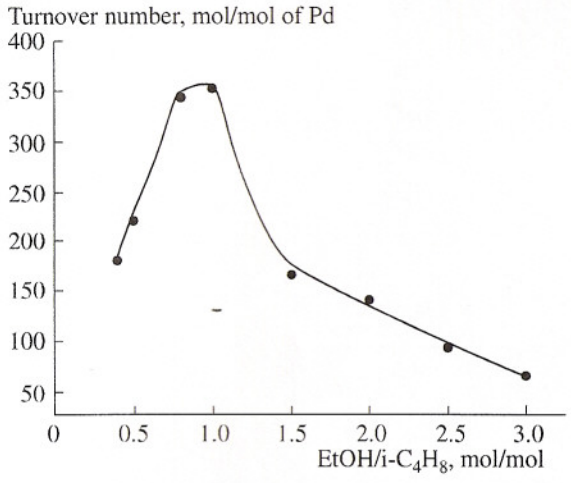

Dependence of the productivity of the $Pd(Acac)_2$–PPh_3–TsOH catalytic system on the ethanol/isobutylene molar ratio. Amount of $Pd(Acac)_2$ = 0.035 g (0.115 mmol). Isobutylene : PPh_3 : TsOH molar ratio = 550 : 3 : 12. pCO = 3.0 MPa, T = 100°C. Reaction time, 5 h.

thoxy- and hydroethoxycarbonylation with carbon monoxide and *l*-menthol or ethanol, respectively, was revealed. As expected, the reactions proceed regioselectively to give the linear products, *l*-menthyl isovalerate and ethyl isovalerate. The optimum conditions for the processes at which the yields of *l*-menthylisovalerate and ethyl isovalerate reach 67.6% (94.3% on a reacted *l*-menthol basis) and 79.0%, respectively, were found.

SPELL: 1. OK

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