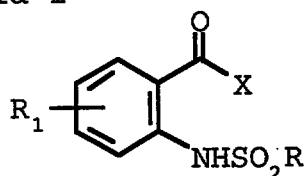




**AMINOPHENYL KETONE DERIVATIVES AND A
METHOD FOR THE PREPARATION THEREOF**

5

The present invention provides *o*-aminophenyl ketone derivatives of formula I

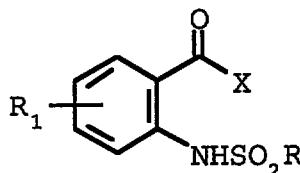


(I)

10 wherein R, R₁ and X are as defined below.

Compounds of formula I are useful as intermediates in the manufacture of a wide variety of herbicidal sulfamoyl urea derivatives, and in particular, the manufacture of the crop-selective herbicidal agent 1-{{*o*-(cyclopropyl-
15 carbonyl)phenyl}sulfamoyl}-3-(4,6-dimethoxy-2-pyrimidinyl)urea. Also provided is a method for the preparation of said formula I intermediate.

20 The invention provides a compound of formula I



(I)

wherein

R is straight or branched C₁-C₆ alkyl or phenyl optionally substituted with one or more substituents the same or



different selected from C₁-C₃ alkyl, C₁-C₃ alkoxy,
chlorine and bromine;

R₁ is hydrogen, cyano, nitro, halogen, formyl, C₁-C₄ alkyl

optionally substituted with one or more

5 substituents the same or different selected from
halogen, C₁-C₃alkoxy, C₁-C₃alkylthio, C₁-C₃-
alkylsulfinyl and C₁-C₃alkylsulfonyl,

C₁-C₄alkoxy optionally substituted with one or more

10 substituents the same or different selected from
halogen, C₁-C₃alkoxy, C₁-C₃alkylthio, C₁-C₃-
alkylsulfinyl and C₁-C₃alkylsulfonyl,

C₁-C₄alkylthio optionally substituted with one or more

15 substituents the same or different selected from
halogen, C₁-C₃alkoxy, C₁-C₃alkylthio, C₁-C₃-
alkylsulfinyl and C₁-C₃alkylsulfonyl,

C₁-C₄alkylsulfinyl optionally substituted with one or
more substituents the same or different selected
from halogen, C₁-C₃alkoxy, C₁-C₃alkylthio, C₁-C₃-
alkylsulfinyl and C₁-C₃alkylsulfonyl,

20 C₁-C₄alkylsulfonyl optionally substituted with one or
more substituents the same or different selected
from halogen, C₁-C₃alkoxy, C₁-C₃alkylthio, C₁-C₃-
alkylsulfinyl and C₁-C₃alkylsulfonyl,

C₁-C₄alkylcarbonyl optionally substituted with one or

25 more substituents the same or different selected
from halogen, C₁-C₃alkoxy, C₁-C₃alkylthio, C₁-C₃-
alkylsulfinyl and C₁-C₃alkylsulfonyl,

C₁-C₄alkoxycarbonyl optionally substituted with one or

30 more substituents the same or different selected
from halogen and C₁-C₃alkoxy,

di(C₁-C₄alkyl)amino optionally substituted with one or
more substituents the same or different selected
from halogen and C₁-C₃alkoxy,

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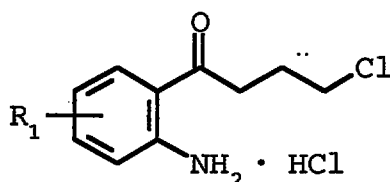
-3-

di(C₁-C₄alkyl)aminocarbonyl optionally substituted
with one or more substituents the same or
different selected from halogen and C₁-C₃alkoxy,
di(C₁-C₄alkyl)aminosulfonyl optionally substituted
5 with one or more substituents the same or
different selected from halogen and C₁-C₃alkoxy,
or

a heterocyclic ring having 2 to 6 carbon atoms and 1
to 3 heteroatoms the same or different selected
10 from nitrogen, oxygen and sulfur atoms and being
optionally substituted on the carbon atoms with
one or more substituents the same or different
selected from halogen, C₁-C₄alkyl and C₁-
C₄haloalkyl;

15 X is -(CH₂)₃-Y, cyclopropyl or tetrahydro-2-oxo-3-furoyl;
and
Y is chlorine, bromine or hydroxy; or
an acid addition salt thereof.

20 The invention also provides a process for preparing a
compound of formula A



25 A

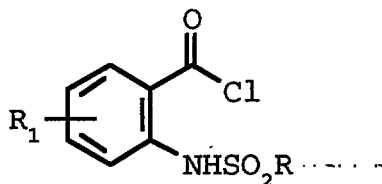
wherein R₁ is as defined in claim 1 which comprises the
following steps:

i) reacting a compound of formula B

30



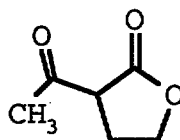
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B

wherein R and R₁ are as defined in claim 1 with a compound of formula C

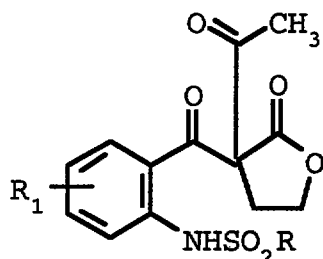
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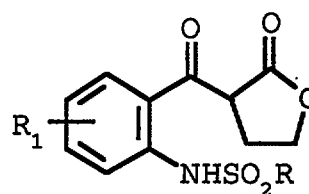
C

in the presence of a base and an organic solvent to form a compound of formula E

10



D

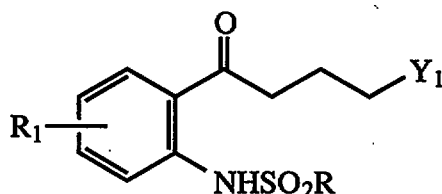


E

and optionally hydrolysing any compound of formula D present to give a compound of formula E;

if desired isolating compound E by crystallization;

15 ii) reacting compound E with concentrated HCl or HBr in the presence of an organic solvent optionally in the presence of water to form a compound of formula F;



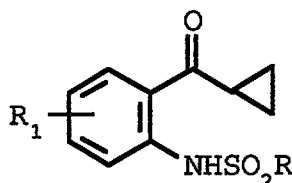
F

20



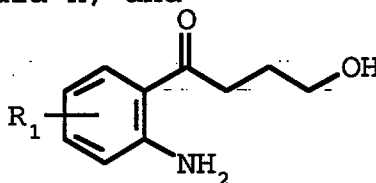
wherein Y₁ is Cl, Br or OH

iii) treating compound F with an aqueous base at an elevated temperature to give a compound of formula G;



G

iv) treating compound G with a strong acid to give a compound of formula H; and



H

and

v) reacting compound H with HCl to form the compound of formula A.

Compound A wherein R₁ is hydrogen, 1-(o-aminophenyl)-4-chloro-1-butanone hydrochloride, is used in the manufacture of the herbicidal intermediate o-(aminophenyl)cyclopropyl ketone. A description of o-(aminophenyl)cyclopropyl ketone and its use in the manufacture of 1-{{o-(cyclopropylcarbonyl)phenyl}-sulfamoyl}-3-(4,6-dimethoxy-2-pyrimidinyl)urea herbicide is described in the prior art. The present invention also avoids the use of o-nitrobenzoyl chloride, which is an explosive, as an intermediate.

The base used in step (i) may be a magnesium C₁-C₄ alkoxide, preferably one which is readily available such as magnesium methoxide or magnesium ethoxide. The organic solvent used in step (i) may be an aromatic hydrocarbon or



dialkyl ether such as toluene, xylene or tetrahydrofuran. The organic solvent used in step (ii) for preparing compound F may be an inert organic solvent such as toluene or xylene and the acid used in step (ii) may be a mineral acid such as concentrated HCl. When water is present compound of formula F wherein Y₁ is OH may be formed. The base used in step (iii) for preparing compound G may be an alkali metal hydroxide such as sodium hydroxide or potassium hydroxide. The elevated temperature in step (iii) may be any temperature in excess of 25 °C, preferably about 90 °-130 °C. The strong acid used in step (iv) for preparing compound H may be sulfuric acid. The acid used for preparing compound A in step (v) may be a mineral acid such as concentrated HCl.

15

The compounds of the invention may be used to prepare herbicidal sulfamoyl urea compounds (K) by employing the process of the invention to prepare compounds of formula A and converting said formula A compounds to the corresponding *o*-(aminophenyl)cyclopropyl ketones (J) using conventional methods described in the prior art, and converting said phenyl ketones to the desired sulfamoylurea herbicidal products, preferably the cereal-selective, herbicidal sulfamoyl urea, 1-{[*o*-(cyclopropyl-carbonyl)phenyl]sulfamoyl}-3-(4,6-dimethoxy-2-pyrimidinyl urea. The conversion of the phenyl ketone derivatives to sulfamoylurea herbicides may be accomplished by known processes.

20

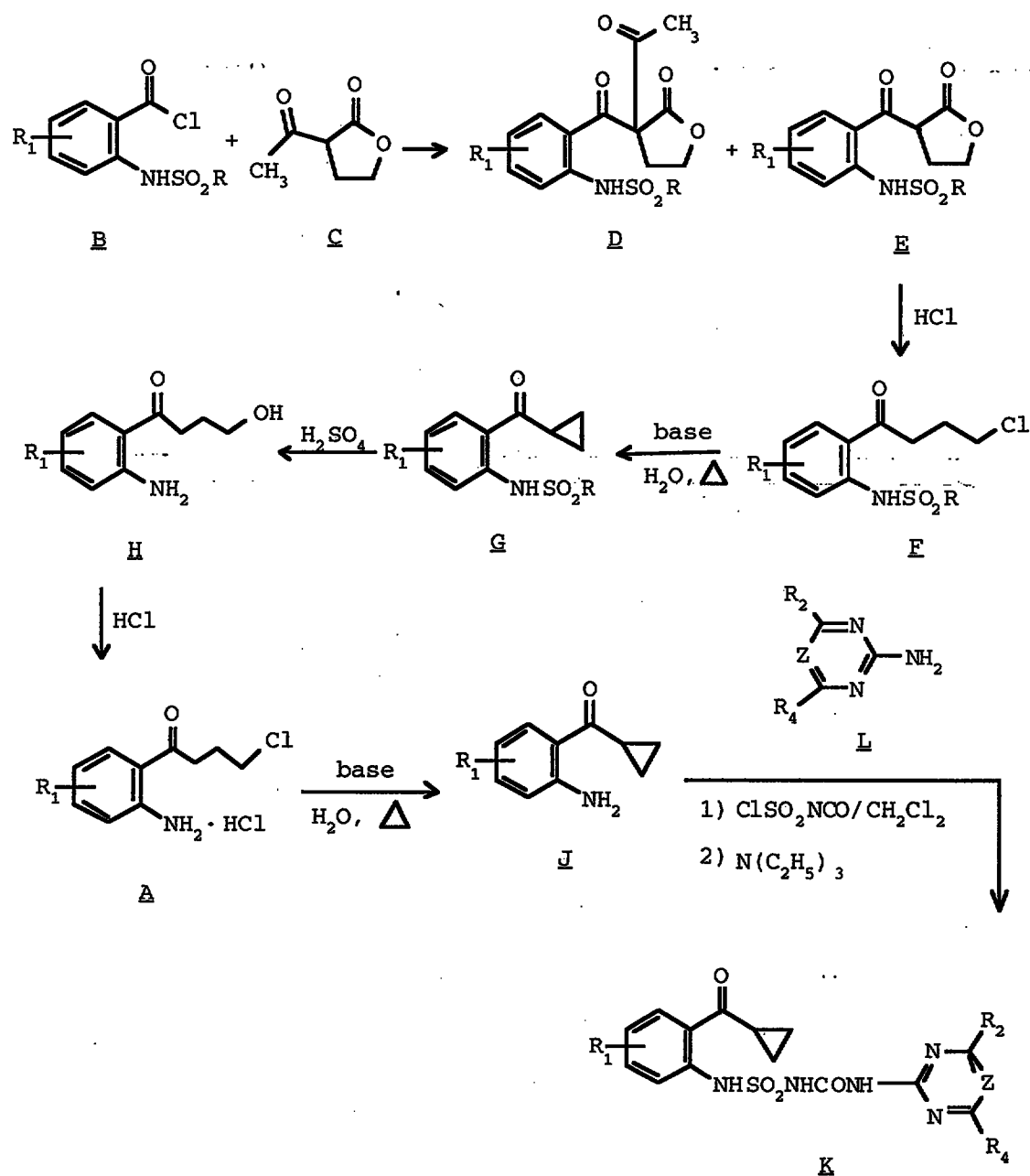
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The preparation is shown in flow diagram I.

30



FLOW DIAGRAM I



5

In accordance with the process of the invention, the compound of formula A is prepared as described hereinabove and converted to the *o*-(aminophenyl)cyclopropyl ketone

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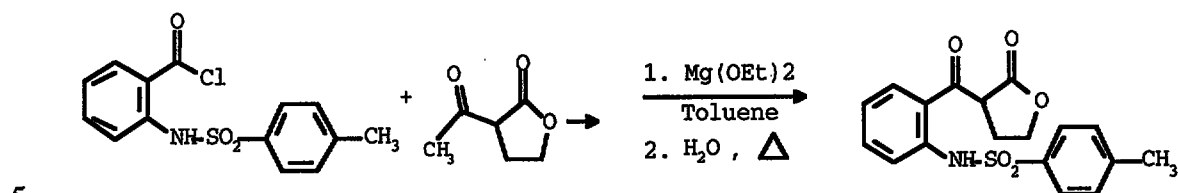


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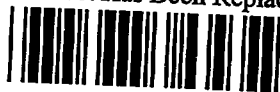
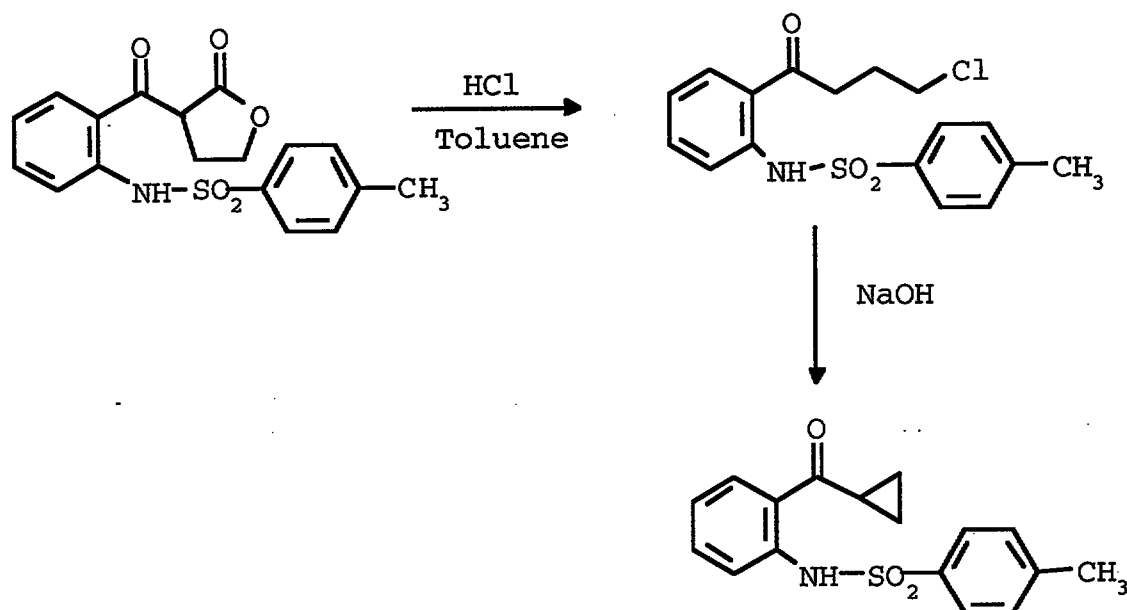
-8-

compound of formula J by conventional dehydrohalogenation techniques and the formula J compound may be reacted with a 2-aminoaryl compound of formula L and chlorosulfonyl isocyanate in the presence of triethylamine
5 and a solvent to give the desired herbicidal sulfamoyl urea of formula K.

The invention is further illustrated in the examples, below, but is not to be deemed limited thereby. The terms NMR and MS designate proton nuclear magnetic resonance and
10 mass spectrometry, respectively.

**EXAMPLE 1****Preparation of 2'-(Tetrahydro-2-oxo-3-furoyl)-p-toluenesulfonanilide**

To a mixture of 40 mL of toluene and 2.03 g (178 mmol) of magnesium ethoxide in a flask under nitrogen at 5-10° C is charged 4.6 g (36 mmol) of 2-acetylbutyrolactone over 2 minutes. The resulting slurry is stirred for 10 minutes at 5-10° C and for about 1.5 hours at 20° C. The reaction mixture is treated with a solution of 10.0 g (32 mmol) of N-p-tolylsulfonyl anthranoyl chloride in 20 mL of toluene, stirred several hours at ambient temperature and for about 2 hours at 45-50° C. Water (120 mL) is added and the gray slurry is stirred for about 4 hours at 65-70° C. The pH is adjusted to 1 with concentrated sulfuric acid. The phases are separated and the organic layer is filtered to afford 7.6 g of 2'-(tetrahydro-2-oxo-3-furoyl)-p-toluenesulfonanilide. The remaining product is isolated from the organic layer filtrate by concentration in vacuo to give an additional 2.1 g of product for an overall yield of 83% (mp 138-141° C). The product is identified by NMR and MS analyses.

**EXAMPLE 2****Preparation of 2'-(Cyclopropylcarbonyl)-p-toluenesulfonanilide**

5

A two phase slurry mixture of 3.56 g (1.0 mmol) of the product from example 1, 25 mL of toluene and 20 mL of 37% HCl is refluxed for about 12 hours, cooled and the resulting slurry is filtered to afford 1.98 g of 4-chloro-1-(2-N-tosylaminophenyl)-1-butanone. The filtrate phases are separated and the aqueous phase is extracted with toluene. The organic phases are combined and concentrated in vacuo to give the remaining 4-chloro-1-(2-N-tosylaminophenyl)-1-butanone product (1.15 g) for an overall yield of 90% (mp 108-113 °C). The product is identified by NMR and MS analyses.

To a solution of 1.62 g (4.6 mmol) of 4-chloro-1-(2-N-tosylaminophenyl)-1-butanone in 10 mL of toluene is charged 17.3 g (28.7 mmol) of 6.6% sodium hydroxide solution. The resulting two phase mixture is refluxed

20

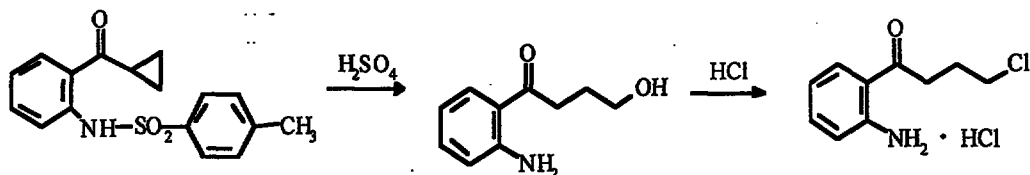


-11-

for about 1 hour, cooled and adjusted to pH 1 with concentrated sulfuric acid. The organic layer is separated and concentrated in vacuo to afford 1.50 g of 2'-(cyclopropylcarbonyl)-p-toluenesulfonanilide in 100% yield (mp 92-100 °C). The product is identified by NMR and MS analyses.

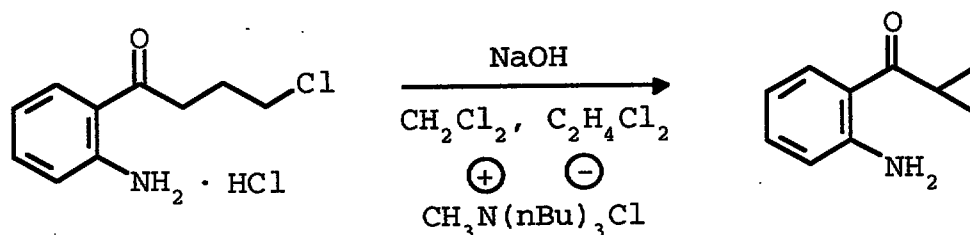
EXAMPLE 3

10 **Preparation of 1-(o-Aminophenyl)-4-chloro-1-butanone hydrochloride**



15 The product of example 2 (1.5 g, 4.7 mmol) is treated with 96% sulfuric acid and heated to 90 °C for 15 minutes. The solution is cooled, adjusted to pH 9 with ammonium hydroxide and extracted with methylene chloride. The combined extracts are concentrated in vacuo to provide 1-(o-aminophenyl)-4-hydroxy-1-butanone (80% yield, mp 58-61 °C). The product is identified by NMR and MS analyses.

20 A mixture of 9.3 g (5.1 mmol) of 1-(o-aminophenyl)-4-hydroxy-1-butanone, 26 mL of water and 90 mL of 37% HCl is refluxed for about 6.5 hours, cooled and filtered to afford 25 8.0 g of 1-(o-aminophenyl)-4-chloro-1-butanone hydrochloride. Extraction of the aqueous mother liquor with methylene chloride gives an additional 1.10 g of the title product for an overall yield of 73% (mp 142-145 °C). The product is identified by NMR and MS analyses.

**EXAMPLE 4****Preparation of o-Aminophenyl cyclopropyl ketone**

5

A solution of 0.30 g (1.3 mmol) of 1-(o-aminophenyl)-4-chloro-1-butanone hydrochloride in 3 mL of methylene chloride and 3 mL of ethylene dichloride is treated with 1.2 g (3 mmol) of 10% sodium hydroxide solution and 0.05 g (0.2 mmol) of 75% aqueous methyl tributylammonium chloride and heated to 50 °C for about 5 hours. After cooling to room temperature, the phases are separated. The aqueous layer is extracted with methylene chloride. The combined organic extracts are washed with water and concentrated in vacuo to give 0.14 g (70% yield) of o-aminophenyl cyclopropyl ketone (mp 46-48 °C). The product is identified by NMR and MS analyses.

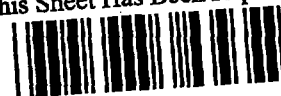
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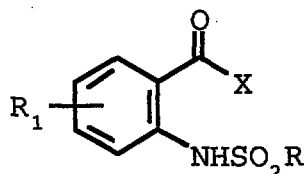


CLAIMS:

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1. A compound of the formula



(I)

wherein

R is straight or branched C₁-C₆ alkyl or phenyl optionally substituted with one or more substituents the same or different selected from C₁-C₃ alkyl, C₁-C₃ alkoxy, chlorine and bromine;

R₁ is hydrogen, cyano, nitro, halogen, formyl, C₁-C₄ alkyl

optionally substituted with one or more substituents the same or different selected from halogen, C₁-C₃alkoxy, C₁-C₃alkylthio, C₁-C₃-alkylsulfinyl and C₁-C₃alkylsulfonyl,

C₁-C₄alkoxy optionally substituted with one or more substituents the same or different selected from halogen, C₁-C₃alkoxy, C₁-C₃alkylthio, C₁-C₃-alkylsulfinyl and C₁-C₃alkylsulfonyl,

C₁-C₄alkylthio optionally substituted with one or more substituents the same or different selected from halogen, C₁-C₃alkoxy, C₁-C₃alkylthio, C₁-C₃-alkylsulfinyl and C₁-C₃alkylsulfonyl,

C₁-C₄alkylsulfinyl optionally substituted with one or more substituents the same or different selected from halogen, C₁-C₃alkoxy, C₁-C₃alkylthio, C₁-C₃-alkylsulfinyl and C₁-C₃alkylsulfonyl,

C₁-C₄alkylsulfonyl optionally substituted with one or more substituents the same or different selected from halogen, C₁-C₃alkoxy, C₁-C₃alkylthio, C₁-C₃-alkylsulfinyl and C₁-C₃alkylsulfonyl,



C₁-C₄alkylcarbonyl optionally substituted with one or more substituents the same or different selected from halogen, C₁-C₃alkoxy, C₁-C₃alkylthio, C₁-C₃alkylsufinyl and C₁-C₃alkylsulfonyl,

C₁-C₄alkoxycarbonyl optionally substituted by one or more substituents the same or different selected from halogen and C₁-C₃alkoxy,

di(C₁-C₄alkyl)amino optionally substituted by one or more substituents the same or different selected from halogen and C₁-C₃alkoxy,

di(C₁-C₄alkyl)aminocarbonyl optionally substituted by one or more substituents the same or different selected from halogen and C₁-C₃alkoxy,

di(C₁-C₄alkyl)aminosulfonyl optionally substituted by one or more substituents the same or different selected from halogen and C₁-C₃alkoxy, or

a heterocyclic ring having 2 to 6 carbon atoms and 1 to 3 heteroatoms the same or different selected from nitrogen, oxygen and sulfur atoms and being optionally substituted on the carbon atoms with one or more substituents the same or different selected from halogen, C₁-C₄alkyl and C₁-C₄haloalkyl;

X is -(CH₂)₃-Y, cyclopropyl or tetrahydro-2-oxo-3-furoyl;
and Y is chlorine, bromine or hydroxy;
or an acid addition salt thereof.

2. The compound according to claim 1 wherein R₁ is hydrogen and optionally R is methyl or p-tolyl.

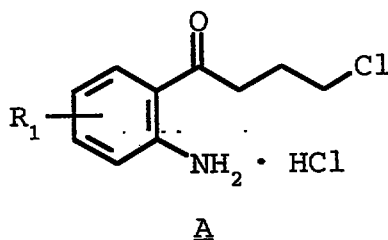
3. The compound according to claim 1 or claim 2 wherein X is cyclopropyl, -(CH₂)₃-Cl, or tetrahydro-2-oxo-3-furoyl.

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4. A process for preparing a compound of formula A

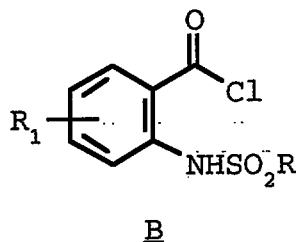


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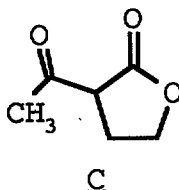


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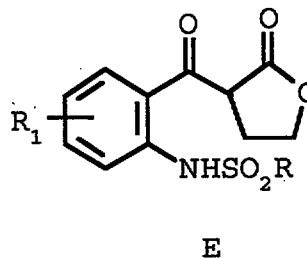
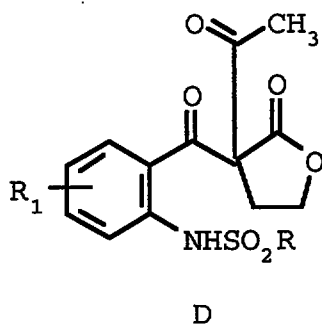
i) reacting a compound of formula B



with a compound of formula C



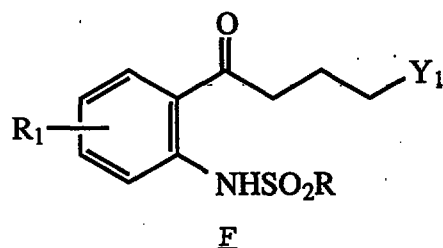
in the presence of a base and an organic solvent to form a compound of formula E



and optionally hydrolysing any compound of formula D present to give a compound of formula E;

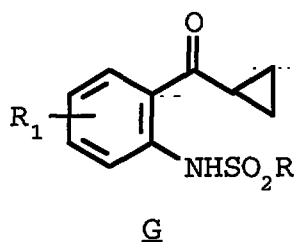


ii) reacting compound E with concentrated HCl or HBr in the presence of an organic solvent optionally in the presence of water to form a compound of formula F

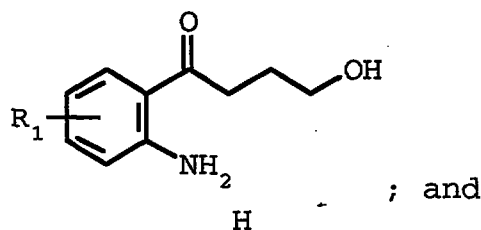


where Y₁ = Cl, Br or OH

iii) treating compound F with an aqueous base at an elevated temperature to give a compound of formula G



iv) treating compound G with a strong acid to give a compound of formula H



v) reacting compound H with HCl to form the compound of formula A;

in which formulae R and R₁ are as defined in claim 1.

5. The process according to claim 4 wherein the base in step (i) is magnesium ethoxide and the organic solvent





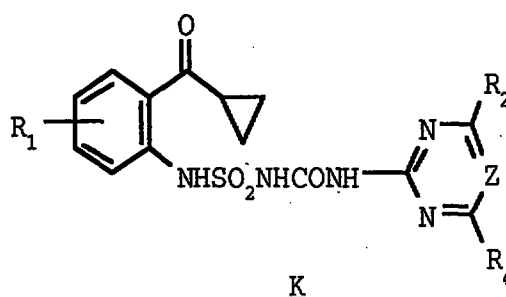
is toluene; the organic solvent in step ii) is toluene; the base in step iii) is NaOH; and the strong acid in step iv) is sulfuric acid.

6. The process according to claim 4 or claim 5 wherein R_1 is hydrogen.

7. The process according to any one of claims 4 to 6 wherein R is p-tolyl or methyl.

8. The process according to any one of claims 4 to 7 which further comprises reacting the compound of formula A with a base to prepare o-aminophenyl cyclopropyl ketone.

9. A process for preparing a sulfamoyl urea compound of formula K



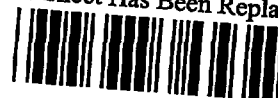
wherein R_1 is as defined in Claim 1;

Z is N or CR_3 ;

R_2 is hydrogen, halogen, C_1 - C_4 alkyl optionally substituted with one or more substituents the same or different selected from halogen or C_1 - C_3 alkoxy,

C_1 - C_4 alkoxy optionally substituted with one or more substituents the same or different selected from halogen and C_1 - C_3 alkoxy,

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C₁-C₄alkylthio optionally substituted with one or more substituents the same or different selected from halogen and C₁-C₃alkoxy,

C₁-C₄alkylsulfinyl optionally substituted with one or more substituents the same or different selected from halogen and C₁-C₃alkoxy,

C₁-C₄alkylsulfonyl optionally substituted with one or more the same or different selected from halogen and C₁-C₃alkoxy groups, or

C₁-C₄alkylamino or di(C₁-C₄alkyl)amino each alkyl group being optionally substituted with one or more substituents the same or different selected from halogen and C₁-C₃alkoxy;

R₃ is hydrogen or halogen; and

R₄ is hydrogen, C₁-C₄alkyl optionally substituted with one or more substituents the same or different selected from halogen and C₁-C₃alkoxy,

C₁-C₄alkoxy optionally substituted with one or more substituents the same or different selected from halogen and C₁-C₃alkoxy,

C₁-C₄alkylthio optionally substituted with one or more substituents the same or different selected from halogen and C₁-C₃alkoxy,

C₁-C₄alkylsulfinyl optionally substituted with one or more substituents the same or different selected from halogen and C₁-C₃alkoxy,

C₁-C₄alkylsulfonyl optionally substituted with one or more substituents the same or different selected from halogen and C₁-C₃alkoxy, or

C₁-C₄alkylamino or di(C₁-C₄alkyl)amino each alkyl group being optionally substituted with one or more substituents the same or different selected from halogen and C₁-C₃alkoxy,

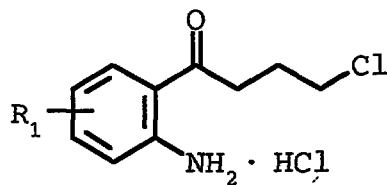
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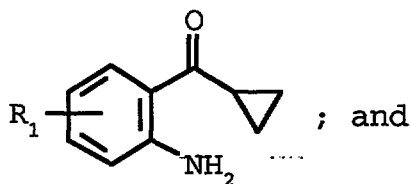


- i) dehydrohalogenating a compound of formula A



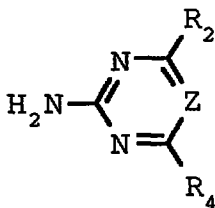
A

wherein formula A is prepared by the process of claim 4, to form the o-(aminophenyl)cyclopropyl ketone of formula J



J

- ii) reacting said o-(aminophenyl)cyclopropyl ketone with a 2-aminoaryl compound of formula L



L

and chlorosulfonyl isocyanate, in the presence of triethylamine and a solvent to give the desired sulfamoyl urea compound of formula K.

10. The process according to claim 9 for preparing a compound of formula K wherein Z is CR₃; R₁ and R₃ are each hydrogen; and R₂ and R₄ are each methoxy.

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