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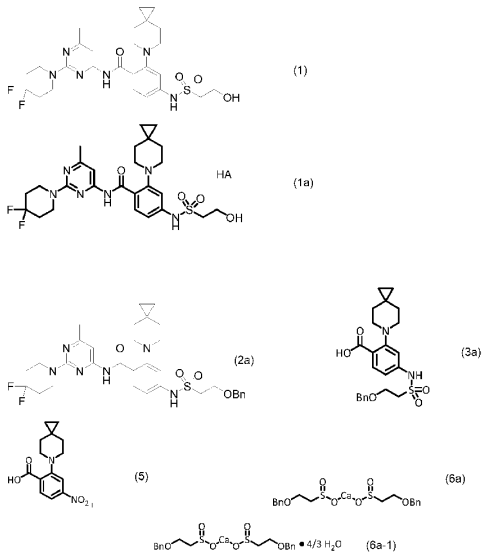
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(54) Title: SYNTHESIS OF A KIF18A INHIBITOR



(57) Abstract: The present invention relates to improved preparation of a KIF18A inhibitor having the chemical structure Compound (1), or a salt thereof Compound (1a); wherein HA is as defined herein; and key intermediates thereof, i.e.,Compound (2a), Compound (3a), Compound (5) or a salt thereof, andCompound (6a) or a hydrate thereof, of the formulae: Compound (2a); Compound (3a); Compound (5) or a salt thereof; and Compound (6a) or a hydrate thereof, preferably Compound (6a-1). The present invention further relates to solid form of Compound (6a), preferably the crystalline hydrate form of Compound (6a-1).

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