

TITLE

CROSS-DIMERIZATION OF OLEFINS

FIELD OF INVENTION

5 This invention concerns a process for the production of chemical intermediates by the cross dimerization of two compounds containing carbon-carbon double bonds. Specifically provided is a process for the production of methyl 4-pentenoate (M4P) by selectively cross-dimerizing ethylene and methyl acrylate. Methyl 4-pentenoate is a nylon 6,6 intermediate.

TECHNICAL BACKGROUND

10 This invention concerns a process for the production of valuable chemical intermediates by the cross dimerization of two compounds containing carbon-carbon double bonds. Specifically provided is a process for the production of methyl 4-pentenoate (M4P).

It is generally known to use nickel catalysts in the dimerization, oligomerization, and polymerization of olefins.

The present invention, however, provides a novel process which is a highly selective route to methyl 4-pentenoate, an intermediate in the manufacture of adipic acid, via cross-dimerization. Adipic acid is one of the starting materials in the manufacture of nylon 6,6.

20 G. Wilke et al., *Angew. Chem. Int. Ed. Engl.* (1988), 27, 185, report the polymerization of ethylene to linear polyethylene by a nickel catalyst.

G. Wilke et al., *Angew. Chem. Int. Ed. Engl.* (1988), 27, 185, present a general review on Ni-catalyzed dimerization, oligomerization and polymerization of olefins.

25 G. Wilke et al., *Angew. Chem. Int. Ed. Engl.* (1966), 5, 151, and 897, and *Angew. Chem.*, Int. Ed. Engl. (1966), 5, 582, disclose general procedures for preparing allyl-nickel-halide and allyl-nickel-methyl complexes. No detailed experimental procedures were reported.

Laufenberg (US 5,324,847) discloses methods of preparing ethylene adducts of polyunsaturated 18-22 carbon fatty acids or alkyl esters in the presence of Ru, Rh, Pd, Ir, and Pt-containing catalysts.

Drent (US 4,692,548) discloses methods of reacting acrylate esters and ethene using Ru or Pd compounds along with Ag or Cu salts.

SUMMARY OF THE INVENTION

35 Disclosed is a process for the preparation of methyl 4-pentenoate, which comprises contacting ethylene with methyl acrylate in the presence of a nickel II catalyst complex of the structure $[QNiL_1L_2]^+X^-$, wherein

Q = η^3 carbon-based allyl or substituted allyl

L_1 = a monodentate trisubstituted phosphine ligand

L_2 = a weakly coordinating ligand

X = a non-coordinating or weakly coordinating nonreactive anion;

5 any liquid medium that may be present as solvent or diluent being non-reactive under the conditions of the process and non-coordinating; and

recovering the crude reaction product.

Optionally, methyl 4-pentenoate can be separated from the crude reaction
10 product by conventional methods, although the crude reaction product often can be used in further reactions without separating methyl 4-pentenoate.

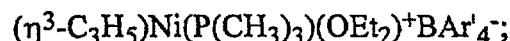
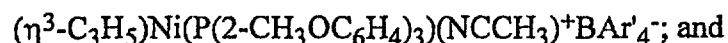
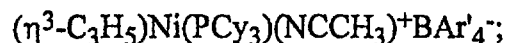
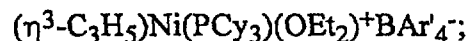
DETAILED DESCRIPTION OF THE INVENTION

L_1 , a monodentate trisubstituted phosphine, is defined as $PR_1R_2R_3$, where each of R_1 , R_2 , and R_3 is independently a linear, branched, or cyclic hydrocarbon
15 up to 20 carbon atoms; two of R_1 , R_2 , and R_3 can form a ring. Preferably, R_1 , R_2 , and R_3 are identical and are hexyl, methyl, or phenyl. The most preferred R_1 , R_2 , or R_3 is cyclohexyl.

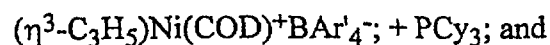
Weakly-coordinating ligands are defined as ligands that are easily displaced from a metal. Examples of such weakly-coordinating ligands are
20 dialkyl ethers or nitriles of aliphatic acids. Preferably L_2 is derived from the solvent used in the reaction; more preferably, L_2 is acetonitrile, diethyl ether, or tetrahydrofuran.

Weakly coordinating anions are known to those skilled in the art. Such anions are often bulky anions, particularly those that may delocalize their negative
25 charge. The coordinating capability of such anions has been discussed in the literature; see, for instance, W. Beck, et al., *Chem. Rev.*, vol. 88, p. 1405-1421 (1988), and S. H. Strauss, *Chem. Rev.*, Vol. 93, p. 927-942 (1993). The preferred weakly coordinating anions of the present are $[B(3,5-(CF_3)_2C_6H_3)_4]^-$ and $[B(C_6F_5)_4]^-$.

30 The preferred catalyst is selected from the group consisting of:

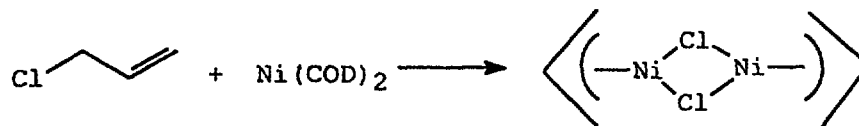


35 and the *in situ* formed catalyst systems:



where Cy = cyclohexyl; Ar' = 3,5-(CF₃)₂C₆H₃-, and COD = 1,5-cyclooctadiene.

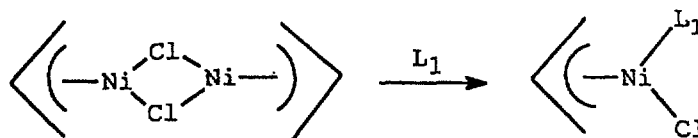
The general procedures used to prepare the catalysts are illustrated in Equations 1-8. Allyl chloride is reacted with nickel(0) dicyclooctadiene to form
5 diallyl-dichloro-dinickel(II) complex (Equation 1).



Equation 1

The notation used at both ends of the formula on the right hand side of the
10 equation represents a delocalized allyl complex with Ni.

This complex is reacted with the phosphine ligand L₁ to form an allyl-chloro-phosphine-nickel complex (Equation 2).



Equation 2

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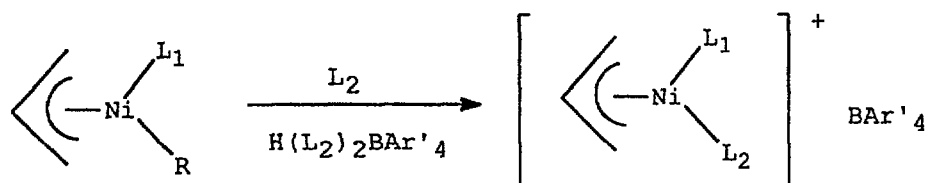
The chlorine atom is replaced with an R group by reacting the complex with an RMgBr Grignard reagent (Equation 3).



Equation 3

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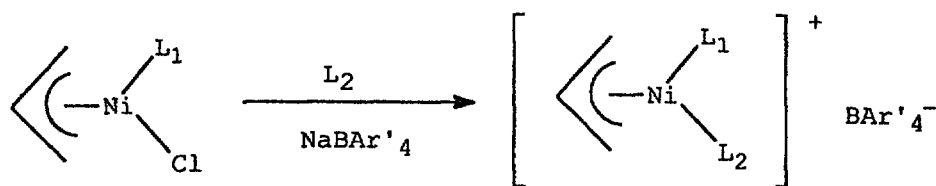
The resulting complex is reacted with L₂ and with the boron compound HBAR'₄ to form the desired catalyst (Equation 4).



Equation 4

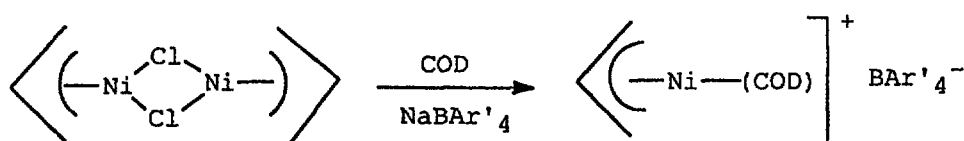
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An alternate synthesis route involves reacting the allyl-chloro-phosphine-nickel complex with L₂ and the Na form of the boron salt (Equation 5).



Equation 5

5 The compound $(\eta^3\text{-C}_3\text{H}_5)\text{Ni}(\text{COD})^+\text{BAR}'_4^-$ is prepared by reacting the diallyl-dichloro-dinickel complex from Equation 1 directly with COD and NaBAR'₄ (Equation 6).



Equation 6

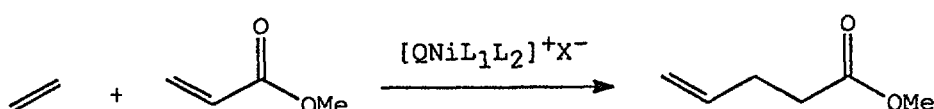
10 The cross-dimerization process is preferably carried out in a non-reacting, weakly coordinating solvent. Non-reacting, weakly-coordinating solvents are defined as solvents that are not coordinated to the metal or, if they are, they can be easily displaced from the metal. Non-reactive is defined as not reacting in the present invention. Aprotic organic solvents such as halogenated aromatic
15 solvents, e.g., monochlorobenzene and o-dichlorobenzene are typically employed. Most preferred are methylene chloride, and excess of neat methyl acrylate.

The process can be carried out at any convenient pressure. Normally, the pressure can vary from about 14 to about 120 psia (96 to 827 kPa). The preferred pressure range is from about 28 to about 69 psia (69 to about 476 kPa).

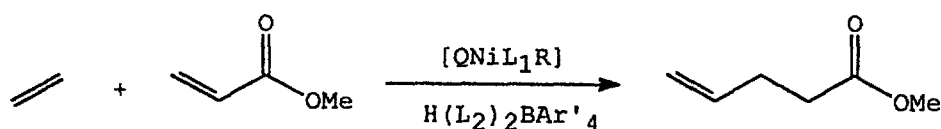
20 A temperature range typically employed is from about 0 to about 100°C. Preferred temperature range is from about 15 to about 60°C.

The process is sensitive to oxygen and moisture and is preferably carried out in an atmosphere of an inert gas, ethylene (which is a reactant) or in a mixture of inert gas and ethylene, in the absence of oxygen and moisture. Typical inert
25 gases are nitrogen and argon. The reacting mixture is preferably agitated.

The dimerization reactions are shown in Equations 7 and 8, below.



Equation 7



Equation 8

In the Experiments and Examples the following abbreviations are used:

Cy = cyclohexyl

Ar' = 3,5-(CF₃)₂C₆H₃⁻

COD is 1,5-cyclooctadiene

M4P = methyl 4-pentenoate

M3P = methyl 3-pentenoate

M2P is methyl 2-pentenoate

Me = methyl

Et = ethyl

TO is turnover; number of moles of cross-dimer formed per mole of catalyst.

EXAMPLES

General Information

All complexes were manipulated in an atmosphere of dry, oxygen-free nitrogen within a dry box or on a standard Schlenk line. Methylene chloride was distilled in a nitrogen atmosphere from phosphorus pentoxide prior to use. Toluene, hexane, and diethyl ether were distilled in a nitrogen atmosphere from sodium and benzophenone prior to use. ¹H and ¹³C NMR spectra were recorded on either a Varian XL-400, Bruker WM-200, a Bruker WM-250, or GE-300 spectrometer. Chemical shifts were reported by reference to protonated residues of solvents. Elemental analyses were performed by Oneida Research Services, Inc., Whitesboro, NY. Gas chromatography (GC) analyses were conducted on a 30-meter DB-210 column from J&W Scientific, Folsom, CA, using flame ionization detection. Ni(COD)₂ was purchased from Strem Chemicals, Inc., Newbury, MA. Some of the following preparations have been reported in the literature but have limited detailed experimental sections. Most of the compounds have not been previously fully characterized.

"Experiments" reported herein describe the preparation of the catalysts used. "Examples" describe the cross-dimerization of ethylene with methyl acrylate.

EXPERIMENT 1Preparation of $[\text{Ni}(\text{C}_3\text{H}_5)\text{Cl}]_2$

The synthesis of this complex was described by G. Wilke et al., *Angew. Chem., Int. Ed. Engl.* 1966, 5, 151. A 500 ml round-bottomed flask was charged with 5.033 g (18.3 mmol) of $\text{Ni}(\text{COD})_2$ suspended in 250 ml of diethyl ether. The solution was cooled to -78°C and 1.5 ml (18.4 mmol) of allyl chloride was added dropwise. The mixture was allowed to warm to ambient temperature and was stirred for 2 hours, during which time the yellowish suspension turned into a deep red solution. The solvent was removed in vacuum and the product was extracted with about 110 ml of hexane. These extracts were filtered and the filtrates placed at -30°C to cause crystallization. Red crystals (2.07 g, 84% yield) were recovered. ^1H NMR (300 MHz, 23°C , C_6D_6); δ 4.81 (m, 1H, $\text{CH}_2\text{-CH-CH}_2$), 2.64 (d, 2H, $J_{\text{cis}} = 6.9$ Hz, H_{cis}), 1.63 (d, 2H, $J_{\text{trans}} = 13.1$ Hz, H_{trans})

EXPERIMENT 2Preparation of $(\text{C}_3\text{H}_5)\text{NiClPCy}_3$

A Schlenk flask was charged with $[\text{Ni}(\text{C}_3\text{H}_5)\text{Cl}]_2$ (204.1 mg, 0.75 mmol) and tricyclohexylphosphine (429 mg, 1.53 mmol). The flask was cooled to -78°C , and Et_2O (60 ml) was added with stirring. The reaction mixture was warmed to 23°C and stirred for 30 min. The solvent was removed at a reduced pressure. The solid residue was extracted with 4 x 10 ml of diethyl ether; the extracts were filtered and placed at -25 to -30°C , at which temperature crystallization occurred. The yield was 455 mg (73%). ^1H NMR (400 MHz, 23°C , C_6D_6); δ 4.92 (m, central allylic H); 4.17 (m, 1H, H_{cis}), 3.12 (dd, $J = 14$ and 5 Hz, 1H, H_{trans}), 2.30 (br, 1H, H_{cis}), 1-2.2 (m, PCy_3). The missing H_{trans} was probably obscured by the tricyclohexylphosphine resonances. ^{13}C NMR (100 MHz, 23°C , C_6D_6); δ 108.7 (d, $J_{\text{C-H}} = 159$ Hz, central allylic C), 74.8 (dt, $J_{\text{C-P}} = 20$ Hz, $J_{\text{C-H}} = 161$ Hz, allylic C *trans* to P), 43.8 (dt, $J_{\text{P-C}} = 7$ Hz, $J_{\text{C-H}} = 153$ Hz, allylic C *cis* to P), 34.0 (dd, $J_{\text{P-C}} = 18$ Hz, $J_{\text{C-H}} = 121$ Hz, cyclohexyl C α to P), 30.3 (t, $J_{\text{C-H}} = 126$ Hz, cyclohexyl C γ to P), 27.9 (dt, $J_{\text{C-H}} = 117$ Hz, $J_{\text{P-C}} = 10$ Hz, cyclohexyl C β to P), 26.8 (t, $J_{\text{C-H}} = 123$ Hz, cyclohexyl C para). Analysis: Found (Calcd.): C, 60.95 (60.68); H, 9.47 (9.21).

EXPERIMENT 3Preparation of $(\text{C}_3\text{H}_5)\text{NiClPMe}_3$

A Schlenk flask was charged with $[\text{Ni}(\text{C}_3\text{H}_5)\text{Cl}]_2$ (426 mg, 1.58 mmol) dissolved in 50 ml of diethyl ether. The solution was cooled to -78°C and 3.15 ml of a 1M solution of PMe_3 in toluene (3.15 mmol) was added dropwise. At -78°C , a solid immediately formed but upon warming to 23°C redissolved. The red-orange mixture was stirred at 23°C for 1 hour, and the solvent was removed at

a reduced pressure. The product was extracted with 20 ml of diethyl ether; the extracts were filtered and the filtrates placed at -30°C to cause crystallization. The yield was 504 mg (76%). ^1H NMR (300 MHz, 23°C , CD_2Cl_2); δ 5.32 (m, central allylic H); 3.92 (m, 1H, H_{Cis}), 2.99 (dd, $J = 14$ and 6 Hz, 1H, H_{trans}), 2.66 (brdd, 1H, H_{Cis}), 1.82 (brd, $J = 13$ Hz, 1H, H_{trans}), 1.32 (d, $J_{\text{P-H}} = 9$ Hz, 9H, $\text{P}(\text{CH}_3)_3$). ^{13}C NMR (75 MHz, 23°C , CD_2Cl_2); δ 110.9 (d, $J_{\text{C-H}} = 160$ Hz, central allylic C), 73.1 (dt, $J_{\text{C-P}} = 22$ Hz, $J_{\text{C-H}} = 156$ Hz, allylic C trans to P), 46.5 (dt, $J_{\text{P-C}} = 6$ Hz, $J_{\text{C-H}} = 152$ Hz, allylic C cis to P), 14.6 (dq, $J_{\text{P-C}} = 27$ Hz, $J_{\text{C-H}} = 130$ Hz, $\text{P}(\text{CH}_3)_3$). Analysis: Found (Calcd.): C, 34.14 (34.11); H, 6.47 (6.68).

EXPERIMENT 4

Preparation of $(\text{C}_3\text{H}_5)(\text{PCy}_3)\text{Ni}(\text{CH}_3)$

A Schlenk flask was charged with 191 mg (0.46 mmol) of $(\text{C}_3\text{H}_5)(\text{PCy}_3)\text{NiCl}$, prepared as above, dissolved in 15 ml of Et_2O (red-orange solution). The flask was cooled to -78°C , at which temperature 165 ml of a 3M solution of MeMgBr in Et_2O (0.5 mmol) was added dropwise. The solution, which immediately lightened in color, with MgBrCl precipitating, was stirred at -78°C for 90 min. The solution was filtered to a flask kept at -78°C . The cold bath was removed and as the reaction mixture was warming the solvent was removed under vacuum. The orange-yellow solid residue was extracted with hexane and recrystallized at -78°C (139 mg, 77% yield). ^1H NMR (300 MHz, 23°C , C_6D_6); δ 4.91 (dddd, $2J_{\text{trans}} = 14$ Hz, $2J_{\text{cis}} = 7$ Hz, central allylic H), 3.49 (ddd, $J_{\text{cis}} = 7$ Hz, $J = 5$ Hz, $J = 3$ Hz, 1H, H_{Cis}), 2.92 (ddd, $J_{\text{cis}} = 7$ Hz, $2J = 3$ Hz, 1H, H_{Cis}), 2.63 (dd, $J_{\text{trans}} = 14$ Hz, $J = 5$ Hz, 1H, H_{trans}), the missing H_{trans} was probably obscured by the cyclohexyl signals, 1-2.2 (m, cyclohexyl), 0.15 (d, 3H, $J_{\text{P-H}} = 7$ Hz, Ni-CH_3). ^{13}C NMR (75 MHz, 23°C , C_6D_6); δ 109.3 (d, $J_{\text{C-H}} = 154$ Hz, central allylic C), 60.8 (dt, $J_{\text{C-P}} = 22$ Hz, $J_{\text{C-H}} = 158$ Hz, allylic C trans to P), 53.5 (dt, $J_{\text{P-C}} = 5$ Hz, $J_{\text{C-H}} = 152$ Hz, allylic C cis to P), 35.2 (dd, $J_{\text{P-C}} = 18$ Hz, $J_{\text{C-H}} = 123$ Hz, cyclohexyl C α to P), 30.5 (t, $J_{\text{C-H}} = 126$ Hz, cyclohexyl C γ to P), 30.4 (t, $J_{\text{C-H}} = 126$ Hz, cyclohexyl C γ to P), 28.1 (t, $J_{\text{C-H}} = 118$ Hz, cyclohexyl C β to P), 28.0 (t, $J_{\text{C-H}} = 118$ Hz, cyclohexyl C β to P), 26.9 (t, $J_{\text{C-H}} = 122$ Hz, cyclohexyl C para), -16.1 (dq, $J_{\text{P-C}} = 16$ Hz, $J_{\text{C-H}} = 122$ Hz, Ni-CH_3).

EXPERIMENT 5

Preparation of $[(\text{C}_3\text{H}_5)(\text{PCy}_3)\text{Ni}(\text{Et}_2\text{O})]^+[\text{BAr}'_4]^-$

A Schlenk flask was charged with 53.4 mg (0.13 mmol) of $(\text{C}_3\text{H}_5)(\text{PCy}_3)\text{Ni}(\text{CH}_3)$ and 143 mg (0.14 mmol) of $\text{H}(\text{Et}_2\text{O})_2\text{BAr}'_4$. The flask was cooled to -78°C , and 3.5 ml of Et_2O was added. The solution was slightly warmed to allow for the complete dissolution and reaction of the reactants. Once complete dissolution had occurred, the flask was kept at -78°C for 15 min. At that

time, 2 x 10 ml of hexane was added, causing the precipitation of the yellow product. After stirring at -78°C for an additional hour, the supernatant was discarded, the remaining solid was washed with hexane and dried under vacuum. Recrystallization from Et₂O/hexane at -30°C yielded 99.5 mg (ca 58%) of a mixture of diethyl ether (30%) and water (70%) complexes. A ¹H NMR spectrum at -80°C was recorded before recrystallization: ¹H NMR (300 MHz, -80°C, CD₂Cl₂); δ 7.72 (s, 8H, Ar'), 7.54 (s, 4H, Ar'), 5.62 (m, central allylic H), 4.36 (d, J_{cis} = 7 Hz, 1H, H_{cis}) 3.83 (brq, J = 7 Hz, 2H, (CH₃CHHO)₂), 3.78 (brq, J = 7 Hz, 2H, (CH₃CHHO)₂), 3.64 (brm, 1H), 3.52 (brm, 1H), 3.19 (dd, J = 4 and 14 Hz, 1H, H_{trans}), 1-2.6 (m, cyclohexyl and (CH₃CH₂O)₂). The ¹³C NMR spectrum was recorded after recrystallization, confirming the presence of a mixture of H₂O (1) and Et₂O (2) complexes: ¹³C{H} NMR (100 MHz, -60°C, CD₂Cl₂); δ counterion signals, 115.1 (s, central allylic (1)), 75.1 (d, J_{C-P} = 15 Hz, allylic C *trans* to P (2)), 74.3 (d, J_{C-P} = 15 Hz, allylic C *trans* to P (1)), 71.0 (s, (CH₃CH₂O)₂), 42.6 (s, allylic C *cis* to P (1)), 40.3 (s, allylic C *cis* to P (2)), 24-36 (cyclohexyl carbons), 14.3 (s, (CH₃CH₂O)₂). Analysis: (mixture of complexes) Found (Calcd.): C, 50.54 (50.92); H, 4.68 (4.29).

EXPERIMENT 6

Preparation of [(C₃H₅)(PCy₃)Ni(CH₃CN)]⁺[BAr'₄]⁻

A Schlenk flask was charged with 40.3 mg (0.097 mmol) of (C₃H₅)Ni(PCy₃)Cl and 88 mg (0.099 mmol) of NaBAr'₄. The flask was cooled to -78°C, at which temperature 50 μl (0.96 mmol) of CH₃CN was added (it froze along the side). Ten ml of Et₂O was added with a syringe, rinsing the acetonitrile into the flask to the reactants. The flask was warmed up to 23°C and stirred for ca 45 min. The clear yellow solution became cloudy as NaCl formed. The solution was filtered, and the solvent was removed from the filtrate under vacuum, yielding a glassy yellow solid (116 mg, 93% yield). ¹H NMR (300 MHz, 23°C, CD₂Cl₂); δ 7.72 (s, 8H, Ar'), 7.57 (s, 4H, Ar'), 5.46 (m, central allylic H), 4.45 (brd, J_{cis} = 7 Hz, ¹H, H_{cis}), 3.25 (brd, J_{trans} = 13 Hz, 1H, H_{trans}), 3.10 (br, 1H, H_{cis}), 2.37 (s, 3H, CH₃CN), 2.10 (brd, J = 13 Hz, 1H, H_{trans}), 1.0-2.0 (m, cyclohexyl). ¹³C NMR (100 MHz, 23°C, CD₂Cl₂); δ 162.2 (q, J_{C-B} = 50 Hz, C₁'), 135.2 (d, J_{C-H} = 159 Hz, C₂'), 130.9 (s, CH₃CN), 129.3 (q, J_{C-F} = 35 Hz, C₃'), 125.0 (q, J_{C-F} = 272 Hz, CF₃), 117.9 (dd, ⁴J_{C-F} = 4 Hz, J_{C-H} = 164 Hz, C₄'), 116.1 (d, J_{C-H} = 162 Hz, central allylic carbon), 78.2 (brt, J_{C-H} = 162 Hz, allylic C), 51.3 (brt, J_{C-H} = 170 Hz, allylic C), 34.8 (dd, J_{C-P} = 20 Hz, J_{C-H} = 125 Hz, cyclohexyl C to P), 30.5 (t, J_{C-H} = 128 Hz, cyclohexyl C γ to P), 28.0 (dt, J_{P-C} = 11 Hz, J_{C-H} = 128 Hz, cyclohexyl C β to P), 26.5 (t, J_{C-H} = 135 Hz, cyclohexyl C para), 4.2 (q,

$J_{C-H} = 140$ Hz, CH_3CN). Analysis: Found (Calcd.): C, 51.69 (51.43); H, 3.88 (4.16); N, 1.00 (1.09).

EXPERIMENT 7

Preparation of $(C_3H_5)(PMe_3)Ni(CH_2SiMe_3)$

- 5 A Schlenk flask was charged with 205 mg (0.97 mmol) of $(C_3H_5)(PMe_3)NiCl$ prepared as above dissolved in 40 ml of Et_2O (orange solution). The flask was cooled to $-78^\circ C$, at which temperature 1.05 ml of a 1M solution of Me_3Si-CH_2MgBr in Et_2O (1.05 mmol) was slowly added with a syringe into the solution. The solution, which turned immediately from orange to
- 10 yellow, was stirred at $-78^\circ C$ for 2 hours. The cold bath was removed, and, as the mixture was warmed, the solvent was removed under vacuum. The yellow-brown solid was extracted with 3 x 5 ml of hexane (a brownish color resulted from some decomposition). Hexane was removed from the filtrate, yielding an orange oil (179 mg, 66% yield). The product was pure by 1H NMR spectroscopy. 1H NMR
- 15 (300 MHz, $23^\circ C$, C_6D_6); δ 4.72 (m, central allylic H), 3.55 (dt, $J = 7.3$ Hz, $2J = 2.3$ Hz, 1H, H_{cis}), 2.56 (d, $J = 6.6$ Hz, 1H, H_{cis}), 2.40 (d, $J = 13.8$ Hz, 1H, H_{trans}), 1.46 (d, $J = 13.6$ Hz, 1H, H_{trans}), 0.84 (d, $J_{P-H} = 8$ Hz, 9H, $P(CH_3)_3$), 0.28 (s, 9H, $Si(CH_3)_3$), 1 methylenic diastereotopic proton was obscured by the $Si(CH_3)_3$ signal, -0.12 (brt, $J = 12.3$ Hz, 1H, $CHH(SiMe_3)$). ^{13}C NMR (75 MHz,
- 20 $23^\circ C$, C_6D_6); δ 109.4 (d, $J_{C-H} = 155$ Hz, central allylic C), 59.6 (dt, $J_{C-P} = 24$ Hz, $J_{C-H} = 155$ Hz, allylic C trans to P), 54.5 (t, dt, $J_{C-H} = 155$ Hz, allylic C cis to P), 16.0 (dq, $J_{P-C} = 25$ Hz, $J_{C-H} = 127$ Hz, $P(CH_3)_3$), 4.2 (q, $J_{C-H} = 117$ Hz, $Si(CH_3)_3$), -8.8 (dt, $J_{P-C} = 10$ Hz, $J_{C-H} = 115$ Hz, CH_2SiMe_3).

EXPERIMENT 8

Preparation of $[(C_3H_5)(PMe_3)Ni(Et_2O)]^+[BAr'_4]^-$

- 25 A Schlenk tube was charged with 41.3 mg (0.16 mmol) of $(C_3H_5)(PMe_3)Ni(CH_2SiMe_3)$ dissolved in 5 ml of diethyl ether. A separate Schlenk tube was charged with $H(Et_2O)_2BAr'_4$ (159 mg, 0.16 mmol) and cooled to $-78^\circ C$. The solution containing the nickel complex was transferred via cannula
- 30 into the cold flask containing the acid. Once all reactants dissolved, 4 x 10 ml portions of hexane were slowly added to the orange solution under vigorous stirring at $-78^\circ C$. An orange-yellow solid precipitated immediately. The supernatant was discarded, and the solid was dried under vacuum (143.8 mg, 82%). Upon recrystallization, disproportionation occurred, giving, presumably,
- 35 $(C_3H_5)Ni(PMe_3)_2^+$ and $(C_3H_5)Ni(Et_2O)_2$ 1H NMR before recrystallization (250 MHz, $23^\circ C$, CD_2Cl_2); δ 7.72 (s, 8H, Ar'), 7.56 (s, 4H, Ar'), 5.67 (m, central allylic H), 4.34 (br, 1H), 3.64 (q, $J = 7$ Hz, 4H, $(CH_3CH_2O)_2$), 3.25 (br, 1H), 2.65 (br, 1H), 1.85 (br, 1H), 1.50 (t, $J = 7$ Hz, 6H, $(CH_3CH_2O)_2$), 1.32 (d, $J_{P-H} = 9$ Hz,

- P(CH₃)₃). Two compounds by ¹³C NMR (-78°C) (H₂O and Et₂O complexes). ¹³C NMR (100 MHz, -78°C, CD₂Cl₂); δ counterion signals, 115.8 (d, J_{C-H} = 162 Hz, central allylic C), 114.0 (d, J_{C-H} = 162 Hz, central allylic C), 73.0 (dt, J_{C-P} = 18 Hz, J_{C-H} = 146 Hz, allylic C *trans* to P), 72.8 (t, J_{C-H} = 146 Hz, (CH₃CH₂O)₂), 72.2 (dt, J_{C-P} 17 Hz, J_{C-H} = 146 Hz, allylic C *trans* to P), 44.1 (dt, J_{P-C} = 6 Hz, J_{C-H} = 157 Hz, allylic C *cis* to P), 43.7 (dt, J_{P-C} = 5 Hz, J_{C-H} = 157 Hz, allylic C *cis* to P), 15.2 (q, J_{C-H} = 126 Hz, (CH₃CH₂O)₂), 13.1 (dq, J_{P-C} = 28 Hz, J_{C-H} = 126 Hz, P(CH₃)₃), 13.0 (dq, J_{P-C} = 29 Hz, J_{C-H} = 126 Hz, P(CH₃)₃).

10

EXPERIMENT 9Preparation of (C₃H₅)NiClP(2-OMe(C₆H₄))₃

- A 100-ml flask was charged with [Ni(C₃H₅)Cl]₂ (100 mg, 0.37 mmol) and tris(2-methoxyphenyl)phosphine (262 mg, 0.74 mmol). The two solids were dissolved in Et₂O (60 ml), and the resulting solution was stirred overnight. As the reaction proceeded, the product (orange powder) precipitated from the solution. The mixture was filtered; the solid was washed with pentane and dried under vacuum. The yield was 250 mg (69%).

15

EXPERIMENT 10Preparation of [(C₃H₅)NiP(2-OMe(C₆H₄))₃(CH₃CN)]⁺[BAR'₄]⁻

- A 50-ml round-bottomed flask was charged with 43 mg (0.088 mmol) of (C₃H₅)NiCl(2-OMeC₆H₄) and 78 mg (0.088 mmol) of NaBAR'₄. A solution of CH₃CN (35 μl, 0.67 mmol) in CH₂Cl₂ (15 ml) was added. The cloudy solution was stirred at 25°C for 45 min (NaCl precipitated). Stirring was stopped for 15 minutes, and the solid was filtered off from the orange solution. Solvent and excess acetonitrile were removed at a reduced pressure from the filtrate. The resulting glassy solid was washed twice with 7 ml of pentane and dried under vacuum. The yield of the orange powder obtained was 70 mg (59%).

25

EXPERIMENT 11Preparation of [(C₃H₅)Ni(COD)]⁺[BAR'₄]⁻

- A 100-ml round-bottomed flask was charged with 106 mg (0.39 mmol) of [(C₃H₅)NiCl]₂ and 696 mg (0.79 mmol) of NaBAR'₄. A solution of 1,5-cyclo-octadiene (2 μl, 16.3 mmol) in Et₂O (50 ml) was added. It was stirred at 25°C for 75 min. The orange-yellow solution was cloudy due to precipitation of NaCl. It was filtered and the solvent and excess COD were removed under vacuum, yielding a yellow powder. It was redissolved in Et₂O and filtered. The solvent was removed under vacuum from the filtrate, giving the desired complex as a yellow powder (630 mg, 75% yield). ¹H NMR (CD₂Cl₂, 23°C, 300 MHz): δ 7.72 (s, 8H, Ar'), 7.56 (s, 4H, Ar'), 5.96 (m, 3H) (2 protons from the COD ligand

35

overlap with the central allylic proton), 5.79 (br m, 2H, COD), 4.50 (dt, $J_{\text{cis}} = 7-5 \text{ Hz}$, $J = 1.25 \text{ Hz}$, $2H_{\text{cis}}$), 3.06 (d, $J_{\text{trans}} = 14-6 \text{ Hz}$, $2H_{\text{trans}}$), 2.75 (m, 4H, COD), 2.48 (m, 4H, COD).

EXAMPLE 1

5 A Fischer-Porter tube was charged with 29 mg (0.022 mmol) of $(C_3H_5)NiPCy_3(Et_2O)^+BAr'_4$. It was placed under 1 atm. (101.3 kPa) of ethylene (the nickel complex reacted in the solid state, turning from a yellow powder to a "wet" appearance due to loss of Et_2O). A solution of methyl acrylate (4.5 μl , 50 mmol) in CH_2Cl_2 (4.5 ml) cooled to -78°C was added with a syringe. The tube
10 was pressurized to 71 psia (393.0 kPa) of ethylene, and the yellow solution was stirred at 15°C for 24 hrs.

1H NMR ($CDCl_3$) analysis of the reaction mixture reveals the presence of 1-butene (37%), methyl 4-pentenoate (M4P) (49%) and trans-2-dimethylhexenedioate (DMHD) (14%). The conversion of methyl acrylate to products (M4P and
15 DMHD) was 17% (390 equiv). Thus, the turnover (TO) number for the cross-dimer, M4P, was 250.

GC-mass spectroscopic analysis of the reaction mixture confirms the selective formation of methyl 4-pentenoate (>96%) over methyl 3-pentenoate (M3P, <2%), methyl 2-pentenoate (M2P, not detected) and methyl 2-methyl-
20 butenoate (branched, <2%).

EXAMPLE 2

A Fischer-Porter tube was charged with 29 mg (0.022 mmol) of $(C_3H_5)NiPCy_3(Et_2O)^+BAr'_4$. It was placed under 1 atm. (101.3 kPa) of ethylene. A solution of methyl acrylate (4.5 μl , 50 mmol) in CH_2Cl_2 (4.5 ml) cooled to
25 -78°C was added with a syringe. The tube was pressurized to 37 psia, (255 kPa) of ethylene, and the yellow solution stirred at 15°C for 23.5 hrs.

1H NMR ($CDCl_3$) analysis of the reaction mixture reveals the presence of 1-butene (20%), methyl 4-pentenoate (M4P) (57%) and trans-2-dimethylhexenedioate (DMHD) (23%). The conversion of methyl acrylate to products (M4P and
30 DMHD) was 12% (270 equiv). Thus, the TO number for the cross-dimer, M4P, was 150.

GC-mass spectroscopic analysis of the reaction mixture confirmed the selective formation of methyl 4-pentenoate (>98% yield).

EXAMPLE 3

35 A Fischer-Porter tube was charged with 24 mg (0.018 mmol) of $(C_3H_5)NiPCy_3(Et_2O)^+BAr'_4$, ($Ar' = 3,5-(CF_3)_2C_6H_3$). It was placed under 1 atm. of ethylene (101.3 kPa). A solution of methyl acrylate (4.5 μl , 50 mmol) in CH_2Cl_2 (4.5 ml) cooled to -78°C was added with a syringe. The tube was

pressurized to 54 psia (372 kPa) of ethylene, and the yellow solution was heated to 60°C. The pressure increased, but when the desired temperature was reached, the pressure was adjusted to 69 psia (476 kPa). Stirring at this temperature and pressure was continued for 15.5 hrs, at which time the solution was allowed to cool to ambient temperature (*ca* 1 hour). The solution was extremely viscous indicating the formation of polymer, presumably through a free radical process. The polymer was precipitated in MeOH; GC analysis of the filtrate revealed the presence of cross-dimer M4P along with dimethyl hexenedioates. Comparison of the ratio of the area of the cross-dimer to that of the homo-methyl acrylate dimers with the corresponding ratio obtained in Example 1 indicates a much larger amount of homodimer in the present example (no quantitative data were obtained).

EXAMPLE 4

A Fischer-Porter tube was charged with 19 mg (0.048 mmol) of $(C_3H_5)Ni(CH_3)(PCy_3)$ and 52 mg (0.051 mmol) of $H(Et_2O)_2^+BAR_4^-$. It was placed under 1 atm. (101.3 kPa) of ethylene. A solution of methyl acrylate (4.5 ml, 50 mmol, 1040 equiv) in CH_2Cl_2 (4.5 ml) cooled to -78°C was added with a syringe. The tube was then pressurized to 69 psia (476 kPa) of ethylene and the yellow solution was stirred at 15°C for 15 hrs and 40 min. 1H NMR ($CDCl_3$) analysis of the reaction mixture reveals the presence of 1-butene (33%), methyl 4-pentenoate (M4P)(61%) and trans-2-dimethylhexenedioate (DMHD) (6%). The conversion of methyl acrylate to products (M4P and DMHD) was 32% (390 equiv). The TO number for the cross-dimer, M4P, was 300. GC-mass spectrometric analysis of the reaction mixture confirms the selective formation of methyl 4-pentenoate (87%) over methyl 3-pentenoate (M3P, 8%), methyl 2-pentenoate (M2P, 4%) and methyl 3-methylbutenoate (branched, 1%).

EXAMPLE 5

A Fischer-Porter tube was charged with 15 mg (0.038 mmol) of $(C_3H_5)Ni(CH_3)(PCy_3)$ and 41 mg (0.040 mmol) of $H(Et_2O)_2^+BAR_4^-$. It was placed under 1 atm. (101.3 kPa) of ethylene. A solution of methyl acrylate (4.5 ml, 50 mmol, 1300 equiv) in Et_2O (4.5 ml) was added with a syringe after being cooled to -78°C. The tube was then pressurized to 69 psia (476 kPa) of ethylene, and the yellow solution was stirred at 25°C for 15 hrs and 40 min. In this example, no quantitative data (TO numbers) were obtained but GC analysis of the reaction mixture indicated a ratio of M4P:M3P:M2P: (branched) of 93:1:4:2.

EXAMPLE 6

A Schlenk tube was charged with 15 mg (0.038 mmol) of $(C_3H_5)Ni(CH_3)(PCy_3)$ and 41 mg (0.040 mmol) of $H(Et_2O)_2^+BAR_4^-$. It was

placed under 1 atm. (101.3 kPa) of ethylene and cooled to -78°C at which temperature a solution of methyl acrylate (4.5 ml, 50 mmol, 1310 equiv) in CH₂Cl₂ (4.5 ml) was added with a syringe. The tube was placed in a water bath at 25°C, and the yellow solution was stirred for *ca* 22 hrs. ¹H NMR (CDCl₃) analysis of the reaction mixture reveals the presence of 1-butene, (M4P), and trans-2-dimethyl hexenedioate (DMHD). The conversion of methyl acrylate to products, M4P (57%), and DMHD (43%) was 16% (210 equiv). Thus the TO number for the cross-dimer, M4P, was 80. GC analysis of the reaction mixture confirms the selective formation of M4P (91%) over M3P (1%), M2P (10.6%), and methyl 3-methylbutenoate (branched, 2%).

EXAMPLE 7

A Fischer-Porter tube was charged with 16 mg (0.040 mmol) of (C₃H₅)Ni(CH₃)(PCy₃) and 43 mg (0.042 mmol) of H(Et₂O)₂⁺BAr'₄⁻. It was placed under 1 atm. (101.3 kPa) of ethylene. A solution of methyl acrylate (4.5 ml, 50 mmol, 1250 equiv.) and tetradecane (1 ml, 3.85 mmol, GC standard) in CH₂Cl₂ (4.5 ml) cooled to 0°C was added with a syringe. The tube was then pressurized to 67 psia (462 kPa) of ethylene, and the yellow solution stirred at 25°C for 19 hrs. GC analysis of the reaction mixture revealed the presence of 1-butene, cross-dimers and methyl acrylate homo-dimers. The major product was the cross-dimer M4P; it accounted for 91% of the total cross-dimer products (M3P represented 3%, M2P 4% and branched 2%). The TO number for the production of cross-dimers was 395.

EXAMPLE 8

A Fischer-Porter tube was charged with 35 mg (0.033 mmol) of (C₃H₅)Ni(COD)⁺BAr'₄⁻, and 11 mg (0.039 mmol) of PCy₃. It was placed under 1 atm. (101.3 kPa) of ethylene. Then a solution of methyl acrylate (4.5 ml, 50 mmol, 1500 equiv) in CH₂Cl₂ (4.5 ml) cooled to -78°C was added with a syringe. The tube was pressurized to 68 psia (469 kPa) of ethylene and the yellow solution stirred at 25°C for 15 hrs and 40 min. GC analysis of the reaction mixture revealed the same selectivity for the cross-dimer M4P (>98%).

EXAMPLE 9

A Fischer-Porter tube was charged with 33 mg (0.031 mmol) of (C₃H₅)Ni(COD)⁺BAr'₄⁻ and 10 mg (0.036 mmol) of PCy₃. Under nitrogen, a solution of methyl acrylate (4.5 ml, 50 mmol, 1610 equiv.) and tetradecane (1 ml, 3.85 mmol, GC standard) in CH₂Cl₂ (4.5 ml) was added at room temperature. The tube was then pressurized to 67 psia (462 kPa) of ethylene, and the yellow solution was stirred at 25°C for 19 hrs. GC analysis of the reaction mixture revealed the presence of 1-butene, cross-dimers and traces of methyl acrylate

homo-dimers. The major product was the cross-dimer M4P; it accounts for 97% of the total cross-dimer products (M3P and M2P were not detected while the branched isomer represented *ca* 3%). The TO number for the production of cross-dimers was 66.

5

EXAMPLE 10

A Fischer-Porter tube was charged with 31 mg(0.024 mmol) of $(C_3H_5)NiPCy_3(CH_3CN)^+BAR'_4$. It was placed under 1 atm. (101.3 kPa) of ethylene. A solution of methyl acrylate (4.5 ml, 50 mmol, 2080 equiv.) and tetradecane (2 ml, 7.69 mmol, GC standard) in CH_2Cl_2 (4.5 ml) was added with a
10 syringe to this solution cooled to 0°C. The tube was then pressurized to 66 psia (358 kPa) of ethylene, and the yellow solution stirred at 25°C for 43.5 hrs. GC analysis of the reaction mixture revealed the presence of butenes, cross-dimers, and traces of homo-methyl acrylate dimers. The TO number (cross-dimers) was 315, with the following percentage of isomers: 59% (M4P), 34% (branched), 4%
15 (M2P), and 3% (M3P).

EXAMPLE 11

A Fischer-Porter tube was charged with 34 mg (0.026 mmol) of $(C_3H_5)NiPCy_3(CH_3CN)^+BAR'_4$. It was placed under 1 atm.(101.3 kPa) of ethylene. A solution of methyl acrylate (4.5 ml, 50 mmol, 1890 equiv.) and
20 tetradecane (0.5 ml, 1.92 mmol, GC standard) in CH_2Cl_2 (4.5 ml) cooled to 0°C was added with a syringe. The tube was then pressurized to 68 psia (469 kPa) of ethylene and the yellow solution stirred at 25°C for 17.25 hrs. GC-mass spectrometric analysis of the reaction mixture reveals the presence of butenes, cross dimers, and traces of home-methyl acrylate dimers. The percentage of
25 cross-dimers was as follows: 53% (M4P), 42% (branched), 3% (M2P), and 2% (M3P).

EXAMPLE 12

A Fischer-Porter tube was charged with 31 mg (0.023 mmol) of $(C_3H_5)NiP(2-OMe(C_6H_4))_3(CH_3CN)^+BAR'_4$. It was placed under 1 atm.
30 (101.3 kPa) of ethylene. A solution of methyl acrylate (4.5 ml, 50 mmol, 2170 equiv) in CH_2Cl_2 (4.5 ml) cooled to -78°C was added with a syringe. The tube was then pressurized to 67 psia (462 kPa) of ethylene, and the orange solution was stirred at 25°C for 15 hrs. GC-mass spectroscopic analysis of the reaction mixture indicates the formation of butenes, cross-dimers and
35 homo-methyl acrylate dimers. In this example, no quantitative data (TO numbers) were obtained but GC analysis revealed the presence of cross-dimer products: M4P (34%), M3P (3%), M2P (42%) and branched cross-dimers (21%).

EXAMPLE 13

A Fischer-Porter tube was charged with 36 mg (0.034 mmol) of $(C_3H_5)Ni(COD)^+BAR'_4^-$ and 13 mg (0.037 mmol) of $P(2-OMe(C_6H_4))_3$. It was placed under 1 atm. (101.3 kPa) of ethylene. A solution of methyl acrylate (4.5 ml, 50 mmol, 1470 equiv) in CH_2Cl_2 (4.5 ml) cooled to $-78^\circ C$ was added with a syringe. The tube was pressurized to 66 psia (455 kPa) of ethylene, and the yellow solution was stirred at $25^\circ C$ for 22.5 hrs. In this example, no quantitative data (TO numbers) were obtained but GC analysis revealed the presence of 1-butene, and a mixture of cross-dimer products: M4P (36%), M3P (1%), M2P (42%) and branched (21%), and methyl acrylate homo-dimers (ca. 73% *trans*-2-dimethyl hexenedioate).

EXAMPLE 14

A Fischer-Porter tube was charged with 26 mg (0.023 mmol) of $(C_3H_5)Ni(PMe_3)(Et_2O)^+BAR'_4^-$ ($Ar' = 3,5-(CF_3)_2C_6H_3$). It was placed under 1 atm. (101.3 kPa) of ethylene (the nickel complex reacts in the solid state turning from a yellow powder to a "wet" appearance as a result of loss of Et_2O). A solution of methyl acrylate (4.5 ml, 50 mmol, 2170 equiv) in CH_2Cl_2 (4.5 ml) cooled to $-78^\circ C$ was added with a syringe. The tube was then pressurized to 66 psia (455 kPa) of ethylene, and the orange solution was stirred at $25^\circ C$ for 17.5 hrs. GC-mass spectroscopic analysis of the reaction mixture indicated the formation of butenes, cross-dimers and homo-methyl acrylate dimers (94% *trans*-2-dimethylhexenedioate). In this example, no quantitative data (TO numbers) were obtained but GC analysis revealed a mixture of cross-dimer products: M4P (37%), M3P (57%), M2P (1%) and branched cross-dimers (5%).

The conditions and results of the cross-dimerization Examples 1-14 are summarized below in Tables 1 and 2.

TABLE 1
Reaction of Ethylene with Methyl Acrylate

<u>Example</u>	<u>Catalyst</u>
1	$(\eta^3-C_3H_5)Ni(PCy_3)(OEt_2)^+BAR'_4^-$
2	as 1
3	as 1
4	$(\eta^3-C_3H_5)Ni(PCy_3)(CH_3) + H(OEt_2)^+BAR'_4^-$
5	as 4 (Et_2O solvent)
6	as 4 (CH_2Cl_2 solvent)
7	as 4 (CH_2Cl_2 solvent)
8	$(\eta^3-C_3H_5)Ni(COD)(OEt_2)^+BAR'_4^- + PCy_3$
9	as 8

- | | |
|----|--|
| 10 | $(\eta^3\text{-C}_3\text{H}_5)\text{Ni}(\text{PCy}_3)(\text{NCCH}_3)^+\text{BAr}'_4^-$ |
| 11 | as 10 |
| 12 | $(\eta^3\text{-C}_3\text{H}_5)\text{Ni}(\text{P}(2\text{-CH}_3\text{OC}_6\text{H}_4)_3)(\text{NCCH}_3)^+\text{BAr}'_4^-$ |
| 13 | $(\eta^3\text{-C}_3\text{H}_5)\text{Ni}(\text{COD})^+\text{BAr}'_4^- + \text{P}(2\text{-CH}_3\text{OC}_6\text{H}_4)_3$ |
| 14 | $(\eta^3\text{-C}_3\text{H}_5)\text{Ni}(\text{P}(\text{CH}_3)_3)(\text{OEt}_2)^+\text{BAr}'_4^-$ |
-

cy = cyclohexyl

Ar' = 3,5-(CF₃)₂C₆H₃

COD = 1,5-cyclooctadiene

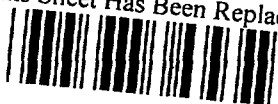
TABLE 2
Reaction of Ethylene with Methyl Acrylate

Example	C ₂ H ₄ Pressure (psia)	(kPa)	Temp °C	Time (hours)	Selectivity (% of cross dimer tha is M4P)	M4P Turnover Number
1	71	(393)	15	24	>96	250
2	37	(255)	15	24	>98	150
3	69	(476)	60	16	no quantitation	
4	69	(476)	15	16	87	300
5	69	(476)	25	16	93	--
6	14	(101)	25	22	91	80
7	67	(462)	25	19	91	395
8	68	(469)	25	16	>98	low
9	67	(462)	25	19	97	66
10	66	(455)	25	44	59	315
11	68	(469)	25	17	53	--
12	67	(462)	25	15	34	--
13	66	(455)	25	23	36	--
14	66	(455)	25	18	37	--



What is claimed is:

1. A process for the preparation of methyl 4-pentenoate, said process comprising:
 - (a) contacting ethylene with methyl acrylate in an oxygen-free and water-free atmosphere in the presence of a nickel II catalyst complex of the structure $[QNiL_1L_2]^+X^-$ wherein
 - Q is η^3 carbon-based allyl or substituted allyl;
 - L_1 is a monodentate trisubstituted phosphine ligand represented by the formula $PR_1R_2R_3$, wherein each of R_1 , R_2 , and R_3 is independently a linear, branched, or cyclic monovalent hydrocarbon radical having 1-20 carbon atoms; with the proviso that any two of R_1 , R_2 , and R_3 taken together can form a ring, in which case each is a divalent radical;
 - L_2 is a weakly coordinating ligand;
 - X^- is a nonreactive anion that either does not coordinate with nickel or weakly coordinates therewith,
 in the optional presence of a solvent or diluent, wherein any liquid medium that may be present as a solvent or diluent is non-reactive under the conditions of this process and is either not capable of coordinating with nickel or is weakly coordinating therewith; and
 - (b) recovering the crude reaction product produced by said process.
2. The process of Claim 1 further including the step of separating methyl 4-pentenoate from the crude reaction product.
3. The process of Claim 1 wherein L_1 is selected from the group consisting of tricyclohexylphosphine, trimethylphosphine, and triphenylphosphine.
4. The process of Claim 1 wherein L_2 is selected from the group consisting of diethyl ether, tetrahydrofuran, and acetonitrile.
5. The process of Claim 1 wherein X^- is selected from the group consisting of $[B(3,5-(CF_3)_2C_6H_3)_4]^-$ and $[B(C_6F_5)_4]^-$.
6. The process of Claim 1 which is carried out at a pressure from atmospheric to about 689.5 kPa and at a temperature of about 0°C to 100°C.
7. The process of Claim 6 which is carried out at a pressure of about 96.5 to 379.2 kPa and at a temperature of about 15 to 60°C.
8. The process of Claim 1 wherein the nickel catalyst is selected from the group consisting of:
 - $(\eta^3-C_3H_5)Ni(PCy_3)(OEt_2)-BAR'_4^-$;
 - $(\eta^3-C_3H_5)Ni(PCy_3)(NCCH_3)^+BAR'_4^-$;
 - $(\eta^3-C_3H_5)Ni(P(2-CH_3OC_6H_4)_3)(NCCH_3)^+BAR'_4^-$; and





where Ar is 3,5-(CF₃)₂C₆H₃-, and Cy is cyclohexyl.

9. The process of Claim 1 wherein the nickel catalyst is formed *in situ* and is selected from the group consisting of:

- 5 $(\eta^3\text{-C}_3\text{H}_5)\text{Ni}(\text{PCy}_3)(\text{CH}_3) + \text{H}(\text{OEt}_2)_2^+\text{BAr}'_4^-;$
 $(\eta^3\text{-C}_3\text{H}_5)\text{Ni}(\text{COD}) + \text{BAr}'_4^-; + \text{PCy}_3;$ and
 $(\eta^3\text{-C}_3\text{H}_5)\text{Ni}(\text{COD}) + \text{BAr}'_4^- + \text{P}(2\text{-CH}_3\text{OC}_6\text{H}_4)_3;$
 where Cy = cyclohexyl, Ar' = 3,5-(CF₃)₂C₆H₃-, and COD =
 1,5-cyclooctadiene.

10 10. The process of Claim 8 wherein the nickel catalyst is
 $\eta^3\text{-C}_3\text{H}_5)\text{Ni}(\text{PCy}_3)(\text{OEt}_2)^+\text{BAr}'_4^-.$

11. The process of Claim 1 which is carried out in a solvent.

12. The process of Claim 11 wherein the solvent is an aprotic organic solvent.

15 13. The process of Claim 12 wherein the aprotic organic solvent is selected from the group consisting of monochlorobenzene, o-dichlorobenzene, methylene chloride, diethyl ether, and tetrahydrofuran.

14. The process of Claim 13 which is carried out in the atmosphere of nitrogen.

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