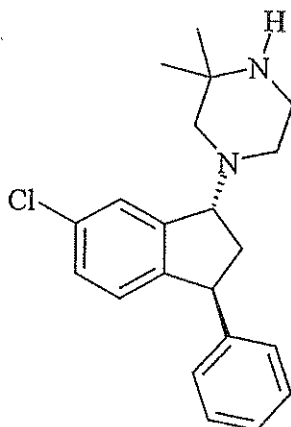


**PROCESS FOR MAKING
TRANS-1- ((1R, 3S) - 6-CHLORO-3 -PHENYLINDAN-1-YL) -3 , 3-DIMETHYLPYPERAZINE**

The present invention relates to a process for making *trans*-1-((1*R*,3*S*)-6-chloro-3-phenylindan-1-yl)-3,3-dimethylpiperazine (Compound I) and salts thereof.

5 BACKGROUND OF THE INVENTION

The compound, which is the subject of the present invention (Compound I, *trans*-1-((1*R*,3*S*)-6-chloro-3-phenylindan-1-yl)-3,3-dimethylpiperazine) has the general formula (I).



(I)

10 Compound I and salts thereof, including a fumarate and maleate salt thereof, and the medical uses thereof, e.g. in schizophrenia or other diseases involving psychotic symptoms, are described in PCT/DK04/000546 (WO05/016901).

As described in PCT/DK04/000546 the inventors have found that Compound I displays high
15 affinity for dopamine (DA) D1 receptors, DA D2 receptors and for α_1 adrenoceptors. Furthermore, Compound I was found to be an antagonist at dopamine D1 and D2 receptors, and at serotonin 5-HT_{2a} receptors. As further described in PCT/DK04/000546, Compound I is a relatively weak inhibitor of CYP2D6 (i.e. reduced potential for drug to drug interaction) and has a relatively low effect on the QT interval in a rabbit model (i.e. reduced potential for
20 introducing drug-induced QT interval prolongation and appearance of fatal cardiac arrhythmias, torsade de pointes (TdP), in humans). Additionally, the 5-HT₂ antagonistic activity of Compound I suggests that Compound I may have a relatively low risk of extrapyramidal side effects.

The properties outlined above, e.g. binding assays (including alfa-1, DA D1 or D2 receptors), efficacy assays (including DA D1 or D2, or serotonin 5-HT_{2A} receptors), CYP2D6 inhibition and QT-interval may be determined as described in PCT/DK04/000546, cf. in particular the "Example" section page 19-24 in the application text as filed for
5 PCT/DK04/000546. □

Further, the inventors have found that Compound I did not induce dystonia when tested in pigs sensitized to haloperidol, indicating that Compound I does not possess EPS (extrapyramidal symptoms) response/liability in humans.

10 PCT/DK04/000546 describes the following medical uses of Compound I: a disease in the central nervous system, including psychosis, in particular schizophrenia (e.g. positive, negative, and/or depressive symptoms) or other diseases involving psychotic symptoms, such as, e.g., Schizophrenia, Schizophreniform Disorder, Schizoaffective Disorder,
15 Delusional Disorder, Brief Psychotic Disorder, Shared Psychotic Disorder as well other psychotic disorders or diseases that present with psychotic symptoms, e.g. mania in bipolar disorder. Also described is the use of Compound I for treatment of anxiety disorders, affective disorders including depression, sleep disturbances, migraine, neuroleptic-induced parkinsonism, or cocaine abuse, nicotine abuse, alcohol abuse and other abuse disorders.

20 As indicated in PCT/DK04/000546 a group of compounds structurally related to Compound I, i.e. *trans* isomers of 3-aryl-1-(1-piperaziny)indanes substituted in the 2- and/or 3-position of the piperazine ring, has been described in EP 638 073; Bøgesø et al. in J. Med. Chem., 1995, 38, 4380-4392 and Klaus P. Bøgesø in "Drug Hunting, the Medicinal Chemistry of 1-Piperazino-3-phenylindans and Related Compounds", 1998, ISBN 87-88085-10-41. For
25 example, an enantiomeric pure compound corresponding to formula (I) but differing in that it has an *N*-methyl group instead of an *N*-hydrogen on the piperazine has been disclosed in Bøgesø et al. in J. Med. Chem., 1995, 38, 4380-4392, see table 5, compound (-)-38.

30 None of the above references apart from PCT/DK04/000546 disclose the specific enantiomeric form above (Compound I) or medical use thereof. The *trans* isomer in the form of the racemate of Compound I is only indirectly disclosed as an intermediate in the

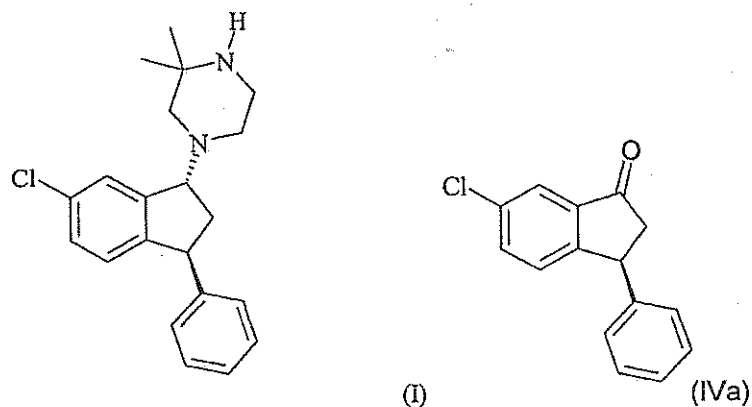
synthesis of compound 38 in Bøgesø et al. in J. Med. Chem., 1995, 38, 4380-4392 while medical use of Compound I or its corresponding racemate is not described. Compound I as an intermediate is disclosed in PCT/DK04/000545 (WO05/016900).

5 SUMMARY

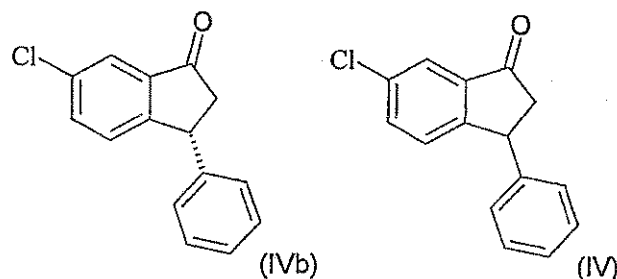
According to a first aspect, there is provided a method for manufacturing a compound of formula I (Compound I) or a salt thereof, which method comprises conversion of a compound of formula IVa (Compound IVa) to the compound of formula I, wherein formula I and IVa are as follows:

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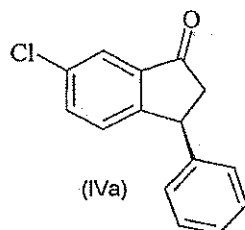
20 According to a second aspect, there is provided a method for the conversion of the enantiomerically enriched compound IVb into essentially racemic compound IV, where in IVb and IV are:



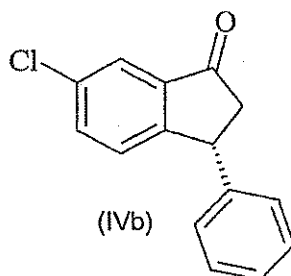
25

and wherein the racemisation is obtained by using one equivalent or more of a non nucleophilic base, followed by addition of a catalytic amount, or one equivalent or more of the same or another base.

According to a third aspect, there is provided a compound (IVa) having the structure as follows:



According to a fourth aspect, there is provided a compound (IVb) having the structure as follows:



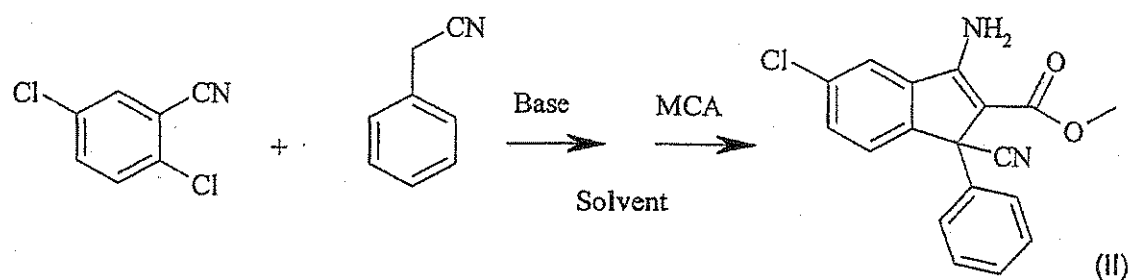
According to a fifth aspect, there is provided a compound as defined in the third or fourth aspect which is substantially pure.

DETAILED DESCRIPTION OF THE INVENTION

The present invention in one aspect relates to a new process for the preparation of Compound I wherein the chirality is introduced earlier in the manufacturing process as compared to the process described in PCT/DK04/000546. The introduction of the chirality one step earlier is an advantage because the following step becomes more efficient in terms of *e.g.* volume yield, and consumption of reagents and solvents and production of less waste. In PCT/DK04/000546, the chirality is introduced by resolving the racemic intermediate V below, either enzymatically or by chiral HPLC. The present inventors have now developed a route of synthesis in which the enantiomer of formula (I) is obtained via a sequence starting from enantiomeric pure IV, *i.e.* Compound IVa ((S)-6-chloro-3-phenylindan-1-one, see below). Thus, in this process, the intermediate of formula IV is resolved, *e.g.* by chiral chromatography, to obtain the enantiomer of formula IVa.

Furthermore, the present inventors have developed a method for the racemisation of the undesired enantiomer (Compound IVb, see below), which then can be reused in the resolution. This has a tremendous impact on the efficiency of the whole synthesis, as the efficiency of the steps before the resolution is increased as well as the subsequent steps.

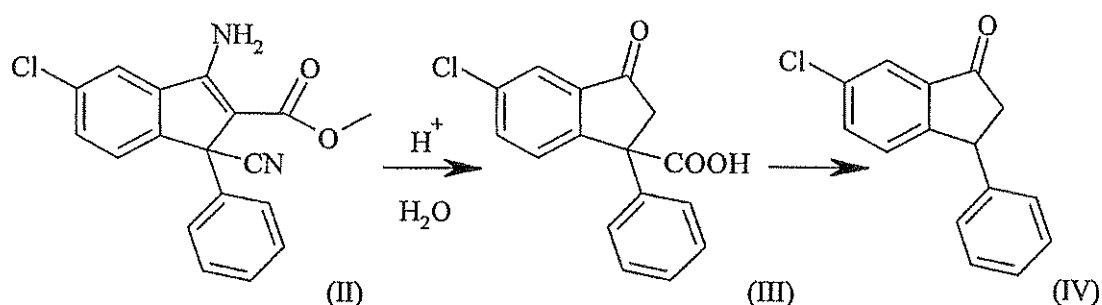
Accordingly, the enantiomer of formula (I) may be obtained by a process involving the following steps:



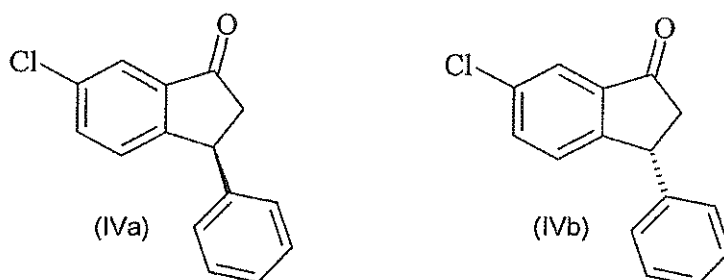
Benzyl cyanide is reacted with 2,5-dichlorobenzonitril in the presence of a base, suitably potassium tert-butoxide (t-BuOK) in a suitable solvent such as 1,2-dimethoxyethane (DME),

further reaction with methyl chloro acetate (MCA) leads to spontaneous ring closure and one pot formation of the compound of formula (II).

The compound of formula (II) is then subjected to acidic hydrolysis to form a compound of formula (III), suitably by heating in a mixture of acetic acid, sulphuric acid and water, and thereafter decarboxylation, e.g., by heating the compound of formula (III) in a suitable solvent, such as toluene with triethyl amine or N-methyl pyrrolidin-2-one (NMP), to form a compound of formula (IV).



- 10 The compound of formula (IV) is resolved to achieve the desired enantiomer (formula IVa) for the further synthesis of Compound I, and the undesired enantiomer (formula IVb) which may be subjected to racemisation and recycling:



15

The resolution of IV may, e.g., be performed using chiral chromatography, preferable liquid chromatography, or sub- or supercritical fluid chromatography.

- 20 Chiral liquid chromatography may, e.g., be performed on a chiral stationary phase, suitably on a column of silica gel with an immobilized chiral polymer, or preferably on a column of silica gel coated with a chiral polymer, e.g. a modified cellulose, or a modified amylose,

such as amylose tris [(S)- α -methylbenzylcarbamate], preferably a column of silica gel coated with amylose tris [(S)- α -methylbenzylcarbamate].

A suitable solvent is used for the chiral liquid chromatography, such as, *e.g.* an alcohol (preferably a C₁₋₄-alcohol), a nitrile, an ether, or an alkane (preferably a C₅₋₁₀-alkane), or mixtures thereof, suitably ethanol, methanol, iso-propanol, acetonitrile, methyl tert-butyl ether or n-heptane or mixtures thereof, preferably ethanol or n-heptane or a mixture thereof. Acidic or basic modifiers can be added to the eluent, *e.g.* formic acid, acetic acid, trifluoroacetic acid, triethylamine, or *N,N*-diethylamine.

Sub- or supercritical fluid chromatography may, *e.g.*, be performed on a chiral stationary phase, suitably on a column of silica gel with an immobilized chiral polymer, or on a column of silica gel coated with a chiral polymer, *e.g.* a modified amylose, such as amylose tris [(S)- α -methylbenzylcarbamate], or preferably amylose tris (3,5-dimethylphenylcarbamate), most preferably amylose tris (3,5-dimethylphenylcarbamate) coated on silica gel, or a modified cellulose, such as cellulose tris (4-methylbenzoate), or preferable cellulose tris (3,5-dimethylphenylcarbamate), most preferably cellulose tris (3,5-dimethylphenylcarbamate) coated on silica gel. Other types of chiral stationary phases may be used, *e.g.* the Pirkle type columns, suitable on a column of silica gel with covalently bonded 3,5-dinitrobenzoyl tetrahydrophenanthrene amine.

Sub- or supercritical carbon dioxide, suitable supercritical carbon dioxide, containing a modifier may be used as eluent for the sub- or supercritical fluid chromatography. The modifier is selected from the lower alcohols such as methanol, ethanol, propanol and isopropanol, or *e.g.* acetonitril may be used. An amine, such as diethylamine, optionally 0.1% diethylamine, triethylamine, propylamine, and dimethyl iso-propyl amine, and optionally an acid, such as formic acid, acetic acid and trifluoroacetic acid may be added.

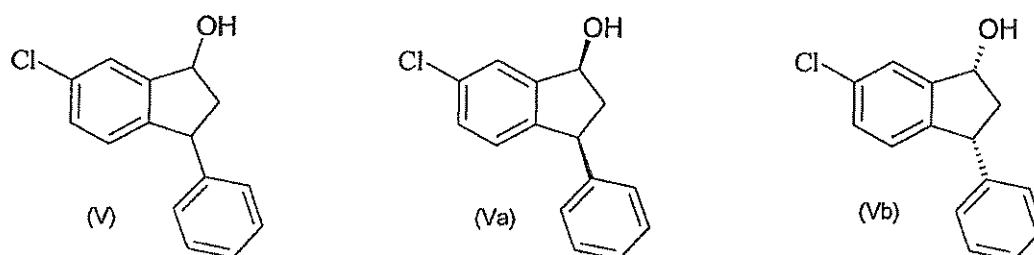
In a further embodiment of the invention the modifier is selected from the lower alcohols such as methanol, ethanol, propanol and isopropanol, or *e.g.* acetonitril may be used, as long as the modifier is compatible with the column.

The chiral chromatography can be scaled up using suitable technologies, *e.g.* simulated moving bed technology (SMB), or sub- or supercritical fluid technology (*cf.* G. B. Cox (ed.) *Preparative Enantioselective Chromatography*, Blackwell Publishing Ltd., Oxford, UK, 2005).

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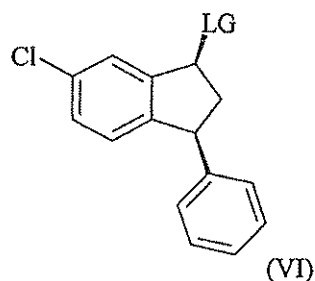
The compound of formula (IVa) is then reduced *e.g.* with a complex metal hydride, such as borohydride, suitably with sodium borohydride (NaBH_4) or such as lithium aluminiumhydride, in a solvent, such as an alcohol (*e.g.* a C_{1-5} -alcohol), *e.g.* ethanol or *iso*-propanol, and preferably at a temperature in the range of about -30° to $+30^\circ\text{C}$, *e.g.* below 30°C , below 20°C , below 10°C , or preferably below 5°C , to form a compound of formula (Va) with *cis* configuration:

10



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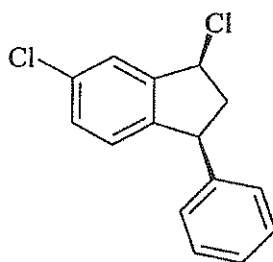
The alcohol group of the *cis*-alcohol of formula (Va) is converted to a suitable leaving group, such as, *e.g.*, a halogen, *e.g.* Cl or Br, preferably Cl, or a sulphonate, *e.g.* mesylate (methanesulfonylate) or tosylate (4-toluenesulfonylate), suitably by reaction with an agent, such as thionyl chloride, mesyl (methanesulfonyl) chloride or tosyl (4-toluenesulfonyl) chloride, in an inert solvent, *e.g.* an ether, suitably tetrahydrofuran. The resulting compound has formula (VI), where LG is the leaving group:



20

In a preferred embodiment, LG is Cl, i.e. the *cis*-chloride of formula (VIa):

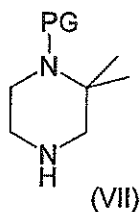
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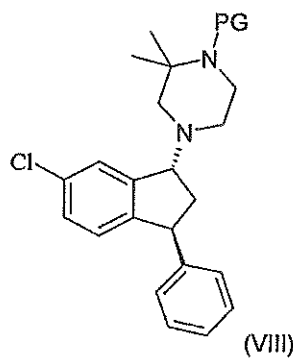
(VIa)

Compound VI, *e.g.* with LG as chloro, is then reacted with 2,2-dimethylpiperazine in a suitable solvent, *e.g.* a ketone such as, *e.g.*, methyl isobutyl ketone or methyl ethyl ketone, preferably methyl isobutyl ketone in the presence of a base, such as *e.g.*, potassium carbonate, to obtain Compound I.

Alternatively, the piperazine part of the molecule may be introduced by reacting Compound VI with a compound of formula (VII) below, where PG is a protecting group, such as, but not restricted to, *e.g.* phenylmethoxycarbonyl (often called Cbz or Z), tert-butyloxycarbonyl (often called BOC), ethoxycarbonyl, or benzyl, thereby obtaining the compound of formula (VIII) below. Compound VIII is subsequently deprotected to afford Compound I.



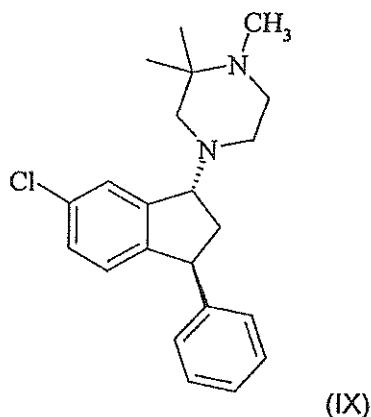
(VII)



(VIII)

A further embodiment of the invention relates to a method for the manufacturing of a compound [Compound IX: 4-((1*R*,3*S*)-6-chloro-3-phenylindan-1-yl)-1,2,2-trimethylpiperazine] having the following formula (IX) or a salt thereof:

8



which method comprises:

- (i) manufacturing Compound I by a method of the present invention, i.e. in particular from Compound IVa; and
- 5 (ii) converting Compound I into Compound IX, preferably by methylating the secondary amine functionality, suitably by reductive alkylation using suitable agents, such as, e.g., formaldehyde, paraformaldehyde, trioxane, or diethoxy methane (DEM).

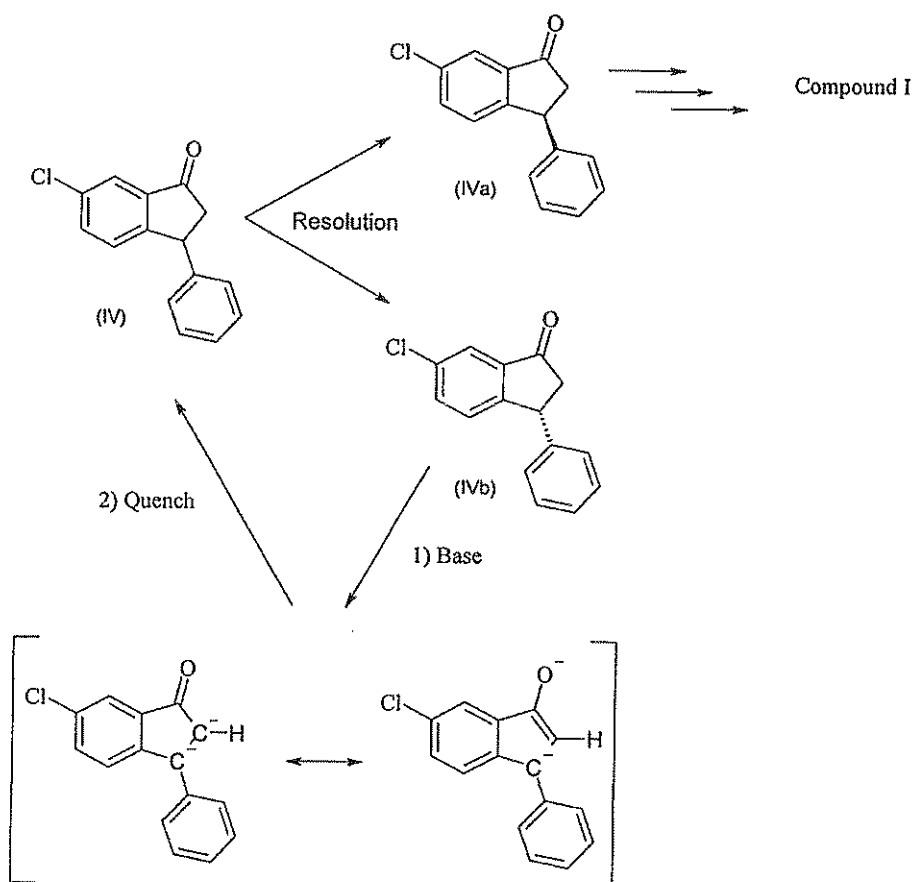
The term reductive alkylation refers to the above-mentioned reagents in combination with a
10 reductive agent, such as formic acid.

Thus, further embodiment of the invention relates to the methods as described herein for the manufacturing of Compound I, wherein Compound I is "replaced" by Compound IX.

15 Compound IX is described generically in EP 638 073 while the enantiomer of formula (IX) has been described by Bøgesø et al. in J. Med. Chem., 1995, 38, page 4380-4392, in the form of the fumarate salt, see table 5, compound (-)-38. Compound IX and a method for manufacturing Compound IX from Compound I, and salts of Compound IX (in particular a crystalline succinate salt and a crystalline malonate salt) are further described in
20 PCT/DK2004/00545.

As indicated above the invention also relates to a method for the manufacturing of Compound I or Compound IX as described herein wherein Compound IVb is recycled such that it can be used for the synthesis of Compound I or Compound IX, respectively, see also
25 the illustration below.

9



5 Surprisingly, the racemisation of compound IVb can be achieved using different types of bases, *e.g.* an amide, preferably a dialkylamide, *e.g.* but not limited to lithium diethylamide, lithium diisopropylamide, lithium tetramethylpiperidide, suitable lithium diisopropylamide (LDA), or a metal bis-silylamide, *e.g.* alkali bis(trimethylsilyl)amide, or an metal alkoxide, *e.g.* but not limited to metal methoxide, metal ethoxide, metal *tert*-butoxide, suitably alkali
 10 alkoxide, preferably potassium alkoxide, must preferably potassium *tert*-butoxide, or an alkyl metal, suitable an alkyl lithium, preferably butyl lithium or *tert*-butyl lithium. After quenching the reaction mixture, the racemic ketone IV can be isolated.

The racemisation can be achieved using two different bases as well; again, different types of
 15 non nucleophilic bases can be used as "the former base" (base 1), *e.g.* an amide, preferably a dialkylamide, *e.g.* but not limited to lithium diethylamide, lithium diisopropylamide,

lithium tetramethylpiperidide, suitable lithium diisopropylamide (LDA), or a metal bis-silylamide, *e.g.* lithium bis-silylamide, suitably lithium bis(trimethylsilyl)amide, or an metal alkoxide, *e.g.* but not limited to metal methoxide, metal ethoxide, metal *tert*-butoxide, suitably alkali alkoxide, preferably lithium alkoxide, must preferably lithium *tert*-butoxide.

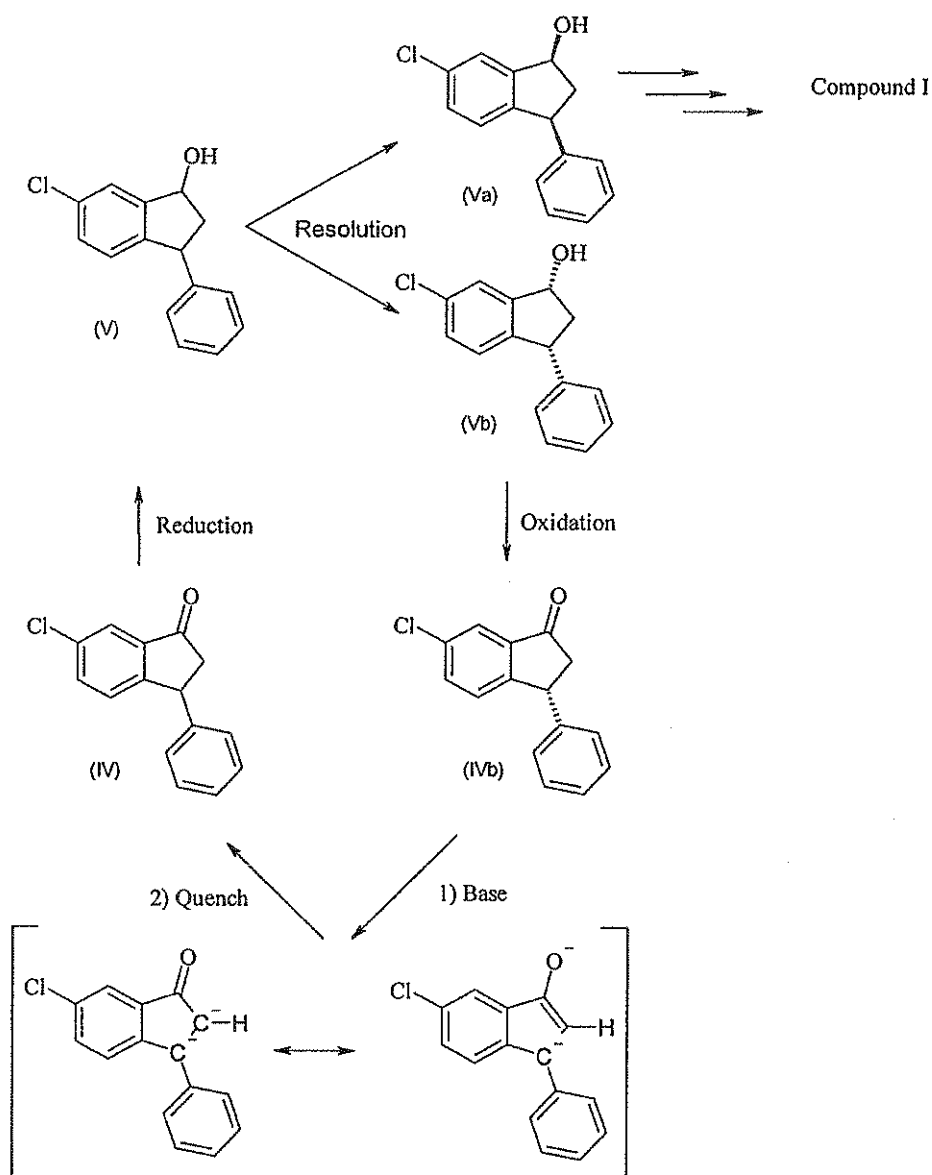
- 5 After the former base (base 1) have been mixed with the ketone, "the latter base" (base 2) is added. As with the former base, different types of bases can be used; *e.g.* an amide, preferably a dialkylamide, *e.g.* but not limited to lithium diethylamide, lithium diisopropylamide, lithium tetramethylpiperidide, suitable lithium diisopropylamide (LDA), or a metal bis-silylamide, *e.g.* alkali bis(trimethylsilyl)amide, or an metal alkoxide, *e.g.* but
10 not limited to metal methoxide, metal ethoxide, metal *tert*-butoxide, suitably alkali alkoxide, preferably potassium alkoxide, must preferably potassium *tert*-butoxide, or an alkyl metal, suitable an alkyl lithium, preferably butyl lithium or *tert*-butyl lithium.

- Furthermore, racemisation can be obtained using two or more different bases by adding
15 them all from the very start, preferable by adding two different bases from the very start.

In a further embodiment of the invention the racemisation can achieved by using a nucleophilic base.

- 20 Alternatively, the racemic alcohol V can be resolved by chiral chromatography as described in PCT/DK04/000546, to obtain Va for the synthesis of Compound I, and Vb, which can be racemised and reused in the resolution as indicated in the figure below. The racemisation of Vb is obtained by oxidation of Vb to IVb, *e.g.* by using pyridinium chlorochromate (PCC), racemisation of IVb to IV as described above, and then reduction of IV to V in the
25 usual way, as described above.

11



When studying the racemisation on a 10 g scale, an impurity as a by product can be detected by LC-MS (liquid chromatography – mass spectroscopy); analytic data suggest that the impurity is a dimer of IV and/or the enantiomers IVa and IVb. The analytical data furthermore indicates, that the dimer can eliminate water, depending on the work up procedure. Laborious work has shown, that the formation of the dimer can be suppressed appreciably by carefully selecting the conditions for the racemisation, and the content of the dimer in the product can be further reduced by recrystallising the product from a suitably solvent, *e.g.* an alcohol, preferably ethanol or 2-propanol.

During the synthesis of Compound I some *cis* diastereoisomer of Compound I (*i.e.* 1-
5 ((1*S*,3*S*)-6-chloro-3-phenylindan-1-yl)-3,3-dimethylpiperazine) may be formed as an
impurity in the final product. This impurity is due mainly to the formation of some of the
trans form of (VI) (*e.g.* (1*S*,3*R*)-3,5-dichloro-1-phenylindan when LG is Cl) in the step
where Compound VI is formed. Therefore, the impurity can be minimized by crystallisation
of the desired *cis* form of Compound VI, from the mixture of *trans* and *cis* (VI); in the case
10 where LG is Cl in Compound VI this can be done by stirring the mixture with a suitable
solvent, *e.g.* an alkane (C₅₋₁₀-alkane), such as heptane, whereby the desired *cis* form of VI
precipitates and the undesired *trans* form of Compound VI goes into solution. The desired
cis form of Compound VI (*e.g.* when LG is Cl) is isolated, *e.g.*, by filtration, and preferably
washed with the solvent in question and dried.

15

The *cis* form of Compound I may also be removed by precipitation of a suitable salt of
Compound I, *e.g.* a hydrochloride salt or a salt of an organic acid, such as an organic diacid,
suitably a fumarate salt or a maleate salt of the compound of formula (I), optionally followed
by one or more re-crystallisations *e.g.* as described in PCT/DK2004/000546.

20

The *cis* form of Compound I may also be removed by isolating Compound I as the free base
from a suitable solvent.

The invention in further aspects also relates to the intermediates as described herein for the
25 synthesis of the Compound I, in particular the intermediates IVa and IVb. In this context is
understood when specifying the stereoisomeric form, that the stereoisomer is the main
constituent. In particular, when specifying the enantiomeric form, then the compound has an
enantiomeric excess of the enantiomer in question.

30 Accordingly, one embodiment of the invention relates to the compound of formula (IVa),
preferably having an enantiomeric excess of at least 60% (60% enantiomeric excess means
that the ratio of Compound IVa to its enantiomer is 80:20 in the mixture in question), at

least 70%, at least 80%, at least 85%, at least 90%, at least 96%, preferably at least 98%.
One embodiment relates to substantially pure Compound IVa.

A further embodiment of the invention relates to the compound of formula (IVb), preferably
5 having an enantiomeric excess of at least 60%.

The invention in a further aspect relates to Compound I or a salt thereof (e.g. a HCl, a fumarate or a maleate salt thereof) obtained by a method of the invention, and the medical use thereof, in particular for the medical indication as disclosed herein, e.g. as an
10 antipsychotic, such as for schizophrenia. Also within the invention are a pharmaceutical composition of Compound I or salt thereof obtained by a method of the invention.

In the present context, in particular for the pharmaceutical uses of Compound I, it is understood that when specifying the enantiomer form as done in formula (I), then the
15 compound is preferably relatively stereochemically pure, preferably the enantiomeric excess is at least 60%, at least 70%, and more preferably at least 80% (80% enantiomeric excess means that the ratio of I to its enantiomer is 90:10 in the mixture in question) at least 90%, at least 96%, or preferably at least 98%. In a preferred embodiment, the diastereomeric excess of Compound I is at least 90% (90% diastereomeric purity means the ratio of
20 Compound I to *cis*-1-((1*S*,3*S*)-6-chloro-3-phenylindan-1-yl)-3,3-dimethylpiperazine is 95:5), at least 95%, at least 97%, or at least 98%.

Accordingly, the process of the invention may comprise a step whereby Compound I or a salt thereof is formulated into a pharmaceutical composition. The compound, salt or
25 composition of Compound I may be administered in any suitable way *e.g.* orally, buccal, sublingual or parenterally, and the compound or salt may be presented in any suitable form for such administration, *e.g.* in the form of tablets, capsules, powders, syrups or solutions or dispersions for injection. In one embodiment, the compound or salt of the invention are administered in the form of a solid pharmaceutical entity, suitably as a tablet or a capsule.

30

Methods for the preparation of solid pharmaceutical preparations are well known in the art. Tablets may thus be prepared by mixing the active ingredient with ordinary adjuvants, fillers

and diluents and subsequently compressing the mixture in a convenient tableting machine. Examples of adjuvants, fillers and diluents comprise corn starch, lactose, talcum, magnesium stearate, gelatine, lactose, gums, and the like. Any other adjuvant or additive such as colourings, aroma, preservatives, etc. may also be used provided that they are
5 compatible with the active ingredients.

Solutions for injections may be prepared by dissolving a salt of the invention and possible additives in a part of the solvent for injection, preferably sterile water, adjusting the solution to desired volume, sterilisation of the solution and filling in suitable ampules or vials. Any
10 suitable additive conventionally used in the art may be added, such as tonicity agents, preservatives, antioxidants, solubilising agents etc.

The daily dose of the compound of formula (I) above, calculated as the free base, is suitably between 1.0 and 160 mg/day, more suitable between 1 and 100 mg, e.g. preferably between
15 2 and 55 mg.

The term "treatment" as used herein in connection with a disease or disorders includes also prevention as the case may be.

20 The invention will be illustrated in the following non-limiting examples.

EXAMPLES

ANALYTICAL METHODS

25 The enantiomeric excess of compounds (IV), (IVa), and (IVb) is determined by supercritical fluid chromatography using a Gilson SF3 Supercritical Fluid Chromatography System, detection is performed using a Gilson UV/VIS-831 detector at 254nm. Either a CHIRALPAK® AD-H column, 0.46cm ID X 25cm L, at room temperature is used under the following conditions: Eluent: Ethanol with 0.1% diethylamine is used at modifier (30%),
30 the flow is 3 ml/min, and the pressure is 200 bar. The retention time of the two enantiomers are 2.36 min. (IVa) and 2.99 min. (IVb). Or a CHIRALCEL® OD-H column, 0.46 cm ID X

25 cm L, at room temperature is used under the following conditions: Eluent: Ethanol (30%) is used as modifier, the flow is 4 ml/min, and the pressure is 200 bar.

The enantiomeric excess of compound (Va) in Example 8 is determined by supercritical fluid chromatography using a Gilson SF3 Supercritical Fluid Chromatography System with a CHIRALPAK® AD-H column, 0.46cm ID X 25cm L, at room temperature. Eluent: Ethanol with 0.1% diethylamine is used at modifier (30%), the flow is 3 ml/min, and the pressure is 200 bar. Detection is performed using a Gilson UV/VIS-831 detector at 254nm. The retention time of the two enantiomers are 2.41 min. (Va) and 3.06 min. (Vb). The enantiomeric excess of compound (Va) in Example 1a is determined by chiral HPLC using a CHIRALCEL® OD column, 0.46cm ID X 25 cm L, 10µm at 40 °C. n-Hexan/ethanol 95:5 (vol/vol) is used as mobile phase at a flow rate of 1.0 ml/min, detection is performed using a UV detector at 220nm.

The enantiomeric excess of compound (I) is determined by fused silica capillary electrophoresis (CE) using the following conditions: Capillar: 50µm ID X 48.5 cm L, run buffer: 1.25mM β cyclo dextrin in 25mM sodium dihydrogen phosphate, pH 1.5, voltage: 16kV, temperature: 22°C, injection: 40mbar for 4 seconds, detection: column diode array detection at 195nm, sample concentration: 500µg/ml. In this system, Compound I has a retention time of approximately 10 min, and the other enantiomer has a retention time of approximately 11 min.

The enantiomeric excess of compound (IX) is determined by fused silica capillary electrophoresis (CE) using the following conditions: Capillar: 50µm ID X 64.5 cm L, run buffer: 3.0 mM β cyclo dextrin and 10 mM hydroxypropyl β cyclo dextrin in 50 mM sodium dihydrogen phosphate, pH 1.5, voltage: 15kV, temperature: 22°C, injection: 40mbar for 4 seconds, detection: column diode array detection at 192nm, sample concentration: 100µg/ml. In this system, Compound IX has a retention time of approximately 47 min, and the enantiomer has a retention time of approximately 46 min. The other two diastereoisomers 4-((1*R*,3*R*)-6-Chloro-3-phenyl-indan-1-yl)-1,2,2-trimethyl-piperazine and 4-((1*S*,3*S*)-6-Chloro-3-phenyl-indan-1-yl)-1,2,2-trimethyl-piperazine have retention times of approximately 49 min. and 52 min. respectively.

¹H NMR spectra are recorded at 500.13 MHz on a Bruker Avance AV-500 instrument or a Bruker Avance DRX500 instrument, or at 250.13 MHz on a Bruker Avance DPX-250 instrument or a Bruker AC 250 instrument. Chloroform (99.8%D) or dimethyl sulfoxide
5 (99.8%D) is used as solvents, and tetramethylsilane (TMS) is used as internal reference standard.

The *cis/trans* ratio of Compound I and IX is determined using ¹H NMR as described in Bøgesø *et al.*, *J. Med. Chem.* **1995**, 38, 4380-4392 (page 4388, right column). The *cis/trans*
10 ratio of compound VIa is determined by ¹H NMR in DMSO-d₆, using the integrals of the signal at 5.6 ppm for the *cis* isomer and the signal at 5.75 ppm for the *trans* isomer, or by ¹H NMR in chloroform, using the integrals of the signal at 5.3 ppm for the *cis* isomer and the signal at 5.5 ppm for the *trans* isomer. Generally, a content of approximately 1% of the undesired isomer can be detected by NMR.

15 The Melting points are measured using Differential Scanning Calorimetry (DSC). The equipment is a TA-Instruments DSC-Q1000 or a TA-instruments DSC-2920 calibrated at 5°/min to give the melting point as onset value. About 2 mg of sample is heated 5°/min in a loosely closed pan under nitrogen flow.

20 The elemental analysis is performed using a Vario El analyser from Elementar build to measure C, H, and N content. The value given is the mean of two determinations using approximately 4 mg each.

25 The optical rotation is measured using a Perkin Elmer model 241 polarimeter, the concentration is 1% in methanol unless otherwise stated.

LC-MS is performed using a Waters Symmetry C-18 column, 0.46cm ID X 3cm L, 3.5 µm, at 60°C. The eluent is a gradient of (A) water with 0.05% trifluoroacetic acid and (B) acetonitril with 5% water and 0.035% trifluoroacetic acid, going from 90% A and 10% B to
30 100% B in 2 minutes; flow 3 ml/min. Detection is performed using a Shimadzu detector at 254nm. The mass spectrum is recorded by a Sciex API300 mass spectrometer.

SYNTHESIS

Synthesis of key starting materials

5 Compound V is synthesised from IV by reduction with sodium borohydride (NaBH_4) adapting a method described in Bøgesø *J. Med. Chem.* **1983**, 26, 935, using ethanol as solvent, and performing the reaction at approximately 0 °C. Both compounds are described in Bøgesø *et al. J. Med. Chem.* **1995**, 38, 4380-4392. Compound IV is synthesised from II using the general procedures described in Sommer *et al., J. Org. Chem.* **1990**, 55, 4822,
10 which also describes II and the synthesis thereof.

Example 0a Synthesis of (S)-6-chloro-3-phenylindan-1-one (IVa) and (R)-6-chloro-3-phenylindan-1-one (IVb) by use of chiral chromatography

Racemic 6-chloro-3-phenylindan-1-one (IV) is resolved by preparative chromatography,
15 using a CHIRALPAK® AS-V column. A mixture of n-heptane, ethanol and *N,N*-diethylamine is used as mobile phase, detection is performed using a UV detector at 220nm. The racemic ketone (IV) is injected as a solution in the eluent; suitable volumes of the solution is injected with suitable intervals. All the fractions, which contain compound (IVa) with more than 98% enantiomeric excess, are combined and evaporated to dryness using a
20 rotary evaporator. All fractions, which contain compound (IVb) or mixtures of compounds (IVa) and (IVb) are combined and evaporated to dryness using a rotary evaporator.

Example 0b Synthesis of enantiomeric pure (R)-6-chloro-3-phenylindan-1-one (IVb) by oxidation of (1R,3R)-6-chloro-3-phenylindan-1-ol (Vb)

25 (1R,3R)-6-chloro-3-phenylindan-1-ol (Vb) isolated as in example 1a (20g) is dissolved in dichloromethane (400 ml) and pyridinium chlorochromate (PCC) (26.5 g) is added. The mixture is stirred for 1½ hour at room temperature. The mixture is filtered, and the oily residue in the reaction vessel is washed with dichloromethane. The combined organic fractions are evaporated to dryness on a rotary evaporator, giving a black oil (25 g). Ethyl
30 acetate (200 ml) and sodium hydroxide (2M in water, 200 ml) are added. The phases are separated, and the water phase is extracted twice with ethyl acetate (200 ml). The combined organic phases are washed three times with sodium hydroxide (2M in water, 100 ml), twice

with water (100 ml), and once with brine (100 ml), and finally dried with sodium sulphate. Evaporation to dryness followed by drying in a vacuum oven at 40 °C gives 15 grams of crystals. $[\alpha]_D^{20}$ -61° (c=1.0, methanol). 90% ee according to the chiral analysis.

5 **Example 0c Racemisation of (R)-6-chloro-3-phenylindan-1-one (IVb)**

Diisopropyl amine (5.1 ml) is dissolved in dry tetrahydrofuran (THF) (50 ml) and the solution is stirred under nitrogen with cooling in an acetone/dry ice bath. Butyl lithium (1.6 M in hexane, 22.6 ml) is added slowly, where after the cooling bath is replaced with an ice/water bath. After stirring for 1½ hour, (R)-6-chloro-3-phenylindan-1-one (IVb) synthesised in example 0b (7.05 g, 90% ee) dissolved in dry THF (60 ml) is added over 30 minutes, and stirring on the cooling bath is continued for 17 minutes. Then potassium *tert*-butoxide (1.0 M in THF, 28.8 ml) is added over 17 minutes, and then stirring is continued for another two hours on the ice/water bath. The reaction mixture is quenched with hydrochloric acid (4 M, 50 ml), and then THF is removed from the mixture on the rotary evaporator. Water (200 ml) and diethyl ether (350 ml) are added, and the phases are separated. The water phase is extracted twice with diethyl ether (200 ml, then 100 ml). The combined organic phases are washed twice with water (100 ml), once with brine (100 ml), and dried with sodium sulphate. Evaporation to dryness on a rotary evaporator, followed by drying in a vacuum oven at 40°C, gives 6.70g of a red solid. $[\alpha]_D^{20}$ -2.34° (c=1.0, methanol). The product has an enantiomeric excess of 2% according to the chiral analysis, and contains 6% of the by product (see body text) according to HPLC. The raw product (4.99 g) is recrystallised from absolute ethanol (40 ml), giving 3.71 g of a red solid. $[\alpha]_D^{20}$ -0.84° (c=1.0, methanol). Contains 2.6% of the by product (see body text) according to HPLC.

25 **Example 1a Synthesis of (1S,3S)-6-chloro-3-phenylindan-1-ol (Va) and (1R,3R)-6-chloro-3-phenyl-indan-1-ol (Vb) by use of chiral chromatography**

Racemic *cis*-6-chloro-3-phenylindan-1-ol (V) (492 grams) is resolved by preparative chromatography, using a CHIRALPAK® AD column, 10cm ID X 50cm L, 10µm at 40 °C. Methanol is used as mobile phase at a flow rate of 190 ml/min, detection is performed using a UV detector at 287nm. The racemic alcohol (V) is injected as a 50,000 ppm solution in methanol; 90 ml is injected with intervals of 28 min. All the fractions, which contain

compound (Va) with more than 98% enantiomeric excess, are combined and evaporated to dryness using a rotary evaporator, followed by drying "in vacuo" at 40°C. Yield 220 grams as a solid. Elemental analysis and NMR conform to the structure, the enantiomeric excess is higher than 98% according to chiral HPLC, $[\alpha]_D^{20} +44.5^\circ$ (c=1.0, methanol). Likewise, the fractions, which contain compound (Vb) are combined and evaporated to dryness, giving 214g of (Vb).

Example 1b Synthesis of (1S,3S)-6-chloro-3-phenylindan-1-ol (Va) by reduction of enantiomeric pure (IVa)

(S)-6-chloro-3-phenylindan-1-one (IVa) can be reduced with sodium borohydride adapting a method described in Bøgesø *J. Med. Chem.* **1983**, *26*, 935, using ethanol as solvent and performing the reaction at approximately 0 °C, giving compound (Va).

Example 2 Synthesis of (1S,3S)-3,5-dichloro-1-phenylindan (VI, LG=Cl)

Cis-(1S,3S)-6-chloro-3-phenylindan-1-ol (Va) (204 grams) obtained as described in Example 1a is dissolved in THF (1500ml) and cooled to -5°C. Thionyl chloride (119 grams) is added drop wise as a solution in THF (500 ml) over a period of 1 h. The mixture is stirred at room temperature over night. Ice (100 g) is added to the reaction mixture. When the ice has melted the water phase (A) and the organic phase (B) are separated, and the organic phase B is washed twice with saturated sodium bicarbonate (200 ml). The sodium bicarbonate phases are combined with water phase A, adjusted to pH 9 with sodium hydroxide (28%), and used to wash the organic phase B once again. The resulting water phase (C) and the organic phase B are separated, and the water phase C is extracted with ethyl acetate. The ethyl acetate phase is combined with the organic phase B, dried with magnesium sulphate, and evaporated to dryness using a rotary evaporator, giving the title compound as an oil. Yield 240 grams, which is used directly in the example 5. *Cis/trans* ratio 77:23 according to NMR.

Example 3 Synthesis of 3,3-dimethylpiperazin-2-one

Potassium carbonate (390 grams) and ethylene diamine (1001 grams) are stirred with toluene (1.50 l). A solution of ethyl 2-bromoisobutyrate (500 grams) in toluene (750 ml) is

added. The suspension is heated to reflux over night, and filtered. The filter cake is washed with toluene (500 ml). The combined filtrates (volume 4.0 l) are heated on a water bath and distilled at 0.3 atm. using a Claisen apparatus; first 1200 ml distillate is collected at 35 °C (the temperature in the mixture is 75 °C). More toluene is added (600 ml), and another 1200 ml distillate is collected at 76 °C (the temperature in the mixture is 80 °C). Toluene (750 ml) is added again, and 1100 ml of distillate is collected at 66 °C (temperature in the mixture 71 °C). The mixture is stirred on an ice bath and seeded, whereby the product precipitates. The product is isolated by filtration, washed with toluene, and dried over night in a vacuum oven at 50 °C. Yield 171 g (52%) of 3,3-dimethylpiperazin-2-one. NMR consistent with structure.

Example 4 Synthesis of 2,2-dimethylpiperazine

A mixture of 3,3-dimethylpiperazin-2-one (8.28 kg, 64.6 mol) and tetrahydrofuran (THF) (60 kg) is heated to 50-60 °C, giving a slightly unclear solution. THF (50 kg) is stirred under nitrogen, and LiAlH₄ (250 g, in a soluble plastic bag) is added, which gives a slow evolution of gas. After gas evolution has ceased, more LiAlH₄ is added (a total of 3.0 kg, 79.1 mol, is used), and the temperature rises from 22 °C to 50 °C because of an exotherm. The solution of 3,3-dimethylpiperazin-2-one is added slowly over 2 hours at 41-59 °C. The suspension is stirred for another hour at 59 °C (jacket temperature 60 °C). The mixture is cooled, and water (3 l) is added over two hours, keeping the temperature below 25 °C (it is necessary to cool with a jacket temperature of 0 °C). Then sodium hydroxide (15%, 3.50 kg) is added over 20 minutes at 23 °C, cooling necessary. More water (9 l) is added over half an hour (cooling necessary), and the mixture is stirred over night under nitrogen. Filter agent Celit (4 kg) is added, and the mixture is filtered. The filter cake is washed with THF (40 kg). The combined filtrates are concentrated in the reactor until the temperature in the reactor is 70 °C (distillation temperature 66 °C) at 800 mbar. The remanence (12.8 kg) is further concentrated on a rotavapor to approximately 10 l. Finally, the mixture is fractionally distilled at atmospheric pressure, and the product is collected at 163-4 °C. Yield 5.3 kg (72%). NMR complies with the structure.

Example 5 Synthesis of *trans*-1-((1*R*,3*S*)-6-chloro-3-phenylindan-1-yl)-3,3-dimethylpiperazinium (Compound I) hydrogen maleate salt

Cis-(1*S*,3*S*)-3,5-dichloro-1-phenylindan (VI, LG=Cl) (240 g) is dissolved in butan-2-one (1800 ml). Potassium carbonate (272 g) and 2,2-dimethyl piperazine (prepared in Example 4) (113 g) are added and the mixture is heated at reflux temperature for 40 h. To the reaction mixture is added diethyl ether (2 l) and hydrochloric acid (1M, 6 l). The phases are
5 separated, and pH in the water phase is lowered from 8 to 1 with concentrated hydrochloric acid. The water phase is used to wash the organic phase once again in order to ensure, that all product is in the water phase. Sodium hydroxide (28%) is added to the water phase until pH is 10, and the water phase is extracted twice with diethyl ether (2 l). The diethyl ether extracts are combined, dried with sodium sulphate, and evaporated to dryness using a rotary
10 evaporator. Yield 251 grams of the title compound as an oil. *Cis/trans* ratio, 18:82 according to NMR. The crude oil (ca. 20 grams) is further purified by flash chromatography on silicagel (eluent: ethyl acetate/ethanol/triethylamine 90:5:5) followed by evaporation to dryness on a rotary evaporator. Yield 12 grams of the title compound as an oil (*cis/trans* ratio, 10:90 according to NMR). The oil is dissolved in ethanol (100 ml), and to this solution
15 is added a solution of maleic acid in ethanol to pH 3. The resulting mixture is stirred at room temperature for 16 hours, and the formed precipitate is collected by filtration. The volume of ethanol is reduced and another batch of precipitate is collected. Yield 3.5 gram solid (no *cis* isomer is detected according to NMR) of the title compound. Enantiomeric excess according to CE is >99%. Melting point 175-178 °C. NMR complies with the structure.

20

Example 6 Screening conditions for the resolution of 6-chloro-3-phenylindan-1-one (IV) by Super Critical Fluid chromatography

A series of columns is screened for the ability of resolving (IV) using a Gilson SF3 Supercritical Fluid Chromatography System. Eluent: Different solvents containing 0.1%
25 diethylamine are used as modifier (30%), the flow is 4 ml/min, the pressure is 200 bar, and the column is kept at room temperature. Detection is performed using a Gilson UV/VIS-831 detector at 254nm. The retention time of the two enantiomers (RT_1 and RT_2) and the width in half height of the two peaks (ω_1 and ω_2) are calculated using Gilson Unipoint, version 3.2, software. The table below gives the resolution (R_s) calculated for the individual columns
30 with a series of modifiers; R_s is calculated from the formula

$$R_s = 2(RT_2 - RT_1)/(\omega_1 + \omega_2)$$

Column		R _s			
Name	Dimensions ^a	Methanol	Ethanol	Isopropanol	Acetonitril
Chiralpak [®] AD-H	4.6, 250, 5	17.1	10.0	2.0	19.1
Chiralpak [®] AS-H	4.6, 250, 5	3.5	4.0	4.9	3.6
Chiralcel [®] OD-H	4.6, 250, 5	4.0	3.2	2.8	-
Chiralcel [®] OJ-H	4.6, 250, 5	0.7	0.0	0.0	-
Chiralpak [®] IA	4.6, 250, 5	5.4	2.8	0.6	2.6
(R,R)-Whelk-O 1 [®]	4.6, 250, 5	1.0	1.1	1.7	-

^aInternal Diameter (mm), Column length (mm), particle size (μm)

Example 7 Resolution of 6-chloro-3-phenylindan-1-one (IV) by Super Critical Fluid chromatography

The resolution is performed using the Berger Multigram II Prep-SFC system with a CHIRALPAK[®] AD-H column, 20 mm ID x 250 mm L, 5 μm. Eluent: Ethanol is used as modifier (20%), the flow is 50 ml/min, the pressure is 100 bar, and the column is kept at 35°C. Detection is performed using a UV detector at 230 nm. A Berger separator is used for fraction collection and decompression. The equipment is controlled by SFC Pronto software. The two enantiomers have the retention time 3.9 min. (IVa) and 4.8 min. (IVb). The racemic ketone (IV) is injected as a solution in acetonitril (55g of (IV) in 800 ml acetonitril); 500 μl of this solution is injected with intervals of 132 seconds. All the fractions containing compound (IVa) are combined and decompressed giving a solution of (IVa) in ethanol, and all the fractions containing compound (IVb) are combined and decompressed as well.

Compound (IVa) is isolated by evaporating the solution on a rotary evaporator, and drying the residue in a vacuum oven at 40°C. Yield 25.6 g (47%) of solid. Melting point 110.8°C, NMR conforms to structure, $[\alpha]_D^{20} +72.65^\circ$ (c=1.0, methanol). CHN calculated for C₁₅H₁₁OCl: C 74.23, H 4.57; found: C 74.09, H 4.70. >99% ee according to the chiral analysis.

Compound (IVb) is isolated in the same way, giving 23.9 g (43%) of solid. Melting point 110.6°C, NMR conforms to structure, $[\alpha]_D^{20} -70.33$ (c=1.0, methanol). CHN calculated for

$C_{15}H_{11}OCl$: C 74.23, H 4.57; found: C 73.79, H 4.70. >99% ee according to the chiral analysis.

5 **Example 8 Synthesis of (1*S*,3*S*)-6-chloro-3-phenylindan-1-ol (Va) by reduction of enantiomeric pure (IVa)**

(*S*)-6-chloro-3-phenylindan-1-one (IVa) (isolated as in example 7) (23 g) is added in small portions to a suspension of sodium borohydride (1.6 g) in ethanol (160 ml) at 3-5°C. After the addition has been finalised, the mixture is allowed to reach room temperature. The
10 reaction mixture is stirred for 2.75 hours, where after it is evaporated to dryness. The residue is dissolved in a mixture of water (150 ml) and ethyl acetate (200 ml), the phases are separated, and the water phase is extracted with ethyl acetate (100 ml). The organic phases are combined, washed with water (100 ml), dried with magnesium sulphate, filtered and evaporated to dryness. The residue is recrystallised from heptanes (250 ml), giving 20.9 g
15 (90 %) of the title product as a solid. Melting point 108.9°C, NMR conforms to structure, $[\alpha]_D^{20} +48.30^\circ$ (c=1.0, methanol). CHN calculated for $C_{15}H_{13}OCl$: C 73.62, H 5.35; found: C 73.55, H 5.29. >99% ee according to the chiral analysis.

20 **Example 9 Synthesis of (1*S*,3*S*)-3,5-dichloro-1-phenylindan (VI, LG=Cl)**

A solution of (1*S*,3*S*)-6-chloro-3-phenylindan-1-ol (Va) (17 g) (synthesized as in example 8) in tetrahydrofuran (130 ml) is cooled with an ice bath. Thionyl chloride (9.9 g) in tetrahydrofuran (50 ml) is added drop wise at 4-5°C, and then the mixture is stirred over night at ambient temperature. A mixture of water and ice (approximately 25 ml) is added,
25 and stirring is continued until all the ice has melted. The phases are separated, and the organic phase is washed twice with sodium bicarbonate (5% in water, 25 ml). The water phases are then combined, extracted with the organic phase, and then extracted with ethyl acetate (50 ml). The organic phases are then combined, dried with magnesium sulfate, filtered, and evaporated to dryness using a rotary evaporator. Yield 18.7 g (102%) of the title
30 compound as an oil, which partly solidifies. The content of (1*S*,3*R*)-3,5-dichloro-1-phenylindan is 18% according to NMR.

Example 10 Synthesis of *trans*-1-((1*R*,3*S*)-6-chloro-3-phenylindan-1-yl)-3,3-dimethylpiperazine (Compound I)

A mixture of (1*S*,3*S*)-3,5-dichloro-1-phenylindan (VI, LG=Cl) (18 g) (synthesised as in example 9), potassium carbonate (20.8 g), 2,2-dimethylpiperazine, and methyl ethyl ketone (135 ml) is heated to reflux over night. After cooling to room temperature, diethyl ether (150 ml) and hydrochloric acid (1 M, 450 ml) are added, and the mixture is stirred for a few minutes. The phases are separated, and the pH in the water phase is adjusted from 1 to 12 using sodium hydroxide (28%). The water phase is extracted with diethyl ether (two times 170 ml). All the organic phases are combined, dried with magnesium sulphate, filtered, and evaporated using a rotary evaporator. Yield 20.7 g (89 %) of the title compound as an oil. The content of the *cis* isomer is 19% according to NMR.

Example 11 Synthesis of *trans*-4-((1*R*,3*S*)-6-chloro-3-phenylindan-1-yl)-1,2,2-trimethylpiperazinium (IX) hydrogen fumarate

Trans-1-((1*R*,3*S*)-6-chloro-3-phenylindan-1-yl)-3,3-dimethylpiperazine (I, synthesised as in example 10) is stirred with formic acid (15.2 ml) and formaldehyde (37% in water, 12.5 ml), and heated on an oil bath (temperature 110°C) for 1½ hour. Water is added to the reaction mixture after cooling to room temperature, and pH is adjusted to approximately 14 with sodium hydroxide (28%). The product is extracted with diethyl ether and then ethyl acetate, adding sodium hydroxide (28%) in between the extractions, if the pH becomes lower than 12. The organic phases are combined, dried with sodium sulphate, filtered, and evaporated to dryness, using a rotary evaporator. Yield 10.9 g (100%) of (IX) as an oil, containing 20% of the *cis* form according to NMR.

The oil (10 g) is heated with 1-propanol (150 ml), giving a solution. Fumaric acid (3.3 g) is added, and heating is continued until all is dissolved. The mixture is cooled to room temperature and seeded, whereby the product precipitates. The solid is isolated by filtration, washed with a small amount of 1-propanol, and dried in a vacuum oven at 40°C. Yield 6.85 g (52%). Melting point 193.3°C, NMR conforms to structure, $[\alpha]_D^{20} -15.2^\circ$ (c=1.0, methanol). Contains 4% of the *cis* form according to CE, the other two diastereoisomers are not detected (*i.e.* the content is below 1%). CHN calculated for C₂₆H₃₁N₂O₄Cl: C 66.30, H 6.63, N 5.95; found: C 65.96, H 6.61, N 5.57. >98% ee according to CE.

**Example 12 Synthesis of enantiomeric pure (*R*)-6-chloro-3-phenylindan-1-one (IVb)
by oxidation of (1*R*,3*R*)-6-chloro-3-phenylindan-1-ol (Vb)**

Pyridinium chlorochromat (66.1 g) is added to a solution of (1*R*,3*R*)-6-chloro-3-phenyl-
indan-1-ol (Vb) (isolated as in example 1a) (50.0 g) in dichloromethane (840 ml), and the
mixture is stirred at ambient temperature for two hours. The mixture is filtered, and the
residue in the vessel is washed twice with dichloromethane (200 ml), which is used to
wash the filter cake as well. The combined filtrates are evaporated to dryness, using a rotary
evaporator. The residue is stirred with sodium hydroxide (2 M, 1 l) and ethyl acetate
(750 ml) for ½ an hour. The phases are separated, and the water phase is extracted with ethyl
acetate (500 ml). The combined organic phases are washed twice with sodium hydroxide
(2 M, 250 ml), and 25 % sodium chloride (250 ml). Then the organic phase is stirred with
magnesium sulphate (60 g), charcoal (1.4 g), and silica gel 60 (0.06-0.2 mm, 5 g), filtered,
and evaporated to dryness using a rotary evaporator. The residue (31.5 g) is recrystallised
from 2-propanol (125 ml); the product is isolated by filtration and washed with 2-propanol
(40 ml). Drying in a vacuum oven at 50°C gives 26.0 g (53 %) of the product as a solid.
Melting point 110.8°C, NMR conforms to structure, $[\alpha]_D^{20} -75.6^\circ$ (c=1.0, methanol). CHN
calculated for C₁₅H₁₁OCl: C 74.23, H 4.57, N 0.00; found: C 73.89, H 4.71, N 0.05. 99.2%
ee according to the chiral analysis.

20

The reaction was repeated twice giving 48 g of the product with 99.6 % ee, and 48 g of the
product with 98.9 % ee, respectively.

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**Example 13 Screening of bases for the racemisation of (*R*)-6-chloro-3-phenyl-indan-
1-one (IVb)**

The bases used are from Aldrich: Butyl lithium (BuLi) catalogue no. 18,617-1, *tert*-butyl
lithium (tBuLi) catalogue no. 18,619-8, potassium *tert*-butoxide (KOtBu) catalogue no.
32,865-0, Lithium *tert*-butoxide (LiOtBu) catalogue no. 398195, sodium *tert*-butoxide
(NaOtBu) catalogue no. 35,927-0, lithium bis(trimethylsilyl)amide (LiHMDS) catalogue no.
225770, sodium bis(trimethylsilyl)amide (NaHMDS) catalogue no. 24,558-5, and potassium
bis(trimethylsilyl)amide (KHMDS) catalogue no. 324671. Lithium diisopropylamide is

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made from diisopropylamine (Sigma-Aldrich catalogue no. 386464) and BuLi just before use in every experiment.

The following procedure is typical for the experiments and illustrates the use of LDA and the use of two different bases:

A mixture of diisopropylamine (437 μ l) and tetrahydrofuran (THF) (4 ml) is stirred under nitrogen and cooled with a batch of dry ice and acetone. Butyl lithium (BuLi) (1.6 M in hexanes, 1.60 ml) is added over 5 minutes. Stirring is continued for 10 minutes, and then the cooling batch is replaced with an ice-water batch. After stirring for another 10 minutes, a solution of (*R*)-6-chloro-3-phenylindan-1-one (IVb) (synthesised as in example 12) (0.50 g) in THF (4 ml) is added drop wise over 5 minutes to the solution of LDA ("the former base", base 1), and stirring at the water-ice batch is continued for ½ an hour. Then BuLi (1.6 M in hexanes) (1.61 ml) ("the latter base", base 2) is added drop wise over 5 minutes, where after stirring at the ice-water batch is continued for 2½ hours, and then hydrochloric acid (4 M, 4 ml) is added. After stirring for 10 minutes, the phases are separated, and the water phase is extracted with ethyl acetate (two times 10 ml). The combined organic phases are washed with sodium chloride (25 %, 10 ml), dried with magnesium sulphate, filtered, and evaporated to dryness using a rotary evaporator. Yield 0.47 g (94 %) of an oil, the chemical purity is 83 % according to LC-MS, and the enantiomeric excess is 1 % according to the chiral analysis.

The table below summarises the results obtained:

Entry	Equivalents of base 1	Base 1	Equivalents of base 2	Base 2	Time ¹⁾ hr	Purity of raw product %	ee ²⁾ %
1	2.25	LDA ³⁾	N/A	N/A	2.5	91	2
2	2.25	KOtBu	N/A	N/A	2.5	38	-10
3	2.25	BuLi	N/A	N/A	2.5	39	5
4	2.25	tBuLi	N/A	N/A	2.5	40	-13
5	1.25	LDA ⁴⁾	1.25	BuLi	2.5	83	1

6	1.25	LDA ⁴⁾	1	KOtBu	2.5	88	0
7	1.25	LDA ⁴⁾	1.25	tBuLi	2.5	88	-4
8	1.25	LiHMDS	1	KOtBu	2.5	86	1
9	1.25	LiOtBu	1	KOtBu	2.5	93	0
10	1.25	LDA ⁵⁾	1	BuLi	0.5	82	2
11	1.25	LDA ⁵⁾	1	BuLi	1	93	2
12	1.25	LDA ⁵⁾	1	BuLi	2.5	90	-3
13 ⁶⁾	1.25	LDA ⁵⁾	1	BuLi	0.5	85	2
14 ⁶⁾	1.25	LDA ⁵⁾	1	BuLi	1	85	2
15 ⁶⁾	1.25	LDA ⁵⁾	1	BuLi	2.5	86	-1

¹⁾ Indicating the time for stirring at 0°C after all has been mixed.

²⁾ Enantiomeric excess; a negative sign indicates, that IVa is in excess, impurities in the sample may interfere with the analysis.

³⁾ LDA is made using 2.50 equivalents of diisopropylamine and 2.25 equivalents of BuLi.

5 ⁴⁾ LDA is made using 1.50 equivalents of diisopropylamine and 1.25 equivalents of BuLi.

⁵⁾ LDA is made using 1.25 equivalents of diisopropylamine and 1.50 equivalents of BuLi.

⁶⁾ In these experiments, all BuLi - also the amount indicated as base 2 - is added from the beginning of the experiments, before the addition of compound IVb.

10 **Example 14 Scale up of racemisation of (*R*)-6-chloro-3-phenyl-indan-1-one (IVb)**

The bases used are the same as in example 13.

A representative procedure is as follows:

15 Diisopropylamine (6.25 g) is dissolved in tetrahydrofuran (THF) (160 ml), and the mixture is cooled with an dry ice/acetone batch while stirring under nitrogen. Butyl lithium (1.6 M in hexanes, 33 ml) is added slowly keeping the temperature below -60°C. Stirring is continued for 5 minutes at the dry ice/acetone batch, which is then replaced by an ice/water batch. The mixture is stirred for 10 minutes at -10 to 0°C, where after a solution of (*R*)-6-chloro-3-phenylindan-1-one (IVb) (synthesised as in example 12) (10.0 g) in THF (80 ml) is added
20 slowly keeping the temperature below 5°C. After stirring for approximately ½ an hour, butyl lithium (1.6 M in hexanes, 33 ml) is added slowly, keeping the temperature below 5°C. After stirring at 0-5°C for 2½ hours, hydrochloric acid (4 M, 100 ml) is added slowly. The

phases are separated, and the water phase is extracted two times with ethyl acetate (100 ml). The combined organic phases are washed with 25% sodium chloride (100 ml), and stirred for 10 minutes with magnesium sulphate (26 g), charcoal (1 g), and silica gel (2.6 g). After filtration, the organic phase is evaporated to dryness using a rotary evaporator. The residue is recrystallised from 2-propanol (40 ml). The product is isolated by filtration, washed with ice cold 2-propanol (20 ml), and dried in the vacuum oven at 50°C over night. Yield 5.85 g (60 %). Melting point 95.2°C, NMR conforms to structure, $[\alpha]_D^{20} -1.1^\circ$ (c=1.0, methanol). CHN calculated for $C_{15}H_{11}OCl$: C 74.23, H 4.57; found: C 74.29, H 4.62. -1.0 % ee according to the chiral analysis. Purity 97 % according to LC-MS.

The results are summarised in the table below:

Entry	Equivalents of base 1	Base 1	Equivalents of base 2	Base 2	Time ¹⁾ hr	Yield %	Purity %	ee ²⁾ %
1	2.25	LDA ³⁾	N/A	N/A	2.5	53	97	-3
2	1.25	LDA ⁴⁾	1.25	BuLi	2.5	60	97	-1
3	1.25	LDA ⁴⁾	1	KOtBu	2.5	76	87	0
4	1.25	LiOtBu	1	KOtBu	2.5	70	79	-2
5	1.25	LDA ⁵⁾	1	BuLi	2.5	70	97	0
6 ⁶⁾	1.25	LDA ⁶⁾	1.25	BuLi	½	59	96	0

¹⁾ Indicating the time for stirring at 0°C after all has been mixed.

²⁾ Enantiomeric excess; a negative sign indicates, that IVa is in excess.

³⁾ LDA is made using 2.50 equivalents of diisopropylamine and 2.25 equivalents of BuLi.

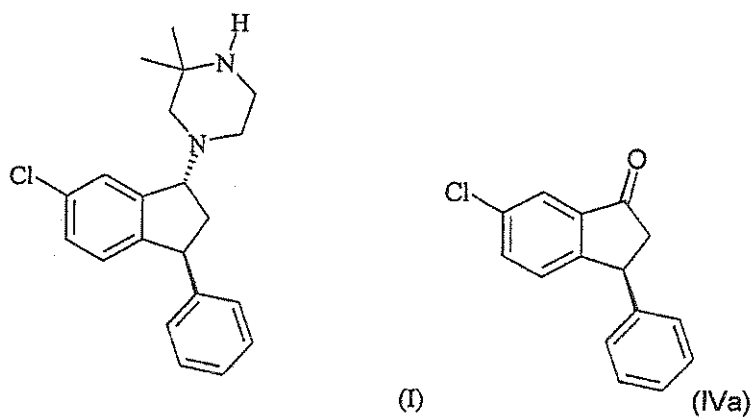
⁴⁾ LDA is made using 1.50 equivalents of diisopropylamine and 1.25 equivalents of BuLi.

⁵⁾ LDA is made using 1.25 equivalents of diisopropylamine and 1.50 equivalents of BuLi.

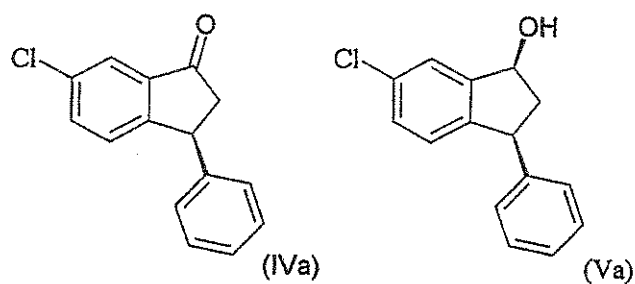
⁶⁾ In this experiment, all BuLi – also the amount indicated as base 2 – is added from the beginning of the experiment, before the addition of compound IVb; *i.e.* 1.25 equivalents of diisopropylamine and a total of 2.50 equivalents of BuLi is used.

5 CLAIMS

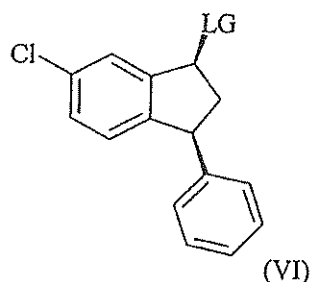
1. A method for manufacturing a compound of formula I (Compound I) or a salt thereof, which method comprises conversion of a compound of formula IVa (Compound IVa) to the compound of formula I, wherein formula I and IVa are as follows:



2. The method of claim 1 comprising converting the compound of formula IVa into the corresponding alcohol Va with cis configuration, wherein IVa and Va are as follows:

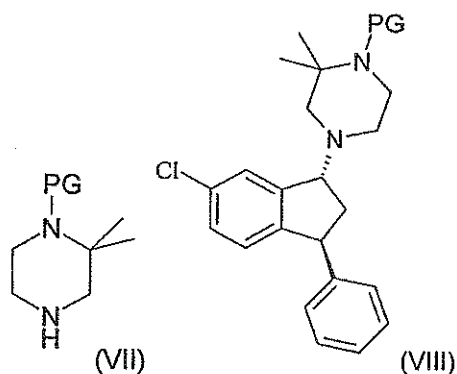


3. The method of claim 2 comprising converting the alcohol group of the cis-alcohol of formula Va to a leaving group LG, resulting in the compound of formula VI.



4. The method of claim 3, wherein LG is a halogen, *e.g.* Cl or Br, preferably Cl, or a sulphonate, *e.g.* a tosylate or a mesylate.
5. The method of claim 3 or 4, wherein Compound VI is precipitated from a suitable solvent.
6. The method of claim 5, wherein LG is a halogen, *e.g.* Cl, and the solvent is an alkane, *e.g.* heptane.
7. The method of any of claims 3-6, wherein Compound VI is reacted with 2,2-dimethylpiperazine to obtain Compound I.
8. The method of claim 7, wherein Compound I is precipitated as a salt.
9. The method of claim 8, wherein the formed salt is a fumarate salt, a maleate salt or a hydrochloride salt of Compound I.
10. The method of claim 7, wherein Compound 1 is isolated as the free base.
11. The method of any of claims 3-10, comprising
 - reacting Compound VI with 1-protected 2,2-dimethylpiperazine (VII), wherein PG is a protection group thereby obtaining a compound of formula VIII; and
 - deprotecting Compound VIII to obtain Compound I,wherein Compound VII and VIII are as follows:

31



12. The method of any of claims 1-11, wherein compound IVa is obtained by resolution of the racemic compound IV using chiral chromatography.

5

13. The method of claim 12, wherein said chiral chromatography is performed using chiral liquid chromatography.

14. The method of claim 12 or claim 13, wherein said chiral chromatography is performed on a chiral stationary phase.

10

15. The method of claim 14, wherein said chiral chromatography is performed on a column of silicagel coated with modified amylose.

15

16. The method of claim 15, wherein said chiral chromatography is performed on a column of silicagel coated with amylose tris-[(S)- α -methylbenzylcarbamate].

17. The method of claim 16 wherein for said chiral chromatography a solvent is used comprising a mixture of n-heptane and ethanol, and optionally *N,N*-diethylamine.

20

18. The method of claim 12, wherein said chiral chromatography is performed using sub- or supercritical fluid chromatography, preferably supercritical fluid chromatography.

19. The method of claim 18, wherein said chiral chromatography is performed on a chiral stationary phase.

25

20. The method of claim 19, wherein said chiral chromatography is performed on a column of silicagel coated with a chiral polymer, or on a column of silicagel with an immobilized chiral polymer, or on a column of silicagel with a covalently bound chiral monomer.

5

21. The method of claim 20, wherein said chiral chromatography is performed on a column of silicagel coated with amylose tris (3,5-dimethylphenylcarbamate) or amylose tris [(S)- α -methylbenzylcarbamate], or on a column of silicagel with immobilized amylose tris (3,5-dimethylphenylcarbamate), or on a column of silicagel coated with cellulose tris (3,5-dimethylphenylcarbamate) or cellulose tris (4-methylbenzoate) or on a column of silicagel with covalently bonded 3,5-dinitrobenzoyl tetrahydrophenanthrene amine.

10

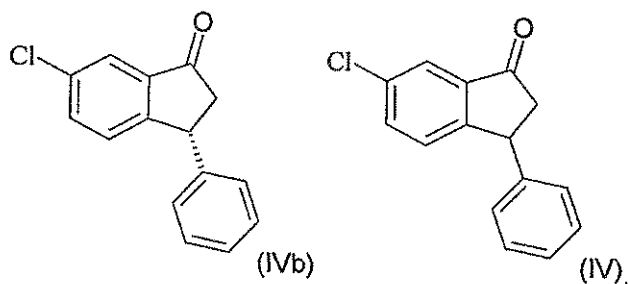
22. The method of any of the claims 20-21, wherein said chiral chromatography is performed on a column of silicagel coated with amylose tris (3,5-dimethylphenylcarbamate).

15

23. The method of any of the claims 20-22, wherein said chiral chromatography is performed with a modifier selected from the group of methanol, ethanol, isopropanol, or acetonitril, optionally containing diethylamine, optionally 0.1% diethylamine.

20

24. The method of any of claims 1-23 comprising recycling Compound IVb by converting enantiomerically enriched compound IVb into essentially racemic compound IV, where IVb and IV are:

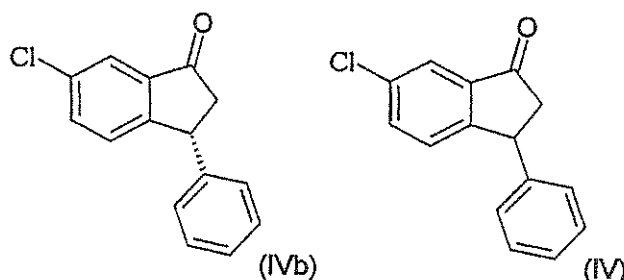


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25. The method of claim 24, wherein the racemisation is obtained by using a base or a mixture of two or more bases.

26. The method of claim 24 or 25, wherein the racemisation is obtained by using one equivalent or more of a non nucleophilic base ("the former base"), followed by addition of a catalytic amount, or one equivalent or more of the same or another base ("the latter base").

27. A method for the conversion of the enantiomerically enriched compound IVb into essentially racemic compound IV, where in IVb and IV are:



and wherein the racemisation is obtained by using one equivalent or more of a non nucleophilic base, followed by addition of a catalytic amount, or one equivalent or more of the same or another base.

28. The method of claim 26 or 27, wherein the racemisation is obtained by using one equivalent or more of a non nucleophilic base ("the former base") selected from the group consisting of an amide, preferably a dialkylamide, such as but not limited to lithium diethylamide, lithium diisopropylamide, lithium tetramethylpiperidide, suitable lithium diisopropylamide (LDA), or a metal bis-silylamide, such as lithium bis-silylamide, suitably lithium bis(trimethylsilyl)amide, or an metal alkoxide, such as but not limited to metal methoxide, metal ethoxide, metal *tert*-butoxide, suitably alkali alkoxide, preferably lithium alkoxide, must preferably lithium *tert*-butoxide followed by the addition of a catalytic amount, or one equivalent or more of the same or another base ("the latter base") selected from the group consisting of an amide, preferably a dialkylamide, such as but not limited to lithium diethylamide, lithium diisopropylamide,

lithium tetramethylpiperidide, suitable lithium diisopropylamide (LDA), or a metal bis-silylamide, such as alkali bis(trimethylsilyl)amide, or an metal alkoxide, such as but not limited to metal methoxide, metal ethoxide, metal *tert*-butoxide, suitably alkali alkoxide, preferably potassium alkoxide, must preferably potassium *tert*-butoxide, or an alkyl
5 metal, suitably an alkyl lithium, preferably butyl lithium or *tert*-butyl lithium, or a mixture thereof.

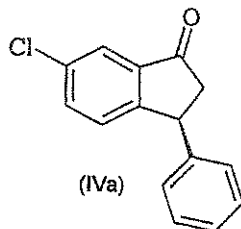
29. The method of claim 28, wherein the non nucleophilic base ("the former base") is selected from the group consisting of lithium diisopropylamide (LDA), lithium
10 bis(trimethylsilyl)amide (LiHMDS), or lithium *tert*-butoxide.

30. The method of claim 28 wherein the "latter base" is selected from the group consisting of lithium diisopropylamide (LDA), potassium *tert*-butoxide, butyl lithium, or *tert*-butyl lithium.
15

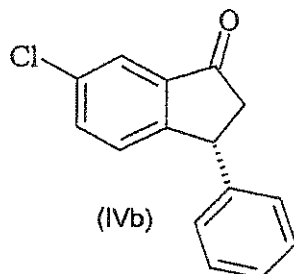
31. The method of any of the claims 24-26 and any of the claims 27-30 wherein "the former base" and "the latter base" are present from the start.

32. The method of any of claims 24-31, wherein the essentially racemic product (IV) is recrystallised from a suitably solvent, such as an alcohol (e.g. a C₁₋₆-alcohol), e.g. ethanol or 2-propanol or a mixture thereof.
20

33. A compound (IVa) having the structure as follow:

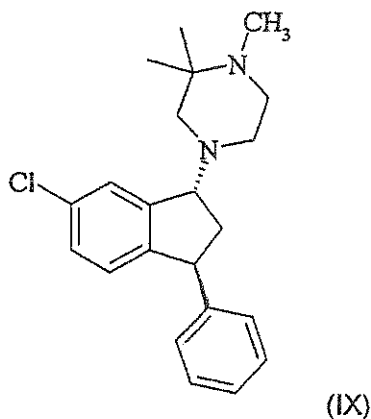


34. A compound (IVb) having the structure as follow:



35. A compound as defined in claim 33 or 34 which is substantially pure.

36. The method of any of the claims 1-8, or any of the claims 11-32, where Compound I is replaced by Compound IX, where Compound IX has the formula:



37. The method according to claim 36, wherein Compound IX is precipitated as a succinate salt or a malonate salt of Compound IX.

38. The method according to claim 37, wherein Compound IX is precipitated as a crystalline succinate salt or a crystalline malonate salt.

39. The method of claim 38, wherein said salt is formulated into a pharmaceutical composition.