



US006995275B2

(12) **United States Patent**  
**Manzer**

(10) **Patent No.:** **US 6,995,275 B2**  
(45) **Date of Patent:** **Feb. 7, 2006**

(54) **PRODUCTION OF N-ARYL-2-LACTAM AND N-ALKYL-2-LACTAM BY REDUCTIVE AMINATION OF LACTONES WITH ARYL AND ALKYL NITRO COMPOUNDS**

(52) **U.S. Cl.** ..... **548/554; 548/552; 106/31.78**

(58) **Field of Classification Search** ..... **548/552, 548/554; 106/31.78**

See application file for complete search history.

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(56) **References Cited**

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U.S. PATENT DOCUMENTS

3,775,431	A	11/1973	Rodewald et al.
4,824,967	A	4/1989	Liu et al.
5,393,888	A	2/1995	Minnock et al.
5,538,985	A	7/1996	Iizuka et al.
6,248,902	B1	6/2001	Bertola
6,348,601	B2	2/2002	Ohlbach et al.
6,350,883	B1	2/2002	Chen et al.

(\*) **Notice:** Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 0 days.

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(21) **Appl. No.:** **10/935,940**

(22) **Filed:** **Sep. 8, 2004**

(65) **Prior Publication Data**

US 2005/0087101 A1 Apr. 28, 2005

(57) **ABSTRACT**

**Related U.S. Application Data**

(62) Division of application No. 10/396,213, filed on Mar. 24, 2003, now Pat. No. 6,828,277.

This invention relates to a process for producing N-aryl-2-lactams, N-alkyl-2-lactams, and N-cycloalkyl-2-lactams by reductive amination of lactones with aryl or alkyl nitro compounds utilizing a metal catalyst, which is optionally supported.

(51) **Int. Cl.**  
**C07D 207/12** (2006.01)  
**C09D 11/02** (2006.01)

**1 Claim, No Drawings**

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**PRODUCTION OF N-ARYL-2-LACTAM AND  
N-ALKYL-2-LACTAM BY REDUCTIVE  
AMINATION OF LACTONES WITH ARYL  
AND ALKYL NITRO COMPOUNDS**

This application is a divisional of application Ser. No. 10/396,213, filed Mar. 24, 2003, now U.S. Pat. No. 6,828,277.

**FIELD OF THE INVENTION**

This invention relates to a process for producing N-aryl-2-lactams, N-alkyl-2-lactams, and N-cycloalkyl-2-lactams by reductive amination of lactones with aryl or alkyl nitro compounds utilizing a metal catalyst, which is optionally supported.

**BACKGROUND OF THE INVENTION**

Lactams, and particularly pyrrolidones, are important constituents in many industrial applications, including as solvents in chemical reactions, components in ink and coating formulations, coating strippers in the electronics industry, formulating agents in crop protection products, and as intermediates in the production of pharmaceuticals. For example, N-cyclohexyl-2-pyrrolidone is used as a solvent or intermediate in many industrial applications, including the electronics industry (photo-resist stripping solutions), industrial cleaners, oil/gas well maintenance, and fiber dyeing. N-[2-hydroxyethyl]-2-pyrrolidone is useful in industrial cleaning, printing inks, and gasoline and oil additives. N-octyl-2-pyrrolidone is useful, for example, in the manufacture of agricultural products, as a detergent and dispersant, in industrial and metal cleaners, in printing inks and in fiber dyeing.

Pyrrolidone derivatives are generally prepared on an industrial scale by the catalytic or non-catalytic reaction of gamma butyrolactone with an alkyl amine or ammonia. For example, U.S. Pat. No. 4,824,967 describes a vapor phase process for the production of 2-pyrrolidone using  $\gamma$ -butyrolactone and ammonia at a temperature of 230–300° C. and a pressure of 0.35 MPa to 2.1 MPa. A magnesium silicate catalyst is used which needs to be separated and regenerated following the reaction, and which may trap considerable amounts of the product. U.S. Pat. No. 5,393,888 describes a liquid-phase process for producing 2-pyrrolidone from  $\gamma$ -butyrolactone and ammonia in the absence of a catalyst, but at high temperature and pressure; the reaction is carried out at 200–375° C. and 4.8 to 12.4 MPa. In U.S. Pat. No. 6,348,601, methanol is reacted with ammonia in the presence of a catalyst, and the resultant mixture of methyl amines is reacted with  $\gamma$ -butyrolactone to form N-methyl-2-pyrrolidone. The reaction temperatures are 300–500° C. and the pressures are 0.8 to 3.6 MPa. U.S. Pat. No. 6,248,902 describes a liquid-phase, non-catalytic process for the production of N-methyl-pyrrolidone from  $\gamma$ -butyrolactone and monomethylamine.

Aryl compounds have also been used as the amine in reactions with lactones. For example, U.S. Pat. No. 3,775,431 describes the synthesis of N-phenyl- $\gamma$ -methyl- $\gamma$ -butyrolactam from  $\gamma$ -methyl- $\gamma$ -butyrolactone and aniline in a reaction that is carried out at a temperature of 250° C. under a nitrogen atmosphere. U.S. Pat. No. 5,538,985 describes the synthesis of 1-(4-chlorophenyl)-2-pyrrolidone from a reac-

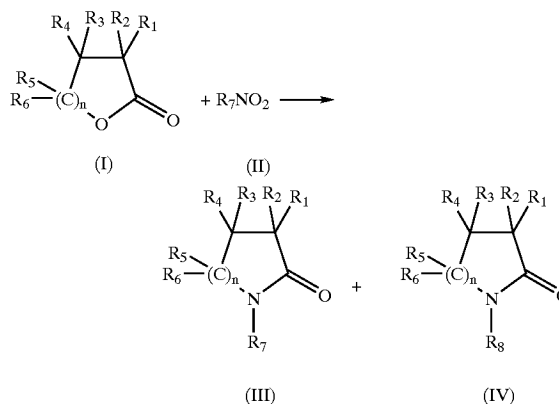
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tion of p-chloroaniline and  $\gamma$ -butyrolactone in the presence of hydrochloric acid; the reaction was carried out for 17 hours at temperatures up to 140° C.; the product was recovered in a multi-step process. U.S. Pat. No. 6,350,883 describes a gas-phase process for reacting lactones with amines or ammonia in the presence of aluminosilicate zeolites to produce lactams; the reactions are carried out at 180–400° C. and 0 to 1 MPa.

An efficient and low cost process for the production of aryl, alkyl and cycloalkyl lactams would be advantageous. The reactions described above do not use nitro compounds. Disclosed herein is a novel, one-step process for converting lactones to aryl, alkyl and cycloalkyl lactams using nitro compounds in the presence of catalysts.

**SUMMARY OF THE INVENTION**

The present invention relates to a process for preparing N-aryl-2-lactam (III), N-cycloalkyl-2-lactam (IV), or a mixture thereof, which comprises the step of contacting a lactone (I) with an aryl nitro compound (II) in the presence of a catalyst and hydrogen gas;



wherein:

(i) n=0–11;

(ii) R<sub>1</sub>, R<sub>2</sub>, R<sub>3</sub>, R<sub>4</sub>, R<sub>5</sub> and R<sub>6</sub> taken independently are hydrogen, hydrocarbonyl or substituted hydrocarbonyl, C<sub>1</sub> to C<sub>18</sub> unsubstituted or substituted alkyl, unsubstituted or substituted alkenyl, unsubstituted or substituted cycloalkyl, unsubstituted or substituted cycloalkyl containing at least one heteroatom, unsubstituted or substituted aryl, and unsubstituted or substituted heteroaryl;

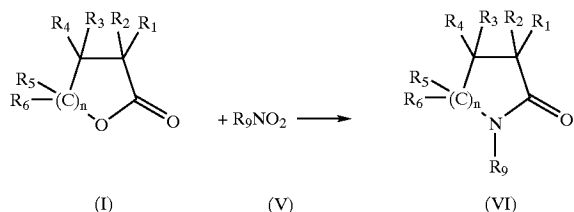
(iii) R<sub>7</sub> is an aromatic group having from 6 to 30 carbons, and R<sub>8</sub> is a fully or partially reduced derivative of R<sub>7</sub>;

(iv) N-aryl-2-lactam (III), N-cycloalkyl-2-lactam (IV), or a mixture thereof, may comprise 100% by weight of the total product formed, or wherein additional products may be produced; and

(v) the catalyst is selected from metals from the group consisting of palladium, ruthenium, rhodium, rhodium, iridium, platinum, nickel, cobalt, copper, iron, osmium; compounds thereof; and combinations thereof.

The present invention also relates to a process for preparing N-alkyl-2-lactam (VI) which comprises the step of contacting a lactone (I) with an alkyl nitro compound (V) in the presence of a catalyst and hydrogen gas;

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wherein:

(i) n=0-11;

(ii) R<sub>1</sub>, R<sub>2</sub>, R<sub>3</sub>, R<sub>4</sub>, R<sub>5</sub> and R<sub>6</sub> taken independently are hydrogen, hydrocarbyl or substituted hydrocarbyl, C<sub>1</sub> to C<sub>18</sub> unsubstituted or substituted alkyl, unsubstituted or substituted alkenyl, unsubstituted or substituted cycloalkyl, unsubstituted or substituted cycloalkyl containing at least one heteroatom, unsubstituted or substituted aryl, and unsubstituted or substituted heteroaryl;

(iii) R<sub>9</sub> is an alkyl group having from 1 to 30 carbons, and wherein R<sub>9</sub> may be C<sub>1</sub>-C<sub>30</sub> unsubstituted or substituted alkyl, C<sub>1</sub>-C<sub>30</sub> unsubstituted or substituted alkenyl, C<sub>1</sub>-C<sub>30</sub> unsubstituted or substituted alkynyl, C<sub>3</sub>-C<sub>30</sub> unsubstituted or substituted cycloalkyl, or C<sub>3</sub>-C<sub>30</sub> unsubstituted or substituted cycloalkyl containing at least one heteroatom;

(iv) N-alkyl-2-lactam (VI) may comprise 100% by weight of the total product formed, or wherein additional products may be produced; and

(v) the catalyst is selected from metals from the group consisting of palladium, ruthenium, rhenium, rhodium, iridium, platinum, nickel, cobalt, copper, iron, osmium; compounds thereof; and combinations thereof.

#### DETAILED DESCRIPTION OF THE INVENTION

By "aryl nitro compound" is meant the compound having the formula R—NO<sub>2</sub> wherein R is an aromatic group.

"Heteroaryl" refers to unsaturated rings of 5 or 6 atoms containing one or two O and S atoms and/or one to four N atoms provided that the total number of hetero atoms in the ring is 4 or less, or bicyclic rings wherein the five or six membered ring containing O, S, and N atoms as defined above is fused to a benzene or pyridyl ring. Common examples are furan and thiophene.

By "catalyst" is meant a substance that affects the rate of the reaction but not the reaction equilibrium, and emerges from the process chemically unchanged.

By "metal catalyst" is meant a catalyst that is comprised of at least one metal, at least one Raney metal, compounds thereof or combinations thereof.

By "promoter" is meant an element of the Periodic Table that is added to enhance the physical or chemical function of the catalyst. The promoter can also be added to retard undesirable side reactions and/or affect the rate of the reaction.

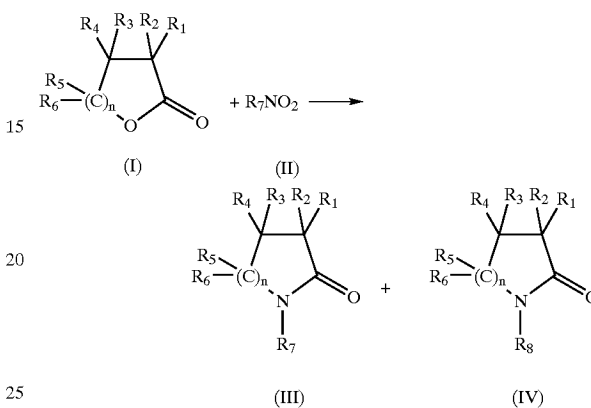
By "metal promoter" is meant a metallic compound that is added to enhance the physical or chemical function of a catalyst. The metal promoter can also be added to retard undesirable side reactions and/or affect the rate of the reaction.

By "fully or partially reduced derivative" of an aryl compound is meant a compound that can be derived from the parent compound by saturating or reducing one or more of the unsaturated bonds in the aromatic ring. Unsaturated

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compounds are compounds that contain one or more carbon to carbon double or triple bonds. For example, a fully reduced derivative of a phenyl group is a cyclohexyl group.

This invention relates to the synthesis of 5-methyl-N-aryl-2-lactam (III), 5-methyl-N-cycloalkyl-2-lactam (IV) or a mixture thereof, from a reaction between a lactone (I) and an aryl nitro compound (II) in the presence of a catalyst and hydrogen gas;



wherein:

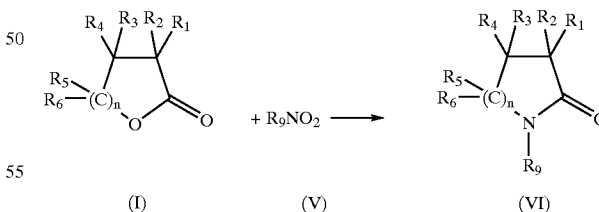
(i) n=0-11;

(ii) R<sub>1</sub>, R<sub>2</sub>, R<sub>3</sub>, R<sub>4</sub>, R<sub>5</sub> and R<sub>6</sub> taken independently are hydrogen, hydrocarbyl or substituted hydrocarbyl, C<sub>1</sub> to C<sub>18</sub> unsubstituted or substituted alkyl, unsubstituted or substituted alkenyl, unsubstituted or substituted cycloalkyl, unsubstituted or substituted cycloalkyl containing at least one heteroatom, unsubstituted or substituted aryl, and unsubstituted or substituted heteroaryl;

(iii) R<sub>7</sub> is an aromatic group having from 6 to 30 carbons, and R<sub>8</sub> is a fully or partially reduced derivative of R<sub>7</sub>; and

(iv) N-aryl-2-lactam (III), N-cycloalkyl-2-lactam (IV), or a mixture thereof, may comprise 100% by weight of the total product formed, or wherein additional products may be produced.

In addition, this invention relates to the synthesis of N-alkyl-2-lactam (VI) from a reaction between a lactone (I) and an alkyl nitro compound (V) in the presence of a catalyst and hydrogen;



wherein:

(i) n=0-11;

(ii) R<sub>1</sub>, R<sub>2</sub>, R<sub>3</sub>, R<sub>4</sub>, R<sub>5</sub> and R<sub>6</sub> taken independently are hydrogen, hydrocarbyl or substituted hydrocarbyl, C<sub>1</sub> to C<sub>18</sub> unsubstituted or substituted alkyl, unsubstituted or substituted alkenyl, unsubstituted or substituted cycloalkyl, unsubstituted or substituted cycloalkyl containing at least one heteroatom, unsubstituted or substituted aryl, and unsubstituted or substituted heteroaryl;

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(iii)  $R_9$  is an alkyl group having from 1 to 30 carbons, and wherein  $R_9$  may be  $C_1-C_{30}$  unsubstituted or substituted alkyl,  $C_1-C_{30}$  unsubstituted or substituted alkenyl,  $C_1-C_{30}$  unsubstituted or substituted alkynyl,  $C_3-C_{30}$  unsubstituted or substituted cycloalkyl, or  $C_3-C_{30}$  unsubstituted or substituted cycloalkyl containing at least one heteroatom; and

(iv) N-alkyl-2-lactam (VI) may comprise 100% by weight of the total product formed, or wherein additional products may be produced.

A catalyst, with or without a support, may be present in the processes of the invention to effect the amination reactions. A promoter may optionally be used to aid the reactions. The promoter can be a metal.

The processes of the present invention may be carried out in batch, sequential batch (i.e., a series of batch reactors) or in continuous mode in any of the equipment customarily employed for continuous process (see for example, H. S. Fogler, *Elementary Chemical Reaction Engineering*, Prentice-Hall, Inc., NJ, USA). The condensate water formed as the product of the reaction is removed by separation methods customarily employed for such separations, such as distillation.

A preferred embodiment of the invention is one in which  $n=1$  to 7, and  $R_1, R_2, R_3, R_4, R_5$  and  $R_6$  taken independently are hydrogen or alkyl. A more preferred embodiment is one in which  $n=1$ ,  $R_5$  is hydrogen or methyl, and  $R_1, R_2, R_3, R_4$ , and  $R_6$  are hydrogen.

The aryl and cycloalkyl groups represented by  $R_7$  and  $R_8$  preferably have from 6 to 30 carbons. More preferably, the aryl and cycloalkyl groups represented by  $R_7$  and  $R_8$  have from 6 to 12 carbons. The unsubstituted or substituted alkyl or cycloalkyl group represented by  $R_9$  preferably has from 1 to 30 carbons. More preferably the unsubstituted or substituted alkyl or cycloalkyl group represented by  $R_9$  has from 1 to 12 carbons.

In the processes of the invention, a molar ratio of aryl or alkyl nitro compound to lactone of from about 0.01/1 to about 100/1 is preferred at the start of the reaction. A molar ratio of aryl or alkyl nitro compound to lactone of from about 0.1/1 to about 10/1 is further preferred at the start of the reaction.

A temperature range of from about 50° C. to about 350° C. is preferred for the processes of the invention. A temperature range of from about 75° C. to about 300° C. is further preferred.

A pressure range of from about 0.3 MPa to about 20 MPa is employed for the processes of the invention. A pressure range of from about 1.3 MPa to about 7.6 MPa is preferred.

The reactions of the present invention can be performed in non-reacting solvent media such as water, alcohols, ethers, and lactams. Alternatively, the excess of aryl or alkyl nitro compound can also act as the solvent medium.

The catalyst useful in the invention is a substance that affects the rate of the reaction but not the reaction equilibrium, and emerges from the process chemically unchanged. A chemical promoter generally augments the activity of a catalyst. The promoter herein may be incorporated into the catalyst during any step in the chemical processing of the catalyst constituent. The chemical promoter generally enhances the physical or chemical function of the catalyst agent, but can also be added to retard undesirable side reactions.

The processes of the invention involve reductive amination of lactones with aryl or alkyl nitro compounds, which is effected in the presence of a catalyst. The principal component of the catalyst useful herein is selected from metals from the group consisting of palladium, ruthenium,

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rhenium, rhodium, iridium, platinum, nickel, cobalt, copper, iron, osmium; compounds thereof; and combinations thereof.

A promoter may be used optionally in the reactions of the present invention. The promoter herein may be incorporated into the catalyst during any step in the chemical processing of the catalyst constituent. Suitable promoters for the processes of the invention include metals selected from tin, zinc, copper, gold, silver, and combinations thereof. The preferred metal promoter is tin. Other promoters that can be used are elements selected from Group 1 and Group 2 of the Periodic Table.

The catalyst used in the process may be supported or unsupported. A supported catalyst is one in which the active catalyst agent is deposited on a support material by a number of methods, such as spraying, soaking or physical mixing, followed by drying, calcination, and if necessary, activation through methods such as reduction or oxidation. Materials frequently used as a support are porous solids with high total surface areas (external and internal) which can provide high concentrations of active sites per unit weight of catalyst. The catalyst support may enhance the function of the catalyst agent. A supported metal catalyst is a supported catalyst in which the catalyst agent is a metal.

A catalyst that is not supported on a catalyst support material is an unsupported catalyst. An unsupported catalyst may be platinum black or a Raney catalyst. The term "Raney catalyst" as used herein refers to catalysts that have a high surface area due to selectively leaching an alloy containing the active metal(s) and a leachable metal (usually aluminum). The term Raney catalyst is not meant to denote any particular source of the material. Raney catalysts have high activity due to the higher specific area and allow the use of lower temperatures in hydrogenation reactions. The active metals of Raney catalysts include nickel, copper, cobalt, iron, rhodium, ruthenium, rhenium, osmium, iridium, platinum, palladium; compounds thereof; and combinations thereof.

Promoter metals may also be added to the base Raney metals to affect selectivity and/or activity of the Raney catalyst. Promoter metals for Raney catalysts may be selected from transition metals from Groups IIIA through VIIIA, IB and IIB of the Periodic Table of the Elements. Examples of promoter metals include chromium, molybdenum, platinum, rhodium, ruthenium, osmium, and palladium, typically at about 2% by weight of the total metal.

The catalyst support useful herein can be any solid, inert substance including, but not limited to, oxides such as silica, alumina and titania; barium sulfate; calcium carbonate; and carbons. The catalyst support can be in the form of powder, granules, pellets, or the like.

A preferred support material of the invention is selected from the group consisting of carbon, alumina, silica, silica-alumina, silica-titania, titania, titania-alumina, barium sulfate, calcium carbonate, strontium carbonate, compounds thereof and combinations thereof. Supported metal catalysts can also have supporting materials made from one or more compounds. More preferred supports are alumina, silica, titania and carbon. Further preferred supports are carbons with a surface area greater than 100 m<sup>2</sup>/g. A further preferred support is carbon with a surface area greater than 200 m<sup>2</sup>/g. Preferably, the carbon has an ash content that is less than 5% by weight of the catalyst support; the ash content is the inorganic residue (expressed as a percentage of the original weight of the carbon) which remains after incineration of the carbon.

Commercially available carbons which may be used in this invention include those sold under the following trademarks; Bameby & Sutcliffe™, Darco™, Nuchar™, Columbia JXN™, Columbia LCK™, Calgon PCB™, Calgon BPL™, Westvaco™, Norit™ and Barnaby Cheny NB™. The carbon can also be commercially available carbon such as Calscat C, Sibunit C, or Calgon C (commercially available under the registered trademark Centaur®).

In the processes of the invention, the preferred content of the metal catalyst in the supported catalyst is from about 0.1% to about 20% of the supported catalyst based on metal catalyst weight plus the support weight. A more preferred metal catalyst content range is from about 1% to about 10% of the supported catalyst. A further preferred metal catalyst content range is from about 3% to about 7% of the supported catalyst.

Combinations of catalyst and support system may include any one of the metals referred to herein with any of the supports referred to herein. Preferred combinations of catalyst and support include palladium on carbon, palladium on calcium carbonate, palladium on barium sulfate, palladium on alumina, palladium on silica, palladium on titania, platinum on carbon, platinum on alumina, platinum on silica, iridium on silica, iridium on carbon, iridium on alumina, rhodium on carbon, rhodium on silica, rhodium on alumina, nickel on carbon, nickel on alumina, nickel on silica, ruthenium on carbon, ruthenium on silica, ruthenium on alumina, ruthenium on carbon, ruthenium on alumina, ruthenium on silica and combinations thereof.

Further preferred combinations of catalyst and support include palladium on carbon, palladium on titania, platinum on carbon, iridium on carbon, rhodium on carbon, ruthenium on carbon, ruthenium on carbon and combinations thereof.

The compounds produced by the processes of the current invention display properties that are useful in diverse applications. N-alkyl pyrrolidones with alkyl chains up to about 8 carbons function as aprotic chemical solvents with a lower toxicity profile than other solvents. The carbon chains of N-lower pyrrolidones are not long enough to allow micelle formation in water; thus these compounds do not exhibit significant surfactant properties. N-alkyl pyrrolidones with alkyl groups of about C<sub>8</sub> to C<sub>14</sub> exhibit surfactant properties, and pyrrolidones with longer N-alkyl chains act as complexing agents. The surface active properties of alkyl pyrrolidones, such as solubility, wetting, viscosity building, emulsifying and complexing are described in U.S. Pat. No. 5,294,644. N-alkyl pyrrolidones can also be used for concentrating colloidal particles. Due to their solvent, surfactant and complexing properties, pyrrolidones are very useful in the manufacture of pharmaceuticals, personal care products, and industrial, agricultural and household chemicals and products.

The lactams produced by the processes of the invention are useful in preparing pharmaceutical products for use on humans, animals, reptiles, and fish. The pyrrolidones disclosed herein are particularly useful in topical formulations, such as ointments, creams, lotions, pastes, gels, sprays, aerosols, lotions, shampoos, foams, creams, gels, ointments, salves, milks, sticks, sprays, balms, emulsions, powders, solid or liquid soaps, or oils. Pyrrolidones, such as 5-methyl-2-pyrrolidones, can be used to enhance the transdermal penetration of active components into human or animal tissues and systems. Pyrrolidones can also act as solubilizers to enhance the solubility of a therapeutic agent in the carrier system.

The pyrrolidones produced by the processes of the invention may also be incorporated into matrix systems, such as

patches, for the transdermal administration of, for example, an antimicrobial, a hormone, or an anti-inflammatory. The methods of preparation of pharmaceutical compositions are as commonly practiced in the pharmaceutical industry are useful with the processes of the invention. For discussion of such methods, see, for example, Remington's Pharmaceutical Sciences (AR Gennaro, ed., 20<sup>th</sup> Edition, 2000, Williams & Wilkins, PA) incorporated herein by reference.

The pyrrolidones made by the processes of the invention may be used as solvents or surfactants in liquid, gel or aerosol cleaning compositions for cleaning a wide range of surfaces, including textiles, such as clothing, fabrics and carpets, and hard surfaces, such as glass, metal, ceramics, porcelain, synthetic plastics and vitreous enamel. The pyrrolidones may also be used in formulations for disinfecting hard surfaces, such as in the household, or in institutional or hospital environments, or the surface of skin, or fabric surfaces, or in the food preparation, restaurant or hotel industries. In addition, cleaning compositions are useful for the removal of industrial soils, such as dirt, grease, oil, ink and the like. The pyrrolidones may also be used as solvents in compositions for cleaning, solvating, and/or removing plastic resins or polymers from manufactured articles or manufacturing equipment.

In addition to pyrrolidones, other components may be included in cleaning compositions. These additional components include nonionic surfactants, anionic surfactants, cationic surfactants, amphoteric surfactants and solvents. Illustrative nonionic surfactants are alkyl polyglycosides, such as Glucocon (Henkel Corporation), ethylene oxide and mixed ethylene oxide/propylene oxide adducts of alkylphenols, the ethylene oxide and mixed ethylene oxide/propylene oxide adducts of long chain alcohols or of fatty acids, mixed ethylene oxide/propylene oxide block copolymers, esters of fatty acids and hydrophilic alcohols, such as sorbitan monooleate, alkanolamides, and the like.

Illustrative anionic surfactants are the soaps, higher alkylbenzene sulfonates containing from 9 to 16 carbons in the higher alkyl group in a straight or branched chain, C<sub>8</sub>-C<sub>15</sub> alkyl toluene sulfonates, C<sub>8</sub>-C<sub>15</sub> alkyl phenol sulfonates, olefin sulfonates, paraffin sulfonates, alcohol and alcohol-ether sulfates, phosphate esters, and the like.

Illustrative cationic surfactants include amines, amine oxides, alkylamine ethoxylates, ethylenediamine alkoxyates such as the Tetronic® series from BASF Corporation, quaternary ammonium salts, and the like.

Illustrative amphoteric surfactants are those which have both acidic and basic groups in their structure, such as amino and carboxyl radicals or amino and sulfonic radicals, or amine oxides and the like. Suitable amphoteric surfactants include betaines, sulfobetaines, imidazolines, and the like.

Illustrative solvents include glycols, glycol ethers, aliphatic alcohols, alkanolamines, pyrrolidones and water.

Such surfactants and solvents are described, for example, in McCutcheon's (2002), Volume 1 (Emulsifiers and Detergents) and Volume 2 (Functional Materials), The Manufacturing Confectioner Publishing Co., Glen Rock, N.J.

Cleaning compositions may also include additional components, such as chelating agents, corrosion inhibitors, antimicrobial compounds, buffering and pH adjusting agents, fragrances or perfumes, dyes, enzymes and bleaching agents.

N-alkyl-2-pyrrolidones are useful in cleaning and stripping formulations which are used to remove (or strip) a photoresist film (or other similar organic polymeric material film) or layer from a substrate, or to remove or clean various types of plasma-etch residues from a substrate. N-alkyl-2-

pyrrolidones are also useful as surfactants in cleaning formulations for removing solder pastes from printing applicators and circuit assemblies.

N-alkyl-2-pyrrolidones, such as 5-methyl-N-octyl-2-pyrrolidone and 5-methyl-N-dodecyl-2-pyrrolidone, may be included as components in ink jet inks in order to improve resistance to highlighter smear when printed into an image, lead to an even print (minimize the degree of banding) and impart an improved waterfast resistance and/or a better dry or wet rub property. 2-Pyrrolidones, such as 5-methyl-N-cyclohexyl-2-pyrrolidone or 5-methyl-N-methyl-2-pyrrolidone, may also be used as a solvent in the preparation of hot melt or phase change inks for color printing.

The pyrrolidones made by the processes of the invention can also be utilized in the manufacture of agrochemicals, including but not limited to herbicides, insecticides, fungicides, bactericides, nematocides, algicides, molluscicides, virucides, compounds inducing resistance to plants, repellants of birds, animals and insects, and plant growth regulators, or mixtures thereof. The method of manufacture comprises contacting an agrochemically effective agent as known to persons skilled in the art with at least one of the pyrrolidones produced by any of the methods of the invention. The agrochemical composition can optionally comprise additional auxiliary components as are commonly used in the agrochemical industry.

Pyrrolidones, such as 5-methyl-N-methyl pyrrolidone and 5-methyl-N-cyclohexyl pyrrolidone, can be used as water insoluble polar co-solvents to solubilize water insoluble pesticides and other agrochemicals and increase the effective amount of active ingredient. N-alkyl pyrrolidones, preferably N—C<sub>3-15</sub> alkyl pyrrolidones, in particular 5-methyl-N-octyl pyrrolidone and 5-methyl-N-dodecylpyrrolidone, can be used as nonionic surfactants that aid as emulsifiers. Plant growth regulators are used to improve the economic yield of agricultural plants. 5-Methyl-N-octyl pyrrolidone and 5-methyl-N-dodecyl pyrrolidone can be utilized as solvents in emulsions containing plant growth regulators.

In addition, pyrrolidones can be utilized in liquid or aerosol formulations for dermal application of insect repellants by humans; examples include mosquito and tick repellants. Manufacture of such insect repellants comprises contacting an effective amount of at least one insect repelling agent with at least one product produced using at least one process of the invention.

Pyrrolidones, such as 5-methyl-N-methyl-2-pyrrolidone, can also be used in antimicrobial formulations for the preservation of animal silage.

5-Methyl-N-alkyl-2-pyrrolidones can also be used as part of a more environmentally-conscious method for dry-cleaning clothing that includes a surfactant and densified carbon dioxide in place of traditional solvents.

In addition, 5-methyl-2-pyrrolidones can be used as components in a protective composition for use on painted surfaces, such as cars. The pyrrolidones function to wet the surface and promote spreadability of the protectant.

Different plastic materials are often not miscible, resulting in products that exhibit insufficient mechanical properties. Monomeric and polymeric 5-methyl-pyrrolidone-containing compounds can be used as compatibilizers for plastic compositions; the compatibilizers attach themselves to the interface between the polymers involved, or penetrate into the polymers, thereby improving the adhesion between the polymers and enhancing mechanical properties.

5-Methyl-N-pyrrolidones can also be used as compatibilizers in the refrigeration and air conditioning industries. Transitioning from chlorofluorocarbon to hydrofluorocarbon

refrigerants has necessitated the use of a new class of lubricants due to immiscibility with conventional lubricants such as mineral oil, poly  $\alpha$ -olefin and alkylbenzene. However the new class of lubricants is expensive and also very hygroscopic. Absorption of water leads to acid formation and corrosion of the refrigeration system, as well as the formation of sludges. The lack of solubility of the hydrofluorocarbons in the conventional lubricants results in a highly viscous lubricant in the non-compressor zones, and results in insufficient lubricant return to the compressor. This can eventually result in a number of problems, including the compressor overheating and seizing and insufficient heat transfer in the refrigeration system. Compatibilizers solubilize the polar halogenated hydrocarbon refrigerant and the conventional non-polar lubricant in the non-compressor zones, which results in efficient return of lubricant to the compressor zone. Compatibilizers may include the 5-methyl-N-alkyl- and 5-methyl-N-cycloalkyl-2-pyrrolidones.

Pyrrolidones can also be used as fuel and lubricant additives. For example, N-alkyl-2-pyrrolidones can be used as detergents and dispersants in fuel additive compositions to keep valves, carburetors and injection systems clean, thereby improving the combustion characteristics and reducing deposits, thus reducing air polluting emissions. In addition, 5-methyl-N-methyl-2-pyrrolidone can be used to remove unsaturated hydrocarbons from raw lube distillates or deasphalted residual lube stocks to produce solvent-refined base oils as lubricants.

Methods for the preparation of cleaning, stripping, agrochemical and plastic formulations are well known to persons skilled in the art. Similarly, methods for the preparation of insect repellants, ink jet inks, protective formulations for paint, fuel additives and lubricants, refrigeration and air conditioning lubricants, and for dry cleaning are well known in the art. Pyrrolidones can act as solvents, surfactants, dispersants, detergents, emulsifiers, viscosity builders and complexing agents in these formulations. Appropriate pyrrolidones are selected based on standard screening procedures for product performance. Additional components, such as pharmaceutical or agrochemical active agents or colorants, may be added to specific formulations as the main functional component; the nature of the functional component or components would be determined by the specific use. Auxiliary components, which enhance or are critical to the efficacy of the formulation, may also be added. Auxiliary components may include solvents or cosolvents, thickeners, antioxidants, spreading agents, preservatives, adhesives, emulsifiers, defoamers, humectants, dispersants, surfactants, suitable carriers, matrix systems, delivery vehicles, fragrances, salts, esters, amides, alcohols, ethers, ketones, acids, bases, alkanes, silicone, evaporation modifiers, paraffins, aliphatic or aromatic hydrocarbons, chelating agents, gases for aerosols, propellants or for dry cleaning, oils and water. Appropriate auxiliary components for the uses described herein are known to persons skilled in the art.

The following examples are illustrative of the invention. Examples 1 to 10 are actual examples; Examples 11 to 16 are prophetic.

## EXAMPLES

The following abbreviations are used:

ESCAT-XXX: Series of catalysts provided by Engelhard Corp. (Iselin, N.J.)

Calsicat Carbon: Catalyst support from Engelhard Corp. (lot S-96-140)

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JM-XXXX: Series of catalysts from Johnson Matthey, Inc. (W. Deptford, N.J.)

ST-XXXX-SA: Series of catalysts from Strem Chemicals (Newburyport, Mass.)

SCCM: Standard cubic centimeters per minute

GC: Gas chromatography

GC-MS: Gas chromatography-mass spectrometry

For catalyst preparation a commercially available support such as carbon, alumina, silica, silica-alumina or titania was impregnated by incipient wetness with a metal salt. The catalyst precursors used were  $\text{NiCl}_2 \cdot 6\text{H}_2\text{O}$  (Alfa Chemical Co., Ward Hill, Mass.),  $\text{Re}_2\text{O}_7$  (Alfa Chemical Co.),  $\text{PdCl}_2$  (Alfa Chemical Co.),  $\text{IrCl}_3 \cdot 3\text{H}_2\text{O}$  (Alfa Chemical Co.),  $\text{RuCl}_3 \cdot x\text{H}_2\text{O}$  (Alrich Chemical Co., Milwaukee, Wis.),  $\text{H}_2\text{PtCl}_6$  (Johnson Matthey, Inc.),  $\text{RhCl}_3 \cdot x\text{H}_2\text{O}$  (Alfa Chemical Co.) and  $\text{IrCl}_3 \cdot 3\text{H}_2\text{O}$  (Alfa Chemical Co.). The samples were dried and reduced at 300–450° C. under  $\text{H}_2$  for 2 hours.

Raney catalysts are available from W. R. Grace & Co. (Columbia, Md.). Butyrolactone, valerolactone, nitropropane, nitrobenzene and dioxane are available from Fisher Scientific (Chicago, Ill.).

Catalyst Preparation: 5% Pt on Acid Washed Calsicat Carbon

In a 150 ml beaker, a solution was made up of 4.5 ml 0.3 M  $\text{H}_2\text{PtCl}_6$  with 4.0 ml deionized  $\text{H}_2\text{O}$ . To the beaker were added 4.75 g Calsicat Acid Washed Carbon (12×20 mesh, dried at 120° C. overnight). The slurry was allowed to stand at room temperature for 1 hr with occasional stirring, followed by drying at 120° C. overnight with frequent stirring (until free flowing).

In an alumina boat, in a quartz lined tube furnace, the catalyst was purged with 500 SCCM  $\text{N}_2$  at room temperature for 15 min and then with 100 SCCM He at room temperature for 15 min. The catalyst was heated to 150° C. and held at 150° C. under He for 1 hr. At this point, 100 SCCM  $\text{H}_2$  were added and the sample was held at 150° C. under He and  $\text{H}_2$  for 1 hr. The temperature was increased to 300° C. and the catalyst was reduced at 300° C. under He— $\text{H}_2$  for 8 hrs. The  $\text{H}_2$  was stopped, the sample was held at 300° C. under He for 30 min and then cooled to room temperature in flowing He. The catalyst was finally passivated in 1.5%  $\text{O}_2$  in  $\text{N}_2$  at 500 SCCM for 1 hr at room temperature and weighed 4.93 g when unloaded.

Additional catalysts used in the present invention were prepared following a similar procedure.

Batch Reduction of Gamma Valerolactone to 5-Methyl-N-Aryl-2-Pyrrolidone and 5-Methyl-N-Cycloalkyl-2-Pyrrolidone

To a 5 ml pressure vessel was added 50 gm of catalyst, and 1 gm of a solution containing 30 wt % gamma valerolactone, 37% aryl nitro compound and 33% dioxane. The vessel was sealed, charged with 5.52 MPa hydrogen and heated to 225° C. for 4 hours. The pressure was maintained at 5.52 MPa during the course of the reaction. At the end of the reaction, the vessel was rapidly cooled in ice, vented and an internal GC standard of methoxyethylether was added. The solution was separated by pipette from the catalyst and analyzed by GC-MS using an HP 6890 (Agilent; Palo Alto, Calif.) equipped with a FFAP 7717 (30 meter) column. The results set forth in the tables below are based on area %.

The examples described below were performed according to a similar procedure under the conditions indicated for each example.

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Examples 1–6

Preparation of 5-Methyl-N-Propyl-2-Pyrrolidone (PrP) by Batch Reduction of Butyrolactone (BL) Using Nitropropane (NP) as the Alkyl Nitro Compound

The reactions were carried out for 4 hrs. at a temperature and pressure of 150° C. and 5.52 MPa, respectively. The feedstock was butyrolactone/nitropropane/dioxane at a ratio (weight %) of 40/21/39. The results are set forth in the following table.

Ex. No.	Catalyst/Support <sup>a</sup>	BL Conversion (%)	PrMP Selectivity (%)
1	5% Pd/C (ESCAT-142)	83.1	92.5
2	5% Pt/C ESCAT-248)	79.2	89.7
3	5% Ru/C (ST-141060-SA)	99.7	30.5
4	5% Rh/C (JM-11761)	100.0	65.1
5	5% Re/C (Fisher)	9.9	0.0
6	5% Ir/Calsicat C	79.6	75.0

<sup>a</sup>Source for commercially available catalyst/support is in parentheses.

## Examples 7–10

Preparation of 5-Methyl-N-Phenyl-2-Pyrrolidone (PhMP) and 5-Methyl-N-Cyclohexyl-2-Pyrrolidone (CHMP) by Batch Reduction of Valerolactone (VL) Using Nitrobenzene (NB) as the Aryl Nitro Compound

The reactions were carried out for 4 hrs. at a temperature and pressure of 225° C. and 5.52 MPa, respectively. The feedstock was valerolactone/nitrobenzene/dioxane at a ratio (weight %) of 30/37/33. The results are set forth in the following table.

Ex. No.	Catalyst/Support <sup>a</sup>	VL Conversion (%)	PhMP Selectivity (%)	CHMP Selectivity (%)
7	5% Pd/C (ESCAT-142)	16.0	1.5	27.9
8	5% Pt/C (ESCAT-248)	8.8	25.2	31.1
9	5% Rh/C (JM-11761)	14.1	3.6	45.0
10	5% Ru/C (ESCAT-440)	73.3	0.4	26.5

<sup>a</sup>Source for commercially available catalyst/support is in parentheses.

## Example 11

## Pharmaceutical Formulations

## A) Topical Formulation:

Solubilizer (diethylene glycol monoethyl ether)	2% to 50%
Skin permeation enhancer (N-hydroxyethyl-2-pyrrolidone)	2% to 50%
Emulsifier	2% to 20%
Emollient (propylene glycol)	2% to 20%
Preservative	0.01 to 0.2%
Active agent	0 to 25%
Carrier	Balance

B) Cream:	
Phase 1:	
Polyethylene glycol and ethylene glycol palmitostearate	5%
Caprylic/capric triglycerides	5%
Oleoyl macroglycerides (Labrafil M 1944CS)	4%
Cetyl alcohol	5.5%
PPG-2 myristyl ether propionate (Crodamol PMP)	6%
5-methyl-N-hydroxyethyl-2-pyrrolidone	2%
Phase 2:	
Xanthan gum	0.3%
Purified water	55%
Phase 3:	
Propylene glycol	1%
Methylparaben	0.18%
Propylparaben	0.02%
Phase 4:	
Naftifine hydrochloride (antifungal)	1%
Diethylene glycol monoethyl ether (Transcutol)	15%

Procedure:

Xanthan gum is dispersed in water and allowed to stand. Phase 1 components and phase 2 components are separately heated to 75° C.; phase 1 is mixed into phase 2 under high speed agitation. The temperature is maintained at 75° C. while stirring for 10 min. The mixture is then slowly cooled while stirring at low speed. At 40° C., phase 3 is added. Naftifine is then mixed well into the Transcutol, and the mixture is added to the cream, mixed well and the cream is cooled to room temperature.

C) Transdermal Patch Formulation:	
Ketoprofen	0.3%
Polysorbate 80	0.5%
5-Methyl-N-methyl-2-pyrrolidone	1%
5-Methyl-N-ethyl-2-pyrrolidone	2%
PEG 400	10%
CMC-Na	4%
Na-polyacrylate	5.5%
Sanwet 1M-1000PS	0.5%
Polyvinyl alcohol	1%
PVP/VA copolymer	3%

Example 12

Cleaning Compositions

A) Grease Removal Formulation:	
Water	89%
Potassium carbonate	1%
Potassium bicarbonate	5%
5-Methyl-N-octyl-2-pyrrolidone	2.5%
Deriphatec 151-C (Henkel Corp.)	2.5%

B) Oil-in-Water Emulsion in Aerosol Form:	
Crillet 45 (Croda)	3.30%
Monamulse DL 1273 (Mona Industries, Inc.)	3.30%
5-Methyl-N-dodecyl-2-pyrrolidone	5.50%
Denatured absolute ethanol 100 AG/F3 (CSR Ltd.)	15.40%
Norpar 15 (Exxon)	5.50%
Deionized water	44.10%
Butane	16.95%
Propane	5.95%

C) All-Purpose Liquid Cleaning Composition:	
Neodol 91-8 (Shell)	3.5%
Linear alkyl (C9-13) benzene sulfonate, Mg salt	10.5%
Propylene glycol mono-t-butyl ether	4.0%
Coco fatty acid	1.4%
5-Methyl-N-decyl-2-pyrrolidone	1.0%
Magnesium sulfate heptahydrate	5.0%
Water	74.6

D) Shower-Rinsing Composition:	
Glucopon 225 (Henkel Corp.)	2.0%
Isopropyl alcohol	2.2%
Sequestrene 40 (45%, Ciba)	1.0%
Fragrance	0.02%
Barquat 4250Z (50%, Lonza)	0.2%
5-Methyl-N-octyl-2-pyrrolidone	1.0%
Water	93.58%

E) Dishwashing Composition:	
Ethanol (95%)	8.6%
Alfonic 1412-A [Ethylene oxide sulfate (59.3%)]	22.5%
Alfonic 1412-10	1.1%
Sodium chloride	0.9%
5-Methyl-N-decyl-2-pyrrolidone	7.5%
Water	59.4%

F) Aqueous Antimicrobial Cleaning Composition:	
Adipic acid	0.40%
Dacpon 27-23 AL (Condea; C <sub>12-14</sub> sodium alkyl sulfate, 28% active)	0.15%
Isopropyl alcohol	1.8%
Dowanol PnB (Dow; propylene glycol mono-N-butyl ether)	0.30%
5-Methyl-N-octyl-2-pyrrolidone	0.4%
Sodium hydroxide	0.05%
Water	96.9%

An antimicrobial wipe can be made by impregnating a substrate with the above composition; the substrate can be spunlace comprising viscose/polyester at a ratio of 70:30 with a specific weight of 50 grams/m<sup>2</sup>. The composition to substrate ratio is about 2.6:1.



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G) Disinfectant:	
Benzalkonium chloride	5%
Sodium carbonate	2%
Sodium citrate	1.5%
Nonoxynol 10	2.5%
5-Methyl-N-octyl-2-pyrrolidone	5%
Water	84%

H) Anti-Parasitidal Agent (for dermal application to animals):	
Antiparasitidal agent	1 to 20%
5-Methyl-N-isopropyl-2-pyrrolidone	30%
Benzyl alcohol (preservative)	3%
Thickener	0.025–10%
Colorant	0.025–10%
Emulsifier	0.025–10%
Water	Balance

## Example 13

## Stripping/Cleaning Formulation

5-Methyl-N-methyl-2-pyrrolidone	30%
Monoethanolamine	55%
Lactic acid	5%
Water	10%

## Example 14

## Ink Jet Ink

CAB-O-JET 300 (Active)	4%
Diethylene glycol	17.5%
5-Methyl-N-octyl-2-pyrrolidone	2.5%
Deionized H <sub>2</sub> O	76%

## Example 15

## Agrochemical Compositions

A) Composition for the Control of Insects:	
Permethrin	2%
5-Methyl-N-decyl-2-pyrrolidone	3%
Dimethyl dipropyl naphthalene	7%
Lauryl alcohol	5%
Hymal 1071 (Matsumoto Yushi Seiyaku, Inc.)	10%
Hytanol N-08 (Daiichi Kogyo Seiyaku, Inc.)	2%
Polyoxyethylene glycol	71%

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B) Pesticide Formulation:	
5-Methyl-N-alkyl pyrrolidone	48%
Sodium dodecyl sulfate	12%
Agrimer AL25	10%
Rodeo (pesticide; Monsanto)	1%
Water	29%

C) Emulsifiable Fungicide Formulation:	
Kresoxin-methyl	0.5%
Propylene carbonate	1.5%
Aromatic petroleum distillate 150 (Exxon)	2.9%
5-methyl-N-octyl-2-pyrrolidone	3.8%
CaH/DBSA [50% (Ca dodecylbenzene Sulfonate + Dodecylbenzene Sulfonic acid (5:1) in Exxon 150	Balance
Water	

## Example 16

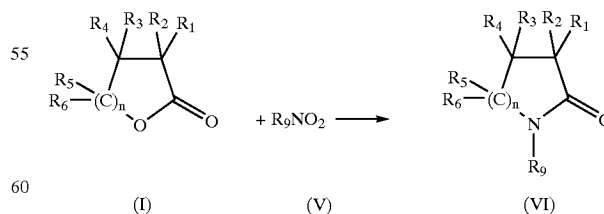
## Formulation for Protective Composition for Painted Automobile Surfaces

Propylene glycol phenyl ether	2.0%
5-Methyl-N-octyl-2-pyrrolidone	0.1%
Emulsified silicone:	3.0%
a) dimethyl silicone (2.67%)	
b) amino-functional silicone (0.21%)	
c) silicone resin (0.12%)	
Water	94.9%

The invention claimed is:

1. A process for preparing an ink jet ink composition, the process comprising the steps of:

- i) preparing Nsubstituted-2-lactam (VI) using a process comprising the step of contacting a lactone (I) with a nitro compound (V) in the presence of hydrogen gas and a metal catalyst, the metal catalyst being optionally supported, and, optionally, in the presence of a solvent;



wherein:

- (a) n=0–11;  
 (b) R<sub>1</sub>, R<sub>2</sub>, R<sub>3</sub>, R<sub>4</sub>, R<sub>5</sub> and R<sub>6</sub> taken independently are hydrogen, hydrocarbyl or substituted hydrocarbyl,

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C<sub>1</sub> to C<sub>18</sub> unsubstituted or substituted alkyl, unsubstituted or substituted alkenyl, unsubstituted or substituted cycloalkyl, unsubstituted or substituted cycloalkyl containing at least one heteroatom, unsubstituted or substituted aryl, or unsubstituted or substituted heteroaryl;

(c) R<sub>9</sub> is C<sub>1</sub>-C<sub>30</sub> unsubstituted or substituted alkyl, C<sub>2</sub>-C<sub>30</sub> unsubstituted or substituted alkenyl, C<sub>2</sub>-C<sub>30</sub>

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unsubstituted or substituted alkynyl, C<sub>3</sub>-C<sub>30</sub> unsubstituted or substituted cycloalkyl, or C<sub>3</sub>-C<sub>30</sub> unsubstituted or substituted cycloalkyl containing at least one heteroatom; and

ii) contacting N-substituted-2-lactam (VI) with at least one colorant.

\* \* \* \* \*