

Electrochemical coupling of two phenols which differ in their oxidation potential

The invention which follows relates to an electrochemical process for coupling two phenols of different oxidation potential. The invention further relates to novel biphenols which can be prepared, for example, by electrochemical coupling.

The term “phenols” is used as a generic term in this application and therefore also encompasses substituted phenols. Two phenols having a different oxidation potential must therefore also have different substitution.

Direct coupling of two different phenols has to date been described only by an electrochemical route: Sartori et al. J. Org. Chem. 1993, 58, 7271-7273. The coupling is effected here using an oxidizing agent such as FeCl_3 , VOCl_3 , p-benzoquinone, CuBr_2 or 2,3-dichloro-5,6-dicyano-1,4-benzoquinone (DDQ), and with addition of AlCl_3 .

Disadvantages of the methods described by Sartori et al. are need for the dry solvents and for exclusion of air. Furthermore, large amounts of oxidizing agents, some of which are toxic (e.g. DDQ), are used. During the reaction, toxic by-products occur, which have to be separated in a complex manner from the desired product and disposed of in an expensive manner.

To date, the coupling only of identical phenols by an electrochemical route has been successfully conducted and described: Kirste et al. Chem. Eur. J. 2011, 17, 14164-14169; Kirste et al. Org. Lett., Vol. 13, No. 12, 2011; Kirste et al. Chem. Eur. J. 2009, 15, 2273-2277.

A problem which occurs in the electrochemical coupling of different molecules is that the co-reactants generally have different oxidation potentials E_{Ox} . The result of this is that the molecule having the lower oxidation potential has a higher propensity to release an electron (e^-) to the anode and an H^+ ion to, for example, the solvent than the molecule having the higher oxidation potential. The oxidation potential E_{Ox} can be calculated via the Nernst equation:

$$E_{\text{Ox}} = E^\circ + (0.059/n) * \lg([\text{Ox}]/[\text{Red}])$$

E_{Ox} : electrode potential for the oxidation reaction (= oxidation potential)

E° : standard electrode potential

n : number of electrons transferred

$[Ox]$: concentration of the oxidized form

$[Red]$: concentration of the reduced form

- 5 If the processes cited in the literature above were to be applied to two different phenols, the result of this would be to form predominantly free radicals of the molecule having a lower oxidation potential, which would then react with themselves. By far the predominant main product obtained would thus be a biphenol which has formed from two identical phenols. This problem does not occur in the coupling of identical molecules.

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The problem addressed by the invention which follows was to provide an electrochemical process in which phenols having different oxidation potentials can be coupled to one another, and the yield of the biphenol formed from two different phenols is above that as achievable by the electrochemical methods known from the literature, i.e. above that of the biphenol formed from two different phenols.

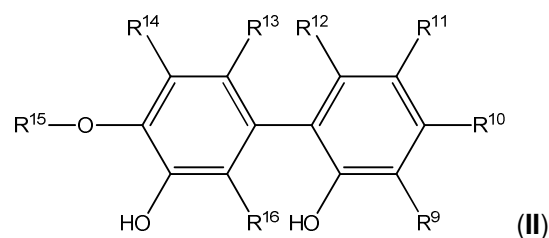
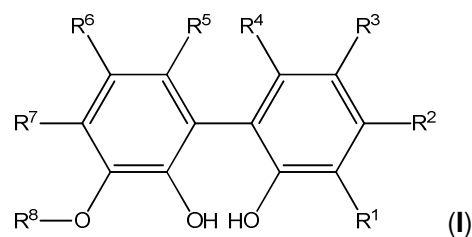
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In addition, novel biphenols were to be synthesized.

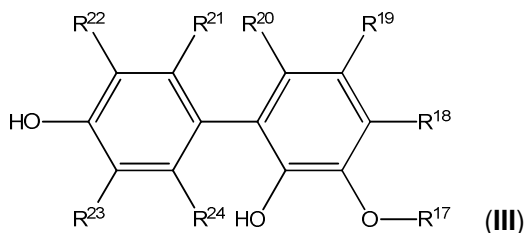
The problem is solved by a process according to Claim 8.

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Compound of one of the general formulae (I) to (III):



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where $R^2, R^3, R^4, R^5, R^6, R^7, R^{10}, R^{11}, R^{12}, R^{13}, R^{14}, R^{16}, R^{18}, R^{19}, R^{20}, R^{21}, R^{24}$ are selected from:

-H, -alkyl, -O-alkyl, -O-aryl, -S-alkyl, -S-aryl;

5 R^8, R^{15}, R^{17} are -alkyl;

R^1, R^9, R^{22}, R^{23} are selected from: -H, -alkyl;

and, if R^3 is -Me, R^1 and R^2 are not both -H.

Alkyl is an unbranched or branched aliphatic carbon chain having 1 to 10 carbon atoms. The
10 carbon chain preferably has 1 to 6 carbon atoms, more preferably 1 to 4 carbon atoms.

Aryl for aromatic (hydrocarbyl) radicals, preferably having up to 14 carbon atoms, e.g. phenyl- (C_6H_5-), naphthyl- ($C_{10}H_7-$), anthryl- ($C_{14}H_9-$), preferably phenyl.

15 In one embodiment of the invention, $R^2, R^3, R^4, R^5, R^6, R^7, R^{10}, R^{11}, R^{12}, R^{13}, R^{14}, R^{16}, R^{18}, R^{19}, R^{20}, R^{21}, R^{24}$ are selected from: -H, -alkyl, -O-alkyl, -O-aryl.

In one embodiment of the invention, $R^2, R^3, R^4, R^5, R^6, R^7, R^{10}, R^{11}, R^{12}, R^{13}, R^{14}, R^{16}, R^{18}, R^{19}, R^{20}, R^{21}, R^{24}$ are selected from: -H, -alkyl.

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In one embodiment of the invention, R^4 and R^5 are -H.

In one embodiment of the invention, R^3 and R^6 are -alkyl.

25 In one embodiment of the invention, R^{11} is -O-alkyl.

In one embodiment of the invention, R^{13} is -alkyl.

In one embodiment of the invention, R^{19} is -alkyl.

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As well as the compounds, also claimed is a process by which, for example, the abovementioned compounds can be prepared.

Electrochemical process for preparing biphenols, comprising the process steps of:

- 5 a) introducing a solvent or solvent mixture and a conductive salt into a reaction vessel,
b) adding a first phenol having an oxidation potential $|E_{Ox}1|$ to the reaction vessel,
c) adding a second phenol having an oxidation potential $|E_{Ox}2|$ to the reaction vessel, where:
 $|E_{Ox}2| > |E_{Ox}1|$ and $|E_{Ox}2| - |E_{Ox}1| = |\Delta E|$,
the second phenol being added in excess relative to the first phenol,
10 and the solvent or solvent mixture being selected such that ΔE is in the range from 10 mV to 450 mV,
d) introducing two electrodes into the reaction solution,
e) applying a voltage to the electrodes,
f) coupling the first phenol to the second phenol to give a biphenol.

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Process steps a) to d) can be effected here in any sequence.

One aspect of the invention is that the yield of the reaction can be controlled via the difference in the oxidation potentials ($|\Delta E|$) of the two phenols.

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The process according to the invention solves the problem mentioned at the start.

For efficient conduct of the reaction, two reaction conditions are necessary:

- the phenol having the higher oxidation potential (second phenol) has to be added in excess,
and
25 - the difference in the two oxidation potentials ($|\Delta E|$) has to be within a particular range.

If the first condition is not met, the main product formed is the biphenol which forms through the coupling of two molecules of the first phenol.

- 30 If $|\Delta E|$ is too small, too much biphenol which forms through the coupling of two molecules of the second phenol is by-produced.

If, in contrast, $|\Delta E|$ is too large, an excessively high excess of the second phenol would be required, which would make the reaction uneconomic.

For the process according to the invention, knowledge of the absolute oxidation potentials of the two phenols is not absolutely necessary. It is sufficient when the difference in the two oxidation potentials from one another is known.

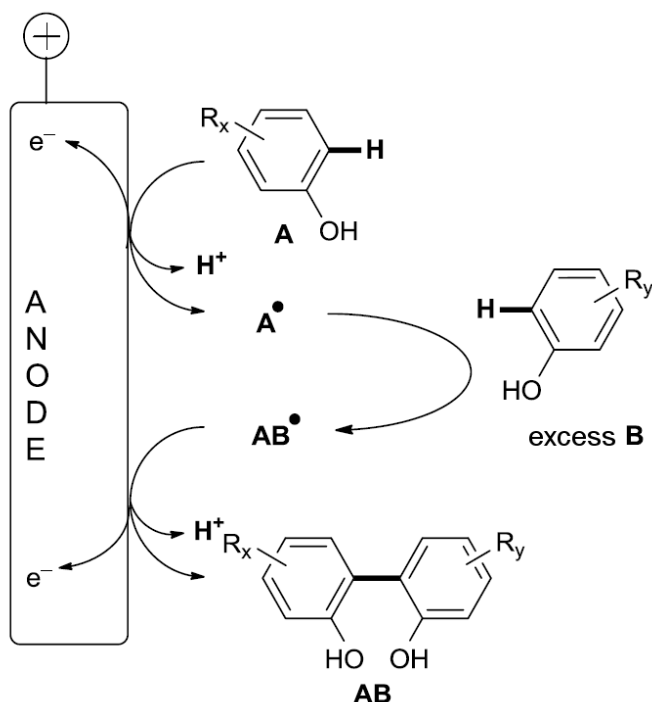
- 5 A further aspect of the invention is that the difference in the two oxidation potentials ($|ΔE|$) can be influenced via the solvents or solvent mixtures used.

For instance, the difference in the two oxidation potentials ($|ΔE|$) can be moved into the desired range by suitable selection of the solvent/solvent mixture.

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Proceeding from 1,1,1,3,3,3-hexafluoroisopropanol (HFIP) as the base solvent, a $|ΔE|$ which is too small can be increased, for example, by addition of alcohol. A $|ΔE|$ which is too large can be lowered, in contrast, by addition of water.

- 15 The reaction sequence which proceeds is shown in the following scheme:



First of all, the compound A having the lower oxidation potential releases an electron to the anode. Because of the positive charge, the compound A becomes a very strong acid and

spontaneously releases a proton. The radical thus formed then reacts with the compound B which is present in the solution in excess relative to the compound A. The biphenol AB radical formed by the coupling releases an electron to the anode and a proton to the solvent.

- 5 If the phenol B had not been added in excess, the phenol A radical would react with a second phenol A radical to give the corresponding biphenol AA.

With the aid of the process according to the invention, it has been possible for the first time to electrochemically couple phenols having different oxidation potentials in good yields.

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In one variant of the process, the conductive salt is selected from the group of alkali metal, alkaline earth metal, tetra(C₁-C₆-alkyl)ammonium, 1,3-di(C₁-C₆-alkyl)imidazolium and tetra(C₁-C₆-alkyl)phosphonium salts.

- 15 In one variant of the process, the counter ions of the conductive salts are selected from the group of sulphate, hydrogensulphate, alkylsulphates, arylsulphates, alkylsulphonates, arylsulphonates, halides, phosphates, carbonates, alkylphosphates, alkylcarbonates, nitrate, tetrafluoroborate, hexafluorophosphate, hexafluorosilicate, fluoride and perchlorate.

- 20 In one variant of the process, the conductive salt is selected from tetra(C₁-C₆-alkyl)ammonium salts, and the counterion is selected from sulphate, alkylsulphate, arylsulphate.

In one variant of the process, the second phenol is used at least in twice the amount relative to the first phenol.

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In one variant of the process, the ratio of the first phenol to the second phenol is in the range from 1:2 to 1:4.

In one variant of the process, either the first phenol the second phenol has an -O-alkyl group.

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In one variant of the process, the solvent or solvent mixture is selected such that $|ΔE|$ is in the range from 20 mV to 400 mV, preferably in the range from 30 mV to 350 mV.

In one variant of the process, the reaction solution is free of fluorinated compounds.

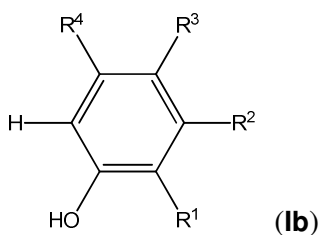
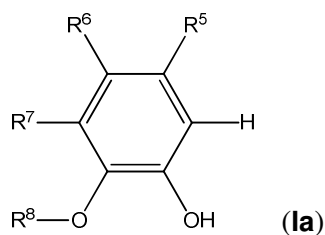
In one variant of the process, the reaction solution is free of transition metals.

5 In one variant of the process, the reaction solution is free of substrates having departing functionalities other than hydrogen atoms.

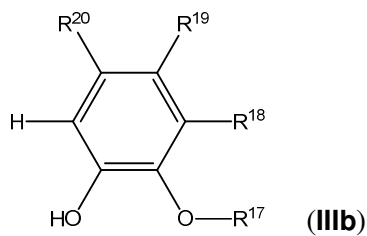
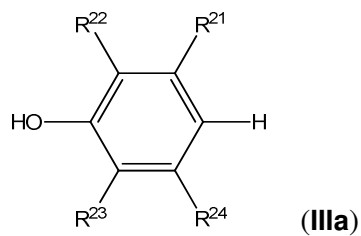
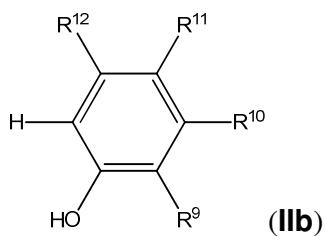
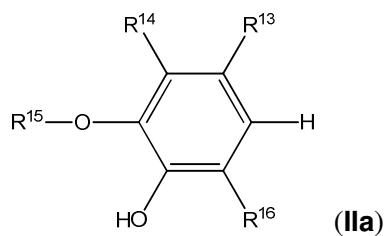
In the process claimed, it is possible to dispense with leaving groups at the coupling sites apart from hydrogen atoms.

10 In one variant of the process, the reaction solution is free of organic oxidizing agents.

In one variant of the process, the first phenol and the second phenol are selected from: **Ia, Ib, IIa, IIb, IIIa, IIIb**:



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where $R^2, R^3, R^4, R^5, R^6, R^7, R^{10}, R^{11}, R^{12}, R^{13}, R^{14}, R^{16}, R^{18}, R^{19}, R^{20}, R^{21}, R^{24}$ are selected from:

-H, -alkyl, -O-alkyl;

R^8, R^{15}, R^{17} are -alkyl;

R^1, R^9, R^{22}, R^{23} are selected from: -H, -alkyl,

5 and the following combinations are possible here:

first phenol	Ia	Ib	IIa	IIb	IIIa	IIIb
second phenol	Ib	Ia	IIb	IIa	IIIb	IIIa

Alkyl is an unbranched or branched aliphatic carbon chain having 1 to 10 carbon atoms. The carbon chain preferably has 1 to 6 carbon atoms, more preferably 1 to 4 carbon atoms.

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Aryl for aromatic (hydrocarbyl) radicals, preferably having up to 14 carbon atoms, e.g. phenyl- (C_6H_5-), naphthyl- ($C_{10}H_7-$), anthryl- ($C_{14}H_9-$), preferably phenyl.

In one variant of the process, if R^3 is -Me, R^1 and R^2 are not both -H.

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The invention is illustrated in detail hereinafter by working examples and a figure.

Figure 1 shows a reaction apparatus in which the above-described coupling reaction can be performed. The apparatus comprises a nickel cathode (1) and an anode composed of boron-doped diamond (BDD) on silicon (5). The apparatus can be cooled with the aid of the cooling jacket (3). The arrows here indicate the flow direction of the cooling water. The reaction space is closed by a Teflon stopper (2). The reaction mixture is mixed by a magnetic stirrer bar (7). On the anode side, the apparatus is closed by screw clamps (4) and seals (6).

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Figure 2 shows a reaction apparatus in which the above-described coupling reaction can be performed on a larger scale. The apparatus comprises two glass flanges (5'), which are used to apply pressure, through screw clamps (2') and seals, to electrodes (3') composed of carrier materials coated with boron-doped diamond (BDD), or other electrode materials known to those skilled in the art. The reaction space may be provided with a reflux condenser via a glass sleeve (1'). The reaction mixture is mixed with the aid of a magnetic stirrer bar (4').

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In Figure 3, the dependence of the oxidation potential ΔE_{Ox} of the *para* substituents on the amount of methanol added is plotted.

5 In Figure 4, the dependence of the oxidation potential ΔE_{Ox} of the *meta* substituents on the amount of methanol added is plotted.

In Figure 5, the dependence of the oxidation potential ΔE_{Ox} of the 2,4-disubstituted phenols on the amount of methanol added is plotted.

10 In Figure 6, the dependence of the oxidation potential ΔE_{Ox} of the 3,4-disubstituted phenols on the amount of methanol added is plotted.

Analysis

15 Chromatography

The preparative liquid chromatography separations via “flash chromatography” were conducted with a maximum pressure of 1.6 bar on 60 M silica gel (0.040-0.063 mm) from *Macherey-Nagel GmbH & Co*, Düren. The unpressurized separations were conducted on Geduran Si 60 silica gel (0.063-0.200 mm) from *Merck KGaA*, Darmstadt. The solvents used as eluents (ethyl acetate (technical grade), cyclohexane (technical grade)) were purified beforehand by
20 distillation on a rotary evaporator.

For thin-layer chromatography (TLC), ready-to-use PSC plates, silica gel 60 F254 from *Merck KGaA*, Darmstadt, were used. The R_f values are reported according to the eluent mixture used. The TLC plates were stained using a cerium-molybdotophosphoric acid solution as a dipping
25 reagent: 5.6 g of molybdotophosphoric acid, 2.2 g of cerium(IV) sulphate tetrahydrate and 13.3 g of concentrated sulphuric acid in 200 ml of water.

Gas chromatography (GC/GCMS)

The gas chromatography analyses (GC) of product mixtures and pure substances were effected
30 with the aid of the GC-2010 gas chromatograph from *Shimadzu*, Japan. Measurement is effected on an HP-5 quartz capillary column from *Agilent Technologies*, USA (length: 30 m; internal diameter: 0.25 mm; film thickness of the covalently bound stationary phase: 0.25 μm ; carrier gas: hydrogen; injector temperature: 250°C; detector temperature: 310°C; programme: “hard” method: start temperature 50°C for 1 min, heating rate: 15°C/min, final temperature

290°C for 8 min). Gas chromatography mass spectra (GCMS) of product mixtures and pure substances were recorded with the aid of the GC-2010 gas chromatograph combined with the GCMS-QP2010 mass detector from *Shimadzu*, Japan. Measurement is effected on an HP-1 quartz capillary column from *Agilent Technologies*, USA (length: 30 m; internal diameter: 0.25 mm; film thickness of the covalently bound stationary phase: 0.25 µm; carrier gas: hydrogen; injector temperature: 250°C; detector temperature: 310°C; programme: “hard” method: start temperature 50°C for 1 min, heating rate: 15°C/min, final temperature 290°C for 8 min; GCMS: ion source temperature: 200°C).

10 Melting points

Melting points were measured with the aid of the SG 2000 melting point measuring instrument from *HW5*, Mainz and are uncorrected.

Elemental analysis

- 15 The elemental analyses were conducted in the Analytical Division of the Department of Organic Chemistry at the Johannes Gutenberg University of Mainz on a Vario EL Cube from *Foss-Heraeus*, Hanau.

Mass spectrometry

- 20 All electrospray ionization analyses (ESI+) were conducted on a QToF Ultima 3 from *Waters Micromasses*, Milford, Massachusetts. EI mass spectra and the high-resolution EI spectra were measured on an instrument of the MAT 95 XL sector-field instrument type from *ThermoFinnigan*, Bremen.

25 NMR spectroscopy

- The NMR spectroscopy studies were conducted on multi-nuclear resonance spectrometers of the AC 300 or AV II 400 type from *Bruker*, Analytische Messtechnik, Karlsruhe. The solvent used was CDCl₃. The ¹H and ¹³C spectra were calibrated according to the residual content of undeuterated solvent according to the *NMR Solvent Data Chart* from *Cambridge Isotopes Laboratories*, USA. Some of the ¹H and ¹³C signals were assigned with the aid of H,H COSY, H,H NOESY, H,C HSQC and H,C HMBC spectra. The chemical shifts are reported as δ values in ppm. For the multiplicities of the NMR signals, the following abbreviations were used: s (singlet), bs (broad singlet), d (doublet), t (triplet), q (quartet), m (multiplet), dd (doublet of doublets), dt (doublet of triplets), tq (triplet of quartets). All coupling constants J were reported
- 30

with the number of bonds covered in Hertz (Hz). The numbers reported in the signal assignment correspond to the numbering given in the formula schemes, which need not correspond to IUPAC nomenclature.

5 General procedure

The coupling reaction was conducted in an apparatus as shown in Figure 1.

5 mmol of the first phenol having an oxidation potential E_{ox1} are dissolved together with 15 mmol of the second phenol having an oxidation potential E_{ox2} in the amounts specified in Table 1 below in 1,1,1,3,3,3-hexafluoroisopropanol (HFIP) and MeOH or in formic acid and MeOH. The electrolysis is effected under galvanostatic conditions. The outer jacket of the electrolysis cell is kept at a temperature of about 10°C by means of a thermostat, while the reaction mixture is stirred and heated to 50°C with the aid of a sand bath. After the end of the electrolysis, the cell contents are transferred with toluene into a 50 ml round-bottom flask and the solvent is removed under reduced pressure on a rotary evaporator at 50°C, 200-70 mbar. Unconverted reactant is recovered by means of short-path distillation (100°C, 10^{-3} mbar).

Electrode material

20 Anode: boron-doped diamond (BDD) on Si
Cathode: Ni mesh

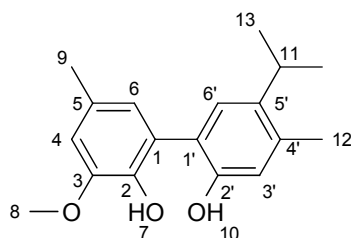
Electrolysis conditions:

Temperature [T]:	50°C
25 Current [I]:	15 mA
Current density [j]:	2.8 mA/cm ²
Quantity of charge [Q]:	2 F/mol of deficiency component
Terminal voltage [U_{max}]:	3-5 V

30 Syntheses

The synthesis of the biphenols was effected according to the above-described general procedure, and in a reaction apparatus as shown in Figure 1.

2,2'-Dihydroxy-4',5'-dimethyl-5'-(methylethyl)-3-methoxybiphenyl



- 5 0.69 g (5 mmol, 1.0 equiv.) of 4-methylguaiacol and 2.28 g (15 mmol, 3.0 equiv.) of 3-methyl-4-(methylethyl)phenol were dissolved in 33 ml of HFIP, 0.68 g of MTES was added and the electrolyte was transferred into the electrolysis cell. The solvent and unconverted amounts of reactant are removed under reduced pressure after the electrolysis, the crude product is purified by flash chromatography on silica gel 60 in a 9:1 eluent (cyclohexane:ethyl acetate) and the
- 10 product is obtained as a colourless solid.

Yield: 716 mg (50%, 2.5 mmol)

GC (*hard* method, HP-5): $t_R = 14.87$ min

$R_f(\text{CH:EA} = 4:1) = 0.43$

- 15 $m_p = 126.8^\circ\text{C}$ (recrystallized from CH)

$^1\text{H NMR}$ (600 MHz, DMSO) $\delta = 1.17\text{--}1.12$ (m, 6H, 13-H), 2.24 (m, 6H, 9-H/12-H), 3.01 (dt, 1H, 11-H), 3.79 (s, 3H, 8-H), 6.55 (s, 1H, 6-H), 6.66 (d, 1H, 6'-H), 6.73 (d, 1H, 4-H), 6.96 (s, 1H, 3'-H), 8.16 (s, 1H, 7-H), 8.84 (s, 1H, 10-H);

Couplings: $^4J_{4\text{-H}, 6\text{-H}} = 2.2$ Hz, $^4J_{6'\text{-H}, 11\text{-H}} = 2.9$ Hz, $^3J_{11\text{-H}, 13\text{-H}} = 6.8$ Hz;

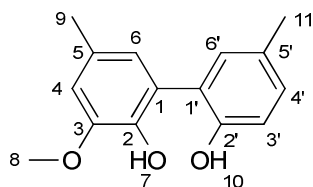
- 20 $^{13}\text{C NMR}$ (151 MHz, DMSO) $\delta = 18.73, 20.80$ (C-9/C-12), 23.54 (C-13), 28.10 (C-11), 55.78 (C-8), 111.23 (C-4), 117.34 (C-6'), 123.42 (C-1'), 123.49 (C-6), 126.43 (C-1), 127.36 (C-5), 127.49 (C-3'), 134.40 (C-5'), 136.62 (C-4'), 141.12 (C-2), 147.65 (C-3), 151.69 (C-2').

HRMS for $\text{C}_{18}\text{H}_{22}\text{O}_3$ (ESI+) $[\text{M}+\text{Na}^+]$: calc.: 309.1467, found: 309.1457

MS (EI, GCMS): $m/z(\%)$: 286 (50) $[\text{M}]^+$, 271 (100) $[\text{M}-\text{CH}_3]^+$, 244 (22) $[\text{M}-\text{C}_3\text{H}_6]^+$.

- 25 Elemental analysis for $\text{C}_{18}\text{H}_{22}\text{O}_3$: calc.: C: 75.50%, H: 7.74%, found: C: 75.01%, H: 7.70%.

2,2'-Dihydroxy-5,5'-dimethyl-3-methoxybiphenyl



1.66 g (12 mmol, 1.0 equiv.) of 4-methylguaiacol and 3.91 g (36 mmol, 3.0 equiv.) of 4-methylphenol were dissolved in 65 ml of HFIP and 14 ml of MeOH, 1.63 g of MTES were added and the electrolyte was transferred to the electrolysis cell. The solvent and unconverted amounts of reactant are removed under reduced pressure after the electrolysis, the crude product is purified by flash chromatography on silica gel 60 in a 4:1 eluent (cyclohexane:ethyl acetate) and the product is obtained as a colourless solid.

Yield: 440 mg (36%, 1.8 mmol)

10 GC (*hard* method, HP-5): t_R = 13.56 min

$R_f(\text{CH:EA} = 4:1) = 0.38$

$m_p = 162.0^\circ\text{C}$ (recrystallized from CH)

^1H NMR (400 MHz, DMSO) δ = 2.18 (s, 3H, 9-H/11-H), 2.21 (s, 3H, 9-H/11-H), 3.76 (s, 3H, 8-H), 6.53 (s, 1H, 6-H), 6.71 (s, 1H, 4-H), 6.75 (d, 1H, 3'-H), 6.86-6.94 (m, 2H, 4'-H/6'-H), 8.53 (bs, 1H, 7-H/12-H);

Couplings: $^3J_{3'-\text{H}, 4'-\text{H}} = 8.4$ Hz;

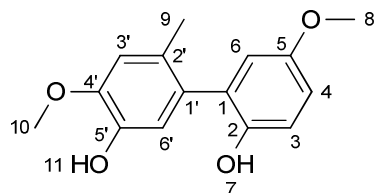
^{13}C NMR (101 MHz, DMSO) δ = 20.21, 20.77 (C-9/C-11), 55.79 (C-8), 111.36 (C-4), 115.69 (C-3'), 123.50 (C-6), 125.72 (C-1'), 126.16 (C-1), 127.20 (C-5), 127.30 (C-5'), 128.50 (C-6'), 131.83 (C-4'), 141.20 (C-2), 147.61 (C-3), 152.11 (C-2').

20 HRMS for $\text{C}_{15}\text{H}_{16}\text{O}_3$ (ESI+) $[\text{M}+\text{Na}^+]$: calc.: 267.0997, found: 267.0999

MS (EI, GCMS): $m/z(\%)$: 244 (100) $[\text{M}]^+$, 229 (64) $[\text{M}-\text{CH}_3]^+$.

Elemental analysis for $\text{C}_{15}\text{H}_{16}\text{O}_3$: calc.: C: 73.75%, H: 6.60%, found: C: 73.81%, H: 6.54%.

2,5'-Dihydroxy-4',5-dimethoxy-2'-methylbiphenyl



1.66 g (12 mmol, 1.0 equiv.) of 4-methylguaiacol and 4.49 g (36 mmol, 3.0 equiv.) of 4-methoxyphenol were dissolved in 80 ml of HFIP, 1.63 g of MTES were added and the electrolyte was transferred to the electrolysis cell. The solvent and unconverted amounts of reactant are removed under reduced pressure after the electrolysis, the crude product is purified by flash chromatography on silica gel 60 in a 4:1 eluent (cyclohexane:ethyl acetate) and the product is obtained as a colourless solid.

Yield: 2.05 g (66%, 7.9 mmol)

GC (*hard* method, HP-5): t_R = 14.03 min

10 $R_f(\text{CH:EA} = 4:1) = 0.33$

$m_p = 118.7^\circ\text{C}$ (recrystallized from DCM/CH)

$^1\text{H NMR}$ (600 MHz, DMSO) δ = 2.01 (s, 3H, 9-H), 3.66 (s, 3H, 8-H), 3.77 (s, 3H, 10-H), 6.53 (d, 1H, 6-H), 6.55 (s, 1H, 6'-H), 6.72 (dd, 1H, 4-H), 6.77 (s, 1H, 3'-H), 6.79 (d, 1H, 3-H), 8.73 (s, 1H, 11-H), 8.75 (s, 1H, 7-H);

15 Couplings: $^3J_{3-H, 4-H} = 8.7 \text{ Hz}$; $^4J_{4-H, 6-H} = 3.0 \text{ Hz}$

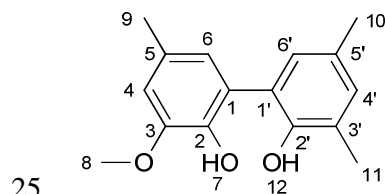
$^{13}\text{C NMR}$ (151 MHz, DMSO) δ = 19.33 (C-9), 55.32 (C-8), 55.73 (C-10), 113.24 (C-4), 113.75 (C-3'), 115.99 (C-3), 116.07 (C-6), 117.40 (C-6'), 126.56 (C-2'), 129.06 (C-1), 130.95 (C-1'), 143.80 (C-5'), 146.52 (C-4'), 148.29 (C-2), 151.81 (C-5).

HRMS for $\text{C}_{15}\text{H}_{16}\text{O}_4$ (ESI+) $[\text{M}+\text{Na}^+]$: calc.: 283.0946, found: 283.0942

20 MS (EI, GCMS): $m/z(\%)$: 260 (100) $[\text{M}]^+$, 245 (12) $[\text{M}-\text{CH}_3]^+$.

Elemental analysis for $\text{C}_{15}\text{H}_{16}\text{O}_4$: calc.: 69.22%, H: 6.20%, found: C: 69.02%, H: 6.34%.

2,2'-Dihydroxy-3-methoxy-3',5,5'-trimethylbiphenyl



0.70 g (6 mmol, 1.0 equiv.) of 4-methylguaiacol and 2.08 g (17 mmol, 3.0 equiv.) of 2,4-dimethylphenol were dissolved in 27 ml of HFIP and 6 ml of MeOH, 0.68 g of MTES was added and the electrolyte was transferred to the electrolysis cell. The solvent and unconverted amounts of reactant are removed under reduced pressure after the electrolysis, the crude product is purified by flash chromatography on silica gel 60 in a 9:1 eluent (cyclohexane:ethyl acetate) and the product is obtained as a pale yellow solid.

Yield: 663 mg (45%, 2.5 mmol)

GC (*hard* method, HP-5): t_R = 13.97 min

$R_f(\text{CH:EA} = 4:1) = 0.29$

- 5 $m_p = 119.7^\circ\text{C}$ (recrystallized from DCM/CH)

$^1\text{H NMR}$ (400 MHz, CDCl_3) δ = 2.34 (s, 3H, 10-H), 2.35 (s, 3H, 11-H), 2.38 (s, 3H, 9-H), 3.94 (s, 3H, 8-H), 6.16 (s, 1H, 12-H), 6.20 (s, 1H, 7-H), 6.76 (d, 1H, 4-H), 6.78 (d, 1H, 6-H), 6.98 (d, 1H, 6'-H), 7.03 (d, 1H, 4'-H);

Couplings: $^4J_{4\text{-H}, 6\text{-H}} = 1.7 \text{ Hz}$, $^4J_{4'\text{-H}, 6'\text{-H}} = 2.1 \text{ Hz}$;

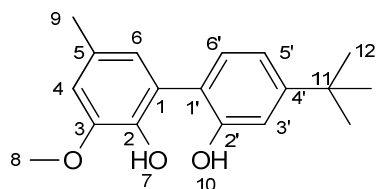
- 10 $^{13}\text{C NMR}$ (101 MHz, CDCl_3) δ = 16.51 (C-9), 20.54 (C-10), 21.20 (C-11), 56.12 (C-8), 110.92 (C-4), 123.95 (C-6), 124.13 (C-1), 124.64 (C-1'), 126.18 (C-3'), 128.82 (C-6'), 129.59 (C-5'), 130.40 (C-5), 131.40 (C-4'), 139.46 (C-2), 146.35 (C-3), 149.42 (C-2').

HRMS for $\text{C}_{18}\text{H}_{16}\text{O}_3$ (ESI+) $[\text{M}+\text{Na}^+]$: calc.: 281.1154, found: 281.1152

MS (EI, GCMS): $m/z(\%)$: 242 (100) $[\text{M}]^+$, 227 (38) $[\text{M}-\text{CH}_3]^+$.

- 15 Elemental analysis for $\text{C}_{16}\text{H}_{18}\text{O}_3$: calc.: C: 68.31%, H: 6.45%, found: C: 68.29%, H: 6.40%.

2,2'-Dihydroxy-3-methoxy-5-methyl-4'-(dimethylethyl)biphenyl



- 20 0.69 g (5 mmol, 1.0 equiv.) of 4-methylguaiaicol and 2.25 g (15 mmol, 3.0 equiv.) of 3-tert-butylphenol were dissolved in 33 ml of HFIP, 0.68 g of MTES was added and the electrolyte was transferred to the electrolysis cell. The solvent and unconverted amounts of reactant are removed under reduced pressure after the electrolysis, the crude product is purified by flash chromatography on silica gel 60 in a 4:1 eluent (cyclohexane:ethyl acetate) and the
- 25 product is obtained as a colourless solid.

Yield: 808 mg (63%, 3.1 mmol)

GC (*hard* method, HP-5): t_R = 13.97 min

$R_f(\text{CH:EA} = 4:1) = 0.29$

- 30 $m_p = 160.3^\circ\text{C}$ (recrystallized from DCM/CH)

^1H NMR (400 MHz, CDCl_3) δ = 1.37 (s, 9H, 12-H), 2.36 (s, 3H, 9-H), 3.94 (s, 3H, 8-H), 6.25 (s, 1H, 7-H), 6.48 (s, 1H, 10-H), 6.75 (d, 1H, 6-H), 6.79 (d, 1H, 4-H), 7.08 (dd, 1H, 5'-H), 7.12 (d, 1H, 3'-H), 7.27 (d, 1H, 6'-H);

Couplings: $^4J_{4\text{-H}, 6\text{-H}}$ = 1.7 Hz; $^3J_{5'\text{-H}, 6'\text{-H}}$ = 8.0 Hz, $^4J_{3'\text{-H}, 5'\text{-H}}$ = 1.7 Hz;

- 5 ^{13}C NMR (101 MHz, CDCl_3) δ = 21.24 (C-9), 31.31 (C-12), 34.58 (C-11), 56.15 (C-8), 110.79 (C-4), 114.94 (C-3'), 118.30 (C-5'), 122.37 (C-1'), 123.88 (C-1), 123.94 (C-6), 130.45 (C-6'), 130.53 (C-4'), 139.24 (C-5), 146.32 (C-3), 152.91 (C-2'), 153.13 (C-2).

HRMS for $\text{C}_{15}\text{H}_{16}\text{O}_4$ (ESI+) $[\text{M}+\text{Na}^+]$: calc.: 309.1467, found: 309.1466

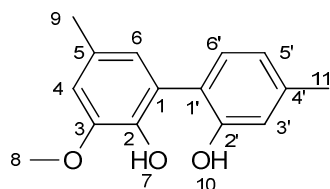
MS (EI, GCMS): $m/z(\%)$: 242 (100) $[\text{M}]^+$, 227 (38) $[\text{M}-\text{CH}_3]^+$.

- 10 Elemental analysis for $\text{C}_{18}\text{H}_{22}\text{O}_3$: calc.: 75.50%, H: 7.74%, found: C: 75.41%, H: 7.72%.

2,2'-Dihydroxy-4',5-dimethyl-3-methoxybiphenyl and
2,4'-dihydroxy-2',5-dimethyl-3-methoxybiphenyl

- 15 0.70 g (5 mmol, 1.0 equiv.) of 4-methylguaiacol and 1.65 g (15 mmol, 3.0 equiv.) of 3-methylphenol were dissolved in 33 ml of HFIP, 0.68 g of MTES was added and the electrolyte was transferred to the electrolysis cell. The solvent and unconverted amounts of reactant are removed under reduced pressure after the electrolysis, the crude product is purified by flash chromatography on silica gel 60 in a 4:1 eluent (cyclohexane:ethyl acetate) and two cross-
- 20 coupling products are obtained as colourless solids.

2,2'-Dihydroxy-4',5-dimethyl-3-methoxybiphenyl (by-product)



- 25 Yield: 266 mg (21%, 1.1 mmol)

GC (*hard* method, HP-5): t_R = 13.72 min

$R_f(\text{CH:EA} = 4:1) = 0.25$

m_p = 136.2°C (recrystallized from DCM/CH)

- ^1H NMR (400 MHz, CDCl_3) δ = 2.35 (s, 3H, 9-H/11-H), 2.37 (s, 3H, 9-H/11-H), 3.94 (s, 3H, 8-H), 6.17 (s, 1H, 10-H), 6.35 (s, 1H, 2-H), 6.74 (d, 1H, 4-H), 6.76 (s, 1H, 6-H), 6.88-6.83 (m, 1H, 5'-H), 6.90 (d, 1H, 3'-H), 7.21 (d, 1H, 6'-H);
- 30

Couplings: $^4J_{4-H, 6-H} = 1.8$ Hz, $^3J_{5'-H, 6'-H} = 7.7$ Hz, $^4J_{3'-H, 5'-H} = 1.5$ Hz;

^{13}C NMR (101 MHz, CDCl_3) $\delta = 21.11, 21.20$ (C-9/C-11), 56.13 (C-8), 110.81 (C-4), 118.25 (C-3'), 121.97 (C-5'), 122.39 (C-1), 123.77 (C-1'), 123.85 (C-6), 130.50 (C-5), 130.68 (C-6'), 139.30 (C-4'), 139.54 (C-2), 146.31 (C-3), 153.33 (C-2').

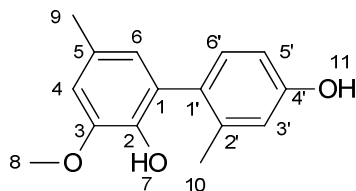
5 HRMS for $\text{C}_{15}\text{H}_{16}\text{O}_3$ (ESI+) $[\text{M}+\text{Na}^+]$: calc.: 267.0997, found: 267.1006

MS (EI, GCMS): $m/z(\%)$: 244 (100) $[\text{M}]^+$, 229 (18) $[\text{M}-\text{CH}_3]^+$.

Elemental analysis for $\text{C}_{15}\text{H}_{16}\text{O}_3$: calc.: C: 73.75%, H: 6.60%, found: C: 73.70%, H: 6.68%.

2,4'-Dihydroxy-2',5-dimethyl-3-methoxybiphenyl (main product)

10



Yield: 285 mg (23%, 1.2 mmol)

GC (*hard* method, HP-5): $t_R = 13.81$ min

$R_f(\text{CH:EA} = 4:1) = 0.19$

15 $m_p = 61.9^\circ\text{C}$ (recrystallized from DCM/CH)

^1H NMR (400 MHz, CDCl_3) $\delta = 2.17$ (s, 3H, 10-H), 2.32 (s, 3H, 9-H), 3.92 (s, 3H, 8-H), 4.77 (s, 1H, 11-H), 5.45 (s, 1H, 7-H), 6.59-6.53 (m, 1H, 6-H), 6.74-6.68 (m, 2H, 4-H/5'-H), 6.76 (d, 1H, 3'-H), 7.09 (d, 1H, 6'-H);

Couplings: $^3J_{5'-H, 6'-H} = 8.2$ Hz, $^4J_{3'-H, 5'-H} = 2.7$ Hz;

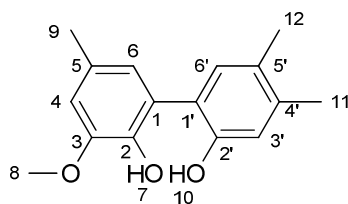
20 ^{13}C NMR (101 MHz, CDCl_3) $\delta = 20.04$ (C-10), 21.09 (C-9), 55.97 (C-8), 110.51 (C-4), 112.53 (C-5'), 116.62 (C-3'), 123.47 (C-6), 127.28 (C-1), 128.74 (C-5), 130.02 (C-1'), 131.17 (C-6'), 138.56 (C-2'), 140.49 (C-2), 146.24 (C-3), 154.84 (C-4').

HRMS for $\text{C}_{15}\text{H}_{16}\text{O}_3$ (ESI+) $[\text{M}+\text{Na}^+]$: calc.: 267.0997, found: 267.0995

MS (EI, GCMS): $m/z(\%)$: 244 (100) $[\text{M}]^+$, 229 (18) $[\text{M}-\text{CH}_3]^+$.

25 Elemental analysis for $\text{C}_{15}\text{H}_{16}\text{O}_3$: calc.: C: 73.75%, H: 6.60%, found: C: 73.70%, H: 6.70%.

2,2'-Dihydroxy-3-methoxy-4'-5,5'-trimethylbiphenyl



0.69 g (5 mmol, 1.0 equiv.) of 4-methylguaiaicol and 1.83 g (15 mmol, 3.0 equiv.) of 3,4-dimethylphenol were dissolved in 27 ml of HFIP and 6 ml of MeOH, 0.68 g of MTES was added and the electrolyte was transferred to the electrolysis cell. The solvent and unconverted
5 amounts of reactant are removed under reduced pressure after the electrolysis, the crude product is purified by flash chromatography on silica gel 60 in a 9:1 eluent (cyclohexane:ethyl acetate) and the product is obtained as a colourless solid.

Yield: 688 mg (52%, 2.6 mmol)

10 GC (*hard* method, HP-5): t_R = 14.52 min

$R_f(\text{CH:EA} = 4:1) = 0.29$

$m_p = 152.3^\circ\text{C}$ (recrystallized from DCM/CH)

$^1\text{H NMR}$ (400 MHz, CDCl_3) δ = 12.25 (s, 3H, 11-H), 2.28 (s, 3H, 12-H), 2.36 (s, 3H, 9-H), 3.93 (s, 3H, 8-H), 6.19 (s, 1H, 7-H), 6.25 (s, 1H, 10-H), 6.73 (d, 1H, 4-H), 6.76 (s, 1H, 6-H), 6.88 (s,
15 1H, 3'-H), 7.08 (s, 1H, 6'-H);

Couplings: $^4J_{4-H, 6-H} = 1.7$ Hz;

$^{13}\text{C NMR}$ (101 MHz, CDCl_3) δ = 18.89 (C-11), 19.60 (C-12), 21.24 (C-9), 56.14 (C-8), 110.74 (C-4), 118.93 (C-3'), 122.54 (C-1), 123.82 (C-6), 123.97 (C-1'), 129.03 (C-5), 130.46 (C-4'), 131.69 (C-6'), 137.94 (C-5'), 139.26 (C-2), 146.31 (C-3), 151.36 (C-2').

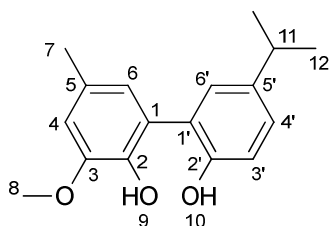
20 HRMS for $\text{C}_{16}\text{H}_{18}\text{O}_3$ (ESI+) $[\text{M}+\text{Na}^+]$: calc.: 281.1154, found: 281.1157

MS (EI, GCMS): $m/z(\%)$: 258 (100) $[\text{M}]^+$, 243 (10) $[\text{M}-\text{CH}_3]^+$.

Elemental analysis for $\text{C}_{16}\text{H}_{18}\text{O}_3$: calc.: 74.39%, H: 7.02%, found: C: 74.32%, H: 7.20%

2,2'-Dihydroxy-5'-isopropyl-3-methoxy-5-methylbiphenyl

25



0.69 g (5 mmol, 1.0 equiv.) of 4-methylguaiacol and 2.05 g (15 mmol, 3.0 equiv.) of 4-isopropylphenol were dissolved in 27 ml of HFIP and 6 ml of MeOH, 0.68 g of MTES was added and the electrolyte was transferred to the electrolysis cell. The solvent and unconverted amounts of reactant are removed under reduced pressure after the electrolysis, the crude product is purified by flash chromatography on silica gel 60 in a 4:1 eluent (cyclohexane:ethyl acetate) and the product is obtained as a brownish oil.

Yield: 0.53 g (39%, 1.9 mmol)

GC (*hard* method, HP-5): t_R = 14.23 min

10 $R_f(\text{CH:EA} = 4:1) = 0.30$

^1H NMR (400 MHz, CDCl_3) δ = 1.27 (m, 6H), 2.36 (s, 3H), 2.91 (dt, J = 13.8, 6.9, 6.9 Hz, 1H), 3.94 (s, 3H), 6.13-6.27 (m, 2H), 6.82-6.65 (m, 1H), 6.25 (m, 2H), 6.75 (s, 1H), 6.77 (s, 1H), 6.99 (d, J = 8.1 Hz, 1H), 7.19-7.12 (m, 2H);

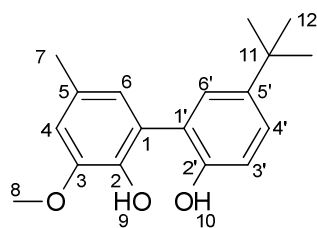
^{13}C NMR (101 MHz, CDCl_3) δ = 21.25, 24.27, 33.40, 56.18, 110.92, 117.60, 123.91, 124.23, 125.07, 127.29, 128.80, 130.57, 139.29, 141.42, 146.31, 151.51.

HRMS for $\text{C}_{17}\text{H}_{20}\text{O}_3$ (ESI+) $[\text{M}+\text{Na}^+]$: calc.: 295.1310, found: 295.1297

MS (EI, GCMS): $m/z(\%)$: 272 (80) $[\text{M}]^+$, 257 (100) $[\text{M}-\text{CH}_3]^+$.

2,2'-Dihydroxy-3-methoxy-5-methyl-5'-tert-butylbiphenyl

20



0.69 g (5 mmol, 1.0 equiv.) of 4-methylguaiacol and 2.26 g (15 mmol, 3.0 equiv.) of 4-*tert*-butylphenol were dissolved in 27 ml of HFIP and 6 ml of MeOH, 0.68 g of MTES was added and the electrolyte was transferred to the electrolysis cell. The solvent and unconverted amounts of reactant are removed under reduced pressure after the electrolysis, the crude product is purified by flash chromatography on silica gel 60 in a 4:1 eluent (cyclohexane:ethyl acetate) and the product is obtained as a yellowish oil.

Yield: 0.48 g (34%, 1.7 mmol)

30 GC (*hard* method, HP-5): t_R = 14.52 min

$R_f(\text{CH:EA} = 4:1) = 0.24$

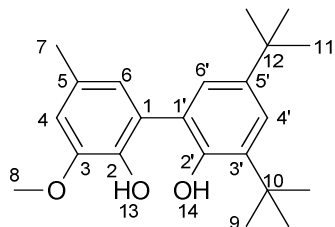
^1H NMR (400 MHz, CDCl_3) δ = 1.34 (s, 9H), 2.37 (s, 3H), 3.94 (s, 3H), 6.17 (s, 1H), 6.24 (s, 1H), 6.75 (s, 1H), 6.77 (s, 1H), 6.99 (d, J = 8.4 Hz, 1H), 7.31-7.29 (m, 1H), 7.33 (dd, J = 8.4, 2.5 Hz, 1H).

5 ^{13}C NMR (101 MHz, CDCl_3) δ = 21.28, 31.61, 34.20, 56.18, 110.91, 117.25, 123.92, 124.41, 124.63, 126.38, 127.78, 130.58, 139.32, 143.70, 146.32, 151.22.

HRMS for $\text{C}_{18}\text{H}_{22}\text{O}_3$ (ESI+) $[\text{M}+\text{Na}^+]$: calc.: 309.1467, found: 309.1476

MS (EI, GCMS): $m/z(\%)$: 286 (28) $[\text{M}]^+$, 271 (100) $[\text{M}-\text{CH}_3]^+$.

10 2,2'-Dihydroxy-3',5'-di-*tert*-butyl-5-methyl-3-methoxybiphenyl



0.69 g (5 mmol, 1.0 equiv.) of 4-methylguaiacol and 3.12 g (15 mmol, 3.0 equiv.) of 2,4-di-*tert*-butylphenol were dissolved in 27 ml of HFIP and 6 ml of MeOH, 0.68 g of MTES was added and the electrolyte was transferred to the electrolysis cell. The solvent and unconverted amounts of reactant are removed under reduced pressure after the electrolysis, the crude product is purified by flash chromatography on silica gel 60 in a 9:1 eluent (cyclohexane:ethyl acetate) and the product is obtained as a colourless solid.

Yield: 0.41 g (24%, 1.2 mmol)

20

GC (*hard* method, HP-5): t_R = 15.15 min

$R_f(\text{CH:EA} = 9:1) = 0.35$

m_p = 120.2 °C (recrystallized in *n*-pentane)

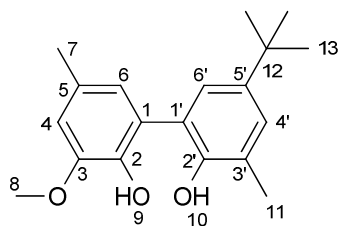
^1H NMR (400 MHz, CDCl_3) δ = 1.36 (s, 9H), 1.50 (s, 9H), 2.38 (s, 3H), 3.96 (s, 3H), 6.00 (s, 1H), 6.05 (s, 1H), 6.77 (s, 1H), 7.16 (d, J = 2.5 Hz, 1H), 7.39 (d, J = 2.5 Hz, 1H).

25

^{13}C NMR (101 MHz, CDCl_3) δ = 21.23, 29.88, 31.69, 34.40, 35.23, 56.17, 111.03, 123.96, 124.17, 125.09, 125.50, 130.42, 136.73, 139.72, 142.36, 146.45, 149.82.

MS (EI, GCMS): $m/z(\%)$: 342 (22) $[\text{M}]^+$, 327 (100) $[\text{M}-\text{CH}_3]^+$.

30 2,2'-Dihydroxy-3',5'-dimethyl-3-methoxy-5'-*tert*-butylbiphenyl



0.69 g (5 mmol, 1.0 equiv.) of 4-methylguaiacol and 2.47 g (15 mmol, 3.0 equiv.) of 2-methyl-4-*tert*-butylphenol were dissolved in 27 ml of HFIP and 6 ml of MeOH, 0.68 g of MTES was added and the electrolyte was transferred to the electrolysis cell. The solvent and unconverted amounts of reactant are removed under reduced pressure after the electrolysis, the crude product is purified by flash chromatography on silica gel 60 in a 4:1 eluent (cyclohexane:ethyl acetate) and the product is obtained as a yellowish oil.

Yield: 0.69 g (46%, 2.3 mmol)

GC (*hard* method, HP-5): t_R = 14.79 min

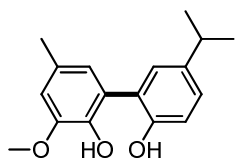
R_f (CH:EA= 4:1) = 0.33

^1H NMR (400 MHz, CDCl_3) δ = 1.37 (s, 9H), 2.39 (d, J = 2.4 Hz, 6H), 3.94 (s, 3H), 6.15 (s, 1H), 6.17 (s, 1H), 6.77 (s, 1H), 6.79 (s, 1H), 7.17 (d, J = 2.5 Hz, 1H), 7.24 (d, J = 2.4 Hz, 1H);

^{13}C NMR (101 MHz, CDCl_3) δ = 16.90, 21.28, 31.67, 34.12, 56.16, 110.94, 124.02, 124.17, 124.59, 125.41, 125.65, 127.86, 130.47, 139.50, 143.07, 146.40, 149.41.

MS (EI, GCMS): m/z (%): 300 (18) $[\text{M}]^+$, 285 (100) $[\text{M}-\text{CH}_3]^+$.

2,2'-Dihydroxy-3-methoxy-5-methyl-5'-(1-methylethyl)biphenyl

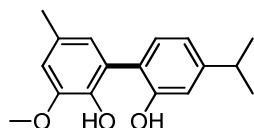


MTES was added to 0.69 g (5 mmol, 1.0 eq.) of 4-methylguaiacol and 2.05 g (15 mmol, 3.0 eq.) of 4-isopropylphenol and 0.68 g of MTES in 27 ml of HFIP + 6 ml of MeOH and the electrolyte was transferred to the electrolysis cell. The solvent and unconverted amounts of reactant are removed under reduced pressure after the electrolysis, the crude product is purified by flash chromatography on silica gel 60 in a 4:1 eluent (cyclohexane:ethyl acetate) and the product is obtained as a brownish oil.

Yield: 39%, 527 mg, 1.9 mmol.

- R_f (cyclohexane:ethyl acetate = 4:1) = 0.30; ^1H NMR (400 MHz, CDCl_3) δ = 1.27 (m, 6H), 2.36 (s, 3H), 2.91 (sept, J = 6.9 Hz, 1H), 3.94 (s, 3H), 6.13-6.27 (m, 2H), 6.65-6.82 (m, 2H), 6.99 (d, J = 8.1 Hz, 1H), 7.12-7.19 (m, 2H); ^{13}C NMR (101 MHz, CDCl_3) δ = 21.37, 24.39, 33.53, 56.31, 111.04, 117.73, 124.04, 124.36, 125.20, 127.42, 128.93, 130.70, 139.42, 141.55, 146.44, 151.64. HRMS for $\text{C}_{17}\text{H}_{20}\text{O}_3$ (ESI+) $[\text{M}+\text{Na}^+]$: calc.: 295.1310, found: 295.1297; MS (EI, GCMS): $m/z(\%)$: 272 (80) $[\text{M}]^+$, 257 (100) $[\text{M}-\text{CH}_3]^+$.

2,2'-Dihydroxy-3-methoxy-5-methyl-4'-(methylethyl)biphenyl



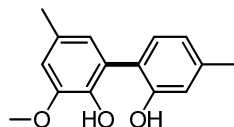
- 0.69 g (5 mmol, 1.0 eq.) of 4-methylguaiacol and 2.065 g (15 mmol, 3.0 eq.) of 3-isopropylphenol and 0.68 g of MTES were dissolved in 33 ml of HFIP and the electrolyte was transferred to the electrolysis cell. The solvent and unconverted amounts of reactant are removed under reduced pressure after the electrolysis, the crude product is purified by flash chromatography on silica gel 60 in a 4:1 eluent (cyclohexane:ethyl acetate) and the product is obtained as a brownish oil (yield: 52%, 705 mg, 2.6 mmol).

- R_f (cyclohexane:ethyl acetate = 4:1) = 0.29; ^1H NMR (400 MHz, CDCl_3) δ = 1H NMR (400 MHz, CDCl_3) δ 1.27 (s, 3H), 1.29 (s, 3H), 2.34 (s, 3H), 2.91 (sept, J = 7.0 Hz, 1H), 3.94 (s, 3H), 6.15 (s, 1H), 6.35 (s, 1H), 6.73 (d, J = 1.8 Hz, 1H), 6.75-6.77 (m, 1H), 6.90 (dd, J = 7.9 Hz, 1.8 Hz, 1H), 6.94 (d, J = 1.7 Hz, 1H), 7.23 (d, J = 7.8 Hz, 1H). ^{13}C NMR (101 MHz, CDCl_3) δ = ^{13}C NMR (101 MHz, CDCl_3) δ 21.36, 24.02, 33.92, 56.30, 77.16, 110.91, 115.77, 119.56, 122.81, 124.00, 124.08, 130.65, 130.84, 139.38, 146.43, 150.72, 153.54. HRMS for $\text{C}_{17}\text{H}_{20}\text{O}_3$ (ESI+) $[\text{M}+\text{Na}^+]$: calc.: 295.1310, found: 295.1305; MS (EI, GCMS): $m/z(\%)$: 272 (100) $[\text{M}]^+$, 257 (50) $[\text{M}-\text{CH}_3]^+$. Elemental anal. for $\text{C}_{17}\text{H}_{20}\text{O}_3$: calc.: 74.97%, H: 7.40%, found: C: 75.05%, H: 7.36%.

2,2'-Dihydroxy-4',5-dimethyl-3-methoxybiphenyl and 2,4'-dihydroxy-2',5-dimethyl-3-methoxybiphenyl

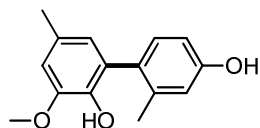
- 0.28 g (2 mmol, 1.0 eq.) of 4-methylguaiacol, 1.22 g (6 mmol, 3.0 eq.) of 3-methylphenyl and 0.77 g of MTBS were dissolved in 25 ml of HFIP and the electrolyte was transferred to the beaker-type electrolysis cell. The solvent and unconverted amounts of reactant are removed under reduced pressure after the electrolysis, the crude product is purified by flash chromatography on silica gel 60 in a 4:1 eluent (cyclohexane:ethyl acetate) and led to the two cross-coupling products as a colourless and viscous oil.

2,2'-Dihydroxy-4',5-dimethyl-3-methoxybiphenyl (by-product)



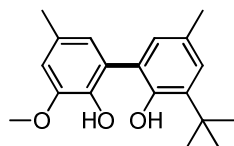
Yield: 21%, 266 mg, 1.1 mmol; R_f (cyclohexane:ethyl acetate = 4:1) = 0.25; m_p = 136.2 °C
5 (crystallized from dichloromethane/cyclohexane); ^1H NMR (400 MHz, CDCl_3) δ = 2.35 (s, 3H), 2.37 (s, 3H), 3.94 (s, 3H), 6.17 (s, 1H), 6.35 (s, 1H), 6.74 (d, J = 1.8 Hz, 1H), 6.76 (s, 1H), 6.88-6.83 (m, 1H), 6.90 (d, 1H, J = 1.5 Hz), 7.21 (d, 1H, J = 7.7 Hz); ^{13}C NMR (101 MHz, CDCl_3)
 δ = 21.11, 21.20, 56.13, 110.81, 118.25, 121.97, 122.39, 123.77, 123.85, 130.50, 130.68, 139.30, 139.54, 146.31, 153.33. HRMS for $\text{C}_{15}\text{H}_{16}\text{O}_3$ (ESI+) $[\text{M}+\text{Na}]^+$: calc.: 267.0997, found:
10 267.1006; MS (EI, GCMS): $m/z(\%)$: 244 (100) $[\text{M}]^+$, 229 (18) $[\text{M}-\text{CH}_3]^+$. Elemental anal. for $\text{C}_{15}\text{H}_{16}\text{O}_3$: calc.: C: 73.75%, H: 6.60%, found: C: 73.70%, H: 6.68%.

2,4'-Dihydroxy-2',5-dimethyl-3-methoxybiphenyl (main product)



15 Yield: 23%, 285 mg, 1.2 mmol; R_f (cyclohexane:ethyl acetate = 4:1) = 0.19 m_p = 61.9°C (crystallized from dichloromethane/cyclohexane); ^1H NMR (400 MHz, CDCl_3) δ = 2.17 (s, 3H), 2.32 (s, 3H), 3.92 (s, 3H), 4.77 (s, 1H), 5.45 (s, 1H), 6.59-6.53 (m, 1H), 6.74-6.68 (m, 2H), 6.76 (d, 1H, J = 2.7 Hz), 7.09 (d, 1H, J = 8.2 Hz); ^{13}C NMR (101 MHz, CDCl_3) δ = 20.04, 21.09, 55.97, 110.51, 112.53, 116.62, 123.47, 127.28, 128.74, 130.02, 131.17, 138.56, 140.49,
20 146.24, 154.84. HRMS for $\text{C}_{15}\text{H}_{16}\text{O}_3$ (ESI+) $[\text{M}+\text{Na}]^+$: calc.: 267.0997, found: 267.0995; MS (EI, GCMS): $m/z(\%)$: 244 (100) $[\text{M}]^+$, 229 (18) $[\text{M}-\text{CH}_3]^+$. Elemental anal. for $\text{C}_{15}\text{H}_{16}\text{O}_3$: calc.: C: 73.75%, H: 6.60%, found: C: 73.70%, H: 6.70%.

2,2'-Dihydroxy-5,5'-dimethyl-3'-(1,1-dimethylethyl)-3-methoxybiphenyl



25

0.69 g (5 mmol, 1.0 eq.) of 4-methylguaiacol, 2.47 g (15 mmol, 3.0 eq.) of 4-methyl-2-*tert*-butylphenol and 0.68 g of MTES were dissolved dissolved in 27 ml of HFIP + 6 ml of MeOH and

the electrolyte was transferred to the electrolysis cell. The solvent and unconverted amounts of reactant are removed under reduced pressure after the electrolysis, the crude product is purified by flash chromatography on silica gel 60 in a 4:1 eluent (cyclohexane:ethyl acetate) and the product is obtained as a yellow oil (yield: 36%, 545 mg, 1.8 mmol).

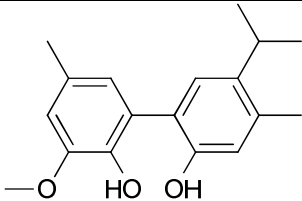
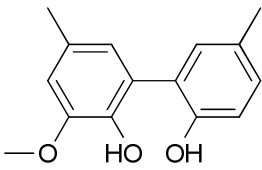
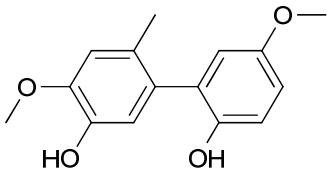
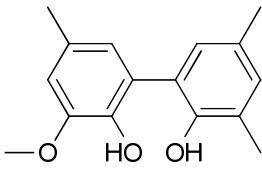
- 5 R_f (cyclohexane:ethyl acetate = 9:1) = 0.36; ^1H NMR (400 MHz, CDCl_3) δ = 1.46 (s, 9H), 2.34 (m, 6H), 3.93 (s, 3H), 5.99 (s, 1H), 6.01 (s, 1H), 6.74 (s, 2H), 6.96 (d, J = 1.9 Hz, 1H), 7.14 (d, J = 1.9 Hz, 1H); ^{13}C NMR (101 MHz, CDCl_3) δ = 21.05, 21.32, 29.96, 35.05, 56.30, 77.16, 111.21, 124.18, 124.24, 125.92, 127.67, 129.15, 129.22, 130.51, 137.57, 139.87, 146.57, 150.10. HRMS for $\text{C}_{22}\text{H}_{30}\text{O}_3$ (ESI+) $[\text{M}+\text{Na}^+]$: calc.: 323.1623, found: 323.1618; MS (EI, GCMS): m/z (%):
- 10 300 (100) $[\text{M}]^+$, 285 (100) $[\text{M}-\text{CH}_3]^+$.

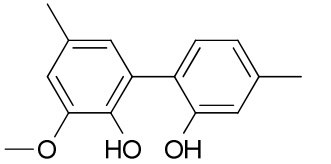
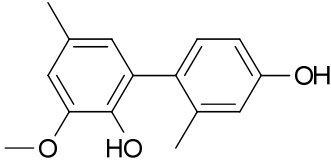
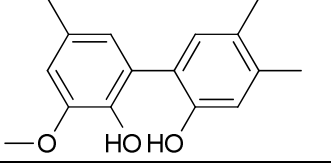
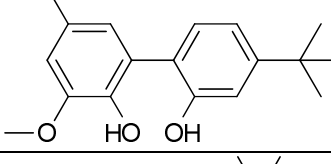
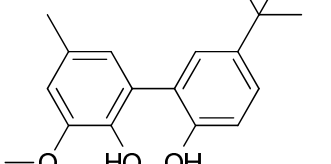
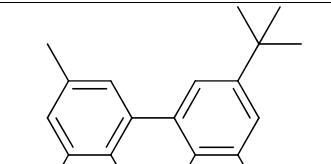
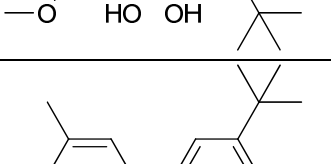
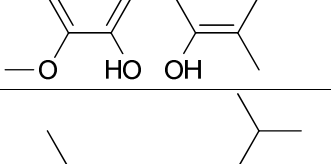
Experimental results

Table 1 lists the yields and selectivities:

15

Table 1:

Product	Solvent	Yield (isolated) ^a	Selectivity (AB:BB) ^b
	HFIP pure	50%	>100:1
	HCOOH + 9% MeOH	28%	>100:1
	HFIP + 18% MeOH	36%	>100:1
	HCOOH + 9% MeOH	13%	>100:1
	HFIP pure	66%	>100:1
	HFIP + 18% MeOH	45%	9:1

 	HFIP pure	21%	>100:1
	HFIP + 18% MeOH	52%	>100:1
	HFIP pure	63%	>100:1
	HFIP + 18% MeOH	34%	>100:1
	HFIP + 18% MeOH	24%	4:1
	HFIP + 18% MeOH	46%	>100:1
	HFIP + 18% MeOH	39%	>100:1

^a: isolated yield based on n(first phenol);

^b: determined via GC. AB: cross-coupling product, BB: homo-coupling product.

HFIP: 1,1,1,3,3,3-hexafluoroisopropanol

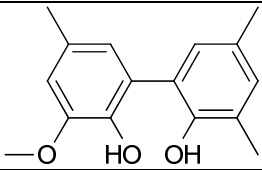
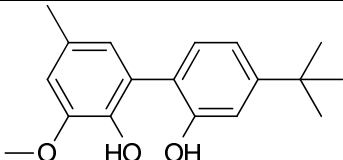
- 5 Table 1 shows that a large spectrum of structurally different phenols can be directly cross-coupled by the method described above.

Comparative experiments

- 10 In a first experimental series (ES1) which was effected under inventive conditions, the general procedure was modified in that 0.757 mmol of the first phenol having an oxidation potential E_{Ox1} and 2.271 mmol of the second phenol having an oxidation potential E_{Ox2} were dissolved.

- As comparative experiments, a second experimental series (ES2) was conducted. Here, the
15 general procedure was modified in that 0.757 mmol of the first phenol having an oxidation potential E_{Ox1} and 0.757 mmol of the second phenol having an oxidation potential E_{Ox2} were dissolved. In the comparative experiment, the two phenols were thus present in equal portions.

- Table 2: Comparison of yields and selectivities on reduction of the excess of one phenol
20 component to one equivalent

Product	ES1 selectivity ^b (AB:BB) at phenol ratio 1:3	ES1 yield ^a at phenol ratio 1:3	ES2 selectivity ^b (AB:BB) at phenol ratio 1:1	ES2 yield ^a at phenol ratio 1:1
	9:1	45%	9:1	27%
	>100:1	63%	5:1	42%

Electrolysis parameters: $n(\text{phenol1}) = 0.757 \text{ mmol}$, conductive salt: MTES, $c(\text{MTES}) = 0.09 \text{ M}$, $V(\text{solvent}) = 5 \text{ ml}$, anode: BDD/Si, cathode: BDD/Si, $j = 2.8 \text{ mA/cm}^2$, $T = 50^\circ\text{C}$, $Q = 2$

$F \cdot n(\text{phenol1})$. The electrolysis is effected under galvanostatic conditions.

^a: isolated yield based on $n(\text{phenol1})$;

5 ^b: determined via GC. AB: cross-coupling product, BB: homo-coupling product.

It can be clearly inferred from Table 2 that, under non-inventive conditions, i.e. in the second experimental series (ES2), much poorer yields are achieved than in the first experimental series (ES1) under inventive experimental conditions.

10

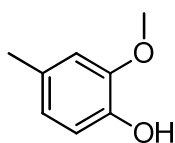
Influence of the solvent

Table 3: Influence of the MeOH addition on the oxidation potential

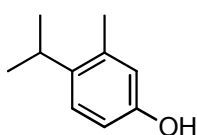
Substrate	5.2% MeOH	7.9% MeOH	10.6% MeOH	13.4% MeOH	16.3% MeOH	19.2% MeOH	22.1% MeOH	25.1% MeOH
1st phenol	0.687	0.675	0.664	0.660	0.655	0.653	0.651	0.653
2nd phenol	0.823	0.818	0.820	0.821	0.824	0.842	0.849	0.865
$\Delta E \text{ [V]}$	0.136	0.143	0.156	0.161	0.169	0.189	0.198	0.212

15

1st phenol:



2nd phenol:



20

The oxidation potential of each of the two phenols shown was determined in a measurement series. The determination was effected here in 1,1,1,3,3,3-hexafluoroisopropanol (HFIP) and

methanol (MeOH), with variation in the amount of methanol (MeOH) (the figures are % by volume).

Working electrode: glassy carbon, counterelectrode: glassy carbon,

5 Reference electrode: Ag/AgCl, $v = 10 \text{ mV/s}$,

Oxidation criterion: $I = 0.1 \text{ mA/cm}^2$, $c(\text{phenol}) = 0.152 \text{ M}$,

Conductive salt: MTES, $c(\text{MTES}) = 0.09 \text{ M}$.

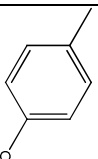
Solvents: HFIP and MeOH

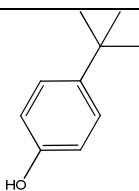
10 The experimental series show clearly that the addition of methanol can noticeably increase the difference in the two oxidation potentials (ΔE).

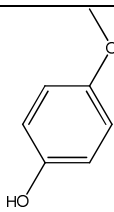
Influence of the oxidation potential differences (ΔE_{Ox}) on yields and selectivities

15 Cyclic voltammetry measurements on substrates used show that differences between individual oxidation potential differences (ΔE_{Ox}) correlate with selectivities and yields of the electrochemical cross-coupling phenols. A greater potential difference results in better yields and improved selectivities.

20 Table 4: ΔE_{Ox} as a function of the *para* substituents

Solvent mixture		HFIP	18% MeOH
		pure	
Coupling partner			
ΔE	with	GC: 5%+3%BP $\Delta = -0.31 \text{ V}$	GC: 14% $\Delta = -0.32 \text{ V}$
4-methylguaiacol			

Solvent mixture		HFIP pure	18% MeOH
Coupling partner			
ΔE	with	GC: 9%+1%BP $\Delta = -0.22 \text{ V}$	GC: 10% $\Delta = -0.26 \text{ V}$
4-methylguaiaicol			

Solvent mixture		HFIP pure	18% MeOH
Coupling partner			
ΔE_{Ox}	with	GC: 23% $\Delta = -0.13 \text{ V}$	GC: 2% $\Delta = -0.05 \text{ V}$
4-methylguaiaicol			

5 Working electrode: glassy carbon, counterelectrode: glassy carbon, reference electrode: Ag/AgCl in sat. LiCl/EtOH, $v = 10 \text{ mV/s}$, oxidation criterion: $I = 0.05 \text{ mA/cm}^2$, $c(\text{phenol}) = 0.152 \text{ M}$, conductive salt: MTES, $c(\text{MTES}) = 0.09 \text{ M}$. Solvent: HFIP. $\Delta E_{\text{Ox}} = E(\text{ox.pot. coupling partner}) - \text{ox.pot. table entry}$. BP: by-product; GC: gas chromatography integration of product ratios.

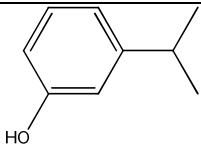
10 In Figure 3, the dependence of the oxidation potential ΔE_{Ox} of the *para* substituents on the amount of methanol added is plotted. With rising methanol concentration in HFIP, lowering of the oxidation potentials (E_{ox}) of almost all *para*-substituted phenols is apparent. Only the isopropyl derivative beyond 15% shows a slight rise by about 50 mV.

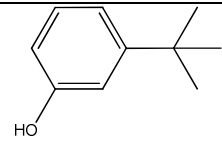
15 Table 4 shows that the greatest possible ΔE_{Ox} are advantageous here. Entry 1 shows a ΔE_{Ox} greater by 10 mV in the HFIP/MeOH system than in pure HFIP, which results in an excellent selectivity for formation of the cross-coupling product. By-products such as homo-coupling

products are also the consequence in Entry 2: here, $\Delta E_{\text{Ox}} = -0.22 \text{ V}$ appears to be much too small to avoid homo-coupling. Side reactions can also severely reduce the yield, as shown by Entry 3. Here, a ΔE_{Ox} in HFIP/MeOH of only -0.05 V causes a collapse in the amount of cross-coupling product formed.

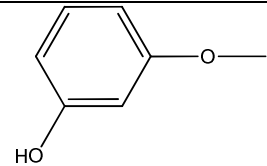
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Table 5: ΔE_{Ox} as a function of the *meta* substituents

Solvent mixture	HFIP pure	18% MeOH
Coupling partner		
ΔE_{Ox} with 4-methylguaiacol	GC: 8%+6%BP $\Delta = -0.14 \text{ V}$	GC: 8%+2%BP $\Delta = -0.41 \text{ V}$

Solvent mixture	HFIP pure	18% MeOH
Coupling partner		
ΔE_{Ox} with 4-methylguaiacol	GC: 16% $\Delta = -0.13 \text{ V}$	GC: 11% $\Delta = -0.25 \text{ V}$

10

Solvent mixture	HFIP pure	18% MeOH
Coupling partner		
ΔE_{Ox} with 4-methylguaiacol	GC: 4% $\Delta = 0.16 \text{ V}$	GC: 0% $\Delta = -0.13 \text{ V}$

Working electrode: glassy carbon, counterelectrode: glassy carbon, reference electrode: Ag/AgCl in sat. LiCl/EtOH, $v = 10 \text{ mV/s}$, oxidation criterion: $I = 0.05 \text{ mA/cm}^2$, $c(\text{phenol}) = 0.152 \text{ M}$, conductive salt: MTES, $c(\text{MTES}) = 0.09 \text{ M}$. Solvent: HFIP. $\Delta E_{\text{Ox}} = \text{ox.pot. coupling partner} - \text{ox.pot. table entry}$. BP: by-product; gas chromatography integration of product ratios.

5

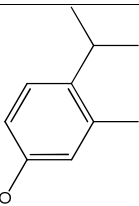
In Figure 4, the dependence of the oxidation potential ΔE_{Ox} of the *meta* substituents on the amount of methanol added is plotted. For the corresponding *meta*-substituted derivatives, the behaviour is similar for 3-methyl- and 3-methoxyphenol. In the case of larger radicals such as isopropyl and *tert*-butyl, the profile of E_{ox} is more complex. In these cases, there is a gradual increase of E_{ox} from about 13%v/v MeOH.

10

Table 5 shows, in Entry 1, that the optimal ΔE_{Ox} window has not been found, either in pure HFIP or with an 18% MeOH content. In both cases, by-products occur, and the GC product integrals suggest only relatively small amounts of the cross-coupling product. Entry 2 shows, with a rising ΔE_{Ox} (here $|\Delta E| = 0.25 \text{ V}$), a loss in yield. The optimum here appears to be at $0.13 \text{ V} < |\Delta E_{\text{optimal}}| < 0.25 \text{ V}$. The limit of $|\Delta E| = 0.13 \text{ V}$ is confirmed in Entry 3. No cross-coupling product formation occurs here, whereas, with slightly greater ΔE_{Ox} in pure HFIP, traces of the desired biphenol are isolable here.

15

20 Table 6: ΔE_{Ox} of further phenol substitution patterns

Solvent mixture	HFIP pure 18% MeOH	
Coupling partner		
ΔE_{Ox} with 4-methylguaiacol	GC: 15% $\Delta = 0.19 \text{ V}$	GC: 10% $\Delta = 0.07 \text{ V}$

Working electrode: glassy carbon, counterelectrode: glassy carbon, reference electrode: Ag/AgCl in sat. LiCl/EtOH, $v = 10 \text{ mV/s}$, oxidation criterion: $I = 0.05 \text{ mA/cm}^2$, $c(\text{phenol}) =$

25

0.152 M, conductive salt: MTES, $c(\text{MTES}) = 0.09 \text{ M}$. Solvent: HFIP. $\Delta E_{\text{Ox}} = \text{ox.pot. coupling partner} - \text{ox.pot. table entry}$. BP: by-product; gas chromatography integration of product ratios.

Table 6 reflects the dependence on the respective substrate classes of the ΔE_{Ox} window sizes.

- 5 The importance of the size of ΔE_{Ox} on the selectivity of the reaction is confirmed thereby.

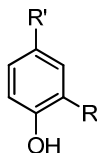


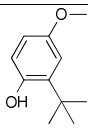
Table 7: ΔE_{Ox} of 2,4-disubstituted phenols

- 10 In Figure 5, the dependence of the oxidation potential ΔE_{Ox} of the 2,4-disubstituted phenols on the amount of methanol added is plotted. 2,4-Disubstituted phenols show, within the margin of error, a distinct drop in the oxidation potential with increasing methanol concentration.

Coupling partner	HFIP pure	18% MeOH
ΔE_{Ox} with 4-methylguaiaicol		
	GC: 10% + 4%	23% + 4%
	BP $\Delta = 0.01 \text{ V}$	BP $\Delta = -0.03 \text{ V}$

Coupling partner	HFIP pure	18% MeOH
ΔE_{Ox} with 4-methylguaiaicol		
	GC: 3% + 1%	11% + 2%
	BP $\Delta = -0.01 \text{ V}$	BP $\Delta = -0.02 \text{ V}$

Coupling partner	HFIP pure	18% MeOH
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ΔE_{Ox} with 4-methylguaiacol		
	GC: 0% $\Delta = 0.06 \text{ V}$	GC: 0% $\Delta = 0.08 \text{ V}$

Working electrode: glassy carbon, counterelectrode: glassy carbon, reference electrode: Ag/AgCl in sat. LiCl/EtOH, $v = 10 \text{ mV/s}$, oxidation criterion: $I = 0.05 \text{ mA/cm}^2$, $c(\text{phenol}) = 0.152 \text{ M}$, conductive salt: MTES, $c(\text{MTES}) = 0.09 \text{ M}$. Solvent: HFIP. $\Delta E_{\text{Ox}} = \text{ox.pot. coupling partner} - \text{ox.pot. table entry}$. BP: by-product; gas chromatography integration of product ratios.

Table 7 reflects the complexity of the ΔE_{Ox} window sizes. According to the substitution pattern, even small ΔE_{Ox} (Entry 2, here $\Delta E_{\text{Ox}} = -20 \text{ mV}$) already cause distinct selectivity for product formation. Generally, the importance of the size of ΔE_{Ox} for the selectivity of the reaction is confirmed. Entry 1, for the coupling with 2,3-dimethylphenol, shows a high proportion of homo-coupling products in pure HFIP. This can be explained by the virtually identical oxidation potential of the two co-reactants. Only in the case of MeOH addition does a ΔE_{Ox} of -30 mV develop. Only then is the formation of the unsymmetric product actually possible. If there is a fall in the difference in the oxidation potentials of phenols used, product formation is suppressed (Entry 2, pure HFIP). In the case of 3-(1,1-dimethylethyl)-4-methoxyphenol (Entry 3), this is entirely absent, since the latter phenol derivative is oxidized first and cross-coupling is impossible.

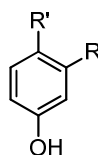


Table 8: ΔE_{Ox} of 3,4-disubstituted phenols

In Figure 6, the dependence of the oxidation potential ΔE_{Ox} of the 3,4-disubstituted phenols on the amount of methanol added is plotted. Apart from 3,4-dimethylphenol, a slight lowering of E_{ox} for all phenols is observed here too. More electron-deficient derivatives experience virtually constant lowering in potential from about 18%v/v methanol.

Coupling partner	HFIP pure	18% MeOH
ΔE_{Ox} with 4-methylguaiacol		
	GC: 11% $\Delta = -0.33 \text{ V}$	GC: 18% $\Delta = -0.17 \text{ V}$

Working electrode: glassy carbon, counterelectrode: glassy carbon, reference electrode: Ag/AgCl in sat. LiCl/EtOH, $v = 10 \text{ mV/s}$, oxidation criterion: $j = 0.10 \text{ mA/cm}^2$, $c(\text{phenol}) = 0.152 \text{ M}$, conductive salt: MTES, $c(\text{MTES})=0.09\text{M}$. Solvent: HFIP. $\Delta E_{\text{Ox}} = \text{ox.pot.coupling partner} -$

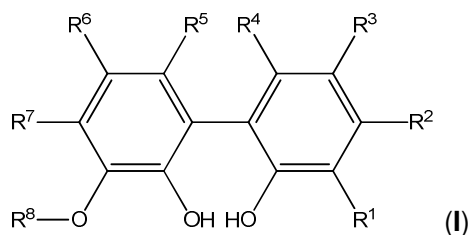
5 ox.pot.-table entry. BP: by-product; gas chromatography integration of product ratios

If the difference between the two potentials becomes too great (Table 8, $\Delta E_{\text{Ox}} = -330 \text{ mV}$, HFIP pure), there is apparently electrochemical combustion of the 4-methylguaiacol used.

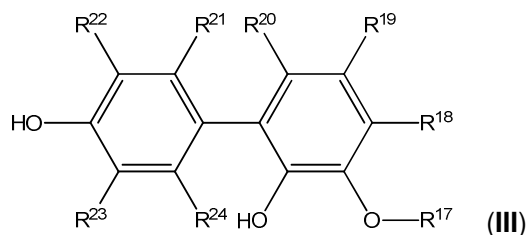
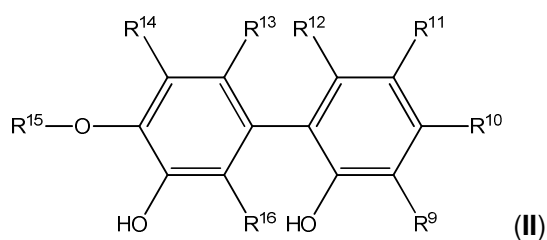
- 10 By the experiments conducted, it has been shown that the difference between the oxidation potentials (ΔE) of the two phenols can be influenced via the solvent or solvent mixtures. In addition, it has been shown that the difference between the oxidation potentials (ΔE) of the two phenols has a distinct effect on the coupling behaviour/outcome. It has thus been demonstrated that the coupling reaction of two phenols having different oxidation potentials can be controlled
- 15 via the appropriate choice of solvent or solvent mixture.

Claims

1. Compound of one of the general formulae (I) to (III):



5



10 where $R^2, R^3, R^4, R^5, R^6, R^7, R^{10}, R^{11}, R^{12}, R^{13}, R^{14}, R^{16}, R^{18}, R^{19}, R^{20}, R^{21}, R^{24}$ are selected from:
-H, -alkyl, -O-alkyl;

R^8, R^{15}, R^{17} are -alkyl;

R^1, R^9, R^{22}, R^{23} are selected from: -H, -alkyl;

and, if R^3 is -Me, R^1 and R^2 are not both -H.

15

2. Compound according to Claim 1,

where $R^2, R^3, R^4, R^5, R^6, R^7, R^{10}, R^{11}, R^{12}, R^{13}, R^{14}, R^{16}, R^{18}, R^{19}, R^{20}, R^{21}, R^{24}$ are selected from:
-H, -alkyl.

20 3. Compound according to either of Claims 1 and 2,
where R^4 and R^5 are -H.

4. Compound according to any of Claims 1 to 3,
where R^3 and R^6 are -alkyl.
5. Compound according to any of Claims 1 to 4,
5 where R^{11} is -O-alkyl.
6. Compound according to any of Claims 1 to 5,
where R^{13} is -alkyl.
- 10 7. Compound according to any of Claims 1 to 6,
where R^{19} is -alkyl.
8. Electrochemical process for preparing biphenols, comprising the process steps of:
 - a) introducing a solvent or solvent mixture and a conductive salt into a reaction vessel,
 - 15 b) adding a first phenol having an oxidation potential $|E_{ox1}|$ to the reaction vessel,
 - c) adding a second phenol having an oxidation potential $|E_{ox2}|$ to the reaction vessel, where:
 $|E_{ox2}| > |E_{ox1}|$ and $|E_{ox2}| - |E_{ox1}| = |\Delta E|$,
 the second phenol being added in excess relative to the first phenol,
 and the solvent or solvent mixture being selected such that $|\Delta E|$ is in the range from 10 mV to
 20 450 mV,
 - d) introducing two electrodes into the reaction solution,
 - e) applying a voltage to the electrodes,
 - f) coupling the first phenol to the second phenol to give a biphenol.
- 25 9. Process according to Claim 8,
wherein the second phenol is used at least in twice the amount relative to the first phenol.
10. Process according to either of Claims 8 and 9,
wherein the ratio of first phenol to the second phenol is in the range from 1:2 to 1:4.
- 30 11. Process according to any of Claims 8 to 10,
wherein either the first phenol the second phenol has an -O-alkyl group.
12. Process according to any of Claims 8 to 11,

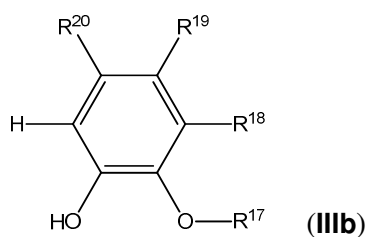
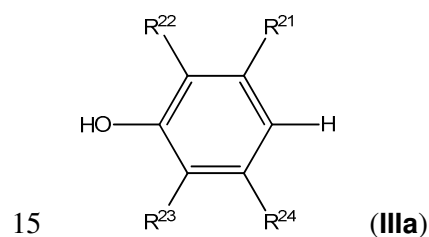
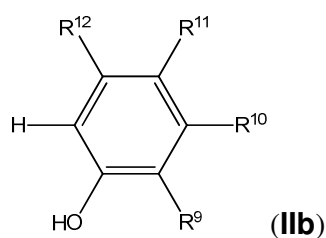
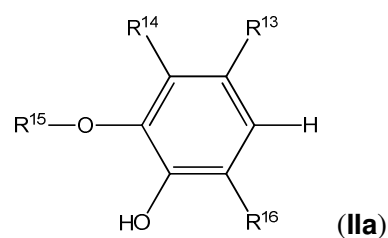
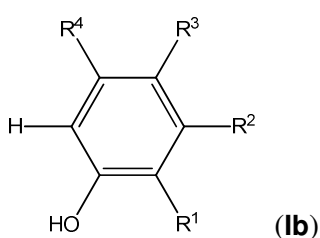
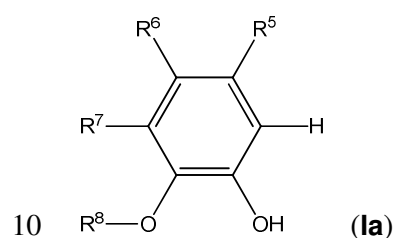
wherein the solvent or solvent mixture is selected such that $|ΔE|$ is in the range from 20 mV to 400 mV.

13. Process according to any of Claims 8 to 12,

5 wherein the reaction solution is free of organic oxidizing agents.

14. Process according to any of Claims 8 to 13,

wherein the first phenol and the second phenol are selected from: **Ia**, **Ib**, **IIa**, **IIb**, **IIIa**, **IIIb**:



where $R^2, R^3, R^4, R^5, R^6, R^7, R^{10}, R^{11}, R^{12}, R^{13}, R^{14}, R^{16}, R^{18}, R^{19}, R^{20}, R^{21}, R^{24}$ are selected from:
-H, -alkyl, -O-alkyl;

20 R^8, R^{15}, R^{17} are -alkyl;

R^1, R^9, R^{22}, R^{23} are selected from: -H, -alkyl,

and the following combinations are possible here:

first phenol	Ia	Ib	IIa	IIb	IIIa	IIIb
second phenol	Ib	Ia	IIb	IIa	IIIb	IIIa

15. Process according to Claim 14,

where, if R^3 is -Me, R^1 and R^2 are not both -H.

5