

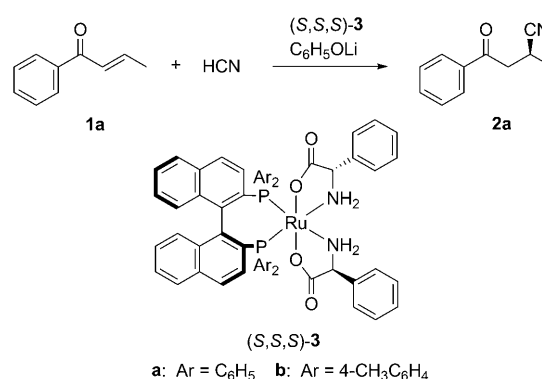
# Asymmetric Hydrocyanation of $\alpha,\beta$ -Unsaturated Ketones into $\beta$ -Cyano Ketones with the $[\text{Ru}(\text{phgly})_2(\text{binap})]/\text{C}_6\text{H}_5\text{OLi}$ Catalyst System\*\*

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Catalytic asymmetric hydrocyanation of  $\alpha,\beta$ -unsaturated ketones into the corresponding chiral  $\beta$ -cyano ketones is a challenging scientific endeavor. Four major hurdles must be cleared before this reaction can be realized: 1) use of HCN as a cyanide source,<sup>[1]</sup> 2) high 1,4-addition selectivity over 1,2-addition, 3) sufficient enantioface selectivity and, 4) high catalytic activity (low catalyst loading). Recently, Shibasaki and co-workers reported pioneering studies on asymmetric 1,4-addition of cyanide to the conjugate enones catalyzed by chiral Gd and Sr compounds.<sup>[2–5]</sup> A wide range of 1,4-adducts were obtained in high enantiomeric excess (*ee*), but two equivalents of a *tert*-C<sub>4</sub>H<sub>9</sub>(CH<sub>3</sub>)<sub>2</sub>SiCN/2,6-dimethylphenol system were required as a cyanide source to achieve the best catalyst performance.<sup>[6]</sup> Furthermore, the substrate-to-catalyst molar ratio (S/C) of 10–200 in these reactions was relatively low.<sup>[2]</sup>

Our research group recently reported the asymmetric cyanation of aldehydes and  $\alpha$ -keto esters catalyzed by our original  $[\text{Ru}(\text{phgly})_2(\text{binap})]/\text{Li}$  salt systems.<sup>[7,8]</sup> The corresponding cyanated products were obtained in high *ee*. The spectroscopic analysis suggested that the bimetallic species  $[\text{Li-Ru}(\text{phgly})_2(\text{binap})]^+$  acted as a chiral Lewis acidic catalyst. Herein, we describe the efficient asymmetric conjugate addition of HCN to  $\alpha,\beta$ -unsaturated ketones catalyzed by the combined system of  $[\text{Ru}(\text{phgly})_2(\text{binap})]$  and  $\text{C}_6\text{H}_5\text{OLi}$ . The reaction was carried out with an S/C of 200–1000 at  $-20$ – $0^\circ\text{C}$  to afford the  $\beta$ -cyano ketones in up to 98% *ee*.

1-Phenyl-2-buten-1-one (**1a**) was selected as a typical enone substrate to optimize the reaction conditions (Scheme 1 and Table 1). The  $[\text{Ru}\{(\text{S})\text{-phgly}\}_2\{(\text{S})\text{-binap}\}]$  ((*S,S,S*)-**3a**) complex was prepared according to the method described in our previous report.<sup>[7]</sup> The reaction of **1a** (1.0 mmol) and HCN prepared by mixing (CH<sub>3</sub>)<sub>3</sub>SiCN (1.5 mmol) and CH<sub>3</sub>OH (1.5 mmol) was conducted in *tert*-C<sub>4</sub>H<sub>9</sub>OCH<sub>3</sub> (6 mL) with (*S,S,S*)-**3a** (20  $\mu\text{mol}$ ,



**Scheme 1.** Asymmetric hydrocyanation of 1-phenyl-2-buten-1-one (**1a**) with **3** and  $\text{C}_6\text{H}_5\text{OLi}$ .

**Table 1:** Asymmetric hydrocyanation of 1-phenyl-2-buten-1-one (**1a**).<sup>[a]</sup>

Entry	<b>1a</b> / <b>3a</b> / $\text{PhOLi}$	Solvent	<i>T</i> [ $^\circ\text{C}$ ]	<i>t</i> [h]	Yield [%] <sup>[b]</sup>	<i>ee</i> [%] <sup>[b]</sup>
1	500:1:1	<i>t</i> BuOMe	25	1	89	89
2	500:0:1	<i>t</i> BuOMe	25	1	35	— <sup>[c]</sup>
3	500:1:0	<i>t</i> BuOMe	25	1	< 1	n.d.
4	500:1:0.5	<i>t</i> BuOMe	25	1	53	90
5	500:1:2	<i>t</i> BuOMe	25	1	> 99	82
6	500:1:1	Et <sub>2</sub> O	25	1	80	83
7	500:1:1	<i>n</i> -hexane	25	1	21	56
8	500:1:1	CH <sub>2</sub> Cl <sub>2</sub>	25	1	< 1	n.d.
9	500:1:1	toluene	25	1	44	64
10	500:1:1	<i>t</i> BuOMe	0	5	99	93
11 <sup>[d]</sup>	500:1:1	<i>t</i> BuOMe	0	5	99	93
12 <sup>[e]</sup>	500:1:1	<i>t</i> BuOMe	0	5	98	90
13	1000:1:1	<i>t</i> BuOMe	0	5	98	90
14	2000:1:1	<i>t</i> BuOMe	0	5	< 1	n.d.
15	500:1:1	<i>t</i> BuOMe	$-20$	18	96	97

[a] Unless otherwise stated, the reactions were carried out using **1a** (1.0 mmol) and HCN (1.5 mmol) in solvent (6 mL) with (*S,S,S*)-**3a** (20  $\mu\text{mol}$  in THF) and  $\text{C}_6\text{H}_5\text{OLi}$  (20  $\mu\text{mol}$  in THF) in the ratio given in the Table. HCN was prepared in situ from (CH<sub>3</sub>)<sub>3</sub>SiCN and CH<sub>3</sub>OH in a 1:1 ratio. [b] Data for (*S*)-**2a** were determined by GC on a chiral stationary phase. [c] A racemic product was obtained. [d] Isolated HCN was used. [e] **3b** was used as a catalyst. n.d. = not determined.

S/C = 500) and  $\text{C}_6\text{H}_5\text{OLi}$  (20  $\mu\text{mol}$  in THF, 2.0  $\mu\text{mol}$ ) at  $25^\circ\text{C}$  for 1 hour and gave (*R*)-3-cyano-1-phenyl-1-butanone ((*R*)-**2a**) in 89% yield and 89% *ee* (Table 1, entry 1). Notably, no 1,2-addition product was observed. The reaction catalyzed only by  $\text{C}_6\text{H}_5\text{OLi}$  gave racemic **2a** in 35% yield (Table 1, entry 2). No conversion was observed in the reaction with **3a** in the absence of  $\text{C}_6\text{H}_5\text{OLi}$  (Table 1, entry 3). The use of a **3a**/ $\text{C}_6\text{H}_5\text{OLi}$  system in a 1:0.5 or 1:2 ratio afforded **2a** in 53%

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yield and 90% *ee*, and >99% yield and 82% *ee*, respectively (Table 1, entries 4 and 5). These observations suggested that **3a** and C<sub>6</sub>H<sub>5</sub>OLi smoothly formed the 1:1 bimetallic species, [Li-Ru(phgly)<sub>2</sub>(binap)]<sup>+</sup>,<sup>[7,8]</sup> and the chiral species had a higher reactivity than that of achiral C<sub>6</sub>H<sub>5</sub>OLi alone. The solvent of choice was *tert*-C<sub>4</sub>H<sub>9</sub>OCH<sub>3</sub>, while (C<sub>2</sub>H<sub>5</sub>)<sub>2</sub>O gave a slightly less satisfactory result (Table 1, entry 6). The yield and enantioselectivity were significantly decreased in less polar solvents (Table 1, entries 7–9). The cyanation at 0°C was completed in 5 hours and afforded the adduct in 93% *ee* (Table 1, entry 10). The same result was obtained by using the isolated HCN prepared according to the method described in the literature,<sup>[9]</sup> despite the very low catalyst loading (S/C = 500; Table 1, entry 11). This high reactivity at the low catalyst loading is the important point of difference between Shibasaki's system and the present system.<sup>[2,6]</sup> We chose the HCN formed in situ for use in this study for operational and safety reasons. The [Ru(phgly)<sub>2</sub>(tol-binap)] (**3b**) exhibited a similar efficiency (Table 1, entry 12).<sup>[10]</sup> The high catalytic activity of the **3a**/C<sub>6</sub>H<sub>5</sub>OLi system allowed us to conduct the cyanation with an S/C of 1000 at 0°C (Table 1, entry 13). The reaction with an S/C of 2000 did not proceed (Table 1, entry 14). The excellent *ee* value of 97% was achieved in the reaction at –20°C, although the reaction took longer to achieve completion (Table 1, entry 15).<sup>[11]</sup>

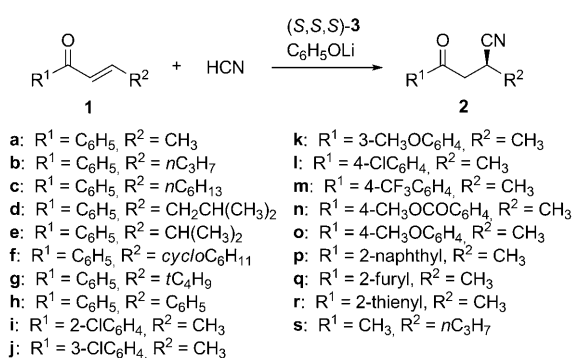
Thus, we selected the reaction conditions using **1a** and 1.5 equivalents of HCN prepared from (CH<sub>3</sub>)<sub>3</sub>SiCN and CH<sub>3</sub>OH in *tert*-C<sub>4</sub>H<sub>9</sub>OCH<sub>3</sub> with **3a** and C<sub>6</sub>H<sub>5</sub>OLi (**3a**/C<sub>6</sub>H<sub>5</sub>OLi = 1:1) at an S/C of 500 at 0°C or –20°C when a higher *ee* value for the product was required (see the Experimental Section). The 1,4-adduct **2a** was quantitatively isolated by column chromatography on silica gel for a reaction carried out on a 3 mmol scale (Table 2, entries 1 and 2). Phenyl ketones (R<sup>1</sup> = C<sub>6</sub>H<sub>5</sub> in Scheme 2) with alkyl substituents at the β position (R<sup>2</sup>), **1b–1g**, reacted with HCN catalyzed by the **3a**/C<sub>6</sub>H<sub>5</sub>OLi system under the standard conditions and afforded the corresponding β-cyano ketones in 90–96% *ee* (Table 2, entries 3–6, 9, and 10). Although the reactivity of **1c** and **1d** with long alkyl chains was somewhat lower, the enones substituted by secondary and tertiary alkyl groups, **1e–1g**, showed reactivity comparable to that of the methyl-substituted ketone **1a**. The cyanation of **1e** with an S/C of 1000 at 0°C or with an S/C of 500 at –20°C proceeded smoothly and gave **2e** in 92% *ee* and 98% *ee*, respectively (Table 2, entries 7 and 8). Chalcone (**1h**), a β-phenyl enone, was much less reactive than the corresponding β-alkyl substrates, but the cyanation product **2h** was obtained in 92% *ee* and 88% yield in the reaction with an S/C of 200 for 47 hours (Table 2, entry 11).<sup>[12]</sup>

A series of substituted phenyl ketones, **1i–1o**, was applied to the asymmetric hydrocyanation. The 2'-Cl phenyl ketone **1i** was treated with **3a** under the typical reaction conditions and gave **2i** in 82% *ee* (Table 2, entry 12). A high enantioselectivity of 95% was achieved in the cyanation of the 3'-Cl substrate **1j** (Table 2, entry 13). The phenyl ketones with an electron-donating CH<sub>3</sub>O group at the 3'- or 4'-position, **1k** and **1o**, showed lower reactivity (Table 2, entries 14 and 20). However, an excellent *ee* value of 98% was observed in the reaction of **1k**. The cyanation of substrates with an electron-

**Table 2:** Asymmetric hydrocyanation of α,β-unsaturated ketones **1**.<sup>[a]</sup>

Entry	<b>1</b>	S/C <sup>[b]</sup>	T [°C]	t [h]	Yield [%] <sup>[c]</sup>	<i>ee</i> [%] <sup>[d]</sup>
1	<b>1a</b>	500	0	5	<b>2a</b> , 99	94
2	<b>1a</b>	500	–20	24	<b>2a</b> , 98	97
3	<b>1b</b>	500	0	3	<b>2b</b> , 98	95
4	<b>1c</b>	500	0	18	<b>2c</b> , 94	93
5	<b>1d</b>	500	0	18	<b>2d</b> , 97	90
6	<b>1e</b>	500	0	3	<b>2e</b> , 99	96
7	<b>1e</b>	1000	0	5	<b>2e</b> , 98	92
8	<b>1e</b>	500	–20	18	<b>2e</b> , 98	98
9	<b>1f</b>	500	0	5	<b>2f</b> , 98	95
10	<b>1g</b>	500	0	5	<b>2g</b> , 99	96
11	<b>1h</b>	200	0	47	<b>2h</b> , 88	92
12	<b>1i</b>	500	0	5	<b>2i</b> , 96	82
13	<b>1j</b>	500	0	5	<b>2j</b> , 97	95
14	<b>1k</b>	200	0	12	<b>2k</b> , 96	98
15	<b>1l</b>	500	0	3	<b>2l</b> , 96	95
16	<b>1m</b>	500	0	2	<b>2m</b> , 97	96
17	<b>1m</b>	1000	0	5	<b>2m</b> , 96	94
18	<b>1m</b>	500	–20	12	<b>2m</b> , 98	98
19	<b>1n</b>	500	0	3	<b>2n</b> , 97	95
20	<b>1o</b>	200	0	12	<b>2o</b> , 99	91
21	<b>1p</b>	500	0	12	<b>2p</b> , 99	93
22	<b>1q</b>	500	0	3	<b>2q</b> , 98	95
23	<b>1r</b>	500	0	5	<b>2r</b> , 97 <sup>[e]</sup>	95
24	<b>1s</b>	200 <sup>[f]</sup>	0	24	<b>2s</b> , 80 <sup>[g]</sup>	93

[a] Unless otherwise stated, reactions were conducted using **1** (3.0 mmol) and HCN (4.5 mmol) in *tert*-C<sub>4</sub>H<sub>9</sub>OCH<sub>3</sub> (18 mL) with a solid (S,S,S)-**3a** and C<sub>6</sub>H<sub>5</sub>OLi (60 mm in THF). **3a**/C<sub>6</sub>H<sub>5</sub>OLi = 1:1. HCN was prepared in situ from (CH<sub>3</sub>)<sub>3</sub>SiCN and CH<sub>3</sub>OH in a 1:1 ratio. [b] Substrate-to-catalyst (**3a**) molar ratio. [c] Yield of isolated **2**. [d] Determined by GC or HPLC on a chiral stationary phase. [e] Contaminated by about 1% of an unidentified compound. [f] **3b** was used as a catalyst. [g] The yield determined by GC methods was 99%.



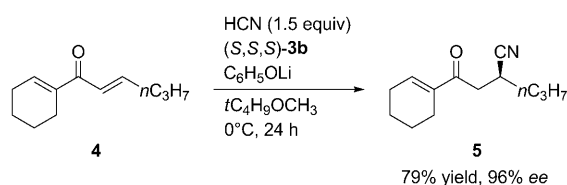
**Scheme 2.** Asymmetric hydrocyanation of α,β-unsaturated ketones **1** to the β-cyano ketones **2**.

withdrawing Cl, CF<sub>3</sub>, or CH<sub>3</sub>OCO group at the 4'-position, **1l–1n**, was faster than the reaction of unsubstituted ketone **1a** with maintaining high enantioselectivity (Table 2, entries 15, 16, and 19). The 4'-CF<sub>3</sub> ketone **1m** smoothly reacted with an S/C of 1000 at 0°C or with an S/C of 500 at –20°C and afforded **2m** in 94% *ee* and 98% *ee*, respectively (Table 2, entries 17 and 18).

The cyanation of 2'-naphthyl ketone **1p** under the standard conditions was completed in 12 hours and gave **2p** in 93% *ee* (Table 2, entry 21). The 2'-furyl and 2'-thienyl

ketones, **1q** and **1r**, were converted into the 1,4-adducts, **2q** and **2r**, with 95 % *ee* in both cases (Table 2, entries 22 and 23). The reaction of 3-hepten-2-one (**1s**), an aliphatic enone, with the **3a**/C<sub>6</sub>H<sub>5</sub>OLi system was slow, but the cyanation with an S/C of 200 at 0 °C for 24 hours afforded **2s** in 99 % yield and 93 % *ee* when **3b** was used instead of **3a** (Table 2, entry 24).<sup>[11]</sup> The chiral Gd and Sr catalysts reported by Shibasaki exhibit wider applicability to the reaction of aliphatic and β,β-disubstituted enones.<sup>[2]</sup>

The **3b**/C<sub>6</sub>H<sub>5</sub>OLi catalyst was applied to the regioselective cyanation of a dialkenyl ketone. When cyclohexenyl pentenyl ketone **4** was subjected to the cyanation conditions, the monocyanoated product **5** (at the pentenyl group) was obtained in 96 % *ee* (Scheme 3). The regioselectivity was estimated to be greater than 99 %.



**Scheme 3.** Regioselective cyanation of dienone **4**.

The Ru complex **3a** was so robust that it was recovered by column chromatography on silica gel from the reaction mixture in the open air, and was reusable as a cyanation catalyst with the addition of fresh C<sub>6</sub>H<sub>5</sub>OLi. As shown in Table 3, **3a** could be used five times in the cyanation of **1a**.

**Table 3:** Recycled use of **3a** in the hydrocyanation of **1a**.<sup>[a]</sup>

Run number <sup>[b]</sup>	Conversion [%] <sup>[c]</sup>	Yield [%] <sup>[d]</sup>	<i>ee</i> [%] <sup>[c]</sup>
1	> 99	97	93
2	> 99	93	94
3	> 99	99	93
4	> 99	99	93
5	> 99	99	92

[a] Reactions were conducted using **1a** (10 mmol) and HCN (15 mmol) in *tert*-C<sub>4</sub>H<sub>9</sub>OCH<sub>3</sub> (60 mL) at 0 °C for 5 h with a solid (S,S,S)-**3a** and C<sub>6</sub>H<sub>5</sub>OLi (50 mm in THF). **1a**/**3a**/C<sub>6</sub>H<sub>5</sub>OLi = 500:1:1 (initial). HCN was prepared in situ from (CH<sub>3</sub>)<sub>3</sub>SiCN and CH<sub>3</sub>OH in a 1:1 ratio. [b] Number of times the catalyst was used. [c] Determined by GC on a chiral stationary phase. [d] Yield of isolated **2a**.

with an initial S/C of 500 at 0 °C with maintaining high enantioselectivity. The total turnover number was about 2500. The notable robustness and reusability of **3a** make it suitable for practical use.

In addition, different α,β-unsaturated ketones **1** were cyanated sequentially with this catalyst-reuse procedure. Table 4 lists the results. The catalyst efficiency and enantioselectivity for all runs were comparable to those of the regular single-run reactions shown in Table 2.

In summary, we have reported here the efficient enantioselective conjugate addition of HCN into the α,β-unsaturated ketones to afford the β-cyano ketones catalyzed by our

**Table 4:** Sequential hydrocyanation of different substrates.<sup>[a]</sup>

Run number <sup>[b]</sup>	<b>1</b>	<i>t</i> [h]	Yield [%] <sup>[c]</sup>	<i>ee</i> [%] <sup>[d]</sup>
1	<b>1n</b>	3	96	93
2	<b>1p</b>	12	96	90
3	<b>1j</b>	5	98	96
4	<b>1l</b>	3	95	95
5	<b>1k</b> <sup>[e]</sup>	12	99	96

[a] Reactions were conducted using **1** (8.2 mmol) and HCN (11.8 mmol) in *tert*-C<sub>4</sub>H<sub>9</sub>OCH<sub>3</sub> (48 mL) at 0 °C with a solid (S,S,S)-**3a** and C<sub>6</sub>H<sub>5</sub>OLi (50 mm in THF). **1**/**3a**/C<sub>6</sub>H<sub>5</sub>OLi = 500:1:1 (initial). HCN was prepared in situ from (CH<sub>3</sub>)<sub>3</sub>SiCN and CH<sub>3</sub>OH in a 1:1 ratio. [b] Number of times the catalyst was used. [c] Yield of isolated **2**. [d] Determined by GC or HPLC on a chiral stationary phase. [e] Reaction using **1k** (3.2 mmol) and HCN (4.8 mmol) in *tert*-C<sub>4</sub>H<sub>9</sub>OCH<sub>3</sub> (19 mL).

original [Ru(phgly)<sub>2</sub>(binap)]/C<sub>6</sub>H<sub>5</sub>OLi system. The reaction was carried out with an S/C in the range of 200–1000 at –20 °C→0 °C. A series of aryl-, hetero-aryl-, and alkyl-substituted enones was converted into the 1,4-addition products in up to 98 % *ee* without formation of a detectable amount of the 1,2-adducts. The reaction of cyclohexenyl pentenyl ketone afforded the monocyanoated product at the less-hindered site in high regio- and enantioselectivity. The robust [Ru(phgly)<sub>2</sub>(binap)] complex can be reused with addition of fresh C<sub>6</sub>H<sub>5</sub>OLi without loss of the stereoselectivity. We hope these findings will contribute to the progress of synthetic organic chemistry.

## Experimental Section

The typical procedure for the hydrocyanation of 1-phenyl-2-buten-1-one (**1a**): **Caution:** (CH<sub>3</sub>)<sub>3</sub>SiCN and HCN that is formed in situ must be used in a well-ventilated fume hood owing to their high toxicity. Ruthenium complex (S,S,S)-**3a** (6.2 mg, 6.1 μmol)<sup>[7,8]</sup> was placed in a 50 mL Schlenk flask, and the air present in this apparatus was replaced by argon. Anhydrous CH<sub>3</sub>OH (146 mg, 4.6 mmol) was added to this flask, and the mixture was cooled to 0 °C. Then (CH<sub>3</sub>)<sub>3</sub>SiCN (445 mg, 4.5 mmol) was added in a dropwise manner, and the mixture was stirred for 15 min. To the solution containing HCN, anhydrous *tert*-C<sub>4</sub>H<sub>9</sub>OCH<sub>3</sub> (18 mL) and C<sub>6</sub>H<sub>5</sub>OLi (60 mm in THF, 100 μL, 6.0 μmol) were added at 0 °C, and the mixture was stirred for 30 min. Then **1a** (447 mg, 3.1 mmol) was added to this solution in a dropwise manner over 5 min, and the reaction mixture was stirred for 5 h. After the solvent and the volatile compounds were evaporated under reduced pressure, the residue was purified by column chromatography on silica gel to give (S)-**2a** (colorless oil, 531 mg, 99 % yield, 94 % *ee*). [ $\alpha$ ]<sub>D</sub><sup>24</sup> = –6.7 deg cm<sup>3</sup> g<sup>–1</sup> dm<sup>–1</sup> (*c* = 1.07 g cm<sup>–3</sup>, CHCl<sub>3</sub>); literature<sup>[2a]</sup> [ $\alpha$ ]<sub>D</sub><sup>25</sup> = –6.2 deg cm<sup>3</sup> g<sup>–1</sup> dm<sup>–1</sup> (*c* = 0.6 g cm<sup>–3</sup>, CHCl<sub>3</sub>), 88 % *ee* (absolute configuration was unreported); <sup>1</sup>H NMR (400 MHz, CDCl<sub>3</sub>): δ = 1.43 (d, 3 H, *J* = 6.8 Hz, CH<sub>3</sub>), 3.23 (dd, 1 H, *J* = 6.5, 17.0 Hz, CHH), 3.31–3.40 (m, 1 H, CHCN), 3.43 (dd, 1 H, *J* = 6.2, 17.0 Hz, CHH), 7.48–7.51 (m, 2 H, aromatic H), 7.60–7.63 (m, 1 H, aromatic H), 7.95–7.97 ppm (m, 2 H, aromatic H); <sup>13</sup>C NMR (67.7 MHz, CDCl<sub>3</sub>): δ = 17.8 (CH<sub>3</sub>), 20.5 (CH), 42.2 (CH<sub>2</sub>), 122.6 (C), 128.0 (CH), 128.8 (CH), 133.8 (CH), 135.8 (C), 195.1 ppm (C); HRMS (ESI): *m/z* calcd for C<sub>11</sub>H<sub>11</sub>ClNO: 208.05292 [*M*+Cl]<sup>–</sup>; found: 208.05292. The *ee* value of **2a** was determined by GC on a chiral stationary phase using an InertCap CHIRAMIX column (0.25 mm × 30 m, depth of film = 0.25 μm, GL Science); carrier gas: helium (217 kPa); column temp: 170 °C heating to 179 °C at a rate of 0.5 °C min<sup>–1</sup>; injection temp: 250 °C; retention time (*t*<sub>R</sub>) of (R)-**2a**: 17.5 min (3.1 %), *t*<sub>R</sub> of (S)-**2a**: 16.5 min (96.9 %). The *ee* value was not changed by purification with column chromatography. The absolute

configuration was determined after conversion to 2-methyl-4-oxo-4-phenylbutanoic acid in 55 % *ee*.  $[\alpha]_{\text{D}}^{26} = -18.4 \text{ deg cm}^3 \text{ g}^{-1} \text{ dm}^{-1}$  ( $c = 0.592 \text{ g cm}^{-3}$ ,  $\text{CHCl}_3$ ); literature<sup>[13]</sup>  $[\alpha]_{\text{D}}^{20} = -32.5 \text{ deg cm}^3 \text{ g}^{-1} \text{ dm}^{-1}$  ( $c = 0.69 \text{ g cm}^{-3}$ ,  $\text{CHCl}_3$ ) for the *S* enantiomer.

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**Keywords:** asymmetric catalysis · hydrocyanation · lithium · ruthenium ·  $\alpha,\beta$ -unsaturated ketones

- [1] HCN is a toxic compound, but it is utilized in industrial processes for the production of useful chemical compounds, such as  $\alpha$ -hydroxy acids,  $\alpha$ -amino acids, and methacrylates; for example, see: P. Poechlauer, W. Skranc, M. Wubbolts in *Asymmetric Catalysis on Industrial Scale: Challenge, Approaches and Solutions* (Eds.: H. U. Blaser, E. Schmidt), Wiley-VCH, Weinheim, **2004**, pp. 151–164.
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