); 143.84 (s, Ph); 143.70 (s, Ph); 129.8 (d, Ph); 129.1 (d, Ph); 128.6-127.5 (d, 10C, Ph); 122.14 (s, Cp*); 112.01 (s, C(2)); 90.34 (s, C(Ph)₂O); 90.19 (s, C(Ph)₂O); 82.17 (d, C(4) or C(5)); 80.58 (d, C(5) or C(4)); 27.56 (q, CH₃); 27.40 (q, CH₃); 10.87 (q, Cp*).

b) [(4R,5R)-2,2-Dimethyl-1,3-dioxolane-4,5-

bis(diphenylmethoxy)]pentamethylcyclopentadienylmethylhafnium

Prepared analogously to Example 9b, but using the hafnium compound of Example 10a as starting material

B) Use Examples:

Example 11: Preparation of (S)-1-phenyl-3-buten-1-ol

A solution of 1.25 mmol of the titanium compound of Example 2b in 60 ml of diethyl ether is cooled to -74°C , and 0.1 ml (1.0 mmol) of freshly distilled benzaldehyde is added. The slightly yellow, clear solution is stirred for a further 2 hours at -74°C and 5 ml of a 5N $\text{H}_2\text{O}/\text{THF}$ solution are added and the mixture is warmed to RT, stirred for a further hour at this temperature, filtered with suction and concentrated on a rotary evaporator. The crude product (0.80 g of a clear colourless oil) is flash-chromatographed (60 g of silica gel, 35 cm long, cross-section 2 cm, 5 ml/fraction, 0.4 bar, 10:1 toluene/ethanol). 0.098 g of product is obtained. Yield: 66 %, ee: 93 %.

Example 12: Preparation of (S)-1-tridecen-4-ol

A solution of 1.25 mmol of titanium compound of Example 2b in 60 ml of diethyl ether is cooled to -74°C and 0.19 ml (0.1 mmol) of freshly distilled capraldehyde is added. The slightly yellow, clear solution is stirred for a further 2 hours at -74°C and 5 ml of a 5N $\text{H}_2\text{O}/\text{THF}$ solution are added and the mixture is warmed to RT, stirred for a further hour at this temperature, filtered with suction and evaporated on a rotary evaporator. The crude product (1.13 g of clear, colourless oil) is flash-chromatographed (60 g of silica gel, 35 cm long, cross-section 2 cm, 5 ml/fraction, 0.4 bar, 10:1 toluene/ethanol) and is then distilled in a bulb tube (b.p.: $\approx 120\text{-}130$ at 0.104 mbar). 0.141 g of product is obtained. Yield: 71 %, ee: 95%.

Example 13: Preparation of (R)-1-phenyl-3-buten-1-ol

A solution of 2.25 mmol of the titanium compound of Example 1b in 120 ml of diethyl ether is cooled to -74°C and 0.2 ml (2.0 mmol) of freshly distilled benzaldehyde is added. The beige suspension is stirred for a further 2 hours at -74°C and 5 ml of a 5N $\text{H}_2\text{O}/\text{THF}$ solution are added. The beige suspension is warmed to RT, stirred for a further hour at this temperature, filtered with suction and concentrated on a rotary evaporator. The crude product (1.53 g of yellow-brown oil) is flash-chromatographed twice (80 g of silica gel, 25 cm long, cross-section 2 cm, 10 ml/fraction, 0.5 bar, 20:1 toluene/ethanol); (50 g of silica gel, 25 cm long, cross-section 2 cm, 15 ml/fraction, 0.5 bar, 15:1

toluene/ethanol). 0.2 g of product are obtained. Yield: 66 %, ee: 82 %.

Example 14: Preparation of ethyl

(2S,3R)-2-(tert-butoxycarbonylamino)-3-hydroxyhexanoate

7.6 ml of a 1.6 M solution of butyllithium in hexane are added at -20 to -30°C to a solution of 1.9 g of cyclohexylisopropylamine in 60 ml of tetrahydrofuran. After 20 minutes the mixture is cooled to -78°C and a solution of 3.0 g of ethyl 1,1,3,3-tetramethyl-1,3-disilaazolidine-N-acetate in 60 ml of tetrahydrofuran is added dropwise. After stirring for 1 hour at -78°C, 161 ml of a 0.083 M solution of [(4R,5R)-2,2-dimethyl-1,3-dioxolane-4,5-bis(diphenylmethoxy)]cyclopentadienyltitanium chloride (according to Example 2a) in ether are added dropwise. The solution is stirred for 43 hours at -78°C and is then added via a steel cannula to a solution, cooled to -78°C, of 0.97 g of butyraldehyde in 15 ml of tetrahydrofuran. After stirring for 22 hours at -78°C, 1.5 ml of water are added and the mixture is warmed to room temperature and filtered. 24 ml of water and 4.8 ml of acetic acid are added to the filtrate and the mixture is stirred for 2 hours at room temperature and evaporated in vacuo. A sample (5 mg) of the residue is made into a derivative by treatment with trifluoroacetic anhydride in methylene chloride for 2 hours and is analysed by capillary gas chromatography (Chirasil-Val, 90-180°C/2°C per minute). According to this, the sample consists of 90.8 % of the (2S,3R)-isomer (retention time 11.7 minutes) and 9.2 % of the (2R,3S)-isomer (retention time 10.8 minutes). 250 ml of ether are added to the remainder of the crude product and the mixture is shaken with three times 100 ml of 0.1 N hydrochloric acid. The aqueous phase is extracted with twice 250 ml of ether, adjusted to pH 4 with sodium hydroxide solution and concentrated to 50 ml in vacuo at room temperature. After 80 ml of dioxane, 6.7 g of sodium bicarbonate and 5.3 g of di-tert-butyl dicarbonate have been added, the mixture is stirred for 15 hours at room temperature. The reaction mixture is diluted with 250 ml of diethyl ether and washed with twice 250 ml of water and with saturated sodium chloride solution, and the aqueous phases are extracted with twice 250 ml of ether. The organic extracts are dried (Na₂SO₄) and evaporated. Chromatographing the residue (silica gel, 1:4 to 1:2 ethyl acetate/hexane) gives 2.09 g of ethyl (2S,3R)-tert-butoxycarbonylamino-3-hydroxyhexanoate.

Example 15: Preparation of

(4R,1'S)-2,2-dimethyl-1,3-dioxolane-4-(1'-hydroxy-3'-buten-1'-yl)

A solution of 4.5 mmol of the titanium compound of Example 2b in 70 ml of diethyl ether is cooled to -74°C and 0.52 g (4.0 mmol) of freshly distilled 2,3-O-isopropylidene-D-glyceraldehyde is added. The orange-yellow suspension is stirred for a further 4 hours at -74°C, 30 ml of a 45 % aqueous ammonium fluoride solution are added and the mixture is warmed to room temperature, stirred overnight at this temperature and filtered with suction through Hyflo. The emulsion is diluted with 50 ml of diethyl ether and the organic phase is then separated off, washed and dried over Na₂SO₄. The crude product (2.5 g of a clear, yellowish oil) is suspended in 10 ml of pentane, and the suspension is stirred for 1 hour at room temperature and filtered with suction. The filtrate is flash-chromatographed (60 g of silica gel, 20 cm long, cross-section 2 cm, 30ml/fraction, 0.4 bar, 1:2 diethyl ether/pentane). Yield: 0.2 g, ee > 95 %.

Example 16: Preparation of

(4R,1'R)-2,2-dimethyl-1,3-dioxolane-4-(1'-hydroxy-3'-buten-1'-yl)

Preparation is carried out as in Example 15, but using the titanium compound of Example 3b. Yield: 0.26 g, ee > 95 %.

Example 17: Preparation of (R)-3-hydroxy-5-methylhexanoic acid

4.4 ml of 1.6 M butyllithium in hexane are added under argon and at -25°C to a solution of 1.12 ml of diisopropylamine in 15 ml of anhydrous diethyl ether (ether). After 25 minutes at -20°C, the mixture is cooled to -78°C and 805 µl of tert-butyl acetate are added dropwise in the course of 10 minutes by means of a syringe. After stirring for 45 minutes at -78°C, a freshly prepared solution, precooled to -78°C, of 4.9 g of [(4R,5R)-2,2-dimethyl-1,3-dioxolane-4,5-bis-(diphenylmethoxy)]-cyclopentadienyltitanium chloride (according to Example 2a) in approx. 100 ml of ether is added via a cannula in the course of 15 minutes. The mixture is stirred for 30 minutes at -78°C and for 3 hours at -30°C and cooled to -78°C and 650 µl of isovaleraldehyde are added by means of a syringe in the course of 5 minutes. After 2 hours at -78°C, 20 ml of 45 % NH₄F solution are added and the mixture is warmed to room temperature. After stirring for 17 hours it is filtered, 10 ml of saturated sodium chloride solution are added to the filtrate and the

mixture is extracted with three times 100 ml of ether. The organic phases are washed with saturated NaCl solution and 1 N HCl, dried (MgSO₄) and evaporated. The residue (5.1 g) is stirred in 6 ml of 2N sodium hydroxide solution and 12 ml of methanol for 2 hours at 50°C. After the methanol has been removed by evaporation in vacuo, the residue is extracted with three times 50 ml of ether. The aqueous phase is acidified with concentrated hydrochloric acid and extracted with three times 100 ml of ethyl acetate. The ethyl acetate phases are washed with twice 50 ml of saturated sodium chloride solution, dried (MgSO₄) and evaporated. The residue, 835 mg of 1-(R)-3-hydroxy-5-methylhexanoic acid of 78 % optical purity, is recrystallized twice from cyclohexane (60 ml and 150 ml). Yield: 595 mg of product of 96 % optical purity, melting point 86°C; $[\alpha]_D = -14.7^\circ$ (c=1, CHCl₃). (+)-(R)-Ipsenol can be prepared from this by the instructions in EP-A 0,254,685 (Example 4ld to 4lg).

Example 18: Preparation of (S)-1-phenyl-3-buten-1-ol

Analogous to Example 11, but [(4R,5R)-2,2-dimethyl-1,3-dioxolane-4,5-bis-(dipentafluorophenylmethoxy)]-cyclopentadienylalyltitanium (prepared as in Example 5c) is used as the starting material. Yield: 62 %, (ee: 53.7 %).

Example 19: Preparation of (S)-1-phenyl-3-buten-1-ol

Analogous to Example 11, but [(4R,5R)-2,2-dimethyl-1,3-dioxolane-4,5-bis-(di-2-furylmethoxy)]-cyclopentadienyl-titanium chloride (prepared as in Example 6c) is used as the starting material. Yield: 63 %, (ee: 65.6 %).

Example 20: Preparation of (S)-1-phenyl-3-buten-1-ol

Analogous to Example 11, but [(4R,5R)-2,2-dimethyl-1,3-dioxolane-4,5-bis-(di-2-propenylmethoxy)]-cyclopentadienyltitanium chloride (prepared as in Example 7c) is used as the starting material. Yield: 53 %, (ee: 713 %).

Example 21: Preparation of tert-butyl

(4S,1'S)-2,2-dimethyl-4-(1'-hydroxy-3'-butenyl)-oxazolidine-3-carboxylate

65 ml of a solution (4.5 mmol) of [(4R,5R)-2,2-dimethyl-1,3-dioxolane-4,5-bis-(diphenylmethoxy)]-cyclopentadienylalyltitanium (prepared as in

Example 2b) is cooled to -74°C and 917 mg (4 mmol) of tert-butyl (4S)-2,2-dimethyl-4-formyloxazolidine-3-carboxylate dissolved in 5 ml of diethyl ether is added dropwise. The slightly yellow, clear solution is stirred for a further 3 hours at -74°C, 25 ml of a 45 % aqueous solution of NH_4F are added and the mixture is warmed to RT, stirred for a further 12 hours at this temperature (white precipitate) and filtered through Celite. The aqueous phase is separated off and extracted with 100 ml of diethyl ether. The organic phase is washed with twice 50 ml of saturated NaCl solution, dried with MgSO_4 and evaporated. The product is purified by being subjected twice to flash chromatography (220 g of SiO_2 , 2.5:1 hexane/ethyl acetate) or (20 g of SiO_2 , 2.5:1 hexane/ethyl acetate). Yield: 1.007 g, 93 %, de (ee) 95 %, $[\alpha]_D^{25} = -17.0^\circ$ ($c=0.95$, C_6H_6).

^{13}C -NMR (C_6D_6 , 62.9 MHz, 340K) 24.1 (CH_3); 27.0 (CH_3); 28.4 ($\text{C}(\text{CH}_3)_3$); 36.1 ($\text{C}(2')$); 61.9 ($\text{C}(4)$); 64.6 ($\text{C}(5)$); 72.3 ($\text{C}(1')$); 80.4 ($\text{C}(\text{CH}_3)_3$); 94.3 ($\text{C}(2)$); 117.0 ($\text{C}(4')$); 135.7 (d, $\text{C}(3')$); 153.8 (COO-t-Bu).

^1H -NMR (C_6D_6 , 250 MHz, 340K): 1.39 (s, $\text{C}(\text{CH}_3)_3$), 1.45 (s, CH_3); 1.62 (s, CH_3); 2.10 (dxdxdxd, 1H, $J = 14.0$, 7.0, 7.0, 1.0, 1.0, H-C(2')); 2.30 (dxdxdxd, 1H, $J = 14.0$, 6.5, 3.0, 1.0, 1.0, H-C(2')); 3.59-3.73 (m, 2H, H-C(5)); 3.84-3.96 (m, H-C(4), H-C(1')); 4.97-5.08 (m, 2H, H-C(4')); 5.92 (dxdxd J = 17.0, 10.0, 7.0, 6.5, H-C(3')).

Example 22: tert-Butyl

(4S,1'R)-2,2-dimethyl-4-(1'-hydroxy-3'-butenyl)-oxazolidine-3-carboxylate

Prepared analogously to Example 21, but using

[(4S,5S)-2,2-dimethyl-1,3-dioxolane-4,5-bis-(diphenylmethoxy)]-cyclopentadienylallyl-titanium (Example 3b). Yield: 1.037 g 95 % de (ee) 99 %, $[\alpha]_D^{25} = +4.4^\circ$ ($c=0.985$, C_6H_6).

^1H -NMR (C_6D_6 , 250MHz, 340K): 1.39 (s, $\text{C}(\text{CH}_3)_3$), 1.46 (s, CH_3); 1.62 (s, CH_3); 2.16-2.23 (m, 2H, H-C(2')); 3.63 (dxd, 1H, 9.0, 6.5, H-C(5)); 3.80-3.92 (m, 3H, H-C(1'), H-C(4), H-C(5)); 4.97-5.12 (m, 2H, H-C(4')); 5.90 (dxdxd J = 17.0, 10.0, 6.50, 6.5, H-C(3'));

^{13}C -NMR (C_6D_6 , 62.9 MHz, 340K) 24.2 (q, CH_3); 27.0 (q, CH_3); 28.4 (q, t-Bu); 38.9 (t, $\text{C}(2')$); 62.0 (d, $\text{C}(4)$); 64.5 (t, $\text{C}(5)$); 72.0 (d, $\text{C}(1')$); 80.1

(s,t-Bu); 94.4 (s, C(2)); 116.9 (t, C(4')); 135.9 (d, C(3')); 153.8 (s)).

Example 23: Preparation of ethyl (2S,3R)-2-(tert-butoxycarbonylamino)-3-hydroxyhexanoate

7.6 ml of a 1.6 M solution of butyllithium in hexane are added at -20 to -30°C to a solution of 1.9 g of cyclohexylisopropylamine in 60 ml of tetrahydrofuran. After 20 minutes the mixture is cooled to -78°C, and a solution of 3.0 g of ethyl 1,1,3,3-tetramethyl-1,3-disilaazolidine-N-acetate in 60 ml of tetrahydrofuran is added. After stirring for 1 hour at -78°C, 161 ml of a 0.083 M solution of [(4R,5R)-2,2-dimethyl-1,3-dioxolane-4,5-bis-(diphenylmethoxy)]-cyclopentadienyltitanium chloride (according to Example 2a) in diethyl ether are added dropwise. The solution is stirred for 43 hours at -78°C and is then added via a steel cannula to a solution, cooled to -78°C, of 0.97 g of butyraldehyde in 15 ml of tetrahydrofuran. After stirring for 22 hours at -78°C, 1.5 ml of water are added and the mixture is warmed to room temperature and filtered. 24 ml of water and 4.8 ml of acetic acid are added to the filtrate, which is stirred for 2 hours at room temperature and evaporated in vacuo under mild conditions. A sample (5 mg) of the residue is reacted for 2 hours with trifluoroacetic anhydride in methylene chloride and analysed by capillary gas chromatography (Chirasil-Val, 90 - 180°C/2°C per minute). According to this, the sample consists of 90.8 % of the (2S-3R)-isomer (retention time 11.7 minutes) and 9.2 % of the (2R,3S)-isomer (retention time 10.8 minutes) 250 ml of diethyl ether are added to the remainder of the crude product and the mixture is shaken with three times 100 ml of 0.1 N hydrochloric acid. The aqueous phase is extracted with twice 250 ml of diethyl ether, adjusted to pH 4 with sodium hydroxide solution and concentrated to about 50 ml in vacuo at room temperature. After 80 ml of dioxane, 6.7 g of sodium bicarbonate and 5.3 g of di-tert-butyl dicarbonate have been added the mixture is stirred for 15 hours at room temperature. The reaction mixture is diluted with 250 ml of diethyl ether and washed with twice 250 ml of water and saturated sodium chloride solution, and the aqueous phases are extracted with twice 250 ml of diethyl ether. The organic extracts are dried (Na₂SO₄) and evaporated. Chromatographing the residue (silica gel, 1:4 to 1:2 ethyl acetate/hexane) gives 2.09 g of ethyl (2S,3R)-tert-butoxycarbonylamino-3-hydroxyhexanoate.

Example 24: Preparation of tert-butyl

(2S,3R)-2-(tert-butoxycarbonylamino)-3-hydroxyhexanoate

a) tert-Butyl 1,1,3,3-tetramethyl-1,3-disilaazolidine-N-acetate

44.0 ml of triethylamine and a solution of 23.4 g of 1,2-bis-(chlorodimethylsilyl)-ethane in 100 ml of methylene dichloride are added slowly, with ice cooling and under an atmosphere of nitrogen, to a suspension of 14.0 g of tert-butyl glycine ester-hydrochloride in 200 ml of methylene dichloride. After stirring for 19 hours at room temperature, a further 7 ml of triethylamine and 5.4 g of 1,2-bis-(chlorodimethylsilyl)-ethane are added and stirring is continued for 22 hours. The reaction mixture is washed with a buffer solution (0.41 M Na_2HPO_4 and 0.28 M KH_2PO_4 in H_2O and saturated sodium chloride solution; the aqueous phases are extracted twice with methylene dichloride. The organic phases are dried with Na_2SO_4 and evaporated, and the residue is distilled: 12.7 g of tert-butyl 1,1,3,3-tetramethyl-1,3-disilaazolidine-N-acetate (60-63°C; 0.02 mbar).

b) tert-Butyl (2S,3R)-2-(tert-butoxycarbonylamino)-3-hydroxyhexanoate

1.5 g of tert-butyl 1,1,3,3-tetramethyl-1,3-disilaazolidine-N-acetate in 30 ml of THF are added dropwise at -78°C to a solution of lithium cyclohexylisopropylamide prepared analogously to Example 23 from 0.93 g of cyclohexylisopropylamine, 30 ml of THF and 3.8 ml of butyllithium (1.6 M in hexane). After stirring for 1 hour at -78°C, 105 ml of a 0.063 M solution of [(4R,5R)-2,2-dimethyl-1,3-dioxolane-4,5-bis-(diphenylmethoxy)-cyclopentadienyl]titanium chloride (according to Example 2a) in diethyl ether are added dropwise. The solution is stirred for 21 hours at -78°C and is then added via a steel cannula to a solution cooled to -78°C, of 0.47 g of butyraldehyde in 10 ml of THF. After stirring for 23 hours at -78°C, 2.4 ml of acetic acid are added, the mixture is stirred for 15 minutes, 12 ml of water are added and the mixture is warmed to room temperature, stirred for 2 hours and evaporated under mild conditions. The residue is taken up in 0.1 M HCl and the solution is extracted three times with diethyl ether. The organic phases are washed twice with 0.1 N HCl. The pH of the combined aqueous phases is adjusted to 4 with 2 N NaOH, the mixture is evaporated to a residual volume of about 50 ml, and 40 ml of dioxane, 3.36 g of NaHCO_3 and 2.39 g of di-tert-butyl dicarbonate are added to the residue.

After being stirred for 18 hours the reaction mixture is diluted with diethyl ether and washed twice with water and saturated sodium chloride solution; the aqueous phases are extracted twice with diethyl ether. The organic extracts are dried (Na_2SO_4) and evaporated: 4.37 g of crude product. A sample (5 mg) of this is heated in 0.3 ml of anhydrous 2 N HCl in ethanol for 2 hours at 100° and the mixture is evaporated, reacted for 2 hours with 0.2 ml of trifluoroacetic anhydride in 0.3 ml of methylene chloride and analysed by capillary gas chromatography (Chirasil-L-Val, $90 - 180^\circ\text{C}/2^\circ\text{C}$ per minute). According to this, the sample consists of 97.1 % of the (2S,3R)-enantiomer (retention time 11.8 minutes) and 2.9 % of the (2R,3S)-enantiomer (retention time 10.9 minutes). Chromatographing the remainder of the residue (silica gel; 1:5 ethyl acetate/hexane) affords 1.03 g of tert-butyl (2S,3R)-tert-butoxycarbonylamino-3-hydroxyhexanoate in the form of an oil ($[\alpha]_D = -10.4$; $^\circ\text{C} = 1.3$ in ethanol).

Example 25: Preparation of (1S,2S)-2-methyl-1-phenyl-3-buten-1-ol

0.4 g (0.64 mmol) of the titanium compound prepared as in Example 4 are dissolved in 40 ml of diethyl ether, the solution is cooled to -74°C , 0.065 ml (0.65 mmol) of benzaldehyde are added and the mixture is stirred for 2 hours at -74°C . The reaction solution is then hydrolysed with 20 ml of aqueous ammonium fluoride solution, stirred overnight at RT, filtered through Hyflo and extracted with 3×40 ml of diethyl ether and the extract is washed with saturated NaCl solution, dried over Na_2SO_4 and evaporated.

The product is purified by flash chromatography (60 g of SiO_2 , 1:5 diethyl ether/hexane). Yield: 0.082 g (90 %), ee = 98 %, de > 97 %.

Example 26: Preparation of (S)-1-phenylethanol

A solution of 5 mmol of zirconium compound of Example 9b in 60 ml of diethyl ether is cooled to -74°C , 0.4 ml (4 mmol) of benzaldehyde are added, the mixture is stirred for 4 hours at this temperature and 30 ml of aqueous 45 % NH_4F solution are then added. The beige suspension is warmed to RT, stirred for a further 12 hours and filtered with suction, and the filtrate is concentrated on a rotary evaporator. The crude product (0.81 g) is flash-chromatographed (80 g of silica gel, 25 cm long, cross-section 2 cm, 30 ml/fraction, 0.4 bar, 1:5 diethyl

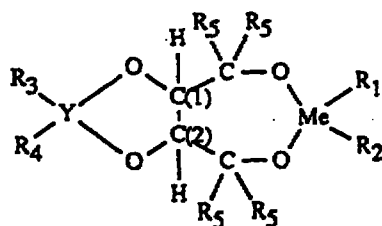
ether/hexane) and distilled in a bulb tube. 0.303 g of product are obtained. Yield: 62 %, ee: 97 %.

The same product is obtained if the corresponding hafnium compound of Example 10b is used instead of the zirconium compound. Yield: 60 %, ee: 97 %.



Patent Claims: for the Contracting States: AT, BE, CH, DE, DK, FR, GB, GR, IT, LI, LU, NL, SE

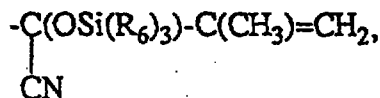
1. A compound of the formula I



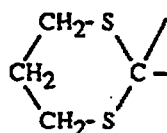
(I).

in which

a) Me is tetravalent titanium and R_1 is allyl, 1-methylallyl, 2-methylallyl, $-\text{CH}_2\text{CH}=\text{CH}-\text{P}(\text{C}_6\text{H}_5)_3$, $-\text{CH}(\text{SO}_2\text{R}_6)\text{CH}=\text{CH}-\text{Si}(\text{R}_6)_3$,



$-\text{CH}_2-\text{CH}=\text{CH}-\text{SO}_2-\text{R}_6$, $-\text{CH}_2-\text{CH}=\text{CH}-\text{OR}'$ or



CH_2-S , CH_2-S , $\text{C}-\text{CH}=\text{CHCH}_3$, R_6 is phenyl, benzyl or C_1-C_8 alkyl and R' is C_1-C_8 -

alkyl or $-\text{Si}(\text{R}_6)_3$, or

R_1 is a radical of an enol, enamine or enhydrazine which has up to 20 C atoms and which is attached via the O atom or N atom; or

b) Me is tetravalent zirconium or hafnium and R_1 is linear or branched C_1-C_{18} alkyl, C_2-C_{12} alkenyl, C_2-C_{12} alkynyl or C_3-C_8 cycloalkyl or C_3-C_8 cycloalkenyl each of which is unsubstituted or substituted by C_1-C_4 alkyl, or is C_6-C_{12} aryl, C_7-C_{16} alkaryl, C_6-C_{16} aralkyl, C_8-C_{16} alkaralkyl, C_8-C_{16} aralkenyl, C_9-C_{16} alkaralkenyl, C_8-C_{16} aralkynyl or C_9-C_{16} alkaralkynyl each of which is unsubstituted or monosubstituted or polysubstituted by $(\text{C}_6\text{H}_5)_2\text{P}-$, $(\text{R}_6\text{O})_2\text{P}(\text{O})-$, $(\text{R}_6)_3\text{Si}-$, $(\text{R}_6)_3\text{SiO}-$, R_6SO_2- , $-\text{S}-\text{C}_2-\text{C}_4\text{alkylene-S-}$ or $-\text{O}-\text{C}_2-\text{C}_4\text{alkylene-O-}$ in which R_6 is phenyl, benzyl or C_1-C_8 alkyl, cyano, F, nitro, C_1-C_{12} alkylthio, C_1-C_{12} alkoxy, $-\text{NR}_{18}\text{R}_{19}$ or $-\text{COR}_7$ in which R_7 is C_1-C_{12} alkoxy, R_{18} and R_{19} are C_1-C_{12} alkyl, cyclopentyl, cyclohexyl, phenyl, benzyl or $(\text{R}_6)_3\text{Si}$, or R_{18} and R_{19} together are C_3-C_6 alkylene, 3-oxapentylene or $-\text{Si}(\text{R}_6)_2-\text{C}_2-\text{C}_3\text{alkylene-Si}(\text{R}_6)_2-$; or R_1 is a radical of an enol, enamine or enhydrazine which has up to 20 C atoms



and which is attached via the O atom or N atom; R_2 is cyclopentadienyl or indenyl each of which is unsubstituted or substituted by C_1 - C_6 alkyl, C_2 - C_6 alkenyl, C_1 - C_6 alkoxy, C_5 - or C_6 cycloalkyl, C_6 - C_{12} aryl, C_7 - C_{13} aralkyl, tri- C_1 - C_6 -alkoxysilyl, tri- C_1 - C_6 alkylsilyl, R_5SO_2 - or halogen, Y is C, Si or -Si-O-Si R_3R_4 -, R_3 and R_4 independently of one another are H, linear or branched C_1 - C_{18} alkyl or C_2 - C_{12} alkenyl or C_3 - C_8 cycloalkyl or C_3 - C_8 cycloalkenyl each of which is unsubstituted or substituted by C_1 - C_4 alkyl, or are C_6 - C_{12} aryl, C_7 - C_{16} aralkyl, C_7 - C_{16} alkaryl, C_8 - C_{16} alkaralkyl, C_8 - C_{16} aralkenyl or C_9 - C_{16} alkaralkenyl, or R_3 and R_4 together are $-C_nH_{2n}-$ in which n is 3 to 7 and which is unsubstituted or substituted by -CN, -F, -Cl, -Br, nitro, C_1 - C_{12} alkylthio or C_1 - C_{12} alkoxy, R_5 is C_6 - C_{10} aryl, heteroaryl, benzyl naphthylmethyl or heteroarylalkyl each of which is unsubstituted or substituted by C_1 - C_{12} alkyl, C_1 - C_{12} alkoxy, C_1 - C_{12} alkylthio, cyano, di- $(C_1$ - C_4 alkyl)-amino, di- $(C_1$ - C_4 alkyl)-aminocarbonyl, fluorine, C_6 - C_{10} aryl, R_5SO_2 -, C_1 - C_{12} alkoxymethyl, C_1 - C_{12} alkylthiomethyl, di- $(C_1$ - C_4 alkyl)-aminomethyl or di- $(C_1$ - C_4 alkyl)-aminocarbonylmethyl, the heteroaryl being 5- or 6-membered and containing a heteroatom from the group O, S and N, or is C_1 - C_{12} alkyl, C_2 - C_{12} alkenyl, C_2 - C_{12} alkynyl, C_3 - C_8 cycloalkyl or C_3 - C_8 cycloalkenyl, and C(1) and C(2) are chiral C atoms, predominantly in the form of enantiomers or diastereomers.

2. A compound according to claim 1, in which R_1 is linear or branched C_1 - C_{12} alkyl, C_2 - C_{12} alkenyl, C_2 - C_{12} alkynyl, cycloalkyl or cycloalkenyl each of which has 3 to 8 ring C atoms, C_6 - C_{12} aryl, C_7 - C_{16} alkaryl, C_7 - C_{16} aralkyl, C_8 - C_{16} alkaralkyl, C_8 - C_{16} aralkenyl, C_9 - C_{16} alkaralkenyl, C_8 - C_{16} aralkynyl or C_9 - C_{16} alkaralkynyl each of which is unsubstituted or monosubstituted or polysubstituted by $R_{18}R_{19}N$ -, cyano, nitro, C_1 - C_6 alkylthio, C_1 - C_6 alkoxy or -COR₇ in which R_7 is C_1 - C_{12} alkoxy; or R_1 is a radical of an enol, enamine or enhydrazine which has up to 20 C atoms and which is attached via the enol oxygen atom or via the enamine nitrogen atom.

3. A compound according to claim 2, in which R_1 is linear or branched C_1 - C_6 alkyl, C_2 - C_6 alkenyl, C_2 - C_6 alkynyl, cycloalkyl or cycloalkenyl each of which has 3 to 6 ring C atoms, phenyl, $(C_1$ - C_{10} alkyl)-phenyl, phenyl- $(C_1$ - C_2 alkyl), $(C_1$ - C_8 alkyl)-phenyl- $(C_1$ - C_2 alkyl), phenylvinyl, phenylethynyl or phenylpropargyl, $(C_1$ - C_8 alkyl)-phenylvinyl, $(C_1$ - C_8 alkyl)-phenylethynyl or $(C_1$ - C_7 alkyl)-phenylpropargyl each of which is unsubstituted or



monosubstituted or polysubstituted by $R_{18}R_{19}N-$, cyano, nitro, C_1-C_6 alkoxy, C_1-C_6 alkylthio or $-COR_7$ in which R_7 is C_1-C_{12} alkoxy; or R_1 is a radical of an enol, enamine or enhydrazine which has up to 20 C atoms and which is attached via an enol oxygen atom or enamino nitrogen atom.

4. A compound according to claim 2, in which R_1 is methyl, ethyl, vinyl, allyl, crotyl, ethynyl, propargyl, cyclopentyl, cyclohexyl, cyclopentenyl, cyclohexenyl, phenyl, methylphenyl, benzyl, 1-phenyleth-2-yl, methylbenzyl, phenylvinyl, methylphenylvinyl, phenylethynyl, phenylpropargyl, methylphenylethynyl, dimethylphenylethynyl or dimethylphenylpropargyl each of which is unsubstituted or monosubstituted or polysubstituted by $R_{18}R_{19}N-$, cyano, nitro, C_1-C_6 alkoxy, C_1-C_6 alkylthio or $-COR_7$ in which R_7 is C_1-C_{12} alkoxy; or R_1 is a radical of an enol, enamine or enhydrazine which has 2 to 16 C atoms and which is attached via the enol oxygen atom or via the enamino nitrogen atom.

5. A compound according to claim 1, in which R_2 is cyclopentadienyl or indenyl each of which is unsubstituted or substituted by C_1-C_6 alkyl, C_2-C_6 alkenyl, C_1-C_6 alkoxy, cycloalkyl having 5 or 6 ring C atoms, phenyl, benzyl, trialkoxysilyl having 1 to 6 C atoms in the alkoxy groups, trialkylsilyl having 1 to 6 C atoms in the alkyl groups, F, Cl, Br or R_6SO_2- in which R_6 is phenyl, tolyl, benzyl or C_1-C_6 alkyl.

6. A compound according to claim 5, in which R_2 is cyclopentadienyl which is unsubstituted or substituted by C_1-C_6 alkyl or trimethylsilyl.

7. A compound according to claim 1, in which R_3 and R_4 independently of one another are H, C_1-C_{12} alkyl, C_2-C_{12} alkenyl, cycloalkyl or cycloalkenyl each of which has 5 or 6 ring C atoms and is unsubstituted or substituted by C_1-C_4 alkyl, or are phenyl, naphthyl, benzyl, C_1-C_6 alkylphenyl or C_1-C_6 alkylbenzyl or R_3 and R_4 together are $-C_nH_{2n}-$ in which n is 4 to 6 and which is unsubstituted or substituted by $-CN$, $-F$, $-Cl$, nitro, C_1-C_6 alkylthio or C_1-C_6 alkoxy.

8. A compound according to claim 7, in which R_3 and R_4 independently of one another are H, C_1-C_6 alkyl, cyclopentyl or cyclohexyl each of which is unsubstituted or substituted by C_1-C_4 alkyl, or are phenyl, benzyl, C_1-C_6 alkylphenyl or C_1-C_6 alkylbenzyl or R_3 and R_4 together are



pentamethylene or tetramethylene.

9. A compound according to claim 1, in which R_3 is H and R_4 or R_3 and R_4 are other than H.

10. A compound according to claim 1, in which Y is C.

11. A compound according to claim 1, in which R_5 is C_2 - C_4 alkenyl, 2-furyl or C_6 - C_{10} aryl each of which is unsubstituted or substituted by C_1 - C_6 alkyl or F.

12. A compound according to claim 11, in which the aryl is phenyl, methylphenyl, pentafluorophenyl or naphthyl.

13. A compound according to claim 11, in which R_5 is propenyl, phenyl, pentafluorophenyl, methylphenyl or furyl.

14. A compound according to claim 1, in which R_1 is linear or branched C_1 - C_4 alkyl, C_2 - C_6 alkenyl or cycloalkyl or cycloalkenyl each of which has 3 to 6 ring C atoms and is unsubstituted or substituted by C_1 - C_4 alkyl, or R_1 is phenyl, benzyl, C_1 - C_6 alkylphenyl or C_1 - C_6 alkylbenzyl each of which is unsubstituted or [lacuna] by secondary amino, cyano, nitro, C_1 - C_6 alkoxy, C_1 - C_6 alkylthio or $-COR_7$ in which R_7 is C_1 - C_{12} alkoxy, or R_1 is a radical of an enol, enamine or enhydrazine which has up to 12 C atoms and which is attached via an enol oxygen atom or an enamino nitrogen atom, R_2 is cyclopentadienyl which is unsubstituted or substituted by C_1 - C_4 alkyl or trimethylsilyl, Y is C, R_3 is H or is as defined for R_4 and R_4 is C_1 - C_{12} alkyl, phenyl, benzyl, cyclopentyl or cyclohexyl or R_3 and R_4 together are tetramethylene or pentamethylene, R_5 is C_2 - C_4 alkenyl, phenyl, pentafluorophenyl or furyl and Me is tetravalent titanium, zirconium or hafnium.

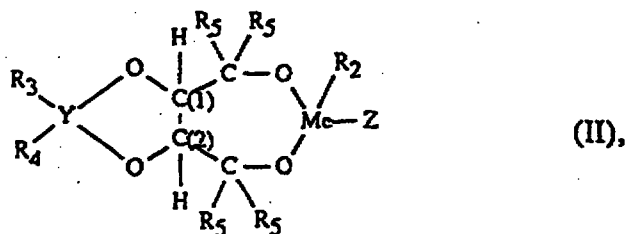
15. A compound according to claim 1, in which the C(1) and C(2) atoms in formula I have either the R,R-configuration or the S,S-configuration.

16. A compound according to claim 15, in which Y is a chiral C atom, in the form of the diastereomers.



17. A compound according to claim 1, in which R_1 is C_1 - C_4 alkyl, allyl or the radical of an ester-enolate which has 2 to 12 C atoms and can be substituted by $R_{18}R_{19}N$ -, R_2 is cyclopentadienyl which is unsubstituted or substituted by methyl or trimethylsilyl, R_3 is H or is as defined for R_4 and R_4 is C_1 - C_6 alkyl, R_5 is propenyl, phenyl, pentafluorophenyl or furyl and Me is tetravalent titanium, zirconium or hafnium and Y is C.

18. A process for the preparation of a compound of the formula I according to claim 1, which comprises reacting a compound of the formula II

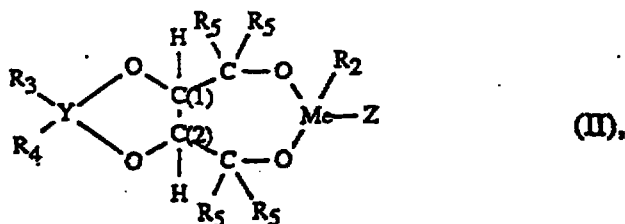


with a compound of the formula III



in the presence of an inert solvent and an inert protective gas, R_1 , R_2 , R_3 , R_4 , R_5 , Me and Y being as defined in claim 1, Z being an anion and $M^{\oplus}$ being $Li^{\oplus}$, $Na^{\oplus}$, $K^{\oplus}$, $MgX^{\oplus}$, $ZnX^{\oplus}$, $CdX^{\oplus}$, $HgX^{\oplus}$, $CuX^{\oplus}$ or quaternary ammonium, X being halogen.

19. A compound of the formula II



in which R_2 , R_3 , R_4 , R_5 , Y and Me are as defined in claim 1 and Z is an anion.



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20. The use of a compound of the formula I according to claim 1 as an enantioselective reactant for compounds containing aldehyde, keto and/or N-substituted imine groups.

21. A process for the preparation of secondary and tertiary alcohols and secondary amines, which comprises reacting aldehydes, ketones or N-substituted aldimines or ketimines with 1 mol of a compound of the formula I according to claim 1 per mole of aldehyde, keto or imine group.

22. A process according to claim 21, which is carried out at temperatures from -80 to 30°C.