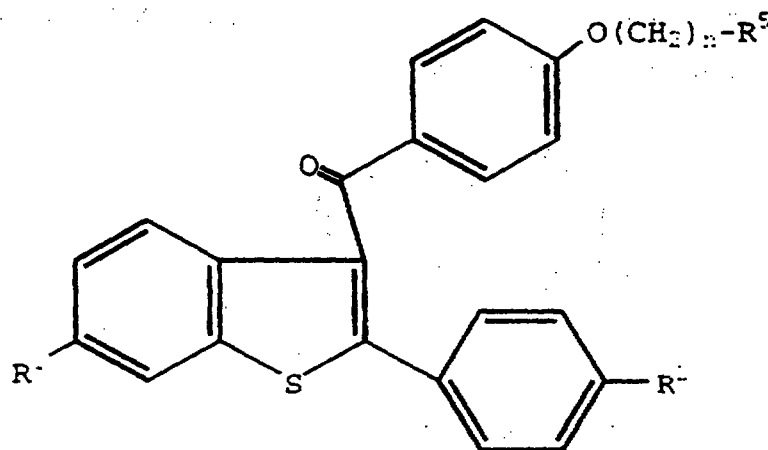


-1-

PROCESS FOR 2-SUBSTITUTED BENZO[b]THIOPHENE COMPOUNDS AND INTERMEDIATES THEREOF

This invention relates to the fields of pharmaceutical and organic chemistry and provides processes for preparing 2-substituted benzo[b]thiophene compounds, some of which are useful as intermediates for preparing pharmaceutically active compounds, and others are useful, *inter alia*, for the treatment of osteoporosis in postmenopausal women.

Compounds of formula VII



VII

wherein

R^1 is -H, -OH, or -OR², in which R² is a hydroxy protecting group;

R^2 is -H, -OH, or -OR⁴, in which R⁴ is a hydroxy protecting group;

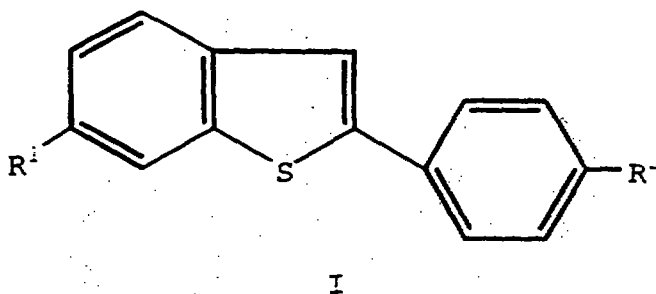
R^5 is 1-piperidinyl, 1-pyrrolidinyl, methyl-1-pyrrolidinyl, dimethyl-1-pyrrolidinyl, 4-morpholino, dimethylamino, diethylamino, diisopropylamino, or 1-hexamethyleneimino;

n is 2 or 3, or a pharmaceutically acceptable salt thereof, are known as antifertility agents (*see*, e.g., U.S. Pat. No. 4,133,814). Certain formula VII compounds,

-2-

particularly those in which R^1 , R^2 , and n are as defined above, and R^5 is 1-piperidinyl, 1-pyrrolidinyl, or 1-hexamethyleneimino, or a pharmaceutically acceptable salt thereof, are known to be useful for inhibiting bone loss in humans (see, e.g., U.S. Pat. No. 5,393,763). The compound known in the art as raloxifene, a formula VII compound in which R^1 and R^2 each are -OH, n is 2, and R^5 is 1-piperidinyl, or a pharmaceutically acceptable salt thereof, especially the hydrochloride salt, is a preferred product of the processes described herein.

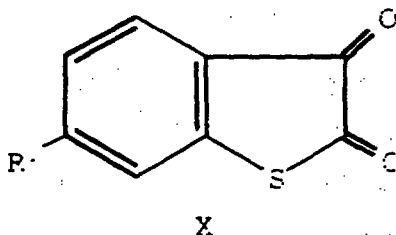
Jones and Suarez, in U.S. Pat. No. 4,133,814, *supra*, first taught processes for preparing compounds of formula VII. In general, Jones, et al., prepared benzothiophenes of formula I



wherein

R^1 is -H, -OH, or OR^3 , in which R^3 is a hydroxy protecting group; and

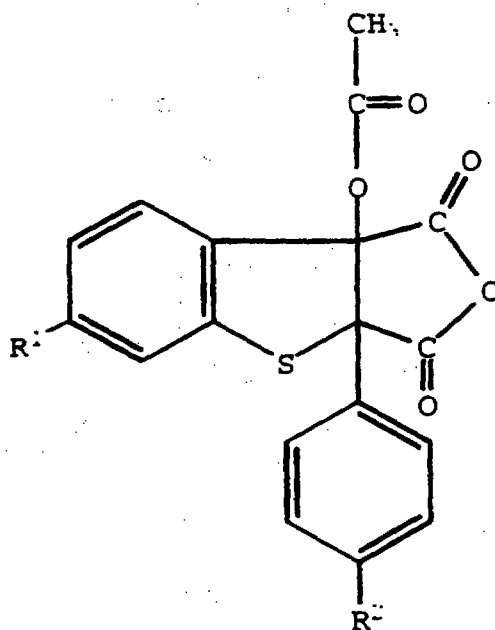
R^2 is -H, -OH, or OR^4 , in which R^4 is a hydroxy protecting group, by first preparing a 2,3-dioxo-2,3-dihydrobenzothiophene of formula X



wherein R^1 is as defined above, and reacting a formula X compound with α -chlorophenylacetic acid, or an appropriately

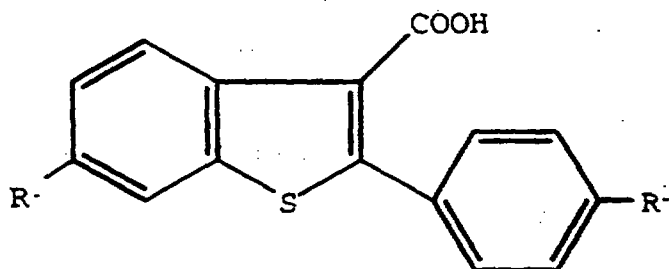
-3-

substituted derivative thereof, to form a diacid which is cyclized with a mixture of sodium acetate and acetic anhydride to give a compound of formula XI



XI

wherein R¹ and R² are as defined above. The formula XI compound is then hydrolyzed in the presence of sodium hydroxide to provide a compound of formula XII



XII

in which R¹ and R² are as defined above, which can finally be decarboxylated or used as such.

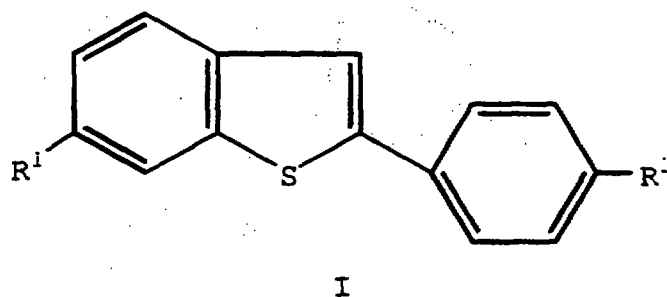
Because the Jones process for preparing formula I compounds of the present invention is costly and time consuming, a less expensive and more direct process for preparing compounds of formula I and, ultimately, compounds

-4-

of formula VII, would be highly desirable and represent a significant advancement in the art. Accordingly, the present invention provides novel processes for preparing compounds of formulae I and VII, as well as novel intermediates therefore.

5

The present invention provides a process for preparing a compound of formula I

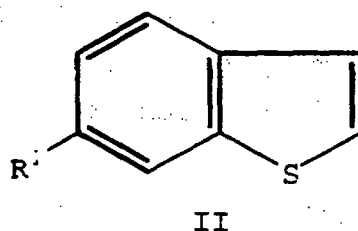


10

comprising

a) forming a 2-position boronic acid derivative of a compound of formula II

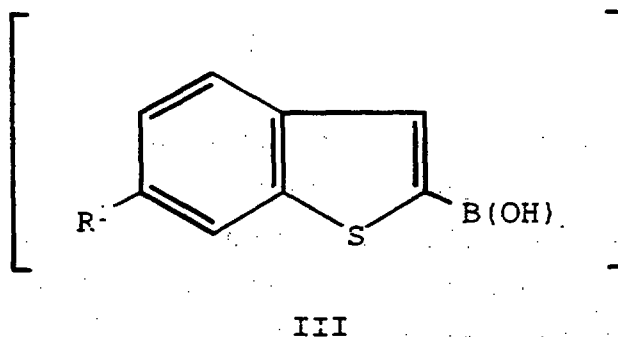
15



; and

b) coupling the reaction product from step a), a compound of formula III

20



with a compound of formula IV

-5-



IV

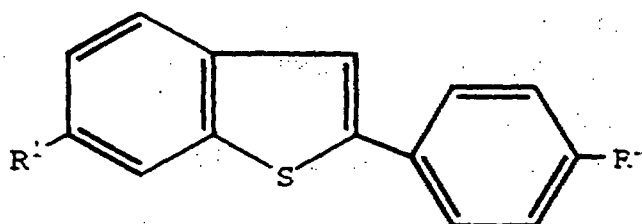
wherein

R^1 is -H, -OH, or OR^3 , in which R^3 is a hydroxy protecting group;

R^2 is -H, -OH, or OR^4 , in which R^4 is a hydroxy protecting group; and

X is bromo, iodo, or triflate.

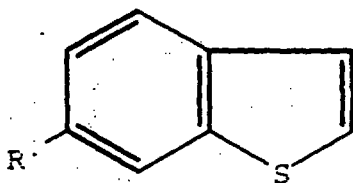
The present invention further provides a process for preparing a compound of formula I



I

comprising

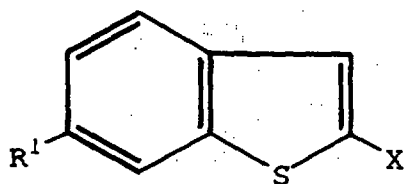
a) selectively brominating or iodinating or forming a triflate leaving group at the 2-position of a compound of formula II



II

to provide a compound of formula V

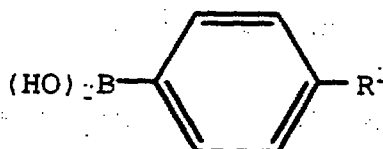
-6-



V

; and

b) - coupling said formula V compound with a
 5 compound of formula VI



VI

wherein

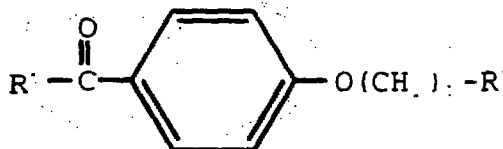
10 R^1 is -H, -OH, or OR^3 , in which R^3 is a hydroxy protecting group;

R^2 is -H, -OH, or OR^4 , in which R^4 is a hydroxy protecting group; and

X is bromo, iodo, or triflate.

15 In addition, the present invention provides methods of preparing a compound of formula I comprising steps a) and b) of either of the above-described processes of the present invention and further comprising

20 c) acylating a compound of formula I with a compound of formula VIII



VIII

wherein

25 R^1 is -H, -OH, or OR^3 , in which R^3 is a hydroxy protecting group;

R^2 is -H, -OH, or OR^4 , in which R^4 is a hydroxy protecting group;

-7-

R^5 is 1-piperidinyl, 1-pyrrolidinyl, methyl-1-pyrrolidinyl, dimethyl-1-pyrrolidinyl, 4-morpholino, dimethylamino, diethylamino, diisopropylamino, or 1-hexamethyleneimino;

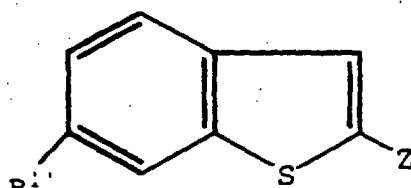
R^6 is bromo, chloro, iodo, or an activating ester group; and

n is 2 or 3;

d) optionally removing the R^3 and/or R^4 hydroxy protecting groups; and

e) optionally forming a pharmaceutically acceptable salt of said formula VII compound.

The present invention also provides compounds of formula IX



IX

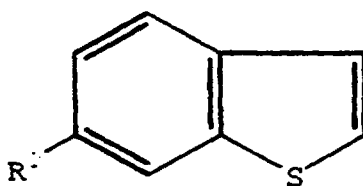
wherein

$R^{1'}$ is $-OH$ or $-OR^3$, in which R^3 is a hydroxy protecting group; and

Z is bromo, iodo, triflate, or $-B(OH)_2$, which are useful intermediates for the preparation of compounds of formulae I and VII of the present invention.

One aspect of the present invention provides convenient processes for preparing benzothiophene compounds of formula I.

The starting material for the instant process of the present invention, a compound of formula II



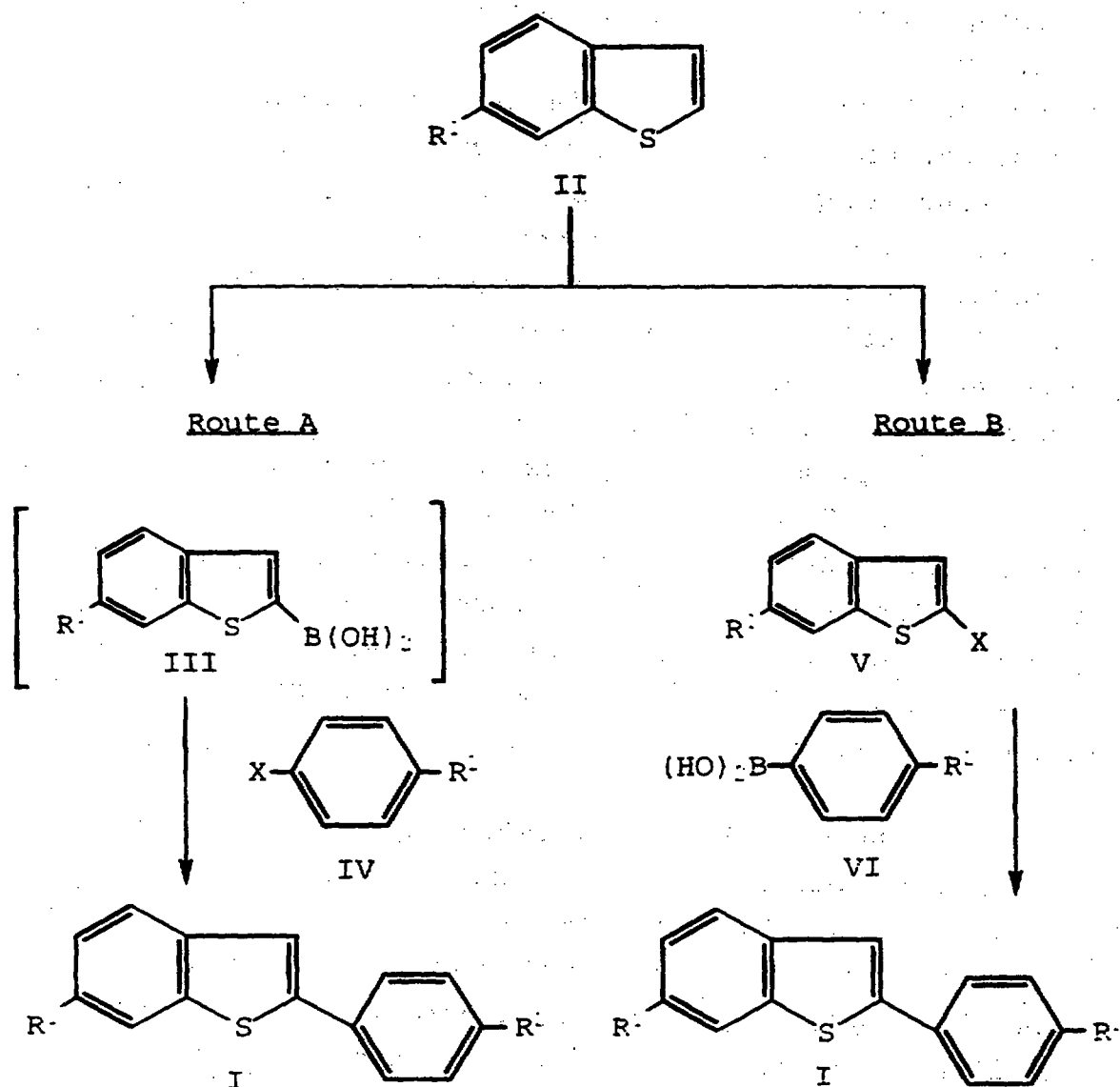
-8-

II

wherein R¹ is as defined above, is commercially available or is prepared via known procedures using known or commercially available materials [see, e. g., Graham, S.L., et al., J. Med. Chem., 32(12):2548-2554 (1989)].

In the present, convenient process, an arylboronic acid derivative of a formula II compound is prepared, providing a compound of formula III, which is then coupled with an arene of formula IV, providing a compound of formula I. Alternatively, a formula II compound is selectively halogenated or a triflate leaving group is placed at the 2-position, providing a compound of formula V, which is then coupled with an arylboronic acid compound of formula VI providing a formula I compound. These reactions are shown in Route A and Route B, respectively, of Scheme I below.

-9-

Scheme I

10 wherein R^1 , R^2 , and X are as defined above.

When R^1 and/or R^2 are OR^3 and OR^4 , respectively, R^3 and R^4 represent hydroxy protecting groups which are moieties which generally are not found in the final, therapeutically active compounds of formula VII, but are intentionally introduced during a portion of the synthetic process to protect a group which otherwise might react in the course of chemical manipulations, and is then removed at a later stage of the synthesis. Because compounds bearing such protecting

15

-10-

groups are important primarily as chemical intermediates (although some derivatives also exhibit biological activity', their precise

structure is not critical. Numerous reactions for the formation, removal, and possibly, reformation of such protecting groups are described in a number of standard works including, for example, *Protective Groups in Organic Chemistry*, Plenum Press (London and New York, 1973); Green, T.W., *Protective Groups in Organic Synthesis*, Wiley New York, 1981; and *The Peptides*, Vol. I, Schrooder and Lubke, Academic Press (London and New York, 1965).

Representative hydroxy protecting groups include, for example, $-C_1-C_4$ alkyl, $-CO-(C_1-C_6 \text{ alkyl})$, $-SO_2(C_4-C_6 \text{ alkyl})$, and $-CO-Ar$ in which Ar is optionally substituted phenyl. The term "substituted phenyl" refers to a phenyl group having one or more substituents selected from the group consisting of C_1-C_4 alkyl, C_1-C_4 alkoxy, hydroxy, nitro, halo, and tri(chloro or fluoro)methyl. Of these, methyl is highly preferred.

General chemical terms used above and throughout the present specification bear their usual meanings. For example, " C_1-C_4 alkyl" refers to straight or branched aliphatic chains of 1 to 4 carbon atoms including moieties such as methyl, ethyl, propyl, isopropyl, butyl, n-butyl, and the like. The term "halo" refers to bromo, chloro, fluoro, and iodo.

In the first step of Route A of Scheme I, a 2-position arylboronic acid of formula III is formed using standard procedures. Generally, a compound of formula II is treated with a slight excess of an n-alkyllithium in hexanes, in an appropriate solvent and, frequently, under an inert atmosphere such as nitrogen, followed by the slow or dropwise addition of an appropriate trialkylborane.

Appropriate solvents include an inert solvent or mixture of solvents such as, for example, diethyl ether, dioxane and tetrahydrofuran (THF). Of these, THF, particularly anhydrous THF, is preferred.

-11-

The preferred trialkylborate used in the present reaction is triisopropyl borate.

The product of this reaction, a compound of formula III, is then reacted with an aryl compound of formula IV, via standard Suzuki coupling procedures to provide compounds of formula I. Compounds of formula IV, in which R^2 is -H or OR^3 , and R^3 is a hydroxy protecting group, are derived from commercially available compounds via procedures well known to one of ordinary skill in the art [see, e.g., *Advanced Organic Chemistry: Reactions, Mechanisms, and Structure*, 4th Edition (J. March, ed., John Wiley and Sons, Inc., 1992); and Suzuki, A., *Pure and Appl. Chem.*, 6(2):213-222 (1994)].

In the present coupling reaction, a slight excess of a formula IV compound is reacted with each equivalent of a formula III compound in the presence of a palladium catalyst and an appropriate base in an inert solvent such as toluene.

Although various palladium catalysts drive this coupling reaction, the catalyst selected usually is reaction specific. Thus, the use of tetrakis triphenylphosphine palladium in the present reaction is highly preferred.

Likewise, various bases may be used in the present coupling reaction. However, it is preferred to use an alkali metal carbonate, particularly 2N sodium carbonate.

The temperature employed in this step should be sufficient to effect completion of the coupling reaction. Typically, heating the reaction mixture to reflux for a period from about 2 to about 4 hours is adequate and preferred.

In Route B of Scheme I, the first step involves the 2-position bromination, iodination, or forming a triflate leaving group of a formula II compound using standard procedures. Generally, when brominating or iodinating, a formula II compound is reacted with a slight excess of n-butyllithium in hexane, in an appropriate solvent and, frequently under an inert atmosphere such as nitrogen, followed by the dropwise addition of a slight excess of the desired brominating or iodinating agent in an appropriate

-12-

solvent. A preferred iodinating agent is iodine, and preferred brominating agents include bromine and N-bromosuccinimide.

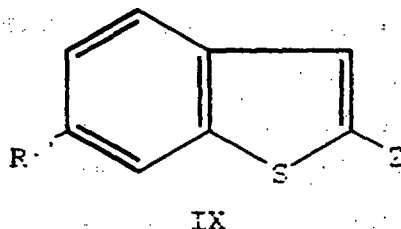
Appropriate solvents include an inert solvent or mixture of solvents such as, for example, diethyl ether, dioxane, or THF. THF is preferred and anhydrous THF is especially preferred.

The present reaction is optionally run at a temperature range from about -75°C to about -85°C .

The product of the above reaction, a halo arene of formula V, is then coupled with an arylboronic acid compound of formula VI, to provide compounds of formula I. The preferred reaction conditions for the coupling reaction are as described for the coupling reaction involving formula III and formula IV compounds in Route A of Scheme I above.

The processes shown in Scheme I and herein described may be carried out in separate steps in which the reaction product from each step is purified and characterized, or the process shown in Route A and the process shown in Route B is carried out *in situ*. Thus, the present processes, preferably, are each carried out in a single vessel.

Compounds of formula III and V, as shown in the present process, are novel when R^1 is $-\text{OH}$ or $-\text{OR}^3$ and useful as intermediates for the preparation of pharmaceutically active compounds of formula VII, and are hereinafter collectively referred to as compounds of formula IX



wherein

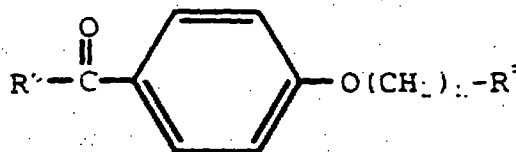
R^1 is $-\text{OH}$, or $-\text{OR}^3$, in which R^3 is a hydroxy protecting group; and

Z is bromo, iodo, triflate, or $-\text{B}(\text{OH})_2$.

-13-

In another aspect of the present invention, compounds of formula VII are prepared by a process comprising the process steps shown in Route A and Route B of Scheme I, and further comprising

c) acylating a compound of formula I with a compound of formula VIII



VIII

wherein

R^1 is -H, -OH, or OR^3 , in which R^3 is a hydroxy protecting group;

R^2 is -H, -OH, or OR^4 , in which R^4 is a hydroxy protecting group;

R^5 is 1-piperidinyl, 1-pyrrolidinyl, methyl-1-pyrrolidinyl, dimethyl-1-pyrrolidinyl, 4-morpholino, dimethylamino, diethylamino, diisopropylamino, or 1-hexamethyleneimino;

R^6 is bromo, chloro, iodo, or an activating ester group; and

n is 2 or 3;

d) optionally removing the R^3 and/or R^4 hydroxy protecting groups; and

e) optionally forming a pharmaceutically acceptable salt of said formula VII compound.

Process steps c), d), and e) are well known in the art individually or collectively and are described in U.S. Pat. Nos. 4,358,593, 4,418,068, 4,133,814, and 4,380,635, which are herein incorporated by reference.

Although the free-base form of formula VII compounds can be used for the aforementioned medical indications, it is preferred to prepare and use a

-14-

pharmaceutically acceptable salt form. Thus, the formula VII compounds primarily form pharmaceutically acceptable acid addition salts with a wide variety of organic and inorganic acids, and include the physiologically acceptable salts which are often used in pharmaceutical chemistry. Such salts are also part of this invention. Typical inorganic acids used to form such salts include hydrochloric, hydrobromic, hydroiodic, nitric, sulfuric, phosphoric, hypophosphoric, and the like. Salts derived from organic acids, such as aliphatic mono and dicarboxylic acids, phenyl substituted alkanolic acids, hydroxyalkanoic and hydroxyalkandioic acids, aromatic acids, aliphatic and aromatic sulfonic acids, may also be used. Such pharmaceutically acceptable salts thus include acetate, phenylacetate, trifluoroacetate, acrylate, ascorbate, benzoate, chlorobenzoate, dinitrobenzoate, hydroxybenzoate, methoxybenzoate, methylbenzoate, o-acetoxybenzoate, naphthalene-2-benzoate, bromide, isobutyrate, phenylbutyrate, β -hydroxybutyrate, butyne-1,4-dioate, hexyne-1,4-dioate, caprate, caprylate, chloride, cinnamate, citrate, formate, fumarate, glycollate, heptanoate, hippurate, lactate, malate, maleate, hydroxymaleate, malonate, mandelate, mesylate, nicotinate, isonicotinate, nitrate, oxalate, phthalate, terephthalate, phosphate, monohydrogenphosphate, dihydrogenphosphate, metaphosphate, pyrophosphate, propiolate, propionate, phenylpropionate, salicylate, sebacate, succinate, suberate, sulfate, bisulfate, pyrosulfate, sulfite, bisulfite, sulfonate, benzenesulfonate, p-bromophenylsulfonate, chlorobenzenesulfonate, ethanesulfonate, 2-hydroxyethanesulfonate, methanesulfonate, naphthalene-1-sulfonate, naphthalene-2-sulfonate, p-toluenesulfonate, xylenesulfonate, tartarate, and the like. A preferred salt is the hydrochloride salt.

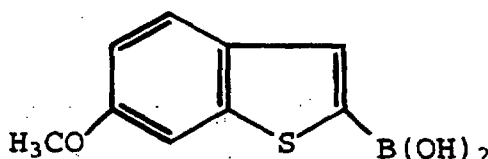
The following examples are presented to further illustrate the preparation of compounds of the present invention. It is not intended that the invention be limited in scope by reason of any of the following examples.

-15-

NMR data for the following Examples were generated on a GE 300 MHz NMR instrument, and anhydrous d-6 DMSO was used as the solvent unless otherwise indicated.

Example 1

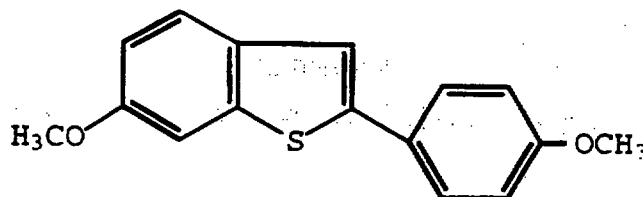
6-methoxybenzo[b]thiophene-2-boronic acid



To a solution of 6-methoxybenzo[b]thiophene (18.13 g, .111 mol) in 150 mL of anhydrous tetrahydrofuran (THF) at -60° C was added n-butyllithium (76.2 mL, .122 mol, 1.6 M solution in hexanes), dropwise via syringe. After stirring for 30 minutes, triisopropyl borate (28.2 mL, .122 mol) was introduced via syringe. The resulting mixture was allowed to gradually warm to 0° C and then distributed between 1N hydrochloric acid and ethyl acetate (300 mL each). The layers were separated, and the organic layer was dried over sodium sulfate. Concentration in vacuo produced a white solid that was triturated from ethyl ether hexanes. Filtration provided 16.4 g (71%) of 6-methoxybenzo[b]thiophene-2-boronic acid as a white solid. mp 200° C (dec). ¹H NMR (DMSO-d₆) δ 7.83 (s, 1H), 7.78 (d, J = 8.6 Hz, 1H), 7.51 (d, J = 2.0 Hz, 1H), 6.97 (dd, J = 6.6, 2.0 Hz, 1H), 3.82 (s, 3H). FD mass spec: 208.

Prepared in an analogous manner was benzo[b]thiophene-2-boronic acid (known compound).

-16-

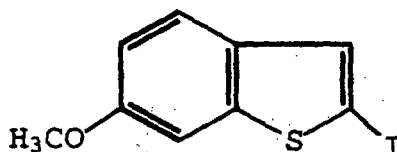
Example 2**[6-methoxy-2-(4-methoxyphenyl)]benzo[b]thiophene**

To a solution of 6-methoxybenzo[b]thiophene-2-boronic acid (1.00 g, 4.81 mmol) in toluene (20 mL) was added 4-iodoanisole (1.24 g, 5.29 mmol) followed by tetrakis(triphenylphosphine) palladium (0.17 g, 0.15 mmol). To this solution was added 5.0 mL of 2N sodium carbonate solution. The resulting mixture was heated to reflux for 2 hours. Upon cooling, a white precipitate ([6-methoxy-2-(4-methoxyphenyl)]benzo[b]thiophene) formed. The solid was collected by filtration and washed with ethyl acetate. The filtrate was distributed between ethyl acetate and saturated sodium bicarbonate solution. The layers were separated, and the organic layer was dried over sodium sulfate. Concentration in vacuo produced a white solid (additional [6-methoxy-2-(4-methoxyphenyl)]benzo[b]thiophene) that was collected by filtration. Total yield of product was 1.25 g (96%). mp 190-194° C. ¹H NMR (DMSO-*d*₆) δ 7.71-7.63 (m, 3H), 7.61 (s, 1H), 7.53 (d, *J* = 2.0 Hz, 1H), 7.03 (d, *J* = 9.0 Hz, 2H), 6.99 (dd, *J* = 9.0, 2.0 Hz, 1H), 3.83 (s, 3H), 3.81 (s, 3H). Anal. Calcd. for C₁₆H₁₄O₂S: C, 71.08; H, 5.22. Found: C, 71.24; H, 5.26.

Alternatively, purification was routinely achieved by chromatography on silicon dioxide.

THIS SHEET HAS BEEN
REPLACED

-17-

Example 3**6-methoxy-2-iodobenzo[b]thiophene**

To a solution of 6-methoxybenzo[b]thiophene (5.00 g, 30.49 mmol) in 200 mL of anhydrous THF at -78°C , was added n-butyllithium (20.0 mL, 32.01 mmol, 1.6 M solution in hexanes). After stirring for 15 minutes, a solution of I_2 (8.10 g, 32.01 mmol) in 25 mL of anhydrous THF was introduced dropwise via canula. The resulting mixture was allowed to gradually warm to ambient temperature. The reaction was quenched by distributing between ethyl acetate/brine (150 mL each). The layers were separated and the organic layer was dried over sodium sulfate. Concentration in vacuo produced a tan solid that was recrystallized from hexanes to provide 6.70 g (75%) of 6-methoxy-2-iodobenzo[b]thiophene. mp $75-77^{\circ}\text{C}$. ^1H NMR (CDCl_3) δ 7.59 (d, $J = 8.6$ Hz, 1H), 7.42 (s, 1H), 7.22 (d, $J = 2.0$ Hz, 1H), 6.92 (dd, $J = 8.6, 2.0$ Hz, 1H), 3.86 (s, 3H). FD mass spec: 290. Anal. Calcd. for $\text{C}_9\text{H}_7\text{OSI}$: C, 37.26; H, 2.43. Found: C, 37.55; H, 2.43.

6-methoxy-2-iodobenzo[b]thiophene was reacted with 4-methoxyphenylboronic acid according to the general procedure described above to provide [6-Methoxy-2-(4-methoxyphenyl)]benzo[b]thiophene in 80% yield.



THIS SHEET HAS BEEN
REPLACED

-18-

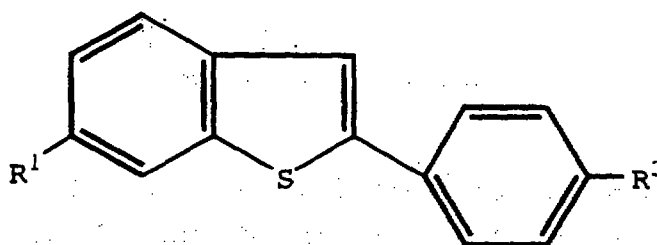


We claim:

1. A process for preparing a compound of formula

I

5

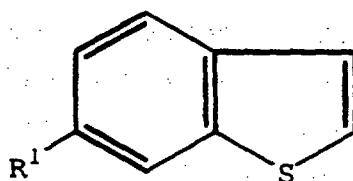


I

comprising

a) forming a 2-position boronic acid derivative
of a compound of formula II

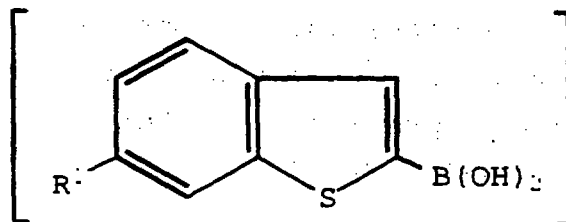
10



II ; and

b) coupling the reaction product from step a), a
compound of formula III

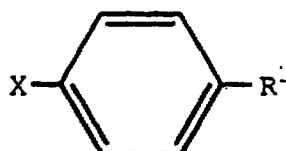
15



III

20

with a compound of formula IV

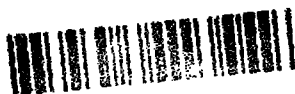


This Sheet Has Been Replaced



THIS SHEET HAS BEEN
REPLACED

-19-

THIS SHEET HAS BEEN
REPLACED

IV



wherein

R^1 is -H, -OH, or OR^3 , in which R^3 is a hydroxy protecting group;

R^2 is -H, -OH, or OR^4 , in which R^4 is a hydroxy protecting group; and

X is bromo, iodo, or triflate.

2. A process according to Claim 1 wherein R^1 is $-OR^3$ and R^2 is $-OR^4$, and R^3 and R^4 each are C_1 - C_4 alkyl.

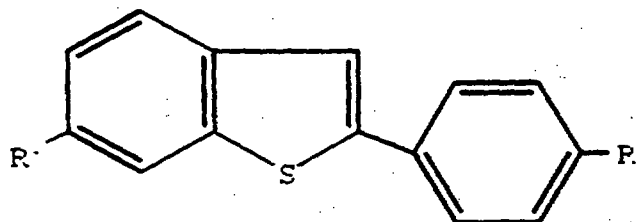
3. A process according to Claim 2 wherein R^3 and R^4 each are methyl.

4. A process according to Claim 3 wherein X is iodo.

5. A process according to Claim 4 wherein steps a) and b) are carried out in the same vessel.

6. A process according to Claim 1 wherein steps a) and b) are carried out in the same vessel.

7. A process for preparing a compound of formula



I

comprising

a) selectively brominating, iodinating or triflating a compound of formula II

This Sheet Has Been Replaced

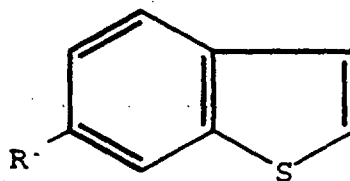
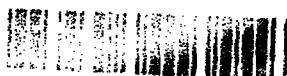




THIS SHEET HAS BEEN
REPLACED

-20-

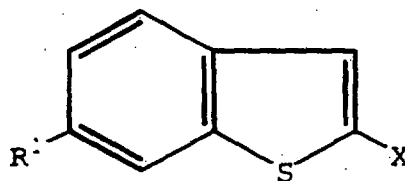
THIS SHEET HAS BEEN
REPLACED



II

to provide a compound of formula V

5

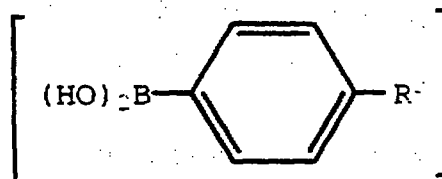


V

; and

10

b) coupling said formula V compound with a
compound of formula VI



VI

wherein

15

R^1 is -H, -OH, or OR^3 , in which R^3 is a hydroxy
protecting group;

R^2 is -H, -OH, or OR^4 , in which R^4 is a hydroxy
protecting group; and

X is bromo, iodo, or triflate.

20

8. A process according to Claim 7 wherein R^1 is
 OR^3 and R^2 is OR^4 , and R^3 and R^4 each are C_1 - C_4 alkyl.

25

9. A process according to Claim 8 wherein R^3 and
 R^4 each are methyl.

This Sheet Has Been Replaced



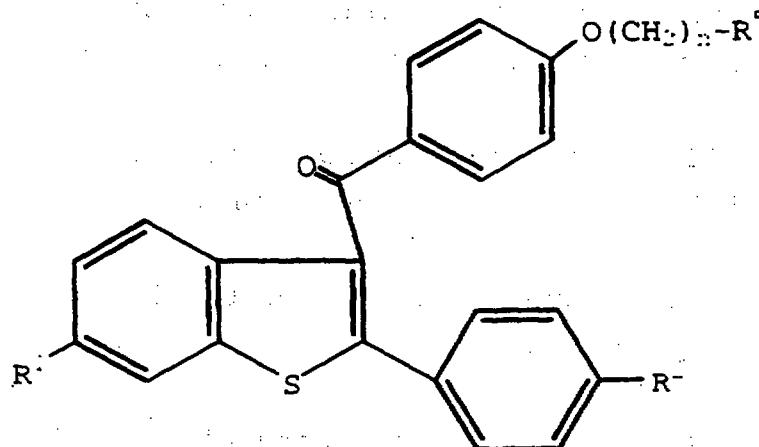


10. A process according to Claim 9 wherein X is iodo.

11. A process according to Claim 10 wherein steps a) and b) are carried out in the same vessel.

12. A process according to Claim 7 wherein steps a) and b) are carried out in the same vessel.

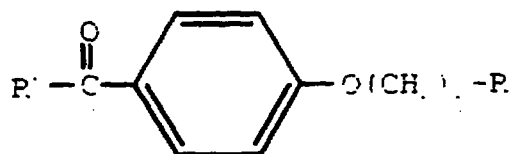
13. A process for preparing a compound of formula VII



VII

comprising steps a) and b) according to Claim 1, and further comprising

c) acylating a compound of formula I with a compound of formula VIII



VIII

wherein

R^1 is -H, -OH, or OR^2 , in which R^2 is a hydroxy protecting group;





R^2 is -H, -OH, or OR^4 , in which R^4 is a hydroxy protecting group;

R^5 is 1-piperidinyl, 1-pyrrolidinyl, methyl-1-pyrrolidinyl, dimethyl-1-pyrrolidinyl, 4-morpholino, dimethylamino, diethylamino, diisopropylamino, or 1-hexamethyleneimino;

R^6 is bromo, chloro, iodo, or an activating ester group; and

n is 2 or 3;

d) optionally removing the R^3 and/or R^4 hydroxy protecting groups; and

e) optionally forming a pharmaceutically acceptable salt of said formula VII compound.

14. A process according to Claim 13 wherein R^1 and R^2 of said formula VII compound each are -OH.

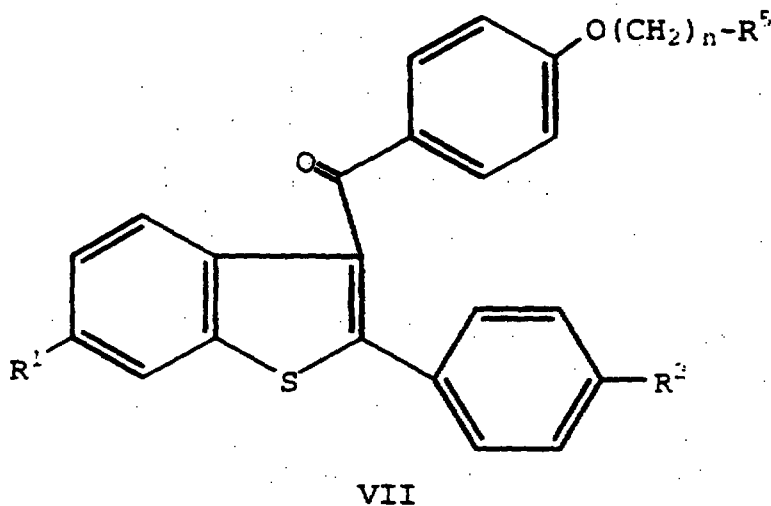
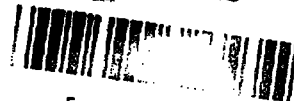
15. A process according to Claim 14 wherein n is 2 and R^5 is 1-piperidinyl.

16. A process according to Claim 15 wherein said pharmaceutically acceptable salt is the hydrochloride salt.

17. A process according to Claim 16 wherein R^6 is bromo or chloro.

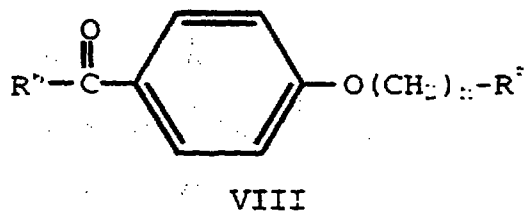
18. A process for preparing a compound of formula VII





comprising steps a) and b) according to Claim 7, and further comprising

c) acylating a compound of formula I with a compound of formula VIII



wherein

R^1 is -H, -OH, or OR^3 , in which R^3 is a hydroxy protecting group;

R^2 is -H, -OH, or OR^4 , in which R^4 is a hydroxy protecting group;

R^5 is 1-piperidinyl, 1-pyrrolidinyl, methyl-1-pyrrolidinyl, dimethyl-1-pyrrolidinyl, 4-morpholino, dimethylamino, diethylamino, diisopropylamino, or 1-hexamethyleneimino;

R^6 is bromo, chloro, iodo, or an activating ester group; and

n is 2 or 3;

d) optionally removing the R^3 and/or R^4 hydroxy protecting groups; and





e) optionally forming a pharmaceutically acceptable salt of said formula VII compound.

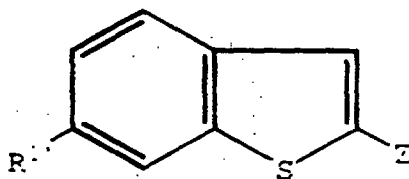
19. A process according to Claim 18 wherein R^1 and R^2 of said formula VII compound each are -OH.

20. A process according to Claim 19 wherein n is 2 and R^5 is 1-piperidinyl.

21. A process according to Claim 20 wherein said pharmaceutically acceptable salt is the hydrochloride salt.

22. A process according to Claim 21 wherein R^6 is bromo or chloro.

23. A compound of formula IX



IX

wherein

$R^{1'}$ is -OH or -OR³, in which R³ is a hydroxy protecting group; and

Z is bromo, iodo, triflate, or -B(OH)₂.

24. A compound according to Claim 23 wherein $R^{1'}$ is -OR³.

25. A compound according to Claim 24 wherein R³ is C₁-C₄ alkyl.

26. A compound according to Claim 25 wherein R³ is methyl.





27. A compound according to Claim 26 wherein Z is
bromo.

28. A compound according to Claim 26 wherein Z is
5 iodo.

29. A compound according to Claim 26 wherein Z is
-B(OH)₂.

10 30. A compound according to Claim 23 whrein Z is
bromo.

31. A compound according to Claim 23 wherein Z is
iodo.

15 32. A compound according to Claim 23 wherein Z is
-B(OH)₂.

This Sheet Has Been Replaced

