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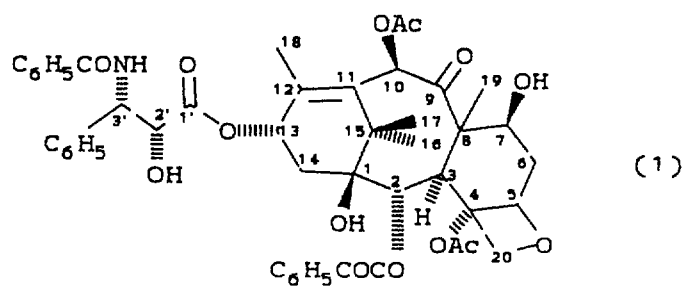
NOVEL SUBSTITUTED TAXANES AND PHARMACEUTICAL COMPOSITIONS CONTAINING THEM

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BACKGROUND OF THE INVENTION

The present invention is directed to novel taxanes which have utility as antileukemia and antitumor agents.

The taxane family of terpenes, of which taxol is a member, has attracted considerable interest in both the biological and chemical arts. Taxol is a promising cancer chemotherapeutic agent with a broad spectrum of antileukemic and tumor-inhibiting activity. Taxol has a 2'R, 3'S configuration and the following structural formula:



wherein Ac is acetyl. Because of this promising activity, taxol is currently undergoing clinical trials in both France and the United States.

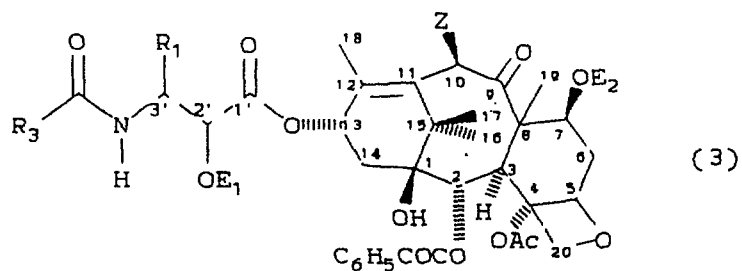
Colin et al. reported in U.S. Patent No. 4,814,470 that taxol derivatives having structural formula (2) below, have an activity significantly greater than that of taxol (1).



Although taxol and taxotere are promising
chemotherapeutic agents, they are not universally
10 effective. Accordingly, a need remains for additional
chemotherapeutic agents.

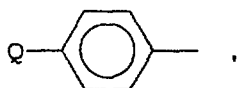
Among the objects of the present invention, therefore, is the provision of novel taxane derivatives
15 which are valuable antileukemia and antitumor agents.

Briefly, therefore, the present invention is directed to taxane derivatives of the formula:



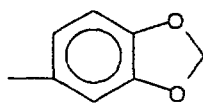
wherein

R₁ and R₃ are independently selected from the group comprising phenyl, naphthyl, C₆H₅CHCH-, and

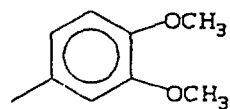


provided, however, R₁ and R₃ are not both phenyl;

Q is CH₃-, (CH₃)₃C-, CH₃O-, Cl, Br, F, -NO₂,



or



10 Z is -OT₁,
 T₁ is hydrogen, hydroxyl protecting group, or
 -COT₂,
 T₂ is H, C₁-C₆ alkyl, C₁-C₆ alkenyl, C₁-C₆
 alkynyl or monocyclic aryl,

Ac is acetyl, and

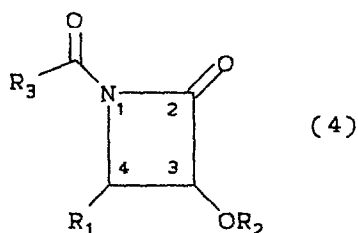
E_1 and E_2 are independently selected from hydrogen, hydroxy protecting groups and functional groups which increase the water solubility of the taxane derivative.

Other objects and features of this invention will be in part apparent and in part pointed out hereinafter.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

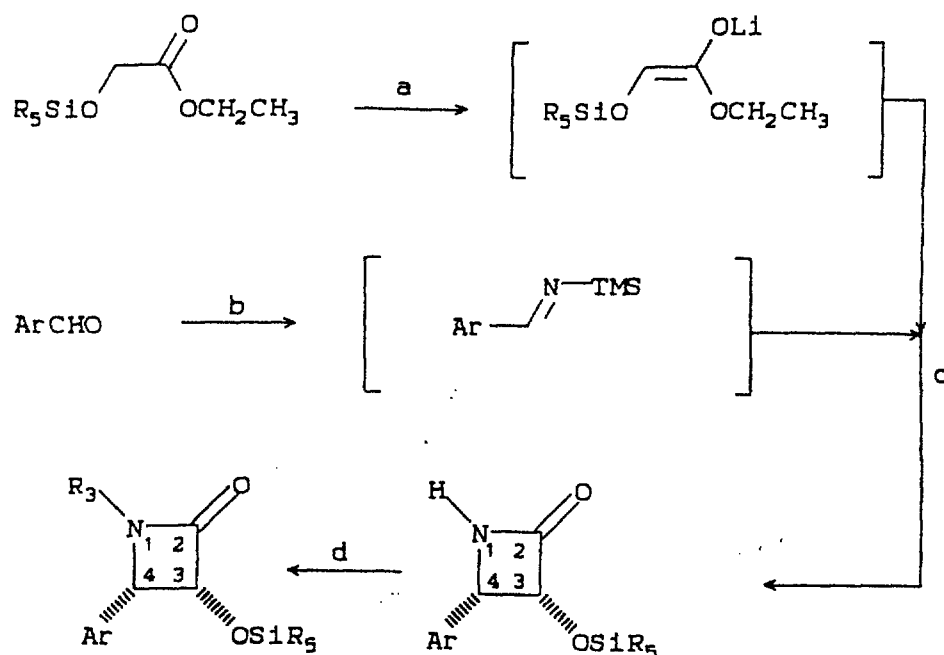
In accordance with the present invention, it has been discovered that compounds having structural formula (3) show remarkable properties, in vitro, and are valuable antileukemia and antitumor agents. Their biological activity has been determined in vitro, using tubulin assays according to the method of Parness et al., J. Cell Biology, 91: 479-487 (1981) and human cancer cell lines, and is comparable to that exhibited by taxol and taxotere.

Taxane derivatives having formula (3) may be obtained by reacting a β -lactam with metal alkoxides having the taxane tetracyclic nucleus and a C-13 metallic oxide substituent to form compounds having a β -amido ester substituent at C-13. The β -lactams have the following structural formula:



wherein R_1 and R_3 are as previously defined, and R_2 is a hydroxy protecting group,

β -lactams (4) can be prepared from readily available starting materials, as is illustrated by the following reaction scheme:



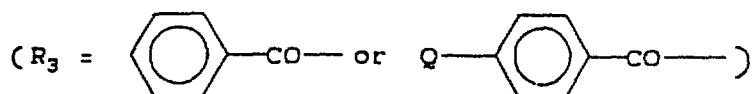
reagents

(a) LDA, THF, $-78^\circ C$ to $-50^\circ C$;

(b) LHMDS, THF, $-78^\circ C$ to $0^\circ C$;

(c) THF, $-78^\circ C$ to $25^\circ C$, (2h); and

(d) triethylamine and an acyl chloride

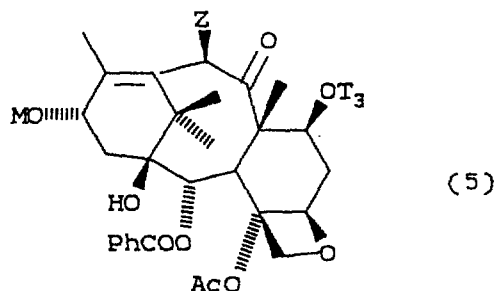


(LDA is lithium diisopropylamide and LHMDS is lithium hexamethyldisilazane)

The 3-hydroxyl protecting group shown in the above reaction scheme is $-SiR_5$ wherein R_5 is trialkyl or triaryl such as triethyl. The 3-hydroxyl may be protected with other standard protecting groups such as 1-ethoxyethyl, or 2,2,2-trichloroethoxymethyl. Additional hydroxy protecting groups and the synthesis thereof may be found in "Protective groups in Organic Synthesis" by T.W. Greene, John Wiley & Sons, 1981.

The racemic β -lactams may be resolved into the pure enantiomers prior to protection by recrystallization of the corresponding 2-methoxy-2-(trifluoromethyl) phenylacetic esters. However, the reaction described
 5 hereinbelow in which the β -amido ester side chain is attached has the advantage of being highly diastereo-selective, thus permitting the use of a racemic mixture of side chain precursor.

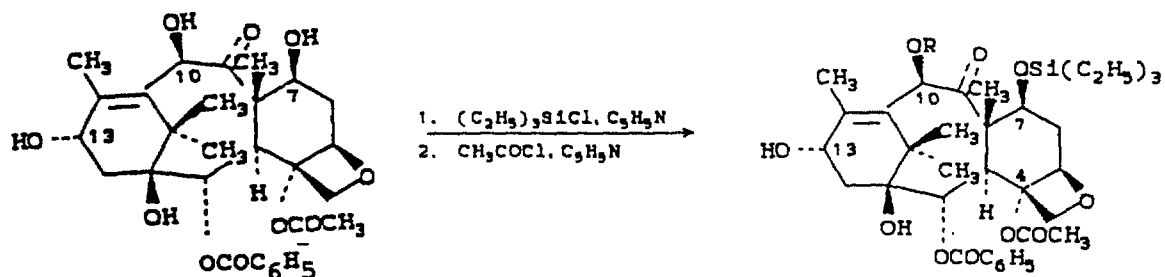
The metal alkoxides having the taxane tetracyclic
 10 nucleus and a C-13 metallic oxide substituent have the following structural formula:



wherein Z is $-\text{OT}_1$; T_1 is hydrogen, hydroxyl protecting group, or $-\text{COT}_2$; T_2 is H, $\text{C}_1\text{-C}_6$ alkyl, $\text{C}_1\text{-C}_6$ alkenyl, $\text{C}_1\text{-C}_6$
 15 alkynyl or monocyclic aryl; T_3 is a hydroxy protecting group; and M is a metal, preferably selected from the group comprising Group IA, Group IIA and transition metals, and most preferably, Li, Mg, Na, K or Ti.

The metal alkoxides are prepared by reacting an
 20 alcohol having the taxane tetracyclic nucleus and a C-13 hydroxyl group with an organometallic compound in a suitable solvent. Preferably, the alcohol is a protected baccatin III, in particular, 7-O-triethylsilyl baccatin III (which can be obtained as described by Greene, et al. in
 25 JACS 110: 5917 (1988) or by other routes) or 7,10-bis-O-triethylsilyl baccatin III.

As reported in Greene et al., 10-deacetyl baccatin III is converted to 7-O-triethylsilyl-10-deacetyl baccatin III according to the following reaction scheme:



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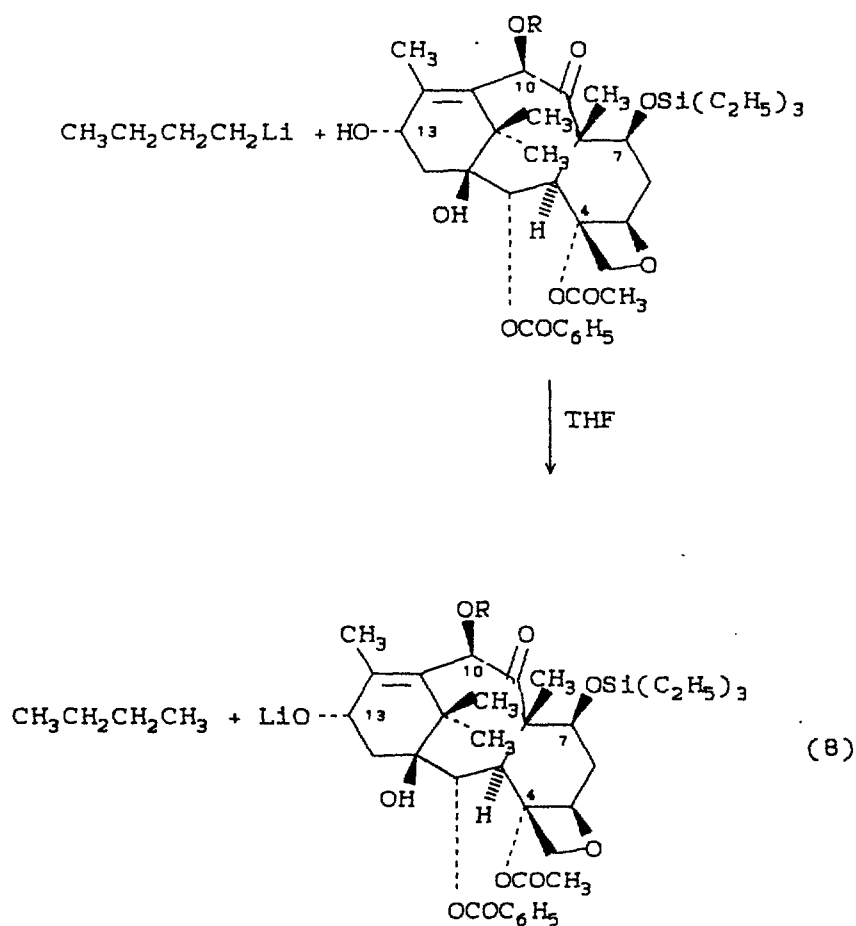
(6)

(7) a, $T_1 = \text{H}$
 b, $T_1 = \text{COCH}_3$

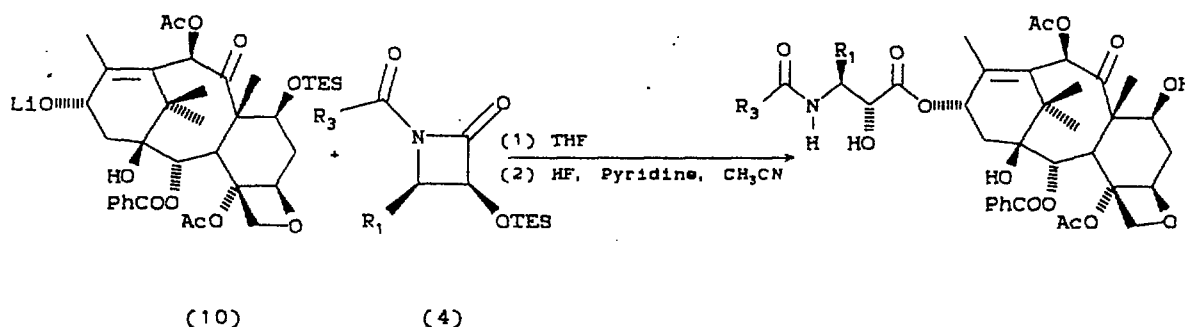
Under what is reported to be carefully optimized conditions, 10-deacetyl baccatin III is reacted with 20 equivalents of $(\text{C}_2\text{H}_5)_3\text{SiCl}$ at 23°C under an argon atmosphere for 20 hours in the presence of 50 ml of pyridine/mmol of 10-deacetyl baccatin III to provide 7-triethylsilyl-10-deacetyl baccatin III (7a) as a reaction product in 84-86% yield after purification. The reaction product may then optionally be acetylated with 5 equivalents of CH_3COCl and 25 mL of pyridine/mmol of 7a at 0°C under an argon atmosphere for 48 hours to provide 86% yield of 7-O-triethylsilyl baccatin III (7b). Greene, et al. in JACS 110, 5917 at 5918 (1988).

The 7-O-triethylsilyl baccatin III (7b) is reacted with an organometallic compound such as

n-butyllithium in a solvent such as tetrahydrofuran (THF), to form the metal alkoxide 13-O-lithium-7-O-triethylsilyl baccatin III (8) as shown in the following reaction scheme:



As shown in the following reaction scheme, 13-O-lithium-7-O-triethylsilyl baccatin III (8) reacts with β -lactam (4) in which R_2 is triethylsilyl to provide an intermediate in which the C-7 and C-2' hydroxyl groups are protected with a triethylsilyl group. The triethylsilyl groups are then hydrolyzed under mild conditions so as not to disturb the ester linkage or the taxane substituents.



wherein

5 R₁ and R₃ are as previously defined,
 Ac is acetyl, TES is triethylsilyl and Ph is
 phenyl.

Both the conversion of the alcohol to the metal
 alkoxide and the ultimate synthesis of the taxane
 derivative can take place in the same reaction vessel.
 10 Preferably, the β -lactam is added to the reaction vessel
 after formation therein of the metal alkoxide.

The present invention also provides
 pharmaceutical compositions containing a compound of
 formula (3) in combination with one or more
 15 pharmaceutically acceptable, inert or physiologically
 active, diluents or adjuvants.

These compositions may be presented in any form
 appropriate for the administration route envisaged. The
 parental route, and especially the intravenous route, is
 20 the preferential route for administration.

The compositions according to the invention for
 parenteral administration may be aqueous or nonaqueous

sterile solutions, suspensions or emulsions. Propylene glycol, vegetable oils, especially olive oil, and injectable organic esters, e.g. ethyl oleate, may be used as the solvent or the vehicle. These compositions may also
 5 contain adjuvants, especially wetting agents, emulsifiers or dispersants. The sterilization may be carried out in several ways, e.g. using a bacteriological filter, by incorporating sterilizing agents into the composition, by irradiation or by heating. They may also be in the form of
 10 sterile solid compositions which may be dissolved or dispersed in sterile water or any other injectable sterile medium.

The products of general formula (3) are more particularly used in the treatment of acute leukemias and
 15 solid tumors, at daily doses which are generally between 1 and 2 mg/kg by the intravenous (perfusion) route for an adult.

The water solubility of compounds of formula (3) may be improved by modification of the C2' and/or C7
 20 substituents to incorporate appropriate functional groups, E₁ and E₂. For increased water solubility, E₁ and E₂ may independently be hydrogen and -COGCR¹ wherein

G is ethylene, propylene, CH=CH, 1,2-cyclohexane, or 1,2-phenylene,

25 $R^1 = \text{OH base, } NR^2R^3, OR^3, SR^3, OCH_2CONR^4R^5, OH$

$R^2 = \text{hydrogen, methyl}$

$R^3 = (CH_2)_nNR^6R^7; (CH_2)_nN^{\oplus}R^6R^7R^8X^{\ominus}$

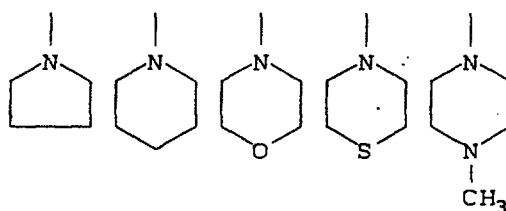
$n = 1 \text{ to } 3$

30 $R^4 = \text{hydrogen, lower alkyl containing 1 to 4 carbons}$

$R^5 = \text{hydrogen, lower alkyl containing 1 to 4 carbons, benzyl, hydroxyethyl, } CH_2CO_2H, \text{ dimethylaminoethyl}$

35 $R^6R^7 = \text{lower alkyl containing 1 or 2 carbons, benzyl or } R^6 \text{ and}$

R^7 together with the nitrogen atom of NR^6R^7
form the following rings



R^8 = lower alkyl containing 1 or 2 carbons, benzyl

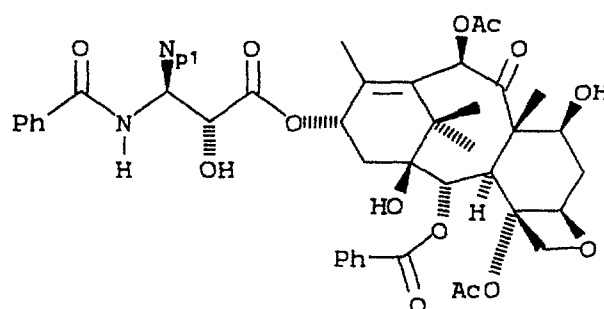
5 $X^\ominus$ = halide

base = NH_3 , $(HOC_2H_4)_3N$, $N(CH_3)_3$, $CH_3N(C_2H_4OH)_2$,
 $NH_2(CH_2)_6NH_2$, N-methylglucamine, NaOH, KOH.

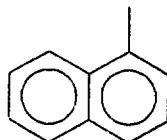
The preparation of compounds in which X_1 or X_2 is $-COGCOR^1$
is set forth in Hangwitz U.S. Patent 4,942,184 which is
10 incorporated herein by reference.

The following examples illustrate the invention.

EXAMPLE 1



wherein N_{Pl} is



Preparation of 3'-desphenyl-3'-(1-naphthyl) taxol.

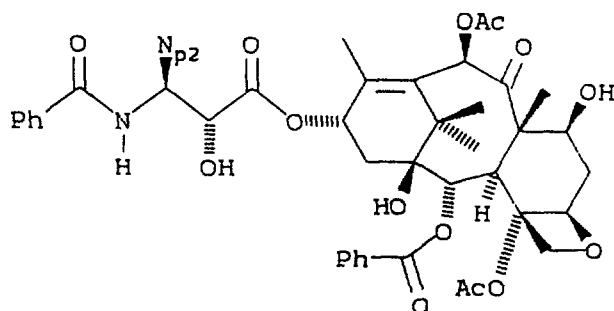
To a solution of 7-triethylsilyl baccatin III (200 mg, 0.286 mmol) in 2 mL of THF at -45°C was added dropwise 0.174 mL of a 1.63M solution of nBuLi in hexane. After 0.5 h at -45°C , a solution of *cis*-1-benzoyl-3-triethylsilyloxy-4-(1-naphthyl)azetidin-2-one (620 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 325 mg of a mixture containing (2'R,3'S)-2',7-(bis)triethylsilyl-3'-desphenyl-3'-(1-naphthyl) taxol and a small amount of the (2'S,3'R) isomer.

To a solution of 325 mg (0.287 mmol) of the mixture obtained from the previous reaction in 18 mL of acetonitrile and 0.93 mL of pyridine at 0°C was added 2.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 260 mg of material which was purified by flash chromatography to give 166 mg (64%) of 3'-(1-naphthyl) taxol, which was recrystallized from methanol/water.

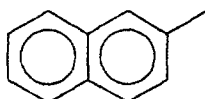
m.p. 164-165 °C; $[\alpha]_D^{25} -52.6^\circ$ (c 0.005, CHCl_3).

^1H NMR (CDCl_3 , 300 MHz) δ 8.11 (d, $J = 7.1$ Hz, 2H, benzoate ortho), 8.11 (m, 3H, aromatic), 7.91 (m, 3H, aromatic), 7.70 (m, 2H, aromatic), 7.63-7.46 (m, 7H, aromatic), 6.75 (d, $J = 8.8$ Hz, 1H, NH), 6.52 (dd, $J = 8.8, 1.6$ Hz, 1H, H3'), 6.27 (s, 1H, H10), 6.27 (dd, $J = 9.1, 9.1$ Hz, 1H, H13), 5.68 (d, $J = 7.1$ Hz, 1H, H2 β), 4.85 (dd, $J = 7.6, 2.2$ Hz, 1H, H5), 4.97 (dd, $J = 1.6$ Hz, 1H, H2'), 4.39 (m, 1H, H7), 4.24 (d, $J = 8.5$ Hz, 1H, H20 α), 4.17 (d, $J = 8.5$ Hz, 1H, H20 β), 3.80 (d, $J = 7.1$ Hz, 1H, H3), 3.65 (br, 1H, 2'OH), 2.55 (m, 1H, H6 α), 2.48 (br, 1H, 7OH), 2.41 (s, 3H, 4Ac), 2.38 (m, 1H, H14), 1.96 (s, 3H, 10Ac), 1.86 (m, 1H, H6 β), 1.80 (br s, 3H, Me18), 1.76 (s, 1H, 1OH), 1.69 (s, 3H, Me19), 1.28 (s, 3H, Me17), 1.16 (s, 3H, Me16).

EXAMPLE 2



wherein N_{p2} is



Preparation of 3'-desphenyl-3'-(2-naphthyl) taxol.

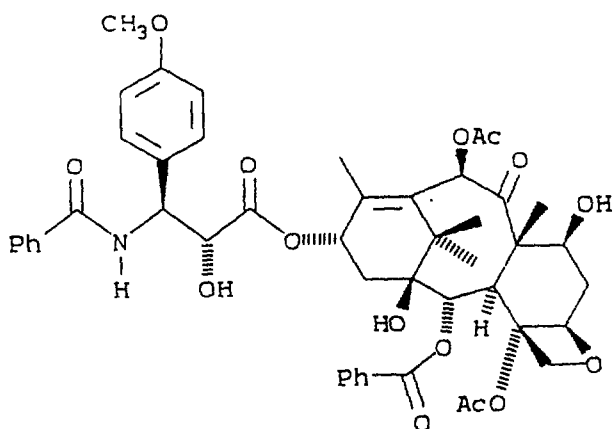
To a solution of 7-triethylsilyl baccatin III (200 mg, 0.286 mmol) in 2 mL of THF at -45°C was added dropwise 0.174 mL of a 1.63M solution of nBuLi in hexane. After 0.5 h at -45°C , a solution of *cis*-1-benzoyl-3-triethylsilyloxy-4-(2-naphthyl)azetidin-2-one (620 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 320 mg of a mixture containing (2'R,3'S)-2',7-(bis)triethylsilyl-3'-desphenyl-3'-(2-naphthyl) taxol and a small amount of the (2'S,3'R) isomer.

To a solution of 320 mg (0.283 mmol) of the mixture obtained from the previous reaction in 18 mL of acetonitrile and 0.93 mL of pyridine at 0°C was added 2.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 255 mg of material which was purified by flash chromatography to give 166 mg (64%) of 3'-desphenyl-3'-(2-naphthyl) taxol, which was recrystallized from

methanol/water.

m.p 164-165 °C; $[\alpha]_D^{25} -52.6^\circ$ (c 0.005, CHCl_3).

^1H NMR (CDCl_3 , 300 MHz) δ 8.14 (d, $J = 7.3$ Hz, 2H, benzoate *ortho*), 7.96 (m, 1H, aromatic), 7.90 (m, 1H, aromatic), 7.85 (m, 2H, aromatic), 7.76 (m, 2H, aromatic), 7.60 (m, 3H, aromatic), 7.52 (m, 4H, aromatic), 7.41 (m, 2H, aromatic), 7.01 (d, $J = 8.8$ Hz, 1H, NH), 6.27 (s, 1H, H10), 6.26 (dd, $J = 9.2$, 9.2 Hz, 1H, H13), 5.97 (dd, $J = 8.8$, 2.5 Hz, 1H, H3'), 5.68 (d, $J = 7.1$ Hz, 1H, H2 β), 4.93 (m, 1H, H5), 4.92 (m, 1H, H2'), 4.39 (m, 1H, H7), 4.30 (d, $J = 8.5$ Hz, 1H, H20 α), 4.20 (d, $J = 8.5$ Hz, 1H, H20 β), 3.81 (d, $J = 7.1$ Hz, 1H, H3), 3.60 (d, $J = 5$ Hz, 1H, 2'OH), 2.48 (m, 1H, H6 α), 2.45 (br, 1H, 7OH), 2.39 (s, 3H, 4Ac), 2.30 (m, 2H, H14), 2.24 (s, 3H, 10Ac), 1.83 (m, 1H, H6 β), 1.82 (br s, 3H, Me18), 1.68 (s, 1H, 1OH), 1.68 (s, 3H, Me19), 1.24 (s, 3H, Me17), 1.14 (s, 3H, Me16).

EXAMPLE 3

Preparation of 3'-desphenyl-3'-(4-methoxyphenyl) taxol.

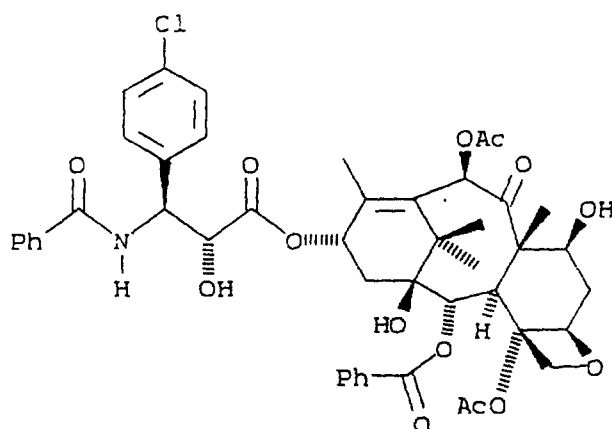
To a solution of 7-triethylsilyl baccatin III (200 mg, 0.286 mmol) in 2 mL of THF at -45°C was added dropwise 0.174 mL of a 1.63M solution of nBuLi in hexane. After 0.5 h at -45°C , a solution of *cis*-1-benzoyl-3-triethylsilyloxy-4-(4-methoxyphenyl)azetidin-2-one (590 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 320 mg of a mixture containing (2'R,3'S)-2',7-(bis)triethylsilyl-3'-desphenyl-3'-(4-methoxyphenyl) taxol and a small amount of the (2'S,3'R) isomer.

To a solution of 320 mg (0.288 mmol) of the mixture obtained from the previous reaction in 18 mL of acetonitrile and 0.93 mL of pyridine at 0°C was added 2.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 255 mg of material which was purified by flash chromatography to give 172 mg (68%) of 3'-desphenyl-3'-(4-methoxyphenyl) taxol, which was recrystallized from

methanol/water.

m.p. 174-176 °C; $[\alpha]_D^{25} -43.86^\circ$ (c 0.05, CHCl_3).

^1H NMR (CDCl_3 , 300 MHz) δ 8.12 (d, $J = 7.1$ Hz, 2H, benzoate ortho), 7.72 (m, 2H, aromatic), 7.59 (m, 1H, aromatic), 7.53-7.36 (m, 8H, aromatic), 6.96 (d, $J = 8.8$ Hz, 1H, NH), 6.90 (m, 2H, aromatic), 6.26 (s, 1H, H10), 6.21 (dd, $J = 9.3, 9.3$ Hz, 1H, H13), 5.70 (dd, $J = 8.8, 2.7$ Hz, 1H, H3'), 5.66 (d, $J = 6.8$ Hz, 1H, H2 β), 4.93 (dd, $J = 9.9, 2.2$ Hz, 1H, H5), 4.74 (dd, $J = 5.5, 2.7$ Hz, 1H, H2'), 4.39 (m, 1H, H7), 4.29 (d, $J = 8.8$ Hz, 1H, H20 α), 4.18 (d, $J = 8.8$ Hz, 1H, H20 β), 3.78 (d, $J = 6.3$ Hz, 1H, H3), 3.78 (s, 3H, ArOMe), 3.67 (d, $J = 5.5$ Hz, 1H, 2'OH), 2.61 (m, 1H, H6 α), 2.50 (d, $J = 4.4$ Hz, 1H, 7OH), 2.37 (s, 3H, 4Ac), 2.31 (m, 2H, H14), 2.22 (s, 3H, 10Ac), 1.84 (m, 1H, H6 β), 1.79 (br s, 3H, Me18), 1.79 (s, 1H, 1OH), 1.67 (s, 3H, Me19), 1.22 (s, 3H, Me17), 1.13 (s, 3H, Me16).

EXAMPLE 4

Preparation of 3'-desphenyl-3'-(4-chlorophenyl) taxol.

To a solution of 7-triethylsilyl baccatin III (200 mg, 0.286 mmol) in 2 mL of THF at -45°C was added dropwise 0.174 mL of a 1.63M solution of $n\text{BuLi}$ in hexane. After 0.5 h at -45°C , a solution of *cis*-1-benzoyl-3-triethylsilyloxy-4-(4-chlorophenyl)azetidin-2-one (595 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 320 mg of a mixture containing (2'R,3'S)-2',7-(bis)triethylsilyl 3'-desphenyl-3'-(4-chlorophenyl) taxol and a small amount of the (2'S,3'R) isomer.

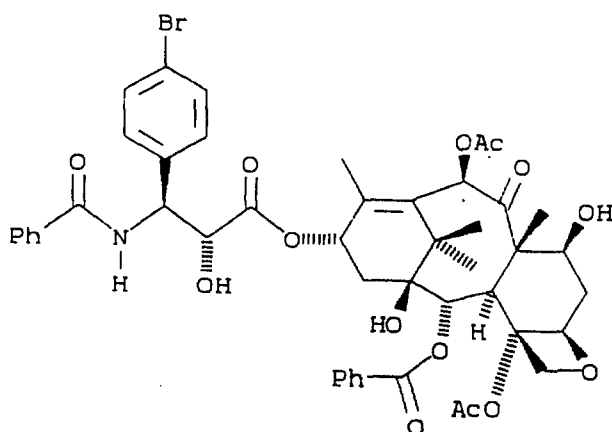
To a solution of 320 mg (0.287 mmol) of the mixture obtained from the previous reaction in 18 mL of acetonitrile and 0.93 mL of pyridine at 0°C was added 2.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 255 mg of material which was purified by flash chromatography to give 158 mg (62%) of 3'-desphenyl-3'-(4-chlorophenyl) taxol, which was recrystallized from

methanol/water.

m.p. 173-175 °C; $[\alpha]_D^{25} -50.8^\circ$ (c 0.01, CHCl₃).

¹H NMR (CDCl₃, 300 MHz) δ 8.13 (d, $J = 7.1$ Hz, 2H, benzoate ortho), 7.72 (d, $J = 8.2$ Hz, 2H, benzamide ortho), 7.65-7.35 (m, 10H, aromatic), 6.97 (d, $J = 8.8$ Hz, 1H, NH), 6.27 (s, 1H, H10), 6.25 (dd, $J = 8.3, 8.3$ Hz, 1H, H13), 5.78 (dd, $J = 8.8, 2.2$ Hz, 1H, H3'), 5.67 (d, $J = 7.1$ Hz, 1H, H2 β), 4.95 (dd, $J = 8.8, 2.2$ Hz, 1H, H5), 4.77 (br s, 1H, H2'), 4.40 (m, 1H, H7), 4.31 (d, $J = 8.2$ Hz, 1H, H20 α), 4.19 (d, $J = 8.2$ Hz, 1H, H20 β), 3.80 (d, $J = 7.1$ Hz, 1H, H3), 3.61 (br s, 1H, 2'OH), 2.54 (m, 1H, H6 α), 2.38 (s, 3H, 4Ac), 2.32 (m, 2H, H14), 2.24 (s, 3H, 10Ac), 1.85 (m, 1H, H6 β), 1.80 (br s, 3H, Me18), 1.68 (s, 3H, Me19), 1.23 (s, 3H, Me17), 1.14 (s, 3H, Me16).

EXAMPLE 5



Preparation of 3'-desphenyl-3'-(4-bromophenyl) taxol.

To a solution of 7-triethylsilyl baccatin III (200 mg, 0.286 mmol) in 2 mL of THF at -45°C was added dropwise 0.174 mL of a 1.63M solution of $n\text{BuLi}$ in hexane. After 0.5 h at -45°C , a solution of *cis*-1-benzoyl-3-triethylsilyloxy-4-(4-bromophenyl)azetidin-2-one (660 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 330 mg of a mixture containing (2'R,3'S)-2',7~(bis)triethylsilyl-3'-desphenyl-3'-(4-bromophenyl) taxol and a small amount of the (2'S,3'R) isomer.

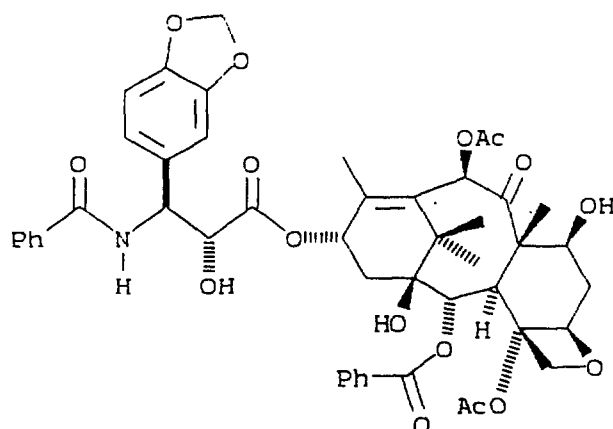
To a solution of 330 mg (0.284 mmol) of the mixture obtained from the previous reaction in 18 mL of acetonitrile and 0.93 mL of pyridine at 0°C was added 2.8 mL of 48% aqueous HF . The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 265 mg of material which was purified by flash chromatography to give 186 mg (64%) of 3'-desphenyl-3'-(4-bromophenyl) taxol, which was recrystallized from

methanol/water.

m.p. 170-172 °C; $[\alpha]_D^{25} -50.94^\circ$ (c 0.01, CHCl₃).

¹H NMR (CDCl₃, 300 MHz) δ 8.12 (d, $J = 7.2$ Hz, 2H, benzoate ortho), 7.71 (m, 2H, aromatic), 7.61 (m, 1H, aromatic), 7.50-7.47 (m, 6H, aromatic), 7.38 (m, 3H, aromatic), 7.04 (d, $J = 8.8$ Hz, 1H, NH), 6.27 (s, 1H, H10), 6.23 (dd, $J = 8.2, 8.2$ Hz, 1H, H13), 5.75 (dd, $J = 8.8, 2.2$ Hz, 1H, H3'), 5.66 (d, $J = 7.1$ Hz, 1H, H2 β), 4.94 (dd, $J = 9.3, 1.7$ Hz, 1H, H5), 4.75 (dd, $J = 2.2$ Hz, 1H, H2'), 4.38 (m, 1H, H7), 4.29 (d, $J = 8.2$ Hz, 1H, H20 α), 4.18 (d, $J = 8.2$ Hz, 1H, H20 β), 3.79 (d, $J = 7.1$ Hz, 1H, H3), 3.7 (br, 1H, 2'OH), 2.53 (m, 1H, H6 α), 2.38 (br, 1H, 7OH), 2.37 (s, 3H, 4Ac), 2.30 (m, 2H, H14), 2.23 (s, 3H, 10Ac), 1.87 (m, 1H, H6 β), 1.80 (br s, 3H, Me18), 1.80 (s, 1H, 1OH), 1.67 (s, 3H, Me19), 1.22 (s, 3H, Me17), 1.13 (s, 3H, Me16).

EXAMPLE 6



Preparation of 3'-desphenyl-3'-(3,4-methylenedioxyphenyl) taxol.

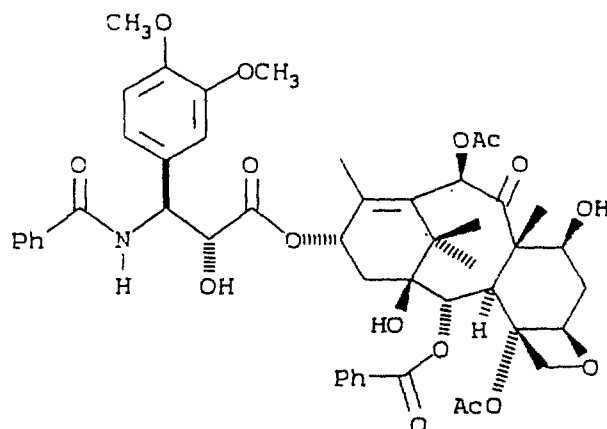
To a solution of 7-triethylsilyl baccatin III (200 mg, 0.286 mmol) in 2 mL of THF at -45°C was added dropwise 0.174 mL of a 1.63M solution of $n\text{BuLi}$ in hexane. After 0.5 h at -45°C , a solution of *cis*-1-benzoyl-3-triethylsilyloxy-4-(3,4-methylenedioxyphenyl)azetidin-2-one (610 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 320 mg of a mixture containing (2'R,3'S)-2',7-(bis)triethylsilyl-3'-desphenyl-3'-(3,4-methylenedioxyphenyl) taxol and a small amount of the (2'S,3'R) isomer.

To a solution of 320 mg (0.284 mmol) of the mixture obtained from the previous reaction in 18 mL of acetonitrile and 0.93 mL of pyridine at 0°C was added 2.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 113 mg of material which was purified by flash chromatography to give 165 mg (64%) of 3'-desphenyl-3'-(3,4-methylenedioxyphenyl) taxol.

(3,4-methylenedioxyphenyl) taxol, which was recrystallized from methanol/water.

m.p. 178-180 °C; $[\alpha]_D^{25} -46.6^\circ$ (c 0.005, CHCl_3).

^1H NMR (CDCl_3 , 300 MHz) δ 8.14 (d, $J = 7.2$ Hz, 2H, benzoate ortho), 7.72 (m, 2H, aromatic), 7.15 (m, 1H, aromatic), 7.50 (m, 2H, aromatic), 7.38 (m, 2H, aromatic), 7.0 (m, 1H, aromatic), 6.94 (m, 2H, aromatic), 6.88 (d, $J = 9.1$ Hz, 1H, NH), 6.83 (m, 1H, aromatic), 6.28 (s, 1H, H10), 6.23 (dd, $J = 9.1, 9.1$ Hz, 1H, H13), 5.97 (s, 2H, methylene), 5.69 (dd, $J = 9.1, 2.5$ Hz, 1H, H3'), 5.68 (d, $J = 6.9$ Hz, 1H, H2 β), 4.95 (dd, $J = 9.6, 2.2$ Hz, 1H, H5), 4.72 (dd, $J = 2.5$ Hz, 1H, H2'), 4.41 (m, 1H, H7), 4.31 (d, $J = 8.4$ Hz, 1H, H20 α), 4.20 (d, $J = 8.4$ Hz, 1H, H20 β), 3.81 (d, $J = 6.9$ Hz, 1H, H3), 3.60 (br, 1H, 2'OH), 2.56 (m, 1H, H6 α), 2.43 (d, $J = 4.1$ Hz, 1H, 7OH), 2.39 (s, 3H, 4Ac), 2.31 (m, 2H, H14), 2.24 (s, 3H, 10Ac), 1.88 (m, 1H, H6 β), 1.82 (br s, 3H, Me18), 1.69 (s, 1H, 1OH), 1.68 (s, 3H, Me19), 1.24 (s, 3H, Me17), 1.15 (s, 3H, Me16).

EXAMPLE 7

Preparation of 3'-desphenyl-3'-(3,4-dimethoxyphenyl)
taxol.

To a solution of 7-triethylsilyl baccatin III (200 mg, 0.286 mmol) in 2 mL of THF at -45°C was added dropwise 0.174 mL of a 1.63M solution of nBuLi in hexane. After 0.5 h at -45°C , a solution of *cis*-1-benzoyl-3-triethylsilyloxy-4-(3,4-dimethoxyphenyl)azetidin-2-one (630 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 330 mg of a mixture containing (2'R,3'S)-2',7-(bis)triethylsilyl-3'-desphenyl-3'-(3,4-dimethoxyphenyl) taxol and a small amount of the (2'S,3'R) isomer.

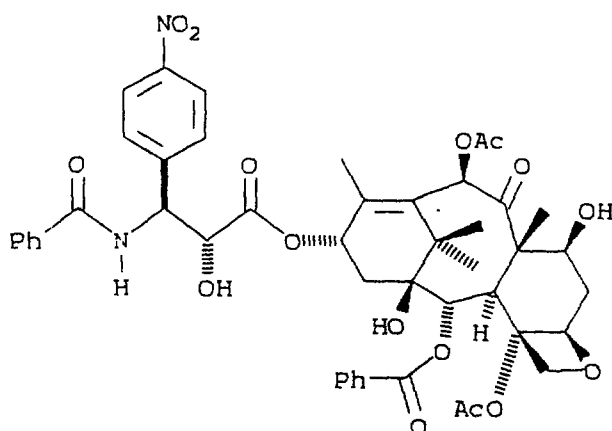
To a solution of 330 mg (0.286 mmol) of the mixture obtained from the previous reaction in 18 mL of acetonitrile and 0.93 mL of pyridine at 0°C was added 2.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 260 mg of material which was purified by flash chromatography to give 175 mg (67%) of 3'-desphenyl-3'-(3,4-dimethoxyphenyl)taxol.

(3,4-dimethoxyphenyl) taxol, which was recrystallized from methanol/water.

m.p. 165-167 °C; $[\alpha]_D^{25} -42.0^\circ$ (c 0.005, CHCl₃).

¹H NMR (CDCl₃, 300 MHz) δ 8.12 (d, $J = 8.3$ Hz, 2H, benzoate ortho), 7.73 (d, $J = 8.2$ Hz, 2H, benzamide ortho), 7.65-7.35 (m, 6H, aromatic), 7.1-7.0 (m, 2H, aromatic), 6.94 (d, $J = 8.8$ Hz, 1H, NH), 6.88 (d, $J = 8.3$ Hz, 2H, aromatic), 6.27 (s, 1H, H10), 6.21 (dd, $J = 9.3, 9.3$ Hz, 1H, H13), 5.69 (m, 2H, H3, H2 β), 4.94 (dd, Hz, $J = 9.9, 2.2$ Hz, 1H, H5), 4.77 (d, $J = 2.8$ Hz, 1H, H2'), 4.39 (dd, $J = 11.0, 6.6$ Hz, 1H, H7), 4.30 (d, $J = 8.5$ Hz, 1H, H20 α), 4.19 (d, $J = 8.5$ Hz, 1H, H20 β), 3.88 (s, 3H, ArOMe), 3.87 (s, 3H, ArOMe), 3.80 (d, $J = 7.1$ Hz, 1H, H3), 3.59 (d, $J = 4.4$ Hz, 1H, 2'OH), 2.54 (m, 1H, H6 α), 2.38 (s, 3H, 4Ac), 2.36 (m, 2H, H14 α , H14 β), 2.23 (s, 3H, 10Ac), 1.86 (m, 1H, H6 β), 1.80 (br s, 3H, Me18), 1.68 (s, 3H, Me19), 1.23 (s, 3H, Me17), 1.14 (s, 3H, Me16).

EXAMPLE 8



Preparation of 3'-desphenyl-3'-(4-nitrophenyl) taxol.

To a solution of 7-triethylsilyl baccatin III (200 mg, 0.286 mmol) in 2 mL of THF at -45 °C was added dropwise 0.174 mL of a 1.63M solution of nBuLi in hexane. After 0.5 h at -45 °C, a solution of *cis*-1-benzoyl-3-triethylsilyloxy-4-(4-nitrophenyl)azetidin-2-one (610 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0 °C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO₃ and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 320 mg of a mixture containing (2'R,3'S)-2',7-(bis)triethylsilyl-3'-desphenyl-3'-(4-nitrophenyl) taxol and a small amount of the (2'S,3'R) isomer.

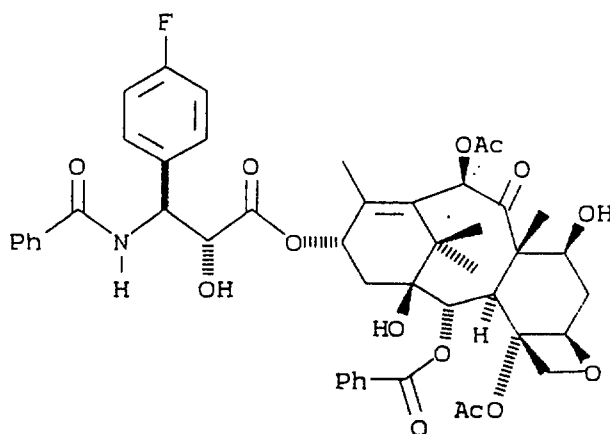
To a solution of 320 mg (0.284 mmol) of the mixture obtained from the previous reaction in 18 mL of acetonitrile and 0.93 mL of pyridine at 0 °C was added 2.8 mL of 48% aqueous HF. The mixture was stirred at 0 °C for 3 h, then at 25 °C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 255 mg of material which was purified by flash chromatography to give 147 mg (57%) of 3'-desphenyl-3'-(4-nitrophenyl) taxol, which was recrystallized from

methanol/water.

m.p. 188-190 °C; $[\alpha]_D^{25}$, -63.7° (c 0.01, CHCl₃).

¹H NMR (CDCl₃, 300 MHz) δ 8.26 (d, *J* = 8.8 Hz, 2H, benzoate ortho), 8.20 (m, 2H, aromatic), 7.73 (m, 4H, aromatic), 7.60 (m, 1H, aromatic), 7.52 (m, 4H, aromatic), 7.41 (m, 1H, aromatic), 7.15 (d, *J* = 8.8 Hz, 1H, NH), 6.26 (s, 1H, H10), 6.26 (dd, *J* = 9.3, 9.3 Hz, 1H, H13), 5.93 (dd, *J* = 8.8, 2.8 Hz, 1H, H3'), 5.66 (d, *J* = 6.6 Hz, 1H, H2β), 4.94 (dd, *J* = 9.3, 1.7 Hz, 1H, H5), 4.82 (dd, *J* = 3.9, 2.8 Hz, 1H, H2'), 4.38 (m, 1H, H7), 4.30 (d, *J* = 8.8 Hz, 1H, H20α), 4.19 (d, *J* = 8.8 Hz, 1H, H20β), 3.86 (d, *J* = 3.9 Hz, 1H, 2'OH), 3.79 (d, *J* = 6.6 Hz, 1H, H3), 2.55 (m, 1H, H6α), 2.46 (d, *J* = 3.8 Hz, 1H, 7OH), 2.41 (s, 3H, 4Ac), 2.38 (m, 2H, H14), 2.23 (s, 3H, 10Ac), 1.82 (m, 1H, H6β), 1.80 (br s, 3H, Me18), 1.74 (s, 1H, 1OH), 1.68 (s, 3H, Me19), 1.21 (s, 3H, Me17), 1.13 (s, 3H, Me16).

EXAMPLE 9



Preparation of 3'-desphenyl-3'-(4-fluorophenyl) taxol.

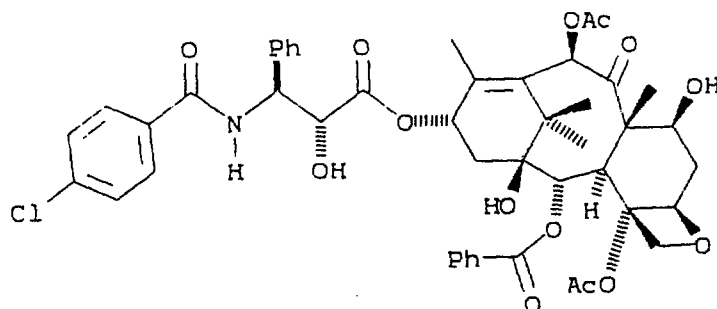
To a solution of 7-triethylsilyl baccatin III (200 mg, 0.286 mmol) in 2 mL of THF at -45°C was added dropwise 0.174 mL of a 1.63M solution of $n\text{BuLi}$ in hexane. After 0.5 h at -45°C , a solution of *cis*-1-benzoyl-3-triethylsilyloxy-4-(4-fluorophenyl)azetidin-2-one (570 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 315 mg of a mixture containing (2'R,3'S)-2',7-(bis)triethylsilyl-3'-desphenyl-3'-(4-fluorophenyl) taxol and a small amount of the (2'S,3'R) isomer.

To a solution of 315 mg (0.286 mmol) of the mixture obtained from the previous reaction in 18 mL of acetonitrile and 0.93 mL of pyridine at 0°C was added 2.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 250 mg of material which was purified by flash chromatography to give 160 mg (64%) of 3'-desphenyl-3'-(4-fluorophenyl) taxol, which was recrystallized from

methanol/water.

m.p. 171-173 °C; $[\alpha]_D^{25} -49.0^\circ$ (c 0.005, CHCl₃).

¹H NMR (CDCl₃, 300 MHz) δ 8.13 (d, $J = 7.5$ Hz, 2H, benzoate ortho), 7.25 (m, 2H, aromatic), 7.61 (m, 1H, aromatic), 7.50 (m, 4H, aromatic), 7.43 (m, 2H, aromatic), 7.10 (m, 2H, aromatic), 6.96 (d, $J = 8.7$ Hz, 1H, NH), 6.27 (s, 1H, H10), 6.25 (dd, $J = 8.7, 8.7$ Hz, 1H, H13), 5.79 (dd, $J = 8.7, 2.4$ Hz, 1H, H3'), 5.67 (d, $J = 7.1$ Hz, 1H, H2 β), 4.45 (dd, $J = 7.9$ Hz, 1H, H5), 4.76 (dd, $J = 4.8, 2.4$ Hz, 1H, H2'), 4.39 (m, 1H, H7), 4.31 (d, $J = 8.9$ Hz, 1H, H20 α), 4.20 (d, $J = 8.9$ Hz, 1H, H20 β), 3.80 (d, $J = 7.1$ Hz, 1H, H3), 3.57 (d, $J = 4.8$ Hz, 1H, 2'OH), 2.58 (m, 1H, H6a), 2.43 (d, $J = 4.3$ Hz, 1H, 7OH), 2.38 (s, 3H, 4Ac), 2.30 (m, 2H, H14), 2.24 (s, 3H, 10Ac), 1.85 (m, 1H, H6 β), 1.80 (br s, 3H, Me18), 1.69 (s, 1H, 1OH), 1.55 (s, 3H, Me19), 1.23 (s, 3H, Me17), 1.14 (s, 3H, Me16).

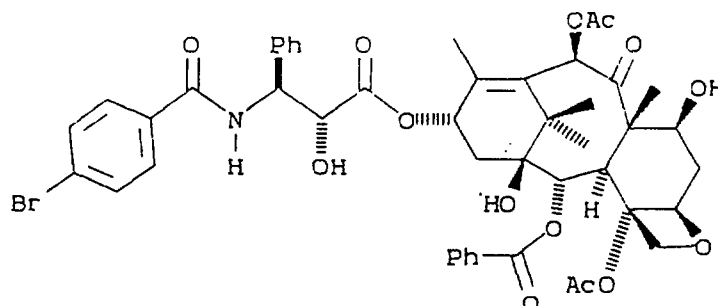
EXAMPLE 10Preparation of *N*-debenzoyl-*N*-(4-chlorobenzoyl) taxol.

To a solution of 7-triethylsilyl baccatin III (200 mg, 0.286 mmol) in 2 mL of THF at -45°C was added dropwise 0.174 mL of a 1.63M solution of *n*BuLi in hexane. After 0.5 h at -45°C , a solution of (+)-*cis*-1-(4-chlorobenzoyl)-3-triethylsilyloxy-4-phenylazetidin-2-one (215 mg, 0.515 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 2 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 320 mg of crude (2'R,3'S)-2',7-(bis)triethylsilyl-*N*-debenzoyl-*N*-(4-chlorobenzoyl) taxol.

To a solution of 320 mg (0.286 mmol) of this crude product in 18 mL of acetonitrile and 0.93 mL of pyridine at 0°C was added 2.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 252 mg of material which was purified by flash chromatography to give 213 mg (84%) of *N*-debenzoyl-*N*-(4-chlorobenzoyl) taxol, which was recrystallized from methanol/water.

m.p. 179-181 °C; $[\alpha]^{25}_{D_a} -49.8^\circ$ (c 0.01, CHCl₃).

¹H NMR (CDCl₃, 300 MHz) δ 8.12 (d, J = 7.1 Hz, 2H, benzoate ortho), 7.64 (m, 2H, aromatic), 7.60 (m, 1H, aromatic), 7.49 (m, 9H, aromatic), 7.03 (d, J = 8.8 Hz, 1H, NH), 6.26 (s, 1H, H10), 6.21 (dd, J = 8.2, 8.2 Hz, 1H, H13), 5.76 (dd, J = 8.8, 2.2 Hz, 1H, H3'), 5.66 (d, J = 7.1 Hz, 1H, H2 β), 4.92 (dd, J = 9.9, 1.1 Hz, 1H, H5), 4.77 (dd, J = 5.5, 2.2 Hz, 1H, H2'), 4.38 (m, 1H, H7), 4.29 (d, J = 8.8 Hz, 1H, H20 α), 4.18 (d, J = 8.5 Hz, 1H, H20 β), 3.78 (d, J = 6.6 Hz, 1H, H3), 3.35 (d, J = 5.5 Hz, 1H, 2'OH), 2.55 (m, 1H, H6 α), 2.49 (d, J = 4.2 Hz, 1H, 7OH), 2.36 (s, 3H, 4Ac), 2.28 (m, 2H, H14), 2.22 (s, 3H, 10Ac), 1.85 (m, 1H, H6 β), 1.77 (br s, 3H, Me18), 1.76 (s, 1H, 1OH), 1.67 (s, 3H, Me19), 1.22 (s, 3H, Me17), 1.13 (s, 3H, Me16).

EXAMPLE 11

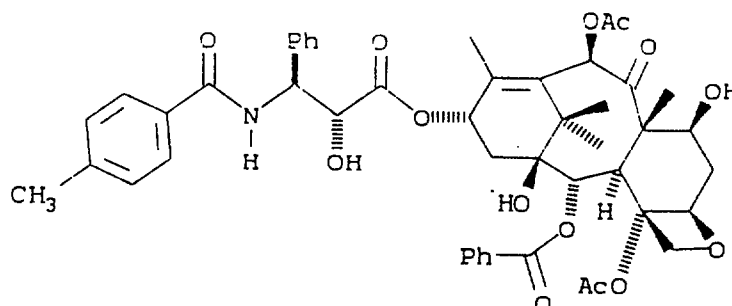
Preparation of N-debenzoyl-N-(4-bromobenzoyl) taxol.

To a solution of 7-triethylsilyl baccatin III (200 mg, 0.285 mmol) in 2 mL of THF at -45°C was added dropwise 0.175 mL of a 1.63M solution of nBuLi in hexane. After 0.5 h at -45°C , a solution of (+)-cis-1-(4-bromobenzoyl)-3-triethylsilyloxy-4-phenylazetidin-2-one (236 mg, 0.513 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 2 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 322 mg of crude (2'R,3'S)-2',7-(bis)triethylsilyl-N-debenzoyl-N-(4-bromobenzoyl) taxol.

To a solution of 322 mg of this crude product in 12 mL of acetonitrile and 0.6 mL of pyridine at 0°C was added 1.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 312.2 mg of material which was purified by flash chromatography to give 254 mg (96%) of N-debenzoyl-N-(4-bromobenzoyl) taxol, which was recrystallized from methanol/water.

m.p. 182.5-185 °C; $[\alpha]_D^{25} -47.8^\circ$ (c 0.0051, CHCl_3).

^1H NMR (CDCl_3 , 300 MHz) δ 8.14 (d, $J = 7.1$ Hz, 2H, benzcate ortho), 7.7-7.3 (m, 12H, aromatic), 6.96 (d, $J = 8.8$ Hz, 1H, NH), 6.27 (s, 1H, H10), 6.22 (dd, $J = 9.1, 9.1$ Hz, 1H, H13), 5.77 (dd, $J = 8.8, 2.2$ Hz, 1H, H3'), 5.67 (d, $J = 7.2$ Hz, 1H, H2b), 4.94 (dd, $J = 9.9, 2.2$ Hz, 1H, H5), 4.78 (dd, $J = 5.0, 2.7$ Hz, 1H, H2'), 4.40 (m, 1H, H7), 4.30 (d, $J = 8.5$ Hz, 1H, H20 α), 4.19 (d, $J = 8.5$ Hz, 1H, H20 β), 3.79 (d, $J = 7.2$ Hz, 1H, H3), 3.48 (d, $J = 5.0$ Hz, 1H, 2'OH), 2.54 (m, 1H, H6 α), 2.45 (d, $J = 4.4$ Hz, 1H, 7OH), 2.37 (s, 3H, 4Ac), 2.30 (m, 2H, H14 α , H14 β), 2.24 (s, 3H, 10Ac), 1.88 (m, 1H, H6 β), 1.78 (br s, 3H, Me18), 1.68 (s, 3H, Me19), 1.24 (s, 3H, Me17), 1.14 (s, 3H, Me16).

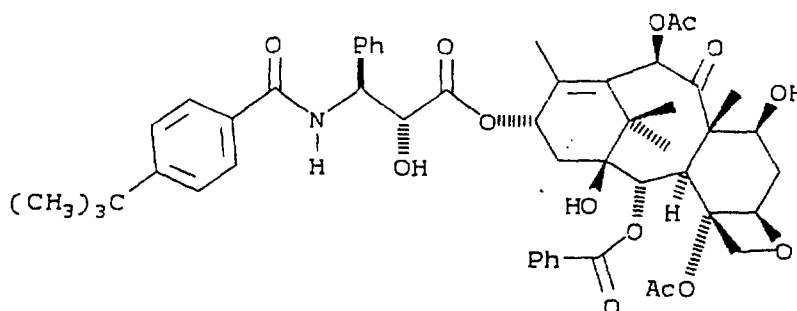
EXAMPLE 12Preparation of *N*-debenzoyl-*N*-(4-methylbenzoyl) taxol.

To a solution of 7-triethylsilyl baccatin III (200 mg, 0.285 mmol) in 2 mL of THF at -45°C was added dropwise 0.175 mL of a 1.63M solution of *n*BuLi in hexane. After 0.5 h at -45°C , a solution of (+)-*cis*-1-(4-methylbenzoyl)-3-triethylsilyloxy-4-phenylazetidin-2-one (203 mg, 0.513 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 2 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 386 mg of crude (2'R,3'S)-2',7-(bis)triethylsilyl-*N*-debenzoyl-*N*-(4-methylbenzoyl) taxol.

To a solution of 386 mg of this crude product in 6 mL of acetonitrile and 0.3 mL of pyridine at 0°C was added 0.9 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 283 mg of material which was purified by flash chromatography to give 240 mg (97%) of *N*-debenzoyl-*N*-(4-methylbenzoyl) taxol, which was recrystallized from methanol/water.

m.p. 175-176.5 °C; $[\alpha]^{25}_{Na} -50.9^{\circ}$ (c 0.00975, CHCl₃).

¹H NMR (CDCl₃, 300 MHz) δ 8.13 (d, J = 7.1 Hz, 2H, benzoate ortho), 7.7-7.3 (m, 10H, aromatic), 7.19 (d, J = 7.7 Hz, 2H, benzoate meta), 6.94 (d, J = 8.8 Hz, 1H, NH), 6.27 (s, 1H, H10), 6.22 (dd, J = 9.3, 9.3 Hz, 1H, H13), 5.77 (dd, J = 9.3, 2.8 Hz, 1H, H3'), 5.67 (d, J = 7.2 Hz, 1H, H2b), 4.94 (dd, J = 9.9, 2.2 Hz, 1H, H5), 4.78 (dd, J = 4.9, 2.8 Hz, 1H, H2'), 4.42 (m, 1H, H7), 4.30 (d, J = 8.5 Hz, 1H, H20a), 4.19 (d, J = 8.5 Hz, 1H, H20b), 3.79 (d, J = 7.2 Hz, 1H, H3), 3.60 (d, J = 4.9 Hz, 1H, 2'OH), 2.53 (m, 1H, H6a), 2.46 (d, J = 4.4 Hz, 1H, 7OH), 2.38 (s, 3H, 4Ac), 2.37 (s, 3H, ArMe), 2.31 (m, 2H, H14a, H14b), 2.23 (s, 3H, 10Ac), 1.87 (m, 1H, H6b), 1.78 (br s, 3H, Me18), 1.68 (s, 3H, Me19), 1.23 (s, 3H, Me17), 1.14 (s, 3H, Me16).

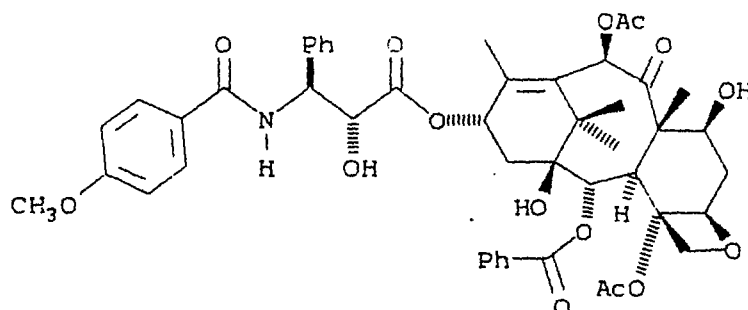
EXAMPLE 13Preparation of N-debenzoyl-N-(4-t-butylbenzoyl) taxol.

To a solution of 7-triethylsilyl baccatin III (200 mg, 0.286 mmol) in 2 mL of THF at -45°C was added dropwise 0.174 mL of a 1.63M solution of *n*BuLi in hexane. After 0.5 h at -45°C , a solution of (+)-*cis*-1-(4-*t*-butylbenzoyl)-3-triethylsilyloxy-4-phenylazetidin-2-one (226 mg, 0.515 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 2 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 330 mg of crude (2'*R*,3'*S*)-2',7-(bis)triethylsilyl-N-debenzoyl-N-(4-*t*-butylbenzoyl) taxol.

To a solution of 330 mg (0.289 mmol) of this crude product in 18 mL of acetonitrile and 0.93 mL of pyridine at 0°C was added 2.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 260 mg of material which was purified by flash chromatography to give 240 mg (92%) of N-debenzoyl-N-(4-*t*-butylbenzoyl) taxol, which was recrystallized from methanol/water.

m.p. 171-173 °C; $[\alpha]_D^{25} -49.1^\circ$ (c 0.05, CHCl_3).

^1H NMR (CDCl_3 , 300 MHz) δ 8.13 (d, $J = 7.1$ Hz, 2H, benzoate *ortho*), 7.76-7.25 (m, 12H, aromatic), 6.98 (d, $J = 8.8$ Hz, 1H, NH), 6.27 (s, 1H, H10), 6.21 (dd, $J = 8.8, 8.8$ Hz, 1H, H13), 5.77 (dd, $J = 8.8, 2.7$ Hz, 1H, H3'), 5.67 (d, $J = 6.6$ Hz, 1H, H2 β), 4.94 (dd, $J = 9.3, 1.2$ Hz, 1H, H5), 4.78 (dd, $J = 4.4, 2.7$ Hz, 1H, H2'), 4.38 (m, 1H, H7), 4.29 (d, $J = 8.2$ Hz, 1H, H20 α), 4.20 (d, $J = 8.2$ Hz, 1H, H20 β), 3.79 (d, $J = 6.6$ Hz, 1H, H3), 3.65 (d, $J = 4.4$ Hz, 1H, 2'OH), 2.57 (m, 1H, H6 α), 2.48 (d, $J = 4.1$ Hz, 1H, 7OH), 2.37 (s, 3H, 4Ac), 2.31 (m, 2H, H14), 2.22 (s, 3H, 10Ac), 1.85 (m, 1H, H6 β), 1.79 (br s, 3H, Me18), 1.68 (s, 1H, 1OH), 1.68 (s, 3H, Me19), 1.29 (s, 9H, Ar^tBu), 1.23 (s, 3H, Me17), 1.13 (s, 3H, Me16).

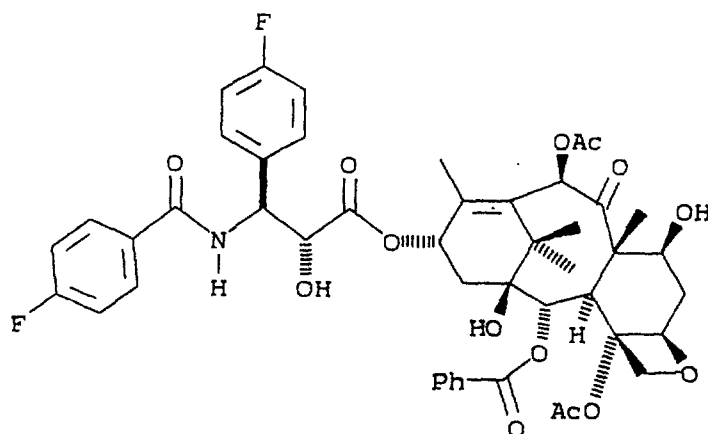
EXAMPLE 14Preparation of *N*-debenzoyl-*N*-(4-methoxybenzoyl) taxol.

To a solution of 7-triethylsilyl baccatin III (200 mg, 0.285 mmol) in 2 mL of THF at -45°C was added dropwise 0.175 mL of a 1.63M solution of *n*BuLi in hexane. After 0.5 h at -45°C , a solution of (+)-*cis*-1-(4-methoxybenzoyl)-3-triethylsilyloxy-4-phenylazetidin-2-one (211 mg, 0.513 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 2 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 406 mg of crude (2'*R*,3'*S*)-2',7-(bis)triethylsilyl-*N*-debenzoyl-*N*-(4-methoxybenzoyl) taxol.

To a solution of 406 mg (0.112 mmol) of this crude product in 12 mL of acetonitrile and 0.6 mL of pyridine at 0°C was added 1.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 308 mg of material which was purified by flash chromatography to give 236 mg (94%) of *N*-debenzoyl-*N*-(4-methoxybenzoyl) taxol, which was recrystallized from methanol/water.

m.p. 174.5-176 °C; $[\alpha]^{25}_{Na} -49.5^{\circ}$ (c 0.0084, $CHCl_3$).

1H NMR ($CDCl_3$, 300 MHz) δ 8.13 (d, $J = 7.1$ Hz, 2H, benzoate ortho), 7.75-7.3 (m, 10H, aromatic), 6.90 (d, $J = 8.2$ Hz, 1H, NH), 6.88 (d, $J = 7.1$ Hz, 2H, benzoate meta), 6.27 (s, 1H, H10), 6.22 (dd, $J = 8.8, 8.8$ Hz, 1H, H13), 5.76 (dd, $J = 8.8, 2.7$ Hz, 1H, H3'), 5.67 (d, $J = 7.1$ Hz, 1H, H2), 4.94 (dd, $J = 9.9, 2.2$ Hz, 1H, H5), 4.78 (d, $J = 2.7$ Hz, 1H, H2'), 4.40 (dd, $J = 11.0, 7.1$ Hz, 1H, H7), 4.30 (d, $J = 8.5$ Hz, 1H, H20 α), 4.19 (d, $J = 8.5$ Hz, 1H, H20 β), 3.82 (s, 3H, OMe), 3.79 (d, $J = 7.1$ Hz, 1H, H3), 2.55 (m, 1H, H6 α), 2.38 (s, 3H, 4Ac), 2.30 (m, 2H, H14 α , H14 β), 2.23 (s, 3H, 10Ac), 1.87 (m, 1H, H6 β), 1.78 (br s, 3H, Me18), 1.68 (s, 3H, Me19), 1.23 (s, 3H, Me17), 1.14 (s, 3H, Me16).

EXAMPLE 15

Preparation of *N*-debenzoyl-*N*-(4-fluorobenzoyl)-3'-desphenyl-3'-(4-fluorophenyl) taxol.

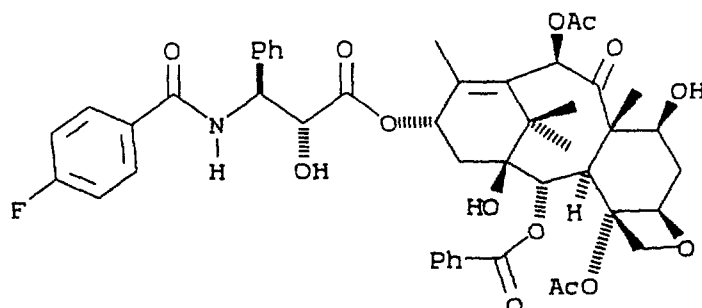
To a solution of 7-triethylsilyl baccatin III (200 mg, 0.286 mmol) in 2 mL of THF at -45°C was added dropwise 0.174 mL of a 1.63M solution of *n*BuLi in hexane. After 0.5 h at -45°C , a solution of *cis*-1-(4-fluorobenzoyl)-3-triethylsilyloxy-4-(4-fluorophenyl)azetidin-2-one (600 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 315 mg of a mixture containing (2'R,3'S)-2',7-(bis)triethylsilyl-*N*-debenzoyl-*N*-(4-fluorobenzoyl)-3'-desphenyl-3'-(4-fluorophenyl) taxol and a small amount of the (2'S,3'R) isomer.

To a solution of 315 mg (0.282 mmol) of the mixture obtained from the previous reaction in 18 mL of acetonitrile and 0.93 mL of pyridine at 0°C was added 2.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 250 mg of material which was purified by flash chromatography to give 160 mg (63%) of *N*-debenzoyl-*N*-(4-

fluorobenzoyl)-3'-desphenyl-3'-(4-fluorophenyl) taxol, which was recrystallized from methanol/water.

m.p. 177-179 °C; $[\alpha]_D^{25} -48.8^\circ$ (c 0.003, CHCl₃).

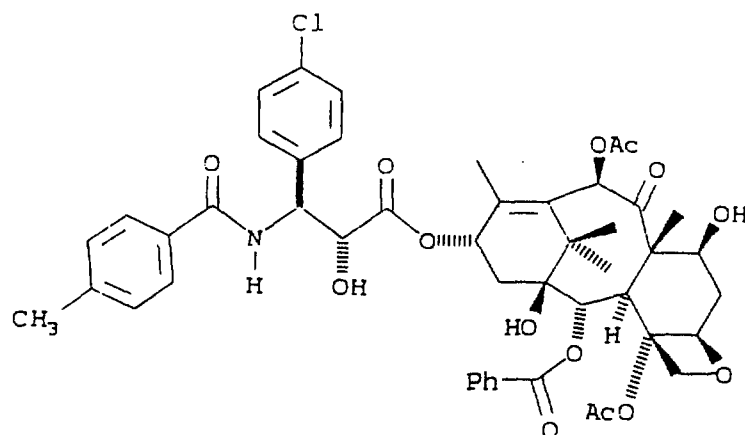
¹H NMR (CDCl₃, 300 MHz) δ 8.11 (d, $J = 7.1$ Hz, 2H, benzoate ortho), 7.76 (d, $J = 8.7$ Hz, 2H, benzamide ortho), 7.73 (m, 2H, aromatic), 7.61 (m, 1H, aromatic), 7.48 (m, 6H, aromatic), 7.06 (m, 2H, aromatic), 7.02 (d, $J = 8.8$ Hz, 1H, NH), 6.26 (s, 1H, H10), 6.22 (dd, $J = 8.8, 8.8$ Hz, 1H, H13), 5.74 (dd, $J = 8.8, 2.2$ Hz, 1H, H3'), 5.66 (d, $J = 7.1$ Hz, 1H, H2 β), 4.93 (dd, $J = 9.3, 1.1$ Hz, 1H, H5), 4.74 (dd, $J = 5.0, 2.2$ Hz, 1H, H2'), 4.36 (m, 1H, H7), 4.29 (d, $J = 8.8$ Hz, 1H, H20 α), 4.18 (d, $J = 8.8$ Hz, 1H, H20 β), 3.77 (d, $J = 7.1$ Hz, 1H, H3), 3.70 (d, $J = 5.0$ Hz, 1H, 2'OH), 2.77 (m, 1H, H6 α), 2.52 (d, $J = 4.4$ Hz, 1H, 7OH), 2.36 (s, 3H, 4Ac), 2.30 (m, 2H, H14), 2.22 (s, 3H, 10Ac), 1.86 (m, 1H, H6 β), 1.78 (br s, 3H, Me18), 1.77 (s, 1H, 1OH), 1.67 (s, 3H, Me19), 1.21 (s, 3H, Me17), 1.13 (s, 3H, Me16).

EXAMPLE 16Preparation of *N*-debenzoyl-*N*-(4-fluorobenzoyl) taxol.

To a solution of 7-triethylsilyl baccatin III (200 mg, 0.286 mmol) in 2 mL of THF at -45°C was added dropwise 0.174 mL of a 1.63M solution of *n*BuLi in hexane. After 0.5 h at -45°C , a solution of (+)-*cis*-1-(4-fluorobenzoyl)-3-triethylsilyloxy-4-phenylazetidin-2-one (225 mg, 0.515 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 2 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 325 mg of crude (2'R,3'S)-2',7-(bis)triethylsilyl- *N*-debenzoyl-*N*-(4-fluorobenzoyl) taxol.

To a solution of 325 mg (0.286 mmol) of this crude product in 18 mL of acetonitrile and 0.93 mL of pyridine at 0°C was added 2.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 260 mg of material which was purified by flash chromatography to give 240 mg (92%) of *N*-debenzoyl-*N*-(4-fluorobenzoyl) taxol, which was recrystallized from methanol/water.

m.p. 175-177 °C; $[\alpha]_D^{25} -51.2^\circ$ (c 0.01, CHCl_3).
 ^1H NMR (CDCl_3 , 300 MHz) δ 8.13 (d, $J = 7.1$ Hz, 2H, benzoate ortho), 7.74 (m, 2H, aromatic), 7.62 (m, 2H, aromatic), 7.46 (m, 6H, aromatic), 7.06 (m, 2H, aromatic), 6.95 (d, $J = 8.8$ Hz, 1H, NH), 6.28 (s, 1H, H10), 6.22 (dd, $J = 8.2, 8.2$ Hz, 1H, H13), 5.76 (dd, $J = 8.8, 2.8$ Hz, 1H, H3'), 5.67 (d, $J = 7.1$ Hz, 1H, H2 β), 4.93 (dd, $J = 9.9, 2.2$ Hz, 1H, H5), 4.78 (dd, $J = 5.5, 2.8$ Hz, 1H, H2'), 4.39 (m, 1H, H7), 4.30 (d, $J = 8.8$ Hz, 1H, H20 α), 4.22 (d, $J = 8.8$ Hz, 1H, H20 β), 3.79 (d, $J = 7.1$ Hz, 1H, H3), 3.54 (d, $J = 5.5$ Hz, 1H, 2'OH), 2.54 (m, 1H, H6 α), 2.46 (d, $J = 4.4$ Hz, 1H, 7OH), 2.37 (s, 3H, 4Ac), 2.30 (m, 2H, H14), 2.26 (s, 3H, 10Ac), 1.87 (m, 1H, H6 β), 1.79 (br s, 3H, Me18), 1.79 (s, 1H, 1OH), 1.67 (s, 3H, Me19), 1.24 (s, 3H, Me17), 1.12 (s, 3H, Me16).

EXAMPLE 17

Preparation of *N*-debenzoyl-*N*-(4-methylbenzoyl)-3'-desphenyl-3'-(4-chlorophenyl) taxol.

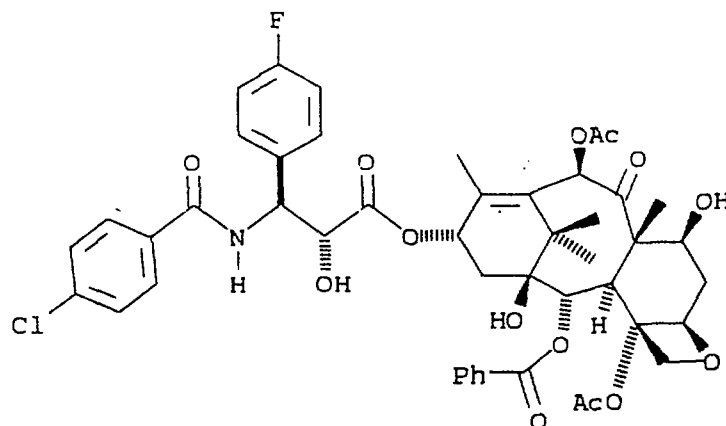
To a solution of 7-triethylsilyl baccatin III (200 mg, 0.285 mmol) in 2 mL of THF at -45°C was added dropwise 0.175 mL of a 1.63M solution of *n*BuLi in hexane. After 0.5 h at -45°C , a solution of *cis*-1-(4-methylbenzoyl)-3-triethylsilyloxy-4-(4-chlorophenyl)azetidin-2-one (718 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 329 mg of a mixture containing (2'R,3'S)-2',7-(bis)triethylsilyl-*N*-debenzoyl-*N*-(4-methylbenzoyl)-3'-desphenyl-3'-(4-chlorophenyl) taxol and a small amount of the (2'S,3'R) isomer.

To a solution of 329 mg of the mixture obtained from the previous reaction in 12 mL of acetonitrile and 0.6 mL of pyridine at 0°C was added 1.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 376 mg of material which was purified by flash chromatography to give 175 mg (68%) of *N*-debenzoyl-*N*-(4-methylbenzoyl)-3'-

desphenyl-3'-(4-chlorophenyl) taxol, which was recrystallized from methanol/water.

m.p. 167.5-171 °C; $[\alpha]_D^{25} -53.7^\circ$ (c 0.01105, CHCl_3).

^1H NMR (CDCl_3 , 300 MHz) δ 8.12 (d, $J = 8.2$ Hz, 2H, benzoate ortho), 7.65-7.3 (m, 9H, aromatic), 7.19 (d, $J = 8.2$ Hz, 2H, benzoate meta), 6.97 (d, $J = 8.8$ Hz, 1H, NH), 6.27 (s, 1H, H10), 6.22 (dd, $J = 9.9, 9.9$ Hz, 1H, H13), 5.76 (dd, $J = 8.8, 2.2$ Hz, 1H, H3'), 5.67 (d, $J = 7.1$ Hz, 1H, H2 β), 4.94 (dd, $J = 9.9, 2.2$ Hz, 1H, H5), 4.76 (dd, $J = 4.4, 2.2$ Hz, 1H, H2'), 4.39 (m, 1H, H7), 4.30 (d, $J = 8.8$ Hz, 1H, H20 α), 4.19 (d, $J = 8.8$ Hz, 1H, H20 β), 3.79 (d, $J = 7.1$ Hz, 1H, H3), 3.75 (d, $J = 4.4$ Hz, 1H, 2'OH), 2.54 (m, 1H, H6 α), 2.49 (d, $J = 4.4$ Hz, 1H, 7OH), 2.38 (s, 3H, 4Ac), 2.37 (s, 3H, ArMe), 2.31 (m, 2H, H14 α , H14 β), 2.23 (s, 3H, 10Ac), 1.87 (m, 1H, H6 α), 1.80 (br s, 3H, Me18), 1.68 (s, 3H, Me19), 1.22 (s, 3H, Me17), 1.13 (s, 3H, Me16).

EXAMPLE 18

Preparation of *N*-debenzoyl-*N*-(4-chlorobenzoyl)-3'-desphenyl-3'-(4-fluorophenyl) taxol.

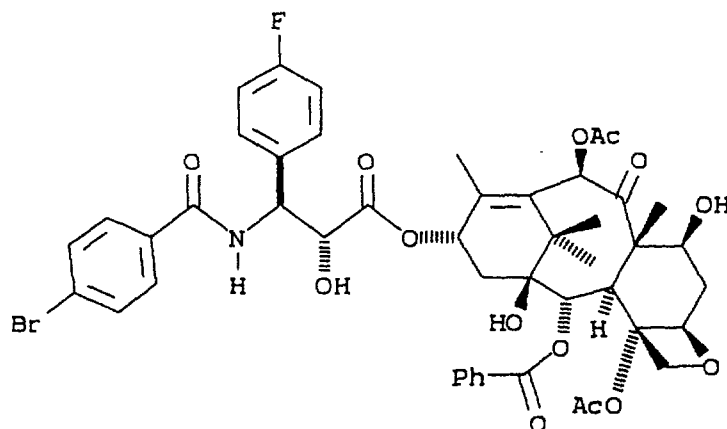
To a solution of 7-triethylsilyl baccatin III (200 mg, 0.286 mmol) in 2 mL of THF at -45°C was added dropwise 0.174 mL of a 1.63M solution of *n*BuLi in hexane. After 0.5 h at -45°C , a solution of *cis*-1-(4-chlorobenzoyl)-3-triethylsilyloxy-4-(4-fluorophenyl)azetidin-2-one (630 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 330 mg of a mixture containing (2'R,3'S)-2',7-(bis)triethylsilyl-*N*-debenzoyl-*N*-(4-chlorobenzoyl)-3'-desphenyl-3'-(4-fluorophenyl) taxol and a small amount of the (2'S,3'R) isomer.

To a solution of 330 mg (0.283 mmol) of the mixture obtained from the previous reaction in 18 mL of acetonitrile and 0.93 mL of pyridine at 0°C was added 2.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 250 mg of material which was purified by flash chromatography to give 166 mg (65%) of *N*-debenzoyl-*N*-(4-

chlorobenzoyl)-3'-desphenyl-3'-(4-fluorophenyl) taxol, which was recrystallized from methanol/water.

m.p. 178-179 °C; $[\alpha]^{25}_{Na} -51.9^{\circ}$ (c 0.01, CHCl₃).

¹H NMR. (CDCl₃, 300 MHz) δ 8.13 (d, $J = 7.1$ Hz, 2H, benzoate ortho), 7.64 (m, 3H, aromatic), 7.49 (m, 4H, aromatic), 7.36 (m, 2H, aromatic), 7.10 (m, 2H, aromatic), 6.97 (d, $J = 8.8$ Hz, 1H, NH), 6.27 (s, 1H, H10), 6.21 (dd, $J = 8.8, 8.8$ Hz, 1H, H13), 5.76 (dd, $J = 8.8, 2.2$ Hz, 1H, H3'), 5.67 (d, $J = 7.2$ Hz, 1H, H2 β), 4.94 (dd, $J = 9.3, 2.2$ Hz, 1H, H5), 4.75 (dd, $J = 4.4, 2.2$ Hz, 1H, H2'), 4.39 (ddd, $J = 11.0, 6.6, 3.9$ Hz, 1H, H7), 4.30 (d, $J = 8.8$ Hz, 1H, H20 α), 4.19 (d, $J = 8.8$ Hz, 1H, H20 β), 3.79 (d, $J = 7.2$ Hz, 1H, H3), 3.60 (d, $J = 4.4$ Hz, 1H, 2'OH), 2.54 (m, 1H, H6 α), 2.47 (d, $J = 3.9$ Hz, 1H, 7OH), 2.38 (s, 3H, 4Ac), 2.30 (m, 2H, H14), 2.28 (s, 3H, 10Ac), 1.87 (m, 1H, H6 β), 1.78 (br s, 3H, Me18), 1.78 (s, 1H, 1OH), 1.68 (s, 3H, Me19), 1.23 (s, 3H, Me17), 1.14 (s, 3H, Me16).

EXAMPLE 19

Preparation of *N*-debenzoyl-*N*-(4-bromobenzoyl)-3'-desphenyl-3'-(4-fluorophenyl) taxol.

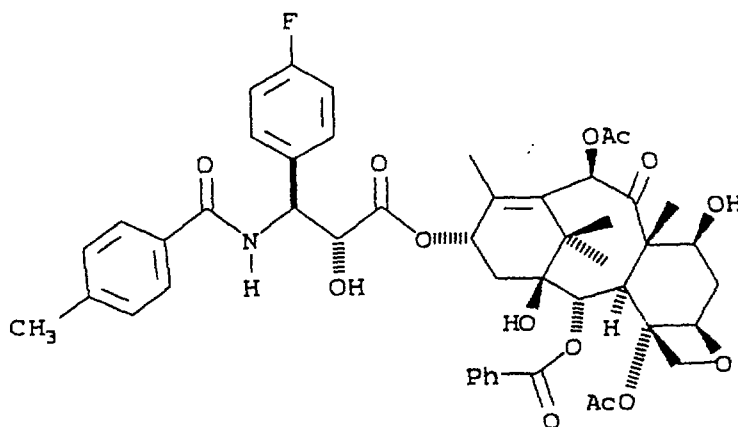
To a solution of 7-triethylsilyl baccatin III (200 mg, 0.285 mmol) in 2 mL of THF at -45°C was added dropwise 0.087 mL of a 1.63M solution of *n*BuLi in hexane. After 0.5 h at -45°C , a solution of *cis*-1-(4-bromobenzoyl)-3-triethylsilyloxy-4-(4-fluorophenyl)azetidin-2-one (684 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 433 mg of a mixture containing (2'*R*,3'*S*)-2',7-(bis)triethylsilyl-*N*-debenzoyl-*N*-(4-bromobenzoyl)-3'-desphenyl-3'-(4-fluorophenyl) taxol and a small amount of the (2'*S*,3'*R*) isomer.

To a solution of 433 mg of the mixture obtained from the previous reaction in 12 mL of acetonitrile and 0.6 mL of pyridine at 0°C was added 1.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 317 mg of material which was purified by flash chromatography to give 187 mg (69%) of *N*-debenzoyl-*N*-(4-bromobenzoyl)-3'-

desphenyl-3'-(4-fluorophenyl) taxol, which was recrystallized from methanol/water.

m.p. 174.5-175.5 °C; $[\alpha]_{\text{Na}}^{25} -46.9^\circ$ (c 0.00735, CHCl_3).

^1H NMR (CDCl_3 , 300 MHz) δ 8.13 (d, $J = 7.2$ Hz, 2H, benzoate ortho), 7.7-7.4 (m, 9H, aromatic), 7.10 (dd, $J = 8.3, 8.3$ Hz, 2H, aromatic), 6.97 (d, $J = 8.8$ Hz, 1H, NH), 6.27 (s, 1H, H10), 6.23 (dd, $J = 8.8, 8.8$ Hz, 1H, H13), 5.76 (dd, $J = 8.8, 2.2$ Hz, 1H, H3'), 5.67 (d, $J = 7.1$ Hz, 1H, H2 β), 4.94 (dd, $J = 9.9, 2.2$ Hz, 1H, H5), 4.75 (dd, $J = 4.4, 2.2$ Hz, 1H, H2'), 4.39 (m, 1H, H7), 4.31 (d, $J = 8.5$ Hz, 1H, H20 α), 4.19 (d, $J = 8.5$ Hz, 1H, H20 β), 3.79 (d, $J = 7.1$ Hz, 1H, H3), 3.59 (d, $J = 4.4$ Hz, 1H, 2'OH), 2.54 (m, 1H, H6 α), 2.47 (d, $J = 4.4$ Hz, 1H, 7OH), 2.36 (s, 3H, 4Ac), 2.30 (m, 2H, H14 α , H14 β), 2.24 (s, 3H, 10Ac), 1.88 (m, 1H, H6 α), 1.78 (br s, 3H, Me18), 1.74 (s, 1H, 1OH), 1.68 (s, 3H, Me19), 1.23 (s, 3H, Me17), 1.14 (s, 3H, Me16).

EXAMPLE 20

Preparation of *N*-debenzoyl-*N*-(4-methylbenzoyl)-3'-desphenyl-3'-(4-fluorophenyl) taxol.

To a solution of 7-triethylsilyl baccatin III (200 mg, 0.286 mmol) in 2 mL of THF at -45°C was added dropwise 0.174 mL of a 1.63M solution of *n*BuLi in hexane. After 0.5 h at -45°C , a solution of *cis*-1-(4-methylbenzoyl)-3-triethylsilyloxy-4-(4-fluorophenyl)azetidin-2-one (592 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 335 mg of a mixture containing (2'R,3'S)-2',7-(bis)triethylsilyl-*N*-debenzoyl-*N*-(4-methylbenzoyl)-3'-desphenyl-3'-(4-fluorophenyl) taxol and a small amount of the (2'S,3'R) isomer.

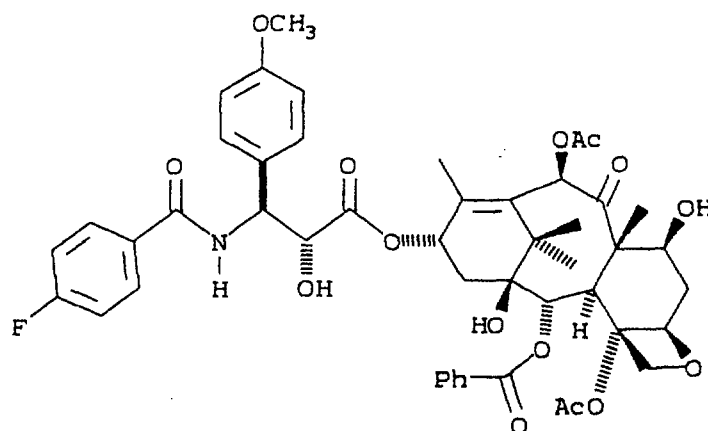
To a solution of 335 mg (0.30 mmol) of the mixture obtained from the previous reaction in 18 mL of acetonitrile and 0.93 mL of pyridine at 0°C was added 2.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 280 mg of material which was purified by flash chromatography to give 163 mg (64%) of *N*-debenzoyl-*N*-(4-

methylbenzoyl)-3'-desphenyl-3'-(4-fluorophenyl) taxol, which was recrystallized from methanol/water.

m.p. 172-173 °C; $[\alpha]^{25}_{Na} -52.0^{\circ}$ (c 0.01, CHCl₃).

¹H NMR (CDCl₃, 300 MHz) δ 8.13 (d, $J = 7.1$ Hz, 2H, benzoate ortho), 7.61 (m, 3H, aromatic), 7.48 (m, 4H, aromatic), 7.18 (m, 2H, aromatic), 7.10 (m, 2H, aromatic), 6.95 (d, $J = 8.8$ Hz, 1H, NH), 6.27 (s, 1H, H10), 6.21 (dd, $J = 8.8, 8.8$ Hz, 1H, H13), 5.77 (dd, $J = 8.8, 2.2$ Hz, 1H, H3'), 5.67 (d, $J = 7.2$ Hz, 1H, H2 β), 4.94 (dd, $J = 9.3, 1.7$ Hz, 1H, H5), 4.75 (dd, $J = 4.4, 2.2$ Hz, 1H, H2'), 4.39 (ddd, $J = 11.0, 6.6, 4.4$ Hz, 1H, H7), 4.30 (d, $J = 8.8$ Hz, 1H, H20 α), 4.19 (d, $J = 8.8$ Hz, 1H, H20 β), 3.79 (d, $J = 7.2$ Hz, 1H, H3), 3.67 (d, $J = 4.4$ Hz, 1H, 2'OH), 2.54 (ddd, $J = 9.3, 14.8, 6.6$ Hz, 1H, H6 α), 2.46 (d, $J = 4.4$ Hz, 1H, 7OH), 2.37 (s, 3H, 4Ac), 2.36 (s, 3H, ArMe), 2.30 (m, 2H, H14), 2.23 (s, 3H, 10Ac), 1.87 (ddd, $J = 11.0, 14.8, 1.7$ Hz, 1H, H6 β), 1.79 (br s, 3H, Me18), 1.79 (s, 1H, 1OH), 1.68 (s, 3H, Me19), 1.22 (s, 3H, Me17), 1.14 (s, 3H, Me16).

EXAMPLE 21



Preparation of *N*-debenzoyl-*N*-(4-fluorobenzoyl)-3'-desphenyl-3'-(4-methoxyphenyl) taxol.

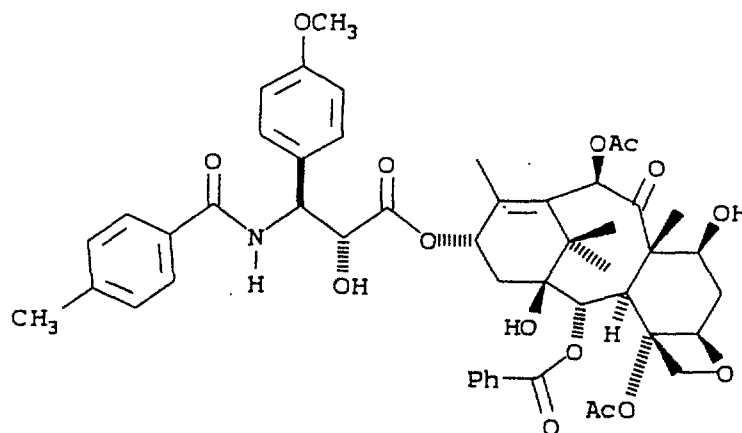
To a solution of 7-triethylsilyl baccatin III (200 mg, 0.286 mmol) in 2 mL of THF at -45°C was added dropwise 0.174 mL of a 1.63M solution of *n*BuLi in hexane. After 0.5 h at -45°C , a solution of *cis*-1-(4-fluorobenzoyl)-3-triethylsilyloxy-4-(4-methoxyphenyl)azetidin-2-one (610 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 330 mg of a mixture containing (2'R,3'S)-2',7-(bis)triethylsilyl-*N*-debenzoyl-*N*-(4-fluorobenzoyl)-3'-desphenyl-3'-(4-methoxyphenyl) taxol and a small amount of the (2'S,3'R) isomer.

To a solution of 330 mg (0.292 mmol) of the mixture obtained from the previous reaction in 18 mL of acetonitrile and 0.93 mL of pyridine at 0°C was added 2.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 260 mg of material which was purified by flash chromatography to give 155 mg (60%) of *N*-debenzoyl-*N*-(4-

fluorobenzoyl)-3'-desphenyl-3'-(4-methoxyphenyl) taxol, which was recrystallized from methanol/water.

m.p. 169-170 °C; $[\alpha]^{25}_{Na} -50.9^\circ$ (c 0.01, CHCl₃).

¹H NMR (CDCl₃, 300 MHz) δ 8.14 (d, $J = 7.1$ Hz, 2H, benzoate *ortho*), 7.57 (m, 7H, aromatic), 7.06 (m, 2H, aromatic), 6.94 (m, 2H, aromatic), 6.85 (d, $J = 8.8$ Hz, 1H, NH), 6.27 (s, 1H, H10), 6.20 (dd, $J = 8.8, 8.8$ Hz, 1H, H13), 5.72 (dd, $J = 8.8, 2.8$ Hz, 1H, H3'), 5.67 (d, $J = 7.2$ Hz, 1H, H2 β), 4.94 (dd, $J = 9.3, 2.1$ Hz, 1H, H5), 4.74 (dd, $J = 4.9, 2.8$ Hz, 1H, H2'), 4.40 (ddd, $J = 11.0, 6.6, 3.9$ Hz, 1H, H7), 4.31 (d, $J = 8.8$ Hz, 1H, H20 α), 4.19 (d, $J = 8.8$ Hz, 1H, H20 β), 3.80 (d, $J = 7.2$ Hz, 1H, H3), 3.79 (s, 3H, ArOMe), 3.51 (d, $J = 4.9$ Hz, 1H, 2'OH), 2.54 (m, 1H, H6 α), 2.50 (d, $J = 3.9$ Hz, 1H, 7OH), 2.37 (s, 3H, 4Ac), 2.31 (m, 2H, H14), 2.24 (s, 3H, 10Ac), 1.87 (m, 1H, H6 β), 1.79 (br s, 3H, Me18), 1.79 (s, 1H, 10H), 1.68 (s, 3H, Me19), 1.24 (s, 3H, Me17), 1.14 (s, 3H, Me16).

EXAMPLE 22

Preparation of *N*-debenzoyl-*N*-(4-methylbenzoyl)-3'-desphenyl-3'-(4-methoxyphenyl) taxol.

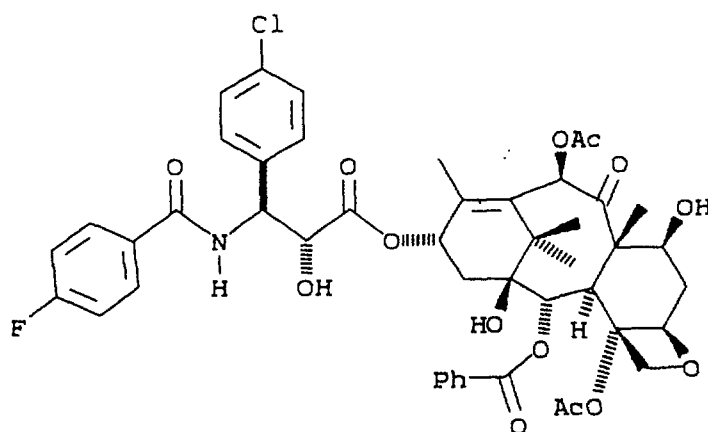
To a solution of 7-triethylsilyl baccatin III (200 mg, 0.286 mmol) in 2 mL of THF at -45 °C was added dropwise 0.174 mL of a 1.63M solution of *n*BuLi in hexane. After 0.5 h at -45 °C, a solution of *cis*-1-(4-methylbenzoyl)-3-triethylsilyloxy-4-(4-methoxyphenyl)azetidin-2-one (610 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0 °C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO₃ and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 325 mg of a mixture containing (2'*R*,3'*S*)-2',7-(bis)triethylsilyl-*N*-debenzoyl-*N*-(4-methylbenzoyl)-3'-desphenyl-3'-(4-methoxyphenyl) taxol and a small amount of the (2'*S*,3'*R*) isomer.

To a solution of 325 mg (0.289 mmol) of the mixture obtained from the previous reaction in 18 mL of acetonitrile and 0.93 mL of pyridine at 0 °C was added 2.8 mL of 48% aqueous HF. The mixture was stirred at 0 °C for 3 h, then at 25 °C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 265 mg of material which was purified by flash chromatography to give 165 mg (64%) of *N*-debenzoyl-*N*-(4-

methylbenzoyl)-3'-desphenyl-3'-(4-methoxyphenyl) taxol, which was recrystallized from methanol/water.

m.p. 173-174 °C; $[\alpha]^{25}_{Na} -50.2^\circ$ (c 0.01, CHCl₃).

¹H NMR (CDCl₃, 300 MHz) δ 8.13 (d, $J = 7.1$ Hz, 2H, benzoate *ortho*), 7.61 (m, 3H, aromatic), 7.51 (m, 2H, aromatic), 7.40 (m, 2H, aromatic), 7.19 (m, 2H, aromatic), 6.93 (m, 2H, aromatic), 6.86 (d, $J = 8.8$ Hz, 1H, NH), 6.27 (s, 1H, H10), 6.21 (dd, $J = 8.8, 8.8$ Hz, 1H, H13), 5.70 (dd, $J = 8.8, 2.8$ Hz, 1H, H3'), 5.66 (d, $J = 7.2$ Hz, 1H, H2 β), 4.94 (dd, $J = 9.9, 2.2$ Hz, 1H, H5), 4.74 (dd, $J = 5.5, 2.8$ Hz, 1H, H2'), 4.40 (ddd, $J = 11.0, 6.5, 3.8$ Hz, 1H, H7), 4.30 (d, $J = 8.8$ Hz, 1H, H20 α), 4.19 (d, $J = 8.8$ Hz, 1H, H20 β), 3.79 (d, $J = 7.2$ Hz, 1H, H3), 3.78 (s, 3H, ArOMe), 3.63 (d, $J = 5.5$ Hz, 1H, 2'OH), 2.54 (m, 1H, H6 α), 2.46 (d, $J = 3.8$ Hz, 1H, 7OH), 2.38 (s, 3H, ArMe), 2.37 (s, 3H, 4Ac), 2.31 (m, 2H, H14), 2.23 (s, 3H, 10Ac), 1.88 (m, 1H, H6 β), 1.80 (br s, 3H, Me18), 1.80 (s, 1H, 1OH), 1.68 (s, 3H, Me19), 1.23 (s, 3H, Me17), 1.14 (s, 3H, Me16).

EXAMPLE 23

Preparation of *N*-debenzoyl-*N*-(4-fluorobenzoyl)-3'-desphenyl-3'-(4-chlorophenyl) taxol.

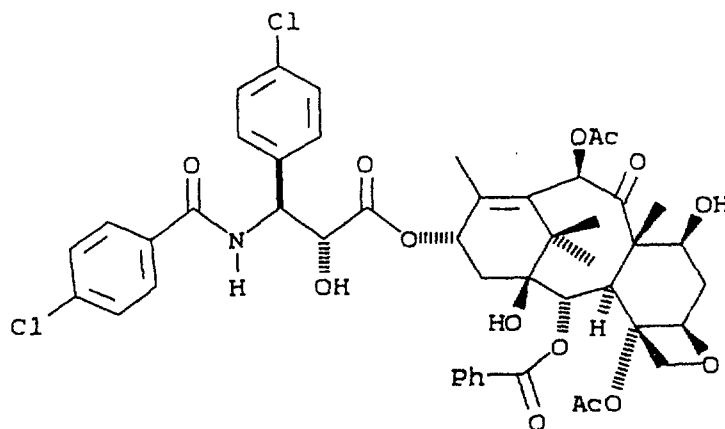
To a solution of 7-triethylsilyl baccatin III (200 mg, 0.286 mmol) in 2 mL of THF at -45°C was added dropwise 0.174 mL of a 1.63M solution of *n*BuLi in hexane. After 0.5 h at -45°C , a solution of *cis*-1-(4-fluorobenzoyl)-3-triethylsilyloxy-4-(4-chlorophenyl)azetidin-2-one (620 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 325 mg of a mixture containing (2'*R*,3'*S*)-2',7-(bis)triethylsilyl-*N*-debenzoyl-*N*-(4-fluorobenzoyl)-3'-desphenyl-3'-(4-chlorophenyl) taxol and a small amount of the (2'*S*,3'*R*) isomer.

To a solution of 325 mg (0.286 mmol) of the mixture obtained from the previous reaction in 18 mL of acetonitrile and 0.93 mL of pyridine at 0°C was added 2.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 260 mg of material which was purified by flash chromatography to give 161 mg (62%) of *N*-debenzoyl-*N*-(4-

fluorobenzoyl)-3'-desphenyl-3'-(4-chlorophenyl) taxol, which was recrystallized from methanol/water.

m.p. 172-174 °C; $[\alpha]_D^{25} -56.0^\circ$ (c 0.01, CHCl₃).

¹H NMR (CDCl₃, 300 MHz) δ 8.12 (d, $J = 7.1$ Hz, 2H, benzoate *ortho*), 7.73 (m, 2H, aromatic), 7.60 (m, 1H, aromatic), 7.50 (m, 2H, aromatic), 7.38 (m, 4H, aromatic), 7.06 (m, 2H, aromatic), 7.05 (d, $J = 8.8$ Hz, 1H, NH), 6.27 (s, 1H, H10), 6.22 (dd, $J = 7.7, 7.7$ Hz, 1H, H13), 5.75 (dd, $J = 8.8, 2.8$ Hz, 1H, H3'), 5.65 (d, $J = 7.1$ Hz, 1H, H2 β), 4.92 (dd, $J = 9.3, 1.6$ Hz, 1H, H5), 4.75 (dd, $J = 4.9, 2.8$ Hz, 1H, H2'), 4.41 (m, 1H, H7), 4.29 (d, $J = 8.2$ Hz, 1H, H20 α), 4.17 (d, $J = 8.2$ Hz, 1H, H20 β), 3.84 (d, $J = 4.4$ Hz, 1H, 2'OH), 3.78 (d, $J = 7.1$ Hz, 1H, H3), 2.55 (d, $J = 4.4$ Hz, 1H, 7OH), 2.52 (m, 1H, H6 α), 2.36 (s, 3H, 4Ac), 2.29 (m, 2H, H14), 2.21 (s, 3H, 10Ac), 1.86 (m, 1H, H6 β), 1.79 (br s, 3H, Me18), 1.78 (s, 1H, 1OH), 1.67 (s, 3H, Me19), 1.24 (s, 3H, Me17), 1.12 (s, 3H, Me16).

EXAMPLE 24

Preparation of N-debenzoyl-N-(4-chlorobenzoyl)-3'-desphenyl-3'-(4-chlorophenyl) taxol.

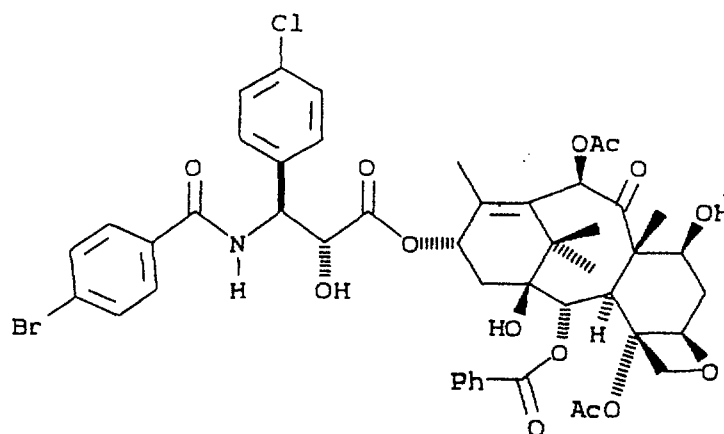
To a solution of 7-triethylsilyl baccatin III (200 mg, 0.286 mmol) in 2 mL of THF at -45°C was added dropwise 0.174 mL of a 1.63M solution of nBuLi in hexane. After 0.5 h at -45°C , a solution of *cis*-1-(4-chlorobenzoyl)-3-triethylsilyloxy-4-(4-chlorophenyl)azetidin-2-one (640 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 335 mg of a mixture containing (2'R,3'S)-2',7-(bis)triethylsilyl-N-debenzoyl-N-(4-chlorobenzoyl)-3'-desphenyl-3'-(4-chlorophenyl) taxol and a small amount of the (2'S,3'R) isomer.

To a solution of 335 mg (0.291 mmol) of the mixture obtained from the previous reaction in 18 mL of acetonitrile and 0.93 mL of pyridine at 0°C was added 2.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 270 mg of material which was purified by flash chromatography to give 158 mg (60%) of N-debenzoyl-N-(4-

chlorobenzoyl)-3'-desphenyl-3'-(4-chlorophenyl) taxol, which was recrystallized from methanol/water.

m.p. 184-185 °C; $[\alpha]_D^{25} -52.5^\circ$ (c 0.01, CHCl₃).

¹H NMR (CDCl₃, 300 MHz) δ 8.13 (d, $J = 7.1$ Hz, 2H, benzoate *ortho*), 7.51 (m, 1H, aromatic), 6.98 (d, $J = 8.8$ Hz, 1H, NH), 6.27 (s, 1H, H10), 6.22 (dd, $J = 8.8, 8.8$ Hz, 1H, H13), 5.76 (dd, $J = 8.8, 2.2$ Hz, 1H, H3'), 5.67 (d, $J = 7.2$ Hz, 1H, H2 β), 4.94 (dd, $J = 9.9, 2.2$ Hz, 1H, H5), 4.76 (dd, $J = 5.0, 2.2$ Hz, 1H, H2'), 4.39 (ddd, $J = 10.8, 6.5, 4.4$ Hz, 1H, H7), 4.30 (d, $J = 8.8$ Hz, 1H, H20 α), 4.19 (d, $J = 8.8$ Hz, 1H, H20 β), 3.79 (d, $J = 7.2$ Hz, 1H, H3), 3.68 (d, $J = 5.0$ Hz, 1H, 2'OH), 2.54 (ddd, $J = 9.9, 14.8, 6.5$ Hz, 1H, H6 α), 2.47 (d, $J = 4.4$ Hz, 1H, 7OH), 2.37 (s, 3H, 4Ac), 2.30 (m, 2H, H14), 2.23 (s, 3H, 10Ac), 1.87 (ddd, $J = 10.8, 14.8, 2.2$ Hz, 1H, H6 β), 1.84 (br s, 3H, Me18), 1.79 (s, 1H, 1OH), 1.68 (s, 3H, Me19), 1.22 (s, 3H, Me17), 1.14 (s, 3H, Me16).

EXAMPLE 25

Preparation of *N*-debenzoyl-*N*-(4-bromobenzoyl)-3'-desphenyl-3'-(4-chlorophenyl) taxol.

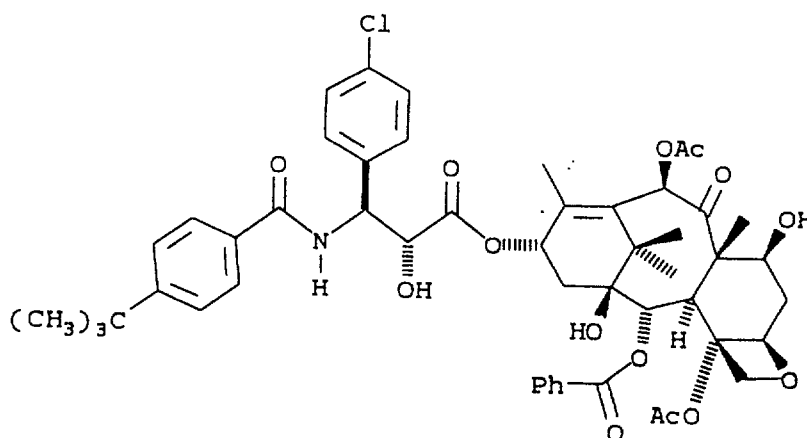
To a solution of 7-triethylsilyl baccatin III (200 mg, 0.285 mmol) in 2 mL of THF at -45 °C was added dropwise 0.175 mL of a 1.63M solution of *n*BuLi in hexane. After 0.5 h at -45 °C, a solution of *cis*-1-(4-bromobenzoyl)-3-triethylsilyloxy-4-(4-chlorophenyl)azetidin-2-one (354 mg, 0.715 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0 °C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO₃ and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 355 mg of a mixture containing (2'*R*,3'*S*)-2',7-(bis)triethylsilyl-*N*-debenzoyl-*N*-(4-bromobenzoyl)-3'-desphenyl-3'-(4-chlorophenyl) taxol and a small amount of the (2'*S*,3'*R*) isomer.

To a solution of 355 mg of the mixture obtained from the previous reaction in 12 mL of acetonitrile and 0.6 mL of pyridine at 0 °C was added 1.8 mL of 48% aqueous HF. The mixture was stirred at 0 °C for 3 h, then at 25 °C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 280 mg of material which was purified by flash chromatography to give 171 mg (62%) of *N*-debenzoyl-*N*-(4-bromobenzoyl)-3'-

desphenyl-3'-(4-chlorophenyl) taxol, which was recrystallized from methanol/water.

m.p. 181-183.5 °C; $[\alpha]_D^{25} -52.8^\circ$ (c 0.0064, CHCl₃).

¹H NMR (CDCl₃, 300 MHz) δ 8.12 (d, $J = 7.2$ Hz, 2H, benzoate ortho), 7.65-7.3 (m, 11H, aromatic), 7.03 (d, $J = 8.8$ Hz, 1H, NH), 6.27 (s, 1H, H10), 6.22 (dd, $J = 9.3, 9.3$ Hz, 1H, H13), 5.75 (dd, $J = 8.8, 2.2$ Hz, 1H, H3'), 5.66 (d, $J = 7.1$ Hz, 1H, H2 β), 4.93 (dd, $J = 9.9, 2.2$ Hz, 1H, H5), 4.75 (dd, $J = 5.0, 2.2$ Hz, 1H, H2'), 4.40 (m, 1H, H7), 4.30 (d, $J = 8.5$ Hz, 1H, H20 α), 4.18 (d, $J = 8.5$ Hz, 1H, H20 β), 3.77 (m, 2H, H3, 2'OH), 2.54 (m, 1H, H6 α), 2.52 (d, $J = 4.4$ Hz, 1H, 7OH), 2.36 (s, 3H, 4Ac), 2.29 (m, 2H, H14 α , H14 β), 2.22 (s, 3H, 10Ac), 1.87 (m, 1H, H6 α), 1.79 (br s, 3H, Me18), 1.73 (s, 1H, 1OH), 1.67 (s, 3H, Me19), 1.21 (s, 3H, Me17), 1.13 (s, 3H, Me16).

EXAMPLE 26

Preparation of *N*-debenzoyl-*N*-(4-*t*-butylbenzoyl)-3'-desphenyl-3'-(4-chlorophenyl) taxol.

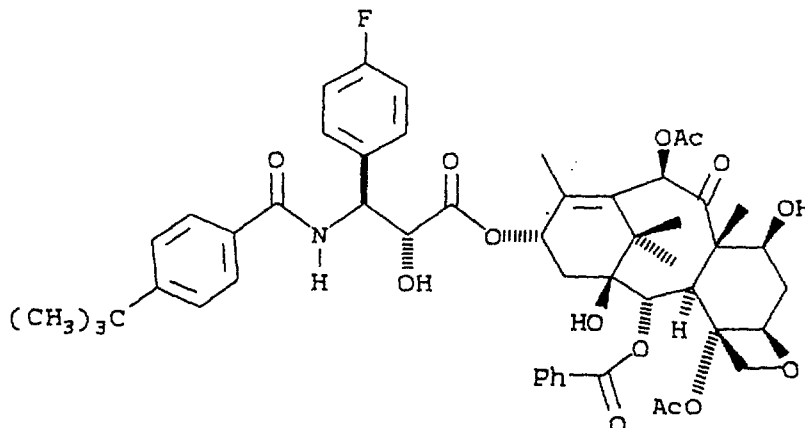
To a solution of 7-triethylsilyl baccatin III (200 mg, 0.285 mmol) in 2 mL of THF at -45 °C was added dropwise 0.175 mL of a 1.63M solution of *n*BuLi in hexane. After 0.5 h at -45 °C, a solution of *cis*-1-(4-*t*-butylbenzoyl)-3-triethylsilyloxy-4-(4-chlorophenyl)azetidin-2-one (675 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0 °C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO₃ and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 317 mg of a mixture containing (2'*R*,3'*S*)-2',7-(bis)triethylsilyl-*N*-debenzoyl-*N*-(4-*t*-butylbenzoyl)-3'-desphenyl-3'-(4-chlorophenyl) taxol and a small amount of the (2'*S*,3'*R*) isomer.

To a solution of 317 mg of the mixture obtained from the previous reaction in 12 mL of acetonitrile and 0.6 mL of pyridine at 0 °C was added 1.8 mL of 48% aqueous HF. The mixture was stirred at 0 °C for 3 h, then at 25 °C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 354 mg of material which was purified by flash chromatography to give 186 mg (69%) of *N*-debenzoyl-*N*-(4-*t*-butylbenzoyl)-3'-

desphenyl-3'-(4-chlorophenyl) taxol, which was recrystallized from methanol/water.

m.p. 176.5-178 °C; $[\alpha]_D^{25} -51.8^\circ$ (c 0.00985, CHCl_3).

^1H NMR (CDCl_3 , 300 MHz) δ 8.14 (d, $J = 8.8$ Hz, 2H, benzoate ortho), 7.7-7.3 (m, 11H, aromatic), 6.94 (d, $J = 8.8$ Hz, 1H, NH), 6.27 (s, 1H, H10), 6.24 (dd, $J = 8.3, 8.3$ Hz, 1H, H13), 5.78 (dd, $J = 9.3, 2.2$ Hz, 1H, H3'), 5.67 (d, $J = 7.1$ Hz, 1H, H2 β), 4.95 (dd, $J = 8.8, 1.1$ Hz, 1H, H5), 4.76 (dd, $J = 5.0, 2.2$ Hz, 1H, H2'), 4.40 (m, 1H, H7), 4.31 (d, $J = 8.5$ Hz, 1H, H20 α), 4.20 (d, $J = 8.5$ Hz, 1H, H20 β), 3.80 (d, $J = 7.1$ Hz, 1H, H3), 3.64 (d, $J = 5.0$ Hz, 1H, 2'OH), 2.55 (m, 1H, H6 α), 2.46 (d, $J = 4.4$ Hz, 1H, 7OH), 2.38 (s, 3H, 4Ac), 2.32 (m, 2H, H14 α , H14 β), 2.23 (s, 3H, 10Ac), 1.88 (m, 1H, H6 α), 1.82 (br s, 3H, Me18), 1.77 (s, 1H, 10H), 1.67 (s, 3H, Me19), 1.30 (s, 9H, t-Bu), 1.23 (s, 3H, Me17), 1.14 (s, 3H, Me16).

EXAMPLE 27

Preparation of *N*-debenzoyl-*N*-(4-*t*-butylbenzoyl)-3'-desphenyl-3'-(4-fluorophenyl) taxol.

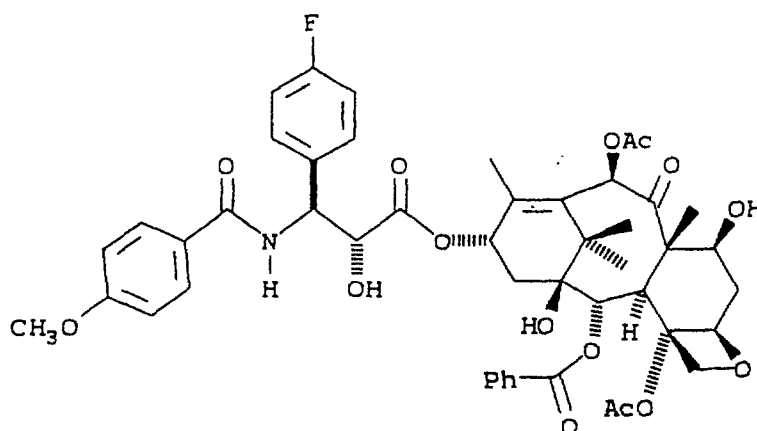
To a solution of 7-triethylsilyl baccatin III (200 mg, 0.286 mmol) in 2 mL of THF at -45 °C was added dropwise 0.174 mL of a 1.63M solution of *n*BuLi in hexane. After 0.5 h at -45 °C, a solution of *cis*-1-(4-*t*-butylbenzoyl)-3-triethylsilyloxy-4-(4-fluorophenyl)azetidin-2-one (650 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0 °C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO₃ and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 330 mg of a mixture containing (2'*R*,3'*S*)-2',7-(bis)triethylsilyl-*N*-debenzoyl-*N*-(4-*t*-butylbenzoyl)-3'-desphenyl-3'-(4-fluorophenyl) taxol and a small amount of the (2'*S*,3'*R*) isomer.

To a solution of 330 mg (0.286 mmol) of the mixture obtained from the previous reaction in 18 mL of acetonitrile and 0.93 mL of pyridine at 0 °C was added 2.8 mL of 48% aqueous HF. The mixture was stirred at 0 °C for 3 h, then at 25 °C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 260 mg of material which was purified by flash chromatography to give 168 mg (64%) of *N*-debenzoyl-*N*-(4-

t-butylbenzoyl)-3'-desphenyl-3'-(4-fluorophenyl) taxol, which was recrystallized from methanol/water.

m.p. 180-182 °C; $[\alpha]^{25}_{Na} -46.3^{\circ}$ (c 0.01, CHCl₃).

¹H NMR (CDCl₃, 300 MHz) δ 8.12 (d, $J = 7.1$ Hz, 2H, benzoate *ortho*), 7.67 (m, 2H, aromatic), 7.60 (m, 1H, aromatic), 7.46 (m, 6H, aromatic), 7.08 (m, 2H, aromatic), 7.00 (d, $J = 8.8$ Hz, 1H, NH), 6.27 (s, 1H, H10), 6.23 (dd, $J = 8.8, 8.8$ Hz, 1H, H13), 5.76 (dd, $J = 8.8, 2.7$ Hz, 1H, H3'), 5.67 (d, $J = 7.1$ Hz, 1H, H2 β), 4.94 (dd, $J = 9.3, 1.7$ Hz, 1H, H5), 4.75 (dd, $J = 4.9, 2.7$ Hz, 1H, H2'), 4.39 (m, 1H, H7), 4.30 (d, $J = 8.2$ Hz, 1H, H20 α), 4.22 (d, $J = 8.2$ Hz, 1H, H20 β), 3.78 (d, $J = 7.1$ Hz, 1H, H3), 3.55 (d, $J = 4.9$ Hz, 1H, 2'OH), 2.56 (m, 1H, H6 α), 2.50 (d, $J = 4.4$ Hz, 1H, 7OH), 2.37 (s, 3H, 4Ac), 2.30 (m, 2H, H14), 2.22 (s, 3H, 10Ac), 1.88 (m, 1H, H6 β), 1.79 (br s, 3H, Me18), 1.75 (s, 1H, 1OH), 1.67 (s, 3H, Me19), 1.29 (s, 9H, Ar^tBu), 1.22 (s, 3H, Me17), 1.13 (s, 3H, Me16).

EXAMPLE 28

Preparation of *N*-debenzoyl-*N*-(4-methoxybenzoyl)-3'-desphenyl-3'-(4-fluorophenyl) taxol.

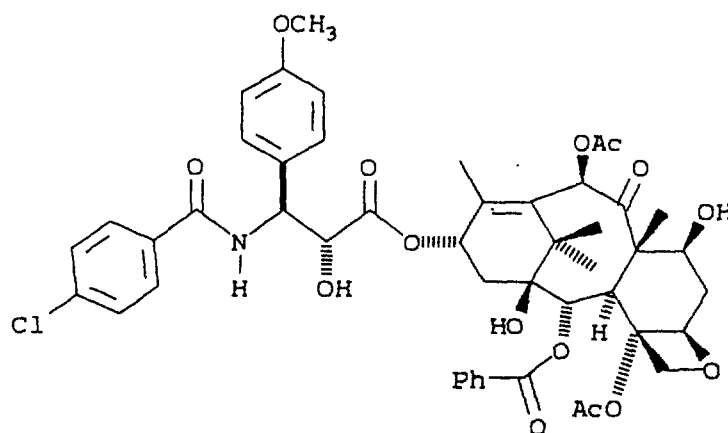
To a solution of 7-triethylsilyl baccatin III (200 mg, 0.285 mmol) in 2 mL of THF at -45°C was added dropwise 0.175 mL of a 1.63M solution of *n*BuLi in hexane. After 0.5 h at -45°C , a solution of *cis*-1-(4-methoxybenzoyl)-3-triethylsilyloxy-4-(4-fluorophenyl)azetidin-2-one (614 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 362 mg of a mixture containing (2'*R*,3'*S*)-2',7-(bis)triethylsilyl-*N*-debenzoyl-*N*-(4-methoxybenzoyl)-3'-desphenyl-3'-(4-fluorophenyl) taxol and a small amount of the (2'*S*,3'*R*) isomer.

To a solution of 362 mg of the mixture obtained from the previous reaction in 12 mL of acetonitrile and 0.6 mL of pyridine at 0°C was added 1.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 269 mg of material which was purified by flash chromatography to give 183 mg (71%) of *N*-debenzoyl-*N*-(4-methoxybenzoyl)-3'-

desphenyl-3'-(4-fluorophenyl) taxol, which was recrystallized from methanol/water.

m.p. 172.5-174.5 °C; $[\alpha]^{25}_{Na} -47.0^\circ$ (c 0.0044, $CHCl_3$).

1H NMR ($CDCl_3$, 300 MHz) δ 8.13 (d, $J = 7.2$ Hz, 2H, benzoate *ortho*), 7.7-7.4 (m, 9H, aromatic), 7.10 (dd, $J = 8.8, 8.8$ Hz, 2H, aromatic), 6.97 (d, $J = 8.8$ Hz, 1H, NH), 6.27 (s, 1H, H10), 6.23 (dd, $J = 8.8, 8.8$ Hz, 1H, H13), 5.76 (dd, $J = 8.8, 2.2$ Hz, 1H, H3'), 5.67 (d, $J = 7.1$ Hz, 1H, H2 β), 4.94 (dd, $J = 9.9, 2.2$ Hz, 1H, H5), 4.75 (dd, $J = 4.4, 2.2$ Hz, 1H, H2'), 4.39 (m, 1H, H7), 4.31 (d, $J = 8.5$ Hz, 1H, H20 α), 4.19 (d, $J = 8.5$ Hz, 1H, H20 β), 3.79 (d, $J = 7.1$ Hz, 1H, H3), 3.59 (d, $J = 4.4$ Hz, 1H, 2'OH), 2.54 (m, 1H, H6 α), 2.47 (d, $J = 4.4$ Hz, 1H, 7OH), 2.36 (s, 3H, 4Ac), 2.30 (m, 2H, H14 α , H14 β), 2.24 (s, 3H, 10Ac), 1.88 (m, 1H, H6 α), 1.78 (br s, 3H, Me18), 1.74 (s, 1H, 1OH), 1.68 (s, 3H, Me19), 1.23 (s, 3H, Me17), 1.14 (s, 3H, Me16).

EXAMPLE 29

Preparation of *N*-debenzoyl-*N*-(4-chlorobenzoyl)-3'-desphenyl-3'-(4-methoxyphenyl) taxol.

To a solution of 7-triethylsilyl baccatin III (200 mg, 0.286 mmol) in 2 mL of THF at -45°C was added dropwise 0.174 mL of a 1.63M solution of *n*BuLi in hexane. After 0.5 h at -45°C , a solution of *cis*-1-(4-chlorobenzoyl)-3-triethylsilyloxy-4-(4-methoxyphenyl)azetidin-2-one (638 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 328 mg of a mixture containing (2'*R*,3'*S*)-2',7-(bis)triethylsilyl-*N*-debenzoyl-*N*-(4-chlorobenzoyl)-3'-desphenyl-3'-(4-methoxyphenyl) taxol and a small amount of the (2'*S*,3'*R*) isomer.

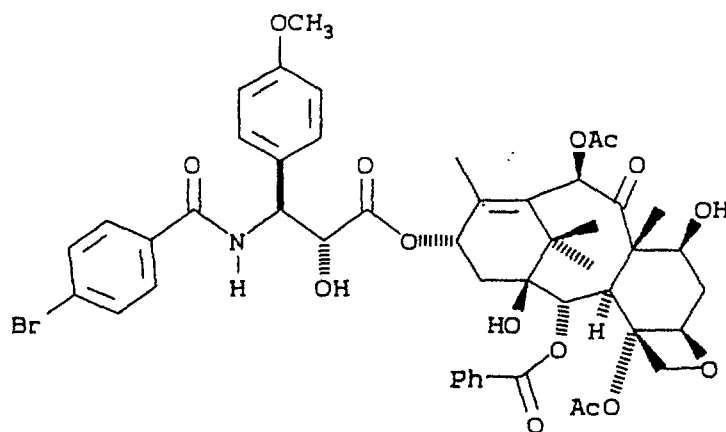
To a solution of 328 mg (0.286 mmol) of the mixture obtained from the previous reaction in 18 mL of acetonitrile and 0.93 mL of pyridine at 0°C was added 2.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 270 mg of material which was purified by flash chromatography to give 170 mg (65%) of *N*-debenzoyl-*N*-(4-

chlorobenzoyl)-3'-desphenyl-3'-(4-methoxyphenyl) taxol, which was recrystallized from methanol/water.

m.p. 169-171 °C; $[\alpha]^{25}_{\text{Na}}$ -51.1° (c 0.035, CHCl₃).

¹H NMR (CDCl₃, 300 MHz) δ 8.12 (d, J = 7.1 Hz, 2H, benzoate ortho), 7.65 (d, J = 8.2 Hz, 2H, benzamide ortho), 7.51 (m, 2H, aromatic), 7.36 (m, 5H, aromatic), 6.91 (m, 2H, aromatic), 6.90 (d, J = 8.2 Hz, 1H, NH), 6.26 (s, 1H, H10), 6.21 (dd, J = 7.7, 8.9 Hz, 1H, H13), 5.69 (dd, J = 8.2, 2.8 Hz, 1H, H3'), 5.67 (d, J = 6.6 Hz, 1H, H2 β), 4.94 (dd, J = 9.9, 2.2 Hz, 1H, H5), 4.74 (dd, J = 4.9, 2.8 Hz, 1H, H2'), 4.39 (ddd, J = 11.0, 6.6, 3.8 Hz, 1H, H7), 4.30 (d, J = 8.2 Hz, 1H, H20 α), 4.19 (d, J = 8.2 Hz, 1H, H20 β), 3.79 (d, J = 6.6 Hz, 1H, H3), 3.79 (s, 3H, ArOMe), 3.57 (d, J = 4.9 Hz, 1H, 2'OH), 2.53 (ddd, J = 9.9, 14.4, 6.6 Hz, 1H, H6 α), 2.47 (d, J = 3.8 Hz, 1H, 7OH), 2.36 (s, 3H, 4Ac), 2.33 (m, 2H, H14), 2.23 (s, 3H, 10Ac), 1.88 (ddd, J = 11.0, 14.4, 2.2 Hz, 1H, H6 β), 1.79 (br s, 3H, Me18), 1.78 (s, 1H, 1OH), 1.68 (s, 3H, Me19), 1.23 (s, 3H, Me17), 1.14 (s, 3H, Me16).

EXAMPLE 30



Preparation of *N*-debenzoyl-*N*-(4-bromobenzoyl)-3'-desphenyl-3'-(4-methoxyphenyl) taxol.

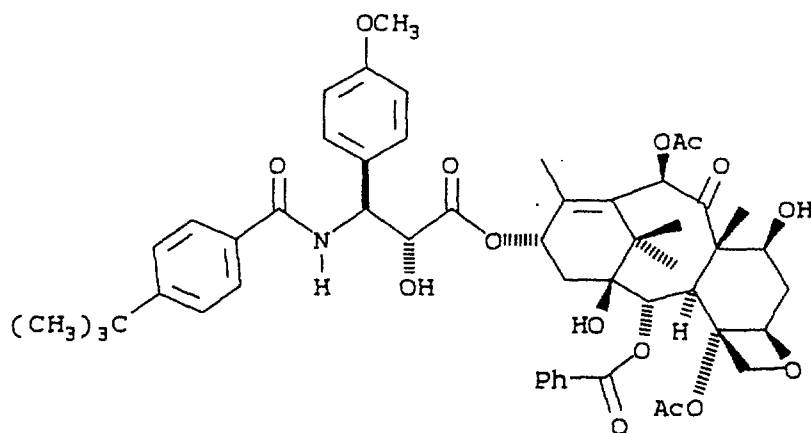
To a solution of 7-triethylsilyl baccatin III (200 mg, 0.285 mmol) in 2 mL of THF at -45°C was added dropwise 0.175 mL of a 1.63M solution of *n*BuLi in hexane. After 0.5 h at -45°C , a solution of *cis*-1-(4-bromobenzoyl)-3-triethylsilyloxy-4-(4-methoxyphenyl)azetidin-2-one (696 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 321 mg of a mixture containing (2'R,3'S)-2',7-(bis)triethylsilyl-*N*-debenzoyl-*N*-(4-bromobenzoyl)-3'-desphenyl-3'-(4-methoxyphenyl) taxol and a small amount of the (2'S,3'R) isomer.

To a solution of 351 mg of the mixture obtained from the previous reaction in 12 mL of acetonitrile and 0.6 mL of pyridine at 0°C was added 1.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 320 mg of material which was purified by flash chromatography

to give 189 mg (69%) of *N*-debenzoyl-*N*-(4-bromobenzoyl)-3'-desphenyl-3'-(4-methoxyphenyl) taxol, which was recrystallized from methanol/water.

m.p. 173.5-176 °C; $[\alpha]_{D}^{25} -48.9^{\circ}$ (c 0.0065, CHCl₃).

¹H NMR (CDCl₃, 300 MHz) δ 8.13 (d, $J = 7.2$ Hz, 2H, benzoate *ortho*), 7.7-7.3 (m, 9H, aromatic), 6.93 (d, $J = 8.8$ Hz, 2H, aromatic), 6.93 (d, $J = 9.3$ Hz, 1H, NH), 6.27 (s, 1H, H10), 6.21 (dd, $J = 8.8, 8.8$ Hz, 1H, H13), 5.68 (m, 2H, H3', H2 β), 4.94 (dd, $J = 8.8, 1.7$ Hz, 1H, H5), 4.74 (dd, $J = 4.9, 2.8$ Hz, 1H, H2'), 4.40 (m, 1H, H7), 4.31 (d, $J = 8.2$ Hz, 1H, H20 α), 4.19 (d, $J = 8.2$ Hz, 1H, H20 β), 3.80 (d, $J = 7.1$ Hz, 1H, H3), 3.80 (s, 3H, ArOMe), 3.51 (d, $J = 4.9$ Hz, 1H, 2'OH), 2.54 (m, 1H, H6 α), 2.46 (d, $J = 4.4$ Hz, 1H, 7OH), 2.37 (s, 3H, 4Ac), 2.31 (m, 2H, H14 α , H14 β), 2.24 (s, 3H, 10Ac), 1.87 (m, 1H, H6 α), 1.79 (br s, 3H, Me18), 1.74 (s, 1H, 1OH), 1.68 (s, 3H, Me19), 1.23 (s, 3H, Me17), 1.14 (s, 3H, Me16).

EXAMPLE 31

Preparation of *N*-debenzoyl-*N*-(4-*t*-butylbenzoyl)-3'-desphenyl-3'-(4-methoxyphenyl) taxol.

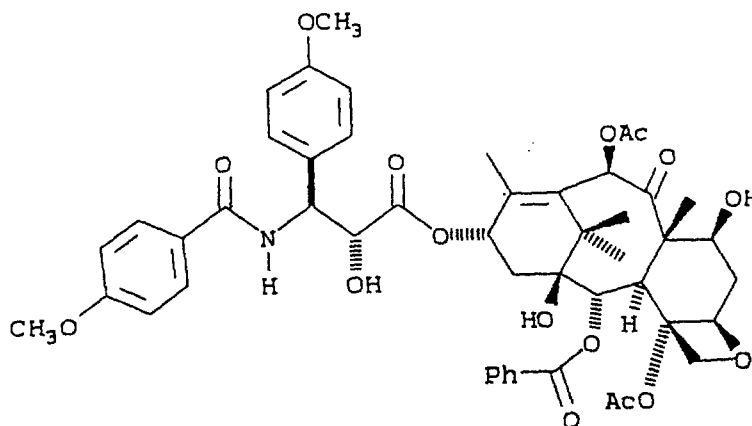
To a solution of 7-triethylsilyl baccatin III (200 mg, 0.286 mmol) in 2 mL of THF at -45°C was added dropwise 0.174 mL of a 1.63M solution of *n*BuLi in hexane. After 0.5 h at -45°C , a solution of *cis*-1-(4-*t*-butylbenzoyl)-3-triethylsilyloxy-4-(4-methoxyphenyl)azetidin-2-one (670 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0°C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO_3 and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 340 mg of a mixture containing (2'*R*,3'*S*)-2',7-(bis)triethylsilyl-*N*-debenzoyl-*N*-(4-*t*-butylbenzoyl)-3'-desphenyl-3'-(4-methoxyphenyl) taxol and a small amount of the (2'*S*,3'*R*) isomer.

To a solution of 340 mg (0.291 mmol) of the mixture obtained from the previous reaction in 18 mL of acetonitrile and 0.93 mL of pyridine at 0°C was added 2.8 mL of 48% aqueous HF. The mixture was stirred at 0°C for 3 h, then at 25°C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 275 mg of material which was purified by flash chromatography to give 188 mg (70%) of *N*-debenzoyl-*N*-(4-

t-butylbenzoyl)-3'-desphenyl-3'-(4-methoxyphenyl) taxol, which was recrystallized from methanol/water.

m.p. 184-185 °C; $[\alpha]^{25}_{Na} -50.4^{\circ}$ (c 0.01, CHCl₃).

¹H NMR (CDCl₃, 300 MHz) δ 8.13 (d, $J = 7.1$ Hz, 2H, benzoate ortho), 7.53 (m, 9H, aromatic), 6.92 (m, 2H, aromatic), 6.88 (d, $J = 8.8$ Hz, 1H, NH), 6.27 (s, 1H, H10), 6.21 (dd, $J = 8.8$, 8.8 Hz, 1H, H13), 5.72 (dd, $J = 8.8$, 2.8 Hz, 1H, H3'), 5.67 (d, $J = 7.1$ Hz, 1H, H2 β), 4.95 (dd, $J = 9.8$, 2.2 Hz, 1H, H5), 4.74 (dd, $J = 5.5$, 2.8 Hz, 1H, H2'), 4.40 (ddd, $J = 11.0$, 6.6, 3.8 Hz, 1H, H7), 4.30 (d, $J = 8.4$ Hz, 1H, H20 α), 4.19 (d, $J = 8.4$ Hz, 1H, H20 β), 3.80 (d, $J = 7.1$ Hz, 1H, H3), 3.79 (s, 3H, ArOMe), 3.63 (d, $J = 5.5$ Hz, 1H, 2'OH), 2.54 (m, 1H, H6 α), 2.46 (d, $J = 3.8$ Hz, 1H, 7OH), 2.38 (s, 3H, 4Ac), 2.32 (m, 2H, H14), 2.23 (s, 3H, 10Ac), 1.87 (ddd, $J = 11.0$, 14.7, 2.2 Hz, 1H, H6 β), 1.81 (br s, 3H, Me18), 1.80 (s, 1H, 10H), 1.68 (s, 3H, Me19), 1.30 (s, 9H, Ar^tBu), 1.23 (s, 3H, Me17), 1.14 (s, 3H, Me16).

EXAMPLE 32

Preparation of *N*-debenzoyl-*N*-(4-methoxybenzoyl)-3'-desphenyl-3'-(4-methoxyphenyl) taxol.

To a solution of 7-triethylsilyl baccatin III (200 mg, 0.286 mmol) in 2 mL of THF at -45 °C was added dropwise 0.174 mL of a 1.63M solution of *n*BuLi in hexane. After 0.5 h at -45 °C, a solution of *cis*-1-(4-methoxybenzoyl)-3-triethylsilyloxy-4-(4-methoxyphenyl)azetidin-2-one (630 mg, 1.43 mmol) in 2 mL of THF was added dropwise to the mixture. The solution was warmed to 0 °C and kept at that temperature for 1 h before 1 mL of a 10% solution of AcOH in THF was added. The mixture was partitioned between saturated aqueous NaHCO₃ and 60/40 ethyl acetate/hexane. Evaporation of the organic layer gave a residue which was purified by filtration through silica gel to give 330 mg of a mixture containing (2'*R*,3'*S*)-2',7-(bis)triethylsilyl-*N*-debenzoyl-*N*-(4-methoxybenzoyl)-3'-desphenyl-3'-(4-methoxyphenyl) taxol and a small amount of the (2'*S*,3'*R*) isomer.

To a solution of 330 mg (0.289 mmol) of the mixture obtained from the previous reaction in 18 mL of acetonitrile and 0.93 mL of pyridine at 0 °C was added 2.8 mL of 48% aqueous HF. The mixture was stirred at 0 °C for 3 h, then at 25 °C for 13 h, and partitioned between saturated aqueous sodium bicarbonate and ethyl acetate. Evaporation of the ethyl acetate solution gave 255 mg of material which was purified by

flash chromatography to give 183 mg (70%) of *N*-debenzoyl-*N*-(4-methoxybenzoyl)-3'-desphenyl-3'-(4-methoxyphenyl) taxol, which was recrystallized from methanol/water.

m.p. 174-175 °C; $[\alpha]_D^{25} -50.6^\circ$ (c 0.01, CHCl₃).

¹H NMR (CDCl₃, 300 MHz) δ 8.13 (d, *J* = 7.1 Hz, 2H, benzoate ortho), 7.69 (d, *J* = 8.8 Hz, 2H, benzamide ortho), 7.62 (m, 1H, aromatic), 7.51 (m, 2H, aromatic), 7.39 (m, 2H, aromatic), 6.90 (m, 4H, aromatic), 6.82 (d, *J* = 8.2 Hz, 1H, NH), 6.27 (s, 1H, H10), 6.20 (dd, *J* = 8.8, 8.8 Hz, 1H, H13), 5.69 (dd, *J* = 8.2, 2.7 Hz, 1H, H3'), 5.67 (d, *J* = 6.6 Hz, 1H, H2 β), 4.95 (dd, *J* = 7.7, 1.6 Hz, 1H, H5), 4.73 (dd, *J* = 5.5, 2.7 Hz, 1H, H2'), 4.40 (ddd, *J* = 11.0, 6.6, 4.4 Hz, 1H, H7), 4.30 (d, *J* = 8.24 Hz, 1H, H20 α), 4.19 (d, *J* = 8.24 Hz, 1H, H20 β), 3.81 (s, 3H, ArOMe), 3.80 (d, *J* = 6.6 Hz, 1H, H3), 3.78 (s, 3H, ArOMe), 3.71 (d, *J* = 5.5 Hz, 1H, 2'OH), 2.54 (ddd, *J* = 7.7, 14.3, 6.6 Hz, 1H, H6 α), 2.47 (d, *J* = 4.4 Hz, 1H, 7OH), 2.37 (s, 3H, 4Ac), 2.31 (m, 2H, H14), 2.23 (s, 3H, 10Ac), 1.89 (ddd, *J* = 11.0, 14.3, 1.6 Hz, 1H, H6 β), 1.79 (br s, 3H, Me18), 1.69 (s, 1H, 1OH), 1.67 (s, 3H, Me19), 1.23 (s, 3H, Me17), 1.13 (s, 3H, Me16).

EXAMPLE 33

Tubulin binding assays were performed using compounds from the previous Examples substantially as set forth in Parness et al., J. Cell Biology 91: 479-487 (1981) and compared to taxol and taxotere. The results are presented in Table 1.

TABLE 1

<u>Compound</u>	<u>Tubulin Assay</u>	
	<u>Init.</u> <u>Peak</u>	<u>Rel.</u> <u>Rate</u>
Example 1	0	0
2	0	0
3	59	87
4	94	97
5	5	74
6	53	85
7	11	26
8	114	105
9	100	
10	75	90
11	67	88
12	107	110
13	67	85
14	95	99
15	89	98
16	66	90
17	101	98
18	109	92
19	88	100
20	85	98
21	45	81
22	77	96
23	63	88
24	35	60
25	60	83
26	13	23
27	55	82
28	106	97
29	42	72
30	44	70
31	24	44
32	51	81
Taxol	100	98
Taxotere	100	

EXAMPLE 34

IC₅₀ data were obtained in vitro on a human cancer cell line (HCT 116) which is available from the National Cancer Institute, and a multidrug resistant cell line (HCT/VM46), which is resistant to a variety of hydrophobic agents, including taxol. Cytotoxicity was assessed in HCT116 and HCT VM46 human colon carcinoma cells by XTT (2,3-bis(2-methoxy-4-nitro-5-sulfo-phenyl)-5-[(phenyl-amino)carbonyl]-2H-tetrazolium hydroxide assay (Scudiero et al, "Evaluation of a soluble tetrazolium/formazan assay for cell growth and drug sensitivity in culture using human and other tumor cell lines", Cancer Res. 48:4827-4833, 1988). Cells were plated at 4000 cells/well in 96 well microtiter plates and 24 hours later drugs were added and serially diluted. The cells were incubated at 37°C for 72 hours at which time the tetrazolium dye, XTT, was added. A dehydrogenase enzyme in live cells reduces the XTT to a form that absorbs light at 450 nm which can be quantitated spectrophotometrically. The greater the absorbance the greater the number of live cells. The results are expressed as an IC₅₀ which is the drug concentration required to inhibit cell proliferation (i.e. absorbance at 450 nm) to 50% of that of untreated control cells. The results are presented in Table 2. Lower numbers indicate greater activity.

TABLE 2

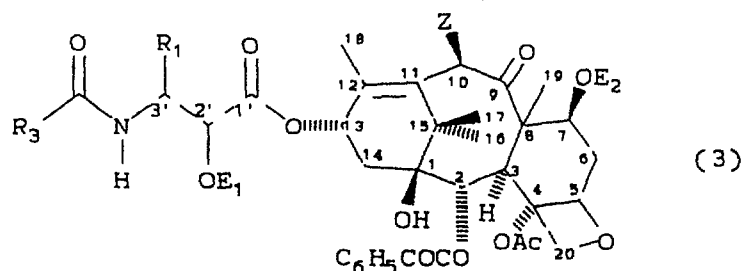
<u>Compound</u>	<u>IC₅₀</u>	
	<u>HCT</u> <u>116</u>	<u>HCT</u> <u>VM46</u>
Example 1	.385	2.58
2	.084	1.89
3	.005	0.469
4	.018	0.825
5	.025	1.38
6	.021	1.7
7	.303	7.8
8	.014	2.6
9	.014	0.817
10	.009	2.26
11	.014	1.85
12	.005	0.442
13	.006	0.651
14	.004	0.973
15	.005	2.17
Taxol	0.004	0.536
Taxotere	0.007	0.246

In view of the above, it will be seen that the several objects of the invention are achieved.

As various changes could be made in the above compositions without departing from the scope of the invention, it is intended that all matter contained in the above description be interpreted as illustrative and not in a limiting sense.

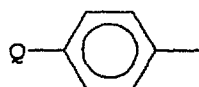
CLAIMS:

1. A taxane derivative of the formula



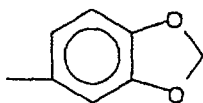
wherein

- R_1 and R_3 are independently selected from the group comprising phenyl, naphthyl, C_6H_5CHCH- , and

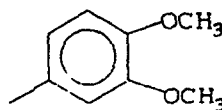


provided, however, R_1 and R_3 are not both phenyl;

Q is CH_3- , $(CH_3)_3C-$, CH_3O- , Cl , Br , F , NO_2 ,



or



10

Z is $-OT_1$,

T_1 is hydrogen, hydroxyl protecting group, or $-COT_2$,



T_2 is H, C_1-C_6 alkyl, C_1-C_6 alkenyl, C_1-C_6 alkynyl or monocyclic aryl,

15 Ac is acetyl, and

E_1 and E_2 are independently selected from hydrogen and functional groups which increase the water solubility of the taxane derivative.

2. The taxane derivative of claim 1 wherein R_1 is phenyl.

3. The taxane derivative of claim 1 wherein R_1 is phenyl, Z is $-OCOCH_3$, E_1 and E_2 are hydrogen, and the taxane has the 2'R, 3'S configuration.

4. The taxane derivative of claim 1 wherein R_1 is phenyl, Z is $-OCOCH_3$, the taxane has the 2'R, 3'S configuration, and at least one of E_1 and E_2 is $-COGCOR^1$ wherein

5 G is ethylene, propylene, $CH=CH$, 1,2-cyclohexane, or 1,2-phenylene,

R^1 = OH base, NR^2R^3 , OR^3 , SR^3 , $OCH_2CONR^4R^5$, OH

R^2 = hydrogen, methyl

R^3 = $(CH_2)_nNR^6R^7$; $(CH_2)_nN^{\oplus}R^6R^7R^8X^{\ominus}$

10 n = 1 to 3

R^4 = hydrogen, lower alkyl containing 1 to 4 carbons

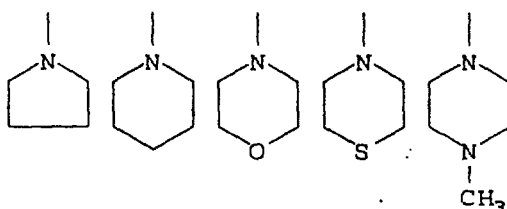
R^5 = hydrogen, lower alkyl containing 1 to 4 carbons, benzyl, hydroxyethyl, CH_2CO_2H , dimethylaminoethyl

15

R^6R^7 = lower alkyl containing 1 or 2 carbons, benzyl or R^6 and

R^7 together with the nitrogen atom of NR^6R^7 form the following rings





R^8 = lower alkyl containing 1 or 2 carbons, benzyl
 $X^\ominus$ = halide

base = NH_3 , $(HOC_2H_4)_3N$, $N(CH_3)_3$, $CH_3N(C_2H_4OH)_2$,
 $NH_2(CH_2)_6NH_2$, N-methylglucamine, NaOH, KOH.

5. The taxane derivative of claim 1 wherein R_3 is phenyl, Z is $-OCOCH_3$, the taxane has the 2'R, 3'S configuration, and at least one of E_1 and E_2 is $-COGCOR^1$ wherein

5 G is ethylene, propylene, $CH=CH$, 1,2-cyclohexane, or 1,2-phenylene,

R^1 = OH base, NR^2R^3 , OR^3 , SR^3 , $OCH_2CONR^4R^5$, OH

R^2 = hydrogen, methyl

R^3 = $(CH_2)_nNR^6R^7$; $(CH_2)_nN^+R^6R^7R^8X^\ominus$

10 n = 1 to 3

R^4 = hydrogen, lower alkyl containing 1 to 4 carbons

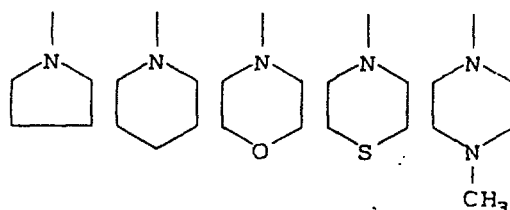
R^5 = hydrogen, lower alkyl containing 1 to 4 carbons, benzyl, hydroxyethyl, CH_2CO_2H , dimethylaminoethyl

15

R^6R^7 = lower alkyl containing 1 or 2 carbons, benzyl or R^6 and

R^7 together with the nitrogen atom of NR^6R^7 form the following rings





R^8 = lower alkyl containing 1 or 2 carbons, benzyl
 $X^\ominus$ = halide

base = NH_3 , $(HOC_2H_4)_3N$, $N(CH_3)_3$, $CH_3N(C_2H_4OH)_2$,
 $NH_2(CH_2)_6NH_2$, N-methylglucamine, NaOH, KOH.

6. A pharmaceutical composition which contains the taxane of claim 1 and one or more pharmacologically acceptable, inert or physiologically active diluents or adjuvants.

7. The composition of claim 6 wherein R_1 is phenyl.

8. The composition of claim 6 wherein R_1 is phenyl, Z is $-OCOCH_3$, and E_1 and E_2 are hydrogen.

9. The composition of claim 6 wherein R_1 is phenyl, Z is $-OCOCH_3$, E_1 and E_2 are hydrogen, and the taxane has the 2'R, 3'S configuration.

10. The composition of claim 6 wherein R_1 is phenyl, Z is $-OCOCH_3$, the taxane has the 2'R, 3'S configuration, and at least one of E_1 and E_2 is $-COGCR^1$ wherein

5 G is ethylene, propylene, $CH=CH$, 1,2-cyclohexane, or 1,2-phenylene,

R^1 = OH base, NR^2R^3 , OR^3 , SR^3 , $OCH_2CONR^4R^5$, OH





R^2 = hydrogen, methyl

R^3 = $(CH_2)_nNR^6R^7$; $(CH_2)_nN^{\oplus}R^6R^7R^8X^{\ominus}$

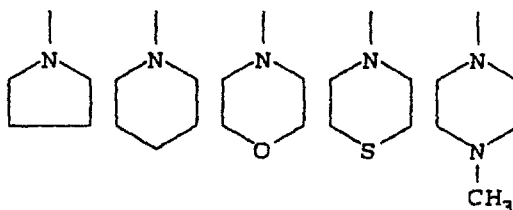
n = 1 to 3

10 R^4 = hydrogen, lower alkyl containing 1 to 4 carbons

R^5 = hydrogen, lower alkyl containing 1 to 4 carbons, benzyl, hydroxyethyl, CH_2CO_2H , dimethylaminoethyl

15 R^6R^7 = lower alkyl containing 1 or 2 carbons, benzyl or R^6 and

R^7 together with the nitrogen atom of NR^6R^7 form the following rings



20 R^8 = lower alkyl containing 1 or 2 carbons, benzyl
 $X^{\ominus}$ = halide

base = NH_3 , $(HOC_2H_4)_3N$, $N(CH_3)_3$, $CH_3N(C_2H_4OH)_2$,
 $NH_2(CH_2)_6NH_2$, N-methylglucamine, NaOH, KOH.

