



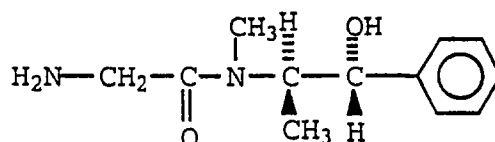
Preparation of (S)-2-Amino-6,6-Dimethoxyhexanoic Acid
Methyl Ester Via Novel Dioxolanes

Abstract Of The Disclosure

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The glycineamide of the formula

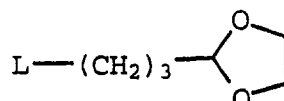
(I)



is reacted with the dioxolane of the formula

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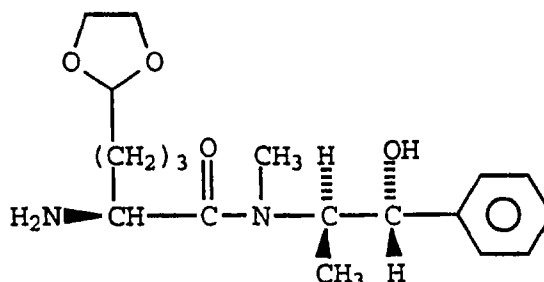
(II)



wherein L is a leaving group such as iodo, bromo,
alkylsulfonyloxy, or arylsulfonyloxy to give the dioxolane
of the formula

15

(III)



20 Treating the dioxolane of formula III under aqueous
refluxing conditions followed by exchanging the dioxolane
acetal with a dimethoxy acetal and introduction of the
methyl ester gives (S)-2-amino-6,6-dimethoxyhexanoic acid,
methyl ester which is an intermediate in the preparation of
the dual inhibitor [4S-[4α(R*),7α,10aβ]]-

25 octahydro-4-[(2-mercapto-1-oxo-3-phenylpropyl)-
amino]-5-oxo-7H-pyrido[2,1-b][1,3]thiazepine-7-carboxylic
acid. Also disclosed are storage stable salts of (S)-2-
amino-6,6-dimethoxyhexanoic acid, methyl ester.

