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| 著者 | Kimura Koji, Watanabe Yoshito, Suda Tokiko, Senda Hitoshi, Hosoi Shinzo, Ohta Tomihisa, Kunimoto Ko-Ki |
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**Crystal Structure of (1*R*, 2*R*)-*trans* -1,2-Cyclohexanedicarboxylic Acid-
(*R*)-1-Phenylethylamine Salt**

Kouji KIMURA^{*}, Yoshito WATANABE^{*}, Tokiko SUDA^{*}, Hitoshi SENDA^{*}, Shinzo HOSOI[†], Tomihisa OHTA^{**} and Ko-Ki KUNIMOTO[†]

** Department of Chemistry and Chemical Engineering, Faculty of Technology,
Kanazawa University, Kakuma-machi, Kanazawa 920-1192, Japan*

*** Department of Pharmacognosy and Natural Products, Faculty of Pharmaceutical
Sciences, Kanazawa University, Takara-machi, Kanazawa 920-0934, Japan*

† To whom correspondence should be addressed.

Although recent advances in asymmetric synthesis and biotechnology are noteworthy, they do not completely satisfy the increasing demand for optically pure compounds. Traditional optical resolutions and physicochemical separations are still employed as useful procedures for the preparation of optically pure compounds in industry.¹ We have studied the optical resolution of *trans*-1,2-cyclohexanedicarboxylic acid (CHDC) through diastereomer crystallization using (*R*)-1-phenylethylamine ((*R*)-PEA) as a resolving agent. In order to perform the optical resolution rationally and with a high probability of success, an improved understanding of the correlation between the crystal structure and the physicochemical properties is indispensable.

Racemic CHDC was dissolved in ethanol at 70 °C and subsequently an equimolar of (*R*)-PEA was added. The solution was allowed to stand undisturbed at 30 °C for 30 h. The precipitated crystals of (*R, R*)-CHDC · (*R*)-PEA **1** were filtered off and dried in vacuo. The diastereomeric salt was recrystallized from ethanol twice (mp 172-174 °C). By acidifying the salt with hydrochloric acid, optically pure (*R, R*)-CHDC was obtained. (59 % yield, 99.5 % e.e., mp 183-185°C)

A colorless prism crystal of **1** with dimensions 0.6 × 0.3 × 0.2 mm was mounted on a glass fiber. All measurements were made on a Rigaku AFC-5R diffractometer with a graphite monochromated Cu K α radiation ($\lambda = 1.54178 \text{ \AA}$). The detailed measurement conditions and crystal data are listed in Table 1. The intensity data were collected at 23°C using the ω -2 θ scan technique to a maximum 2 θ value of 120.1°. A total of 1426 reflections were collected. The intensities of three representative reflections which were measured after every 150 reflections remained constant throughout data collection, indicating crystal and electronic stability. No decay correction was applied. The linear absorption coefficient for Cu K α is 6.8 cm⁻¹. Azimuthal scans of several reflections indicated no need for absorption correction. The data were corrected for Lorentz and

polarization effects.

The structure was solved by direct methods.² The non-hydrogen atoms were refined anisotropically. All hydrogen atoms were located from a difference Fourier map and included in the final cycle of the full-matrix least squares refinement. The atomic scattering factors and anomalous dispersion terms were taken from the International Tables for X-ray Crystallography, Vol. IV.³ All calculations were performed using the program TEXSAN crystallographic software package.⁴ Positional parameters for non-hydrogen atoms are listed in Table 2. The molecular structure is shown in Fig. 2, together with the atomic labeling scheme. Bond distances and selected bond angles are listed in Table 3.

In the crystal structure the (*R, R*)-CHDC molecule is protonated on one of the two carboxylate groups. This is demonstrated by the C-O bond length of the structure. The C8-O4 bond (1.311(3) Å) is significantly longer than the C8-O3 bond (1.209(3) Å) in the carboxylic acid group. On the other hand, the C-O bonds have similar bond lengths in the carboxylate group (C7-O1, 1.231(3) Å; C7-O2, 1.273(3) Å). The (*R, R*)-CHDC molecules are linked by intermolecular hydrogen bondings between the carboxylic acid and the carboxylate groups (O2···O4' 2.561(3) Å, O2···H'-O4' 177.0(4)°, a prime denotes atoms in the neighboring molecules). This hydrogen bonding network forms a pleated sheet structure along the *a* axis. The ammonium groups of the (*R*)-PEA molecules are situated between the rows of the (*R, R*)-CHDC moieties and connect the pleated sheets through the intermolecular hydrogen bondings (N1···O1' 2.700(3) Å, N1-H···O1' 162.0(3)°; N1···O2' 2.833(3) Å, N1-H···O2' 164.0(3)°; N1···O3' 2.821(3) Å, N1-H···O3' 136.0(3)°).

References

1. R. A. Sheldon, "Chirotechnology: Industrial Synthesis of Optically Active Compounds", Chap. 6, pp.173 -204, Marcel Dekker, Inc., New York, 1993.

2. C. J. Gilmore, *J. Appl. Cryst.*, **17**, 42 (1984).
3. “*International Tables for X-ray Crystallography*”, vol. IV, The Kynoch Press, Birmingham, England, 1974.
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Table 1 Crystal and experimental data

Formula: $C_{16}H_{23}NO_4$

Formula weight: 293.36

Crystal system: orthorhombic

Space group: $P2_12_12_1$ $Z=4$

$a= 9.9880(9)\text{\AA}$

$b= 26.034(2)\text{\AA}$

$c= 6.0826(4)\text{\AA}$

$V= 1581.7(2)\text{\AA}^3$

$D_{calc}= 1.232\text{ g/cm}^3$

$R=0.041$, $R_w=0.052$

Goodness-of-fit = 3.01

$\Delta\rho_{max}(e\text{\AA}^{-3}) / \Delta\rho_{min}(e\text{\AA}^{-3}) = 0.17/-0.28$

No. of reflections used= 1360 ($I>1.20\sigma(I)$)

No. of parameters = 282

Measurement: Rigaku AFC-5R

Program system: TEXSAN

Structure determination: direct method

Refinement: full-matrix least-squares

Table 2 Fractional coordinates and thermal parameters for non-hydrogen atoms

| Atom | x | y | z | $B_{eq}/\text{\AA}^2$ |
|------|-----------|------------|-----------|-----------------------|
| O1 | 0.8166(2) | 0.16392(9) | 1.3442(3) | 5.1(1) |
| O2 | 0.8255(2) | 0.20735(7) | 1.0323(3) | 4.01(8) |
| O3 | 0.4884(2) | 0.19424(7) | 1.1399(3) | 4.6(1) |
| O4 | 0.4647(2) | 0.22043(8) | 0.7959(3) | 4.1(1) |
| N1 | 0.9778(2) | 0.2105(1) | 0.6397(5) | 3.3(1) |
| C1 | 0.6992(2) | 0.12927(8) | 1.0415(4) | 2.7(1) |
| C2 | 0.6099(2) | 0.15021(9) | 0.8589(4) | 2.7(1) |
| C3 | 0.5304(3) | 0.1071(1) | 0.7466(6) | 4.1(1) |
| C4 | 0.6220(4) | 0.0649(1) | 0.6634(6) | 4.3(1) |
| C5 | 0.7090(3) | 0.0437(1) | 0.8483(6) | 4.1(1) |
| C6 | 0.7884(3) | 0.0856(1) | 0.9575(5) | 3.5(1) |
| C7 | 0.7856(2) | 0.1699(1) | 1.1501(4) | 3.0(1) |
| C8 | 0.5166(3) | 0.19058(8) | 0.9473(4) | 3.0(1) |
| C9 | 1.1204(3) | 0.1352(1) | 0.7031(5) | 3.7(1) |
| C10 | 1.1678(4) | 0.1174(2) | 0.9037(6) | 5.7(2) |
| C11 | 1.1698(5) | 0.0649(2) | 0.947(1) | 7.7(3) |
| C12 | 1.1274(6) | 0.0309(2) | 0.790(1) | 8.2(3) |
| C13 | 1.0829(4) | 0.0474(1) | 0.589(1) | 6.9(2) |
| C14 | 1.0771(3) | 0.1002(1) | 0.5470(7) | 4.9(1) |
| C15 | 1.1182(3) | 0.1923(1) | 0.6583(5) | 3.7(1) |
| C16 | 1.1941(4) | 0.2074(1) | 0.4540(8) | 5.1(2) |

$$B_{eq} = (4/3) \sum_i \sum_j \beta_{ij} a_i^* a_j^* (a_i a_j)$$

Table 3 Bond distances(Å) and selected bond angles(°)

| Atom | Atom | Distance | Atom | Atom | Distance |
|------|------|----------|------|------|----------|
| O1 | C7 | 1.231(3) | C4 | C5 | 1.524(5) |
| O2 | C7 | 1.273(3) | C5 | C6 | 1.503(4) |
| O3 | C8 | 1.209(3) | C9 | C10 | 1.388(5) |
| O4 | C8 | 1.311(3) | C9 | C14 | 1.386(5) |
| N1 | C15 | 1.485(4) | C9 | C15 | 1.511(4) |
| C1 | C2 | 1.525(3) | C10 | C11 | 1.392(7) |
| C1 | C6 | 1.533(3) | C11 | C12 | 1.366(8) |
| C1 | C7 | 1.518(3) | C12 | C13 | 1.374(8) |
| C2 | C3 | 1.535(4) | C13 | C14 | 1.397(5) |
| C2 | C8 | 1.504(3) | C15 | C16 | 1.508(5) |
| C3 | C4 | 1.517(4) | | | |

| Atom | Atom | Atom | Angle | Atom | Atom | Atom | Angle |
|------|------|------|----------|------|------|------|----------|
| O1 | C7 | O2 | 124.0(2) | C4 | C5 | C6 | 111.4(2) |
| O1 | C7 | C1 | 118.1(2) | C6 | C1 | C7 | 109.4(2) |
| O2 | C7 | C1 | 117.8(2) | C9 | C10 | C11 | 119.8(5) |
| O3 | C8 | O4 | 122.8(3) | C9 | C14 | C13 | 120.6(4) |
| O3 | C8 | C2 | 123.1(2) | C9 | C15 | N1 | 110.0(2) |
| O4 | C8 | C2 | 114.1(2) | C9 | C15 | C16 | 113.5(3) |
| C1 | C2 | C3 | 111.4(2) | C10 | C11 | C12 | 120.1(5) |
| C1 | C2 | C8 | 110.6(2) | C10 | C9 | C14 | 119.3(3) |
| C1 | C6 | C5 | 112.2(2) | C10 | C9 | C15 | 119.4(3) |
| C2 | C1 | C6 | 111.3(2) | C11 | C12 | C13 | 121.2(4) |
| C2 | C1 | C7 | 113.6(2) | C12 | C13 | C14 | 118.9(5) |
| C2 | C3 | C4 | 111.5(2) | C14 | C9 | C15 | 121.3(3) |
| C3 | C4 | C5 | 111.1(3) | C16 | C15 | N1 | 109.1(3) |
| C3 | C2 | C8 | 110.4(2) | | | | |

Estimated standard deviations in the least significant figure are given in parentheses.

Figure Captions

Fig. 1 Chemical structure of **1**.

Fig. 2 Molecular structure with the numbering of the atoms.
Thermal ellipsoids of the non-hydrogen atoms are scaled to enclose 50 % probability.
The spheres of the hydrogen atoms are drawn in an arbitrary scale.

Fig. 3 Molecular packing viewed along the *c* -axis.

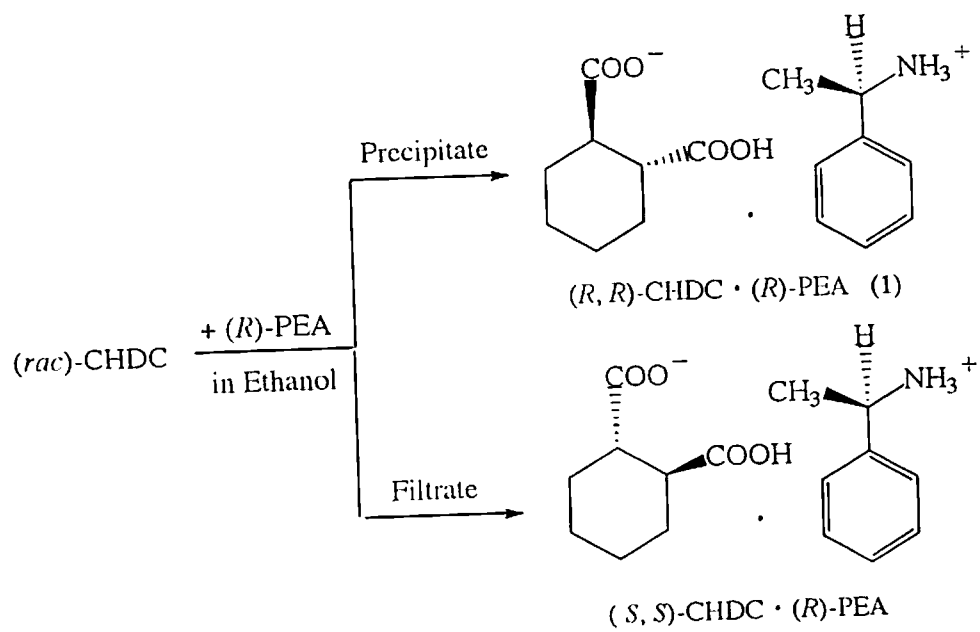


Fig. 1

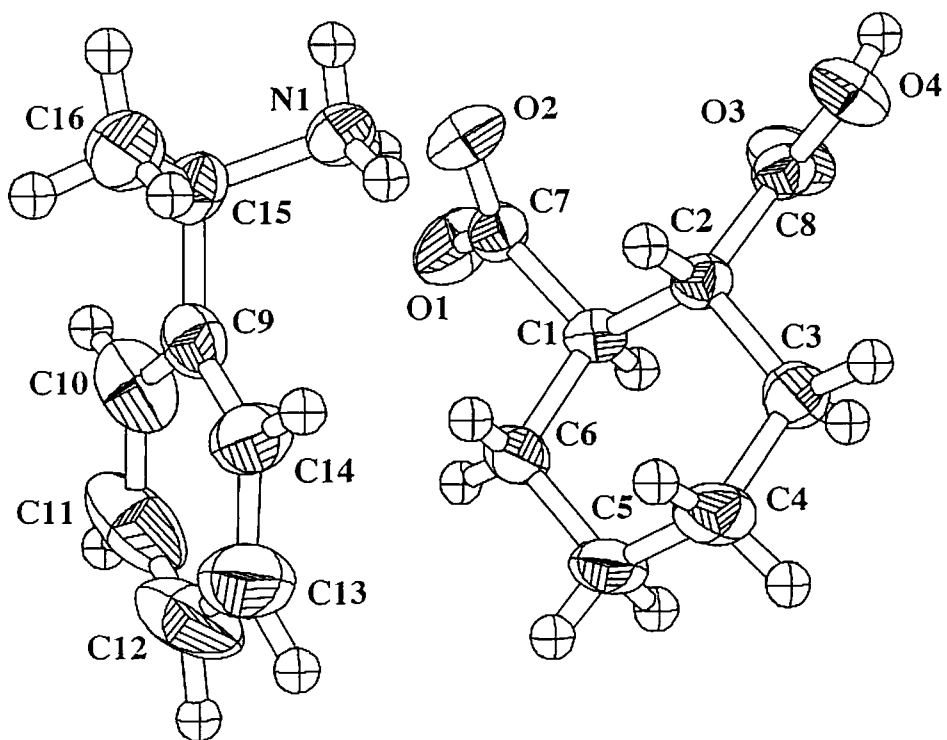


Fig. 2

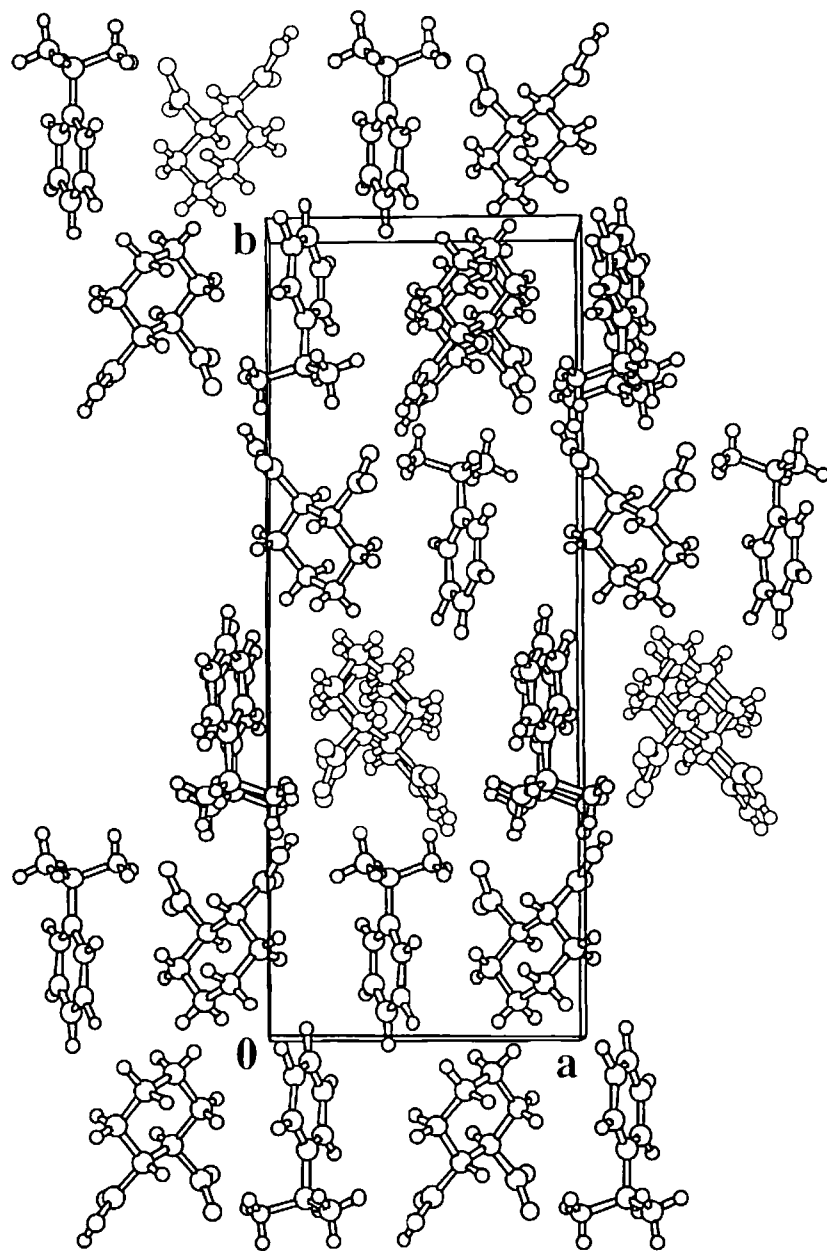


Fig. 3