

PROCESS FOR THE MANUFACTURE OF AN INDOLINONE DERIVATIVE

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The present invention relates to a process for the manufacture of a specific indolinone derivative and a pharmaceutically acceptable salt thereof, namely 3-Z-[1-(4-(N-((4-methyl-piperazin-1-yl)-methylcarbonyl)-N-methyl-amino)-anilino)-10 1-phenyl-methylene]-6-methoxycarbonyl-2-indolinone and its monoethanesulfonate, to new manufacturing steps and to new intermediates of this process.

The indolinone derivative 3-Z-[1-(4-(N-((4-methyl-piperazin-1-yl)-15 methylcarbonyl)-N-methyl-amino)-anilino)-1-phenyl-methylene]-6-methoxycarbonyl-2-indolinone and its monoethanesulfonate are known from the following patent applications: WO 01/027081, WO 04/013099, WO 04/017948, WO 04/096224 and WO 06/067165. These patent applications disclose the compound, a process for its manufacture, a specific salt form of this compound and the use of the compound or its salt in a pharmaceutical composition to treat 20 oncological or non-oncological diseases via inhibition of the proliferation of target cells, alone or in combination with further therapeutic agents. The mechanism of action by which the proliferation of the target cells occurs is essentially a mechanism of inhibition of several tyrosine kinase receptors, and especially an inhibition of the vascular endothelial growth factor receptor 25 (VEGFR).

Although the above-mentioned patent applications already describe a process to manufacture the abovementioned indolinone derivative and its 30 monoethanesulfonate, an object of the present invention is a new and improved process for the manufacture of this compound. Hence, the process in accordance with the present invention presents amongst others the following remarkable advantages when compared to the processes already described in the prior art.

A first advantage is the higher overall yield which can be obtained via the new and improved process. This higher overall yield represents an improvement in the overall efficiency of the process. This implies also an economic advantage.

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A second advantage is that the new and improved process in accordance with the present invention is more friendly towards the environment than the processes already known from the prior art. This advantage is based on the fact that the process steps are conducted at higher concentrations.

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A third advantage which can be pointed out is the large scale production appropriateness of the new and improved process in accordance with the present invention. This appropriateness is characterized by the presence of robust reaction steps, i.e. reaction steps which are less sensitive to the inputs.

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These advantages ensure the required high purity of the active pharmaceutical active ingredient.

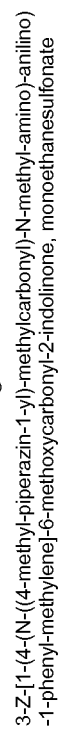
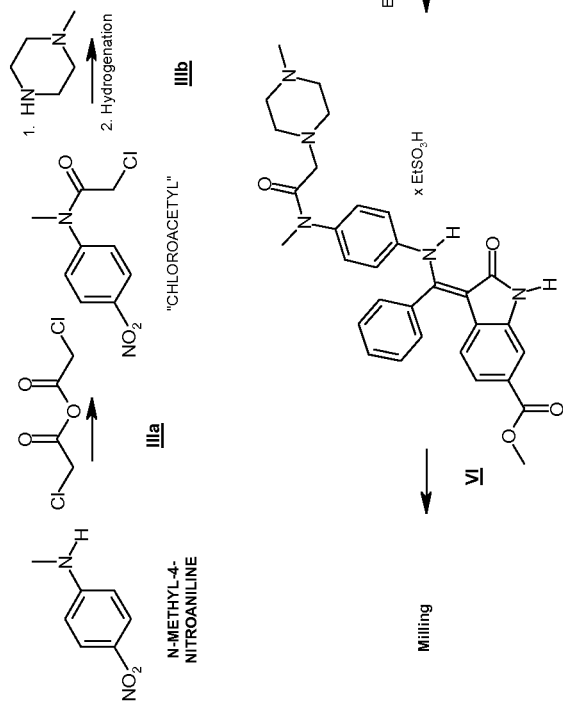
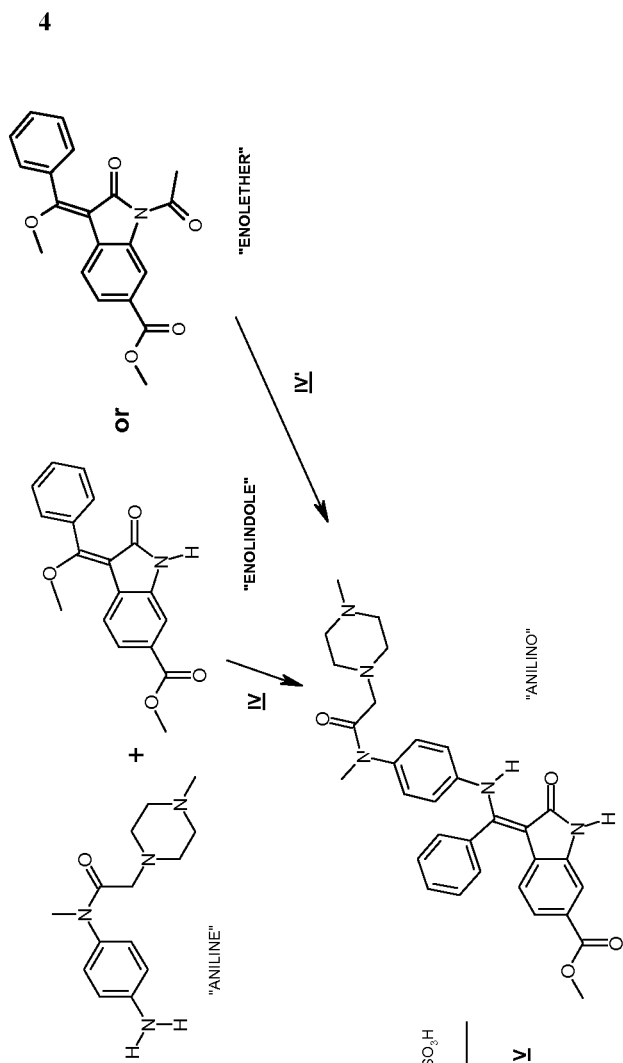
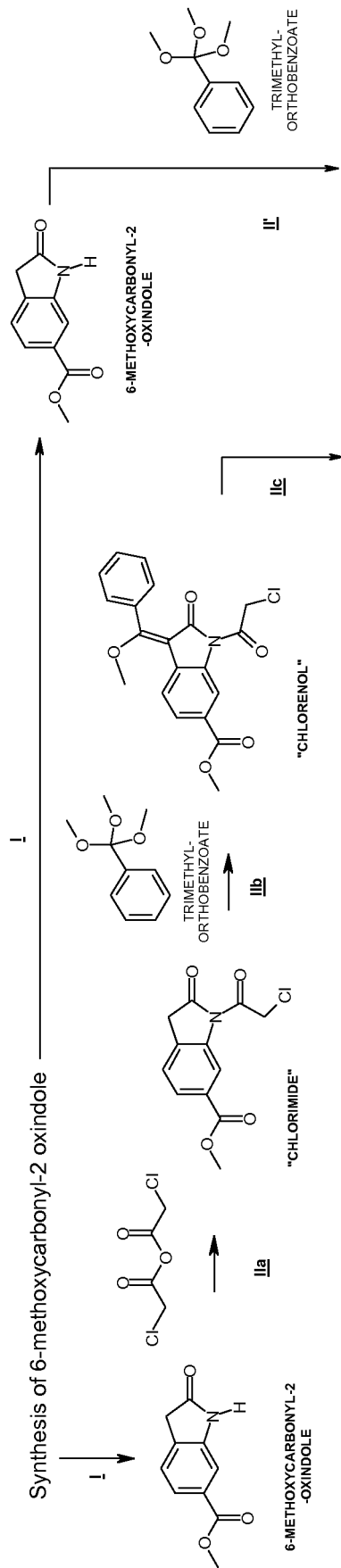
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The process in accordance with the present invention is a convergent process and presents several alternatives, as shown in the following General Synthesis Scheme and using the following nomenclature.

Custom name used in present patent application	Corresponding chemical name used in present patent application	Corresponding IUPAC name
"CHLORIMIDE"		methyl 1-(chloroacetyl)-2-oxoindoline-6-carboxylate
"CHLORENOL" (E or Z isomer)		methyl 1-(chloroacetyl)-3-[methoxy(phenyl)methylene]-2-oxoindoline-6-carboxylate
"CHLOROACETYL"	chloracetyl-N-methyl-4-nitroaniline	N-(4-nitroanilino)-N-methyl-2-chloro-acetamide
"NITROANILINE"		N-(4-nitrophenyl)-N-methyl-2-(4-methylpiperazin-1-

		yl)acetamide
"ANILINE"		N-(4-aminophenyl)-N-methyl-2-(4-methylpiperazin-1-yl)acetamide
"ENOLINDOLE" (E or Z isomer)		methyl 3-[methoxy(phenyl)methylene]-2-oxoindoline-6-carboxylate
"ENOETHER"		methyl 3-[methoxy(phenyl)methylene]-2-oxoindoline-6-carboxylate
"ANILINO"	3-Z-[1-(4-(N-((4-methylpiperazin-1-yl)-methylcarbonyl)-N-methyl-amino)-anilino)-1-phenyl-methylene]-6-methoxycarbonyl-2-indolinone	methyl (3Z)-3-[[[4-{methyl[(4-methylpiperazin-1-yl)acetyl]amino}phenyl)amino](phenyl)methylene]-2-oxoindoline-6-carboxylate
	3-Z-[1-(4-(N-((4-methylpiperazin-1-yl)-methylcarbonyl)-N-methyl-amino)-anilino)-1-phenyl-methylene]-6-methoxycarbonyl-2-indolinone, monoethanesulfonate	ethanesulfonic acid - methyl (3Z)-3-[[[4-{methyl[(4-methylpiperazin-1-yl)acetyl]amino}phenyl)amino](phenyl)methylene]-2-oxoindoline-6-carboxylate (1:1)

General Synthesis Scheme

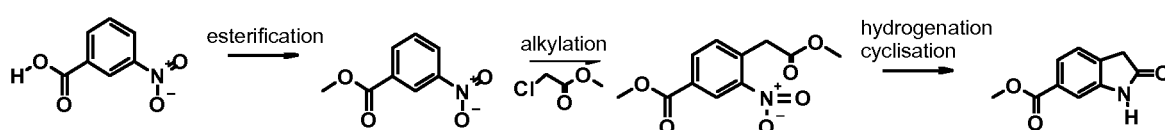


Thus, the process comprises the following steps.

I. Synthesis of the 6-methoxycarbonyl-2-oxindole

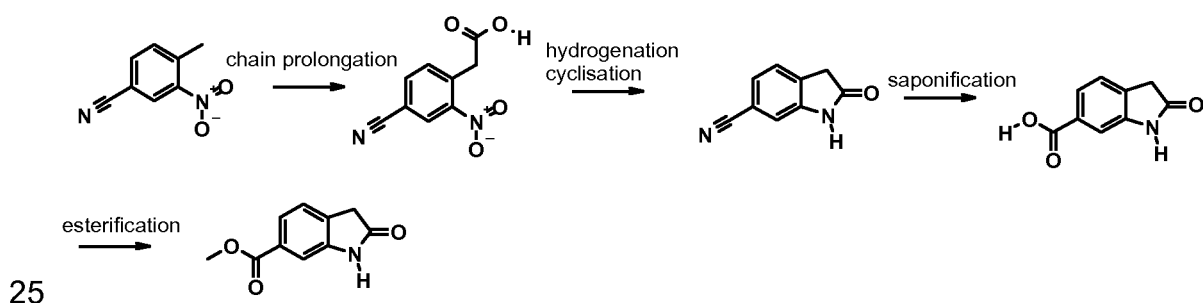
- 5 The 6-methoxycarbonyl-2-oxindole may be synthesized in accordance with the processes shown in following synthesis schemes A or B. These processes have already been described in the prior art.

Synthesis scheme A



Hence, the 6-methoxycarbonyl-2-oxindole is obtainable by a three-step procedure consisting of an esterification of 3-nitro-benzoic acid, followed
 20 by an electrophilic substitution using chloroacetic acid methyl ester, leading to 4-methoxycarbonylmethyl-3-nitro-benzoic acid methyl ester, and to a final hydrogenation-intramolecular amidation sequence.

Synthesis scheme B



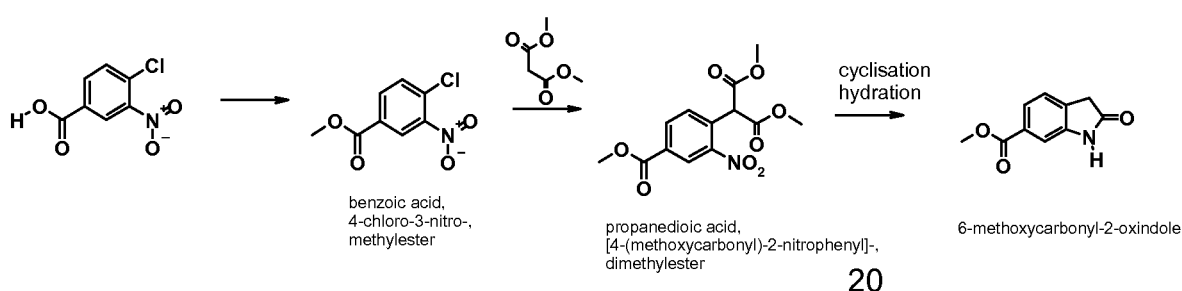
The 6-methoxycarbonyl-2-oxindole is also obtainable by the above four-step procedure. Starting with the chain prolongation of 4-methyl-3-nitro-benzonitrile and reductive cyclisation of the resulting (4-cyano-2-nitro-phenyl)acetic acid to the oxindole scaffold, the synthesis is concluded by
 30 the saponification of the nitrile group and the subsequent esterification of the carboxylic acid functionality.

Alternatively, the 6-methoxycarbonyl-2-oxindole may also be synthesized in accordance with the process to synthesize 2-oxindoles described in US patent 6,469,181.

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Alternatively, the 6-methoxycarbonyl-2-oxindole may be synthesized in accordance with the process shown in the following synthesis scheme C.

Synthesis scheme C



The steps of this synthesis scheme C, which is also an object of the present invention, will be further described in the following experimental Example 1, which shall not be construed as a limitation of the present invention.

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IIa. Reaction of the 6-methoxycarbonyl-2-oxindole with chloroacetic anhydride to obtain the “chlorimide” (methyl 1-(chloroacetyl)-2-oxindoline-6-carboxylate)

The reaction of 6-methoxycarbonyl-2-oxindole with chloroacetic anhydride or another appropriately activated chloroacetic acid derivative, e. g. chloroacetyl chloride, is preferably carried out in a high boiling and aprotic solvent, for instance toluene, xylene or butyl acetate, at a temperature of about 80 °C to about 130 °C.

The crystallisation is initiated by addition of a non-polar solvent, for instance cyclohexane or methyl cyclohexane, at a temperature of about 80 °C to about 100 °C, and completed at a temperature of about -5 °C to room temperature. The solid is collected, washed, preferably with polar solvents such as alcohols, most preferably methanol, and dried, to generate the “chlorimide” compound.

The alkylating agents such as chloroacetyl chloride or chloroacetic anhydride may be purchased from different sources. A supplier of large amounts of chloroacetic anhydride is, for example, SF-Chem (Switzerland).

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The above reaction step **IIa** and the product of the reaction, i.e. the “chlorimide” (methyl 1-(chloroacetyl)-2-oxoindoline-6-carboxylate), are also an object of the present invention.

- 10 **IIb.** Reaction of the “chlorimide” with trimethylorthobenzoate to obtain the “chlorenol” (methyl 1-(chloroacetyl)-3-[methoxy(phenyl)methylene]-2-oxoindoline-6-carboxylate)

The reaction of the methyl 1-(chloroacetyl)-2-oxoindoline-6-carboxylate with
15 trimethylorthobenzoate is carried out in a high boiling and aprotic solvent such as butyl acetate, *N,N*-dimethylformamide, xylene or preferably toluene, at temperatures of about 100 °C to about 140 °C. The reaction is mediated by methanol scavengers such as acetic anhydride. In the course of the reaction, volatile parts can be distilled off with or without replacement of the removed
20 parts by the reaction solvent. The crystallisation is finished at ambient temperature to about -10 °C. The solid is collected and washed, preferably with solvents such as toluene, xylene and/or ethyl acetate. After drying, the “chlorenol” compound is obtained.

- 25 Acetic anhydride may be purchased from different sources.
Trimethylorthobenzoate may be purchased from AMI Drugs & Speciality Chemicals India Inc.

- 30 The above reaction step **IIb** and the product of the reaction, i.e. the “chlorenol” (methyl 1-(chloroacetyl)-3-[methoxy(phenyl)methylene]-2-oxoindoline-6-carboxylate), are also an object of the present invention.

IIc. Reaction of the “chlorenol” with bases to obtain the “enolindole” (methyl-3-[methoxy(phenyl)methylene]-2-oxoindoline-6-carboxylate)

The base catalyzed dechloroacetylation of methyl-1-(chloroacetyl)-3-[methoxy(phenyl)methylene]-2-oxoindoline-6-carboxylate is carried out in protic solvents such as alcohols, e.g. isopropanol or preferably methanol, at temperatures of about 70 °C to ambient temperature. Inorganic bases such as alkali hydroxides or organic bases such as sodium methoxide may be used as catalysator. The crystallisation is finished at ambient temperature to about -10 °C. The solid is collected and washed, preferably with alcohols, most preferably methanol. After drying, the “enolindole” compound is obtained.

The above reaction step **IIc** and the product of the reaction, i.e. the “enolindole” (methyl-3-[methoxy(phenyl)methylene]-2-oxoindoline-6-carboxylate), are also an object of the present invention.

Alternatively, the 6-methoxycarbonyl-2-oxindole may be reacted directly with trimethylorthobenzoate in the presence of acetanhydride to obtain the “enolether” (methyl 3-[methoxy(phenyl)methylene]-2-oxoindoline-6-carboxylate). This alternative embodiment is described in the General Synthesis Scheme as step II' and may be carried out as described above for step IIb.

IIIa. Reaction of N-methyl-4-nitroaniline with chloroacetic anhydride to obtain the “chloroacetyl” (N-(4-nitroanilino)-N-methyl-2-chloro-acetamide)

The chloroacetylation of N-methyl-4-nitroaniline is carried out in aprotic solvents such as toluene, or esters, preferably ethyl acetate, at temperatures of not less than 60 °C. As alkylating agent, activated derivatives of chloroacetic acid, preferably chloroacetic acid chloride, or most preferably chloroacetic anhydride, can be used. The crystallisation is initiated by addition of non-polar solvents, preferably cyclohexane or methyl cyclohexane at temperatures of about 60 °C to about 80 °C, and completed at ambient temperature to about -10 °C. The solid is collected and washed, preferably with non-polar solvents such as methyl cyclohexane. After drying, the “chloroacetyl” compound is obtained.

The alkylating agents such as chloroacetyl chloride or chloroacetic anhydride may be purchased from different sources. A supplier for large amounts of chloroacetic anhydride is, for example, SF-Chem (Switzerland). A supplier for
5 the starting material N-methyl-4-nitroaniline is, for example, RRJ Dyes & Intermediates Ltd (India).

The above reaction step IIIa is also an object of the present invention.

- 10 IIIb. Reaction of the "chloroacetyl" with 1-methylpiperazine to obtain the "nitroaniline" (N-(4-nitrophenyl)-N-methyl-2-(4-methylpiperazin-1-yl)acetamide), and subsequent hydrogenation to obtain the "aniline" (N-(4-aminophenyl)-N-methyl-2-(4-methylpiperazin-1-yl)acetamide).
- 15 The initial reaction of N-(4-nitroanilino)-N-methyl-2-chloro-acetamide with 1-methylpiperazine is carried out in aprotic solvents such as esters (e. g. butyl acetate), ketones (e. g. methyl isobutyl ketone) or aromatic solvents, preferably toluene, at temperatures of about 30 °C to about 60 °C. Subsequently, the organic salts are removed by extraction with water or diluted with aqueous
20 solutions of inorganic salts, e. g. brine. The remaining reaction mixture is diluted with an alcohol, preferably isopropanol, and hydrogenated at temperatures of about 20 °C to about 90 °C, at hydrogen pressures of about 1 bar to 10 bar, using heterogenic hydrogenation catalysts such as palladium on charcoal. After removal of the catalyst, the majority of the solvents are distilled off at reduced
25 pressure and at temperatures of about 40 °C to about 80 °C. The residue is dissolved in toluene or in a mixture of toluene and of an ester, preferably ethyl acetate, at temperatures of about 70 °C to about 90 °C, and then crystallized by lowering of the temperature to about 10 °C to about -10 °C. The crystals are separated and washed with a non-polar solvent, preferably with toluene, and
30 dried to give the "aniline" compound.

The starting material 1-methylpiperazine for the initial substitution reaction may be purchased from different sources, e.g. from Enzal Chemicals (India) Pvt., Ltd.

The above reaction step **IIIb** is also an object of the present invention.

IV. Reaction of the “aniline” with the “enolindole” to obtain the “anilino” (3-Z-[1-(4-(N-((4-methyl-piperazin-1-yl)-methylcarbonyl)-N-methyl-amino)-anilino)-1-phenyl-methylene]-6-methoxycarbonyl-2-indolinone).

This reaction is stereospecific with respect to the Z and E isomers. With this reaction, the Z isoform is obtained.

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The reaction of methyl-3-[methoxy(phenyl)methylene]-2-oxoindoline-6-carboxylate and N-(4-aminophenyl)-N-methyl-2-(4-methylpiperazin-1-yl)acetamide is conducted in protic solvents such as alcohols, e. g. ethanol or preferably methanol, or aromatic solvents such as toluene, or in mixtures of these solvents with highly polar solvents such as *N,N*-dimethylacetamide or preferably *N,N*-dimethylformamide, at a temperature of not less than 50 °C under refluxing conditions. After complete conversion, the crystallization is accomplished at a temperature of at least ambient temperature. The solid is collected and subsequently washed with a protic solvent such as ethanol, or preferably methanol, or with aromatic solvents such as toluene. After drying, the “anilino” compound is isolated in the form of yellow crystals.

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The above reaction step **IV** is also an object of the present invention.

25 Alternatively, the “anilino” compound (3-Z-[1-(4-(N-((4-methyl-piperazin-1-yl)-methylcarbonyl)-N-methyl-amino)-anilino)-1-phenyl-methylene]-6-methoxycarbonyl-2-indolinone) may be obtained by the reaction step IV', in which the “aniline” is reacted with the “enoether” in the presence of MeONa-MeOH. This reaction step **IV'** is also an object of the present invention.

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V. Reaction of the “anilino” (3-Z-[1-(4-(N-((4-methyl-piperazin-1-yl)-methylcarbonyl)-N-methyl-amino)-anilino)-1-phenyl-methylene]-6-methoxycarbonyl-2-indolinone) with EtSO₃H to obtain the monoethanesulfonate salt of this compound.

- The salt formation of 3-Z-[1-(4-(N-((4-methyl-piperazin-1-yl)-methylcarbonyl)-N-methyl-amino)-anilino)-1-phenyl-methylene]-6-methoxycarbonyl-2-indolinone is carried out in highly polar alcohols, e. g. ethanol or preferably methanol, with or without water as a cosolvent, at temperatures of about 40 °C to about 70 °C, by addition of pure or aqueous ethanesulfonic acid. The precipitation is initiated by seeding of the resulting solution at temperatures of about 40 °C to about 60 °C, and subsequent addition of a less polar alcohol such as isopropanol. The crystallization is finished at temperatures of not higher than room temperature.
- The solid is isolated, washed with an alcohol as methanol, or preferably isopropanol, and dried to furnish the monoethanesulfonate salt of the compound in the form of yellow crystals.

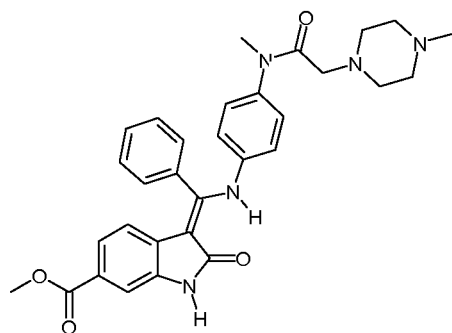
The above reaction step **V** is also an object of the present invention.

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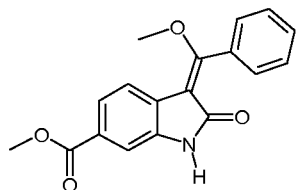
VI. Milling of the 3-Z-[1-(4-(N-((4-methyl-piperazin-1-yl)-methylcarbonyl)-N-methyl-amino)-anilino)-1-phenyl-methylene]-6-methoxycarbonyl-2-indolinone monoethanesulfonate.

- For storage and further processing, the monoethanesulfonate salt of the compound in accordance with the present invention may be milled, e.g. on an impact mill or a classifier mill. This step of milling is also an object of the present invention.

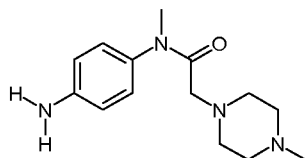
- Thus, a first object of the present invention is the following process D for the manufacture of a compound of formula



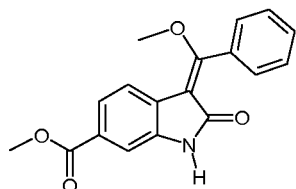
comprising the step of reacting a compound of formula



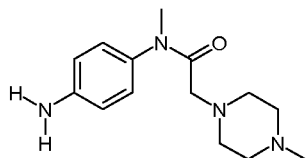
with a compound of formula



5 A further object of the present invention is the compound of formula

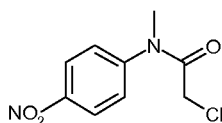


A further object of the present invention is the following process D1, based on the above process D, and in which the compound of formula

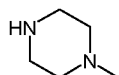


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is obtained by reacting a compound of formula

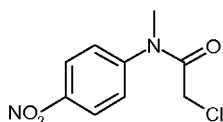


with a compound of formula

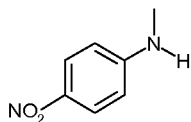


15 and subsequent hydrogenation of the nitro group in an amino group.

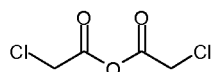
A further object of the present invention is the following process D2, based on the above process D1, and in which the compound of formula



is obtained by reacting a compound of formula

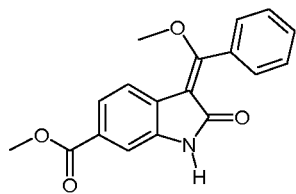


with a compound of formula

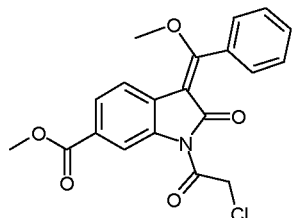


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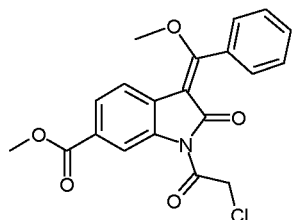
A further object of the present invention is the following process E1, based on the above processes D, D1 or D2, and in which the compound of formula



10 is obtained by base catalyzed dechloroacetylation of a compound of formula

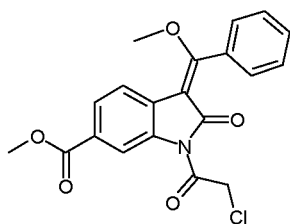


A further object of the present invention is the compound of formula

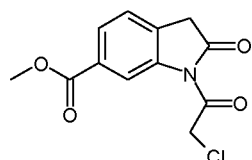


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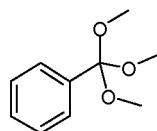
A further object of the present invention is the following process E2, based on the above process E1, and in which the compound of formula



is obtained by reacting a compound of formula

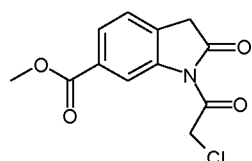


with a compound of formula

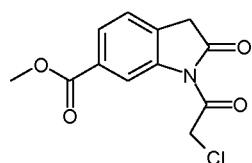


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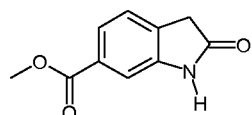
A further object of the present invention is the compound of formula



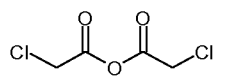
- 10 A further object of the present invention is the following process E3, based on the above process E2, and in which the compound of formula



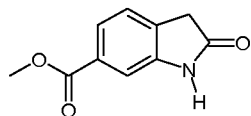
is obtained by reacting a compound of formula



- 15 with a compound of formula

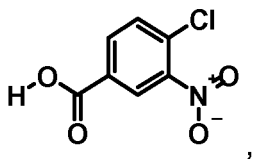


A further object of the present invention is the following process F, based on the above processes E3, and in which the compound of formula

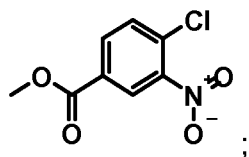


is obtained by the following steps:

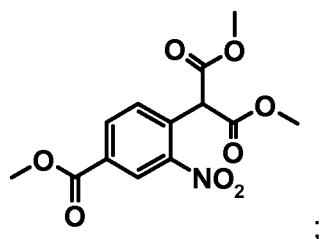
- 5 (i) esterification of a compound of formula



to obtain a compound of formula

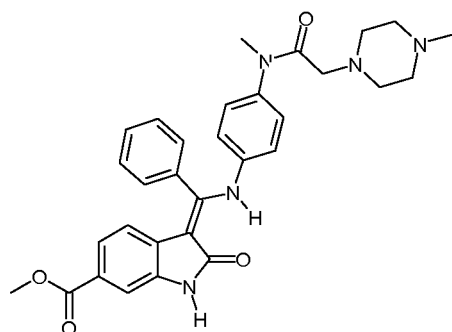


- 10 (ii) reacting the product of the reaction (i) with malonic acid dimethylester, to obtain a compound of formula



- (iii) performing a cyclisation of the product of the reaction (ii) by a reaction of hydrogenation.

- 15 A further object of the present invention is the following process G, based on the above processes D, D1, D2, E1, E2, E3 or F, and in which the compound of formula



is reacted with EtSO₃H in order to obtain a monoethanesulfonate salt of this compound.

- 5 A further object of the present invention is the following process H, based on the above process G, which comprises a step of milling of the monoethanesulfonate salt of the compound.

10 The present invention will be described in more details in the following by way of examples, which are illustrative of further embodiments and shall not construe a limitation of the invention.

Example 1: Synthesis of the 6-methoxycarbonyl-2-oxindole in accordance with the process shown in synthesis scheme C.

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Synthesis of benzoic acid, 4-chloro-3-nitro-, methylester

20 20kg of 4-chloro-3-nitro-benzoic acid (99,22mol) is suspended in 76L methanol. 5,9kg thionylchloride (49,62mol) is added within 15 minutes and refluxed for about 3 hours. After cooling to about 5°C, the product is isolated by centrifugation and drying at 45°C.

Yield: 19,0kg (88,8% of theoretical amount)

Purity (HPLC): 99,8%

25 Synthesis of propanedioic acid, [4-(methoxycarbonyl)-2-nitrophenyl]-, dimethylester

12,87kg of malonic acid, dimethylester (97,41mol) is added to a hot solution (75°C) of 10,73kg sodium-tert.amylate (97,41mol) in 35L 1-methyl-2-pyrrolidinone (NMP). A solution of 10kg benzoic acid, 4-chloro-3-nitro-, methylester (46,38mol) in 25L 1-methyl-2-pyrrolidinone is added at 75°C. After stirring for 1.5 hours at about 75°C and cooling to 20°C, the mixture is acidified with 100L diluted hydrochloric acid to pH 1. After stirring for 1.5 hours at about 5°C, the product is isolated by centrifugation and drying at 40°C.

Yield: 13,78kg (95,4% of theoretical amount)

Purity (HPLC): 99,9%

Alternatively, propanedioic acid, [4-(methoxycarbonyl)-2-nitrophenyl]-, dimethylester can be synthesized as follows:

33,1kg of malonic acid, dimethylester (250,6mol) and 27,0kg benzoic acid, 4-chloro-3-nitro-, methylester (125,3mol) are subsequently added to a solution of 45,1kg sodium-methylate (250,6mol) in 172kg 1-methyl-2-pyrrolidinone (NMP) at 20°C. After stirring for 1.5 hours at about 45°C and cooling to 30°C, the mixture is acidified with 249L diluted hydrochloric acid. At the same temperature, the mixture is seeded, then cooled to 0°C and stirred for an additional hour. The resulting crystals are isolated by centrifugation, washed and dried at 40°C.

Yield: 37,5 kg (86% of theoretical amount)

Purity (HPLC): 99,7%

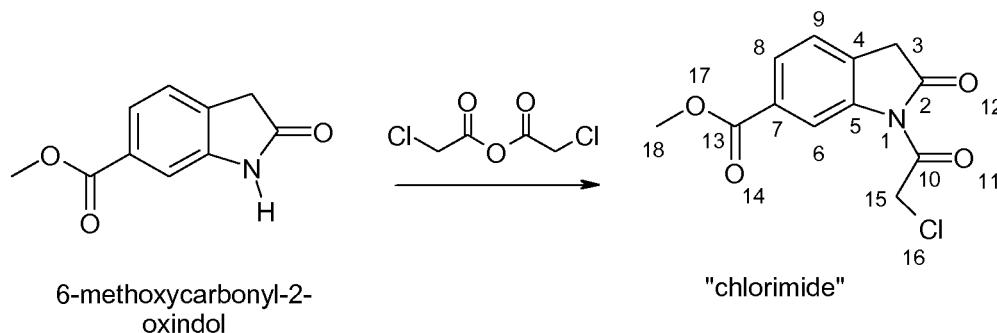
Synthesis of 6-methoxycarbonyl-2-oxindole

A solution of 13kg propanedioic acid, [4-(methoxycarbonyl)-2-nitrophenyl]-, dimethylester (41,77mol) in 88L acetic acid is hydrogenated at 45°C and under 40-50 psi in the presence of 1,3kg Pd/C 10%. After standstill of the hydrogenation, the reaction is heated up to 115°C for 2 hours. The catalyst is filtered off and 180L water is added at about 50°C. The product is isolated after cooling to 5°C, centrifugation and drying at 50°C.

Yield: 6,96kg (87,2% of theoretical amount)

Purity (HPLC): 99,8%

Example 2: Synthesis of the "chlorimide" (methyl-1-(chloroacetyl)-2-oxoindoline-6-carboxylate)



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Method 1

6-methoxycarbonyl-2-oxindole (400 g; 2,071 mol) is suspended in toluene (1200 ml) at room temperature. Chloroacetic anhydride (540 g; 3,095 mol) is added to this suspension. The mixture is heated to reflux for 3 h, then cooled to 80 °C and methyl cyclohexane (600 ml) is added within 30 min. The resulting suspension is further cooled down to room temperature within 60 min. The mother liquor is separated and the solid is washed with ice cold methanol (400 ml). The crystals are dried to afford 515,5 g (93,5 %) of the "chlorimide" compound as a white solid. ¹H-NMR (500 MHz, DMSO-d₆) δ: 8,66 (s, 1 H, 6-H); 7,86 (d, J= 8,3 Hz, 1 H, 8-H); 7,52 (d, J = 8,3 Hz, 1 H, 9-H); 4,98 (s, 2 H, 15-H₂); 3,95 (s, 3 H, 18-H₃); 3,88 (s, 2 H, 3-H₂). ¹³C-NMR (126 MHz, DMSO-d₆) δ: 174,7 (C-2); 36,0 (C-3); 131,0 (C-4); 140,8 (C-5); 115,7 (C-6); 128,9 (C-7); 126,1 (C-8); 124,6 (C-9); 166,6 (C-10); 165,8 (C-13); 46,1 (C-15); 52,3 (C-18). MS: m/z 268 (M+H)⁺. Anal. calcd. for C₁₂H₁₀ClNO₄: C, 53.85; H, 3.77; Cl, 13.25; N, 5.23. Found: C, 52.18; H, 3.64; Cl, 12.89; N, 5.00.

Method 2

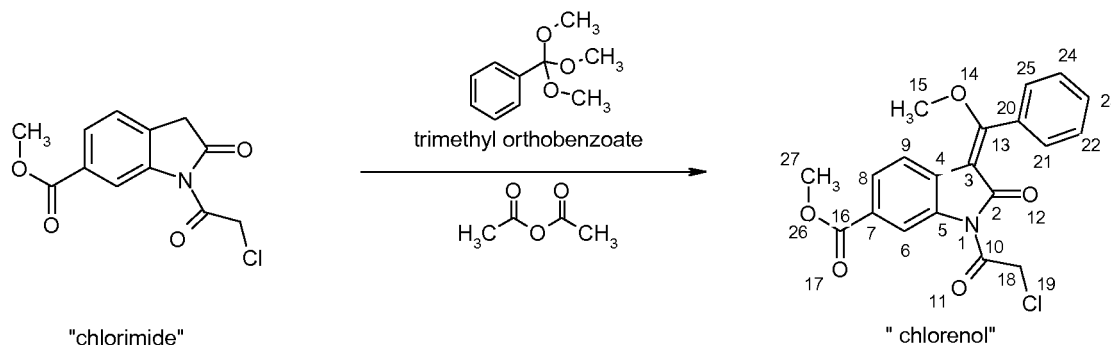
6-Methoxycarbonyl-2-oxindole (10 g; 0,052 mol) is suspended in *n*-butyl acetate (25 ml) at room temperature. To this suspension a solution of chloroacetic anhydride (12,8 g; 0,037 mol) in *n*-butyl acetate (25 ml) is added within 3 min. The mixture is heated to reflux for 2 h, then cooled to 85 °C and methyl cyclohexane (20 ml) is added. The resulting suspension is further cooled down

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to room temperature and stirred for 2 h. The mother liquor is separated and the solid is washed with methanol (400 ml) at ambient temperature. The crystals are dried to afford 12,7 g (91,5 %) of the "chlorimide" compound as a slightly yellow solid.

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Example 3: Synthesis of the "chlorenol" (methyl-1-(chloroacetyl)-3-[methoxy(phenyl)methylene]-2-oxoindoline-6-carboxylate)



Method 1

- 10 Methyl-1-(chloroacetyl)-2-oxoindoline-6-carboxylate (12,0 g; 0,045 mol) is suspended in toluene (60 ml) at ambient temperature. Acetic anhydride (16,2 g; 0,157 mol) is added to this suspension. The mixture is heated to not less than 104 °C and trimethyl orthobenzoate (20,0 g; 0,108 mol) is added within 60 min. During the addition period and subsequent stirring at the same temperature for
- 15 3 h, volatile parts of the reaction mixture are distilled off. The concentration of the reaction mixture is kept constant by replacement of the distilled part by toluene (40 ml). The mixture is cooled down to 5 °C, stirred for 1 h and filtrated. The solid is subsequently washed with toluene (14 ml) and with a mixture of toluene (8 ml) and ethyl acetate (8 ml). After drying, 16,3 g (91,7 %) of the
- 20 "chlorenol" compound are isolated as slightly yellow crystals. ¹H-NMR (500 MHz, DMSO-d₆) δ: 8,73 (d, J = 1,5 Hz, 1 H, 6-H); 8,09 (d, J = 8,0 Hz, 1 H, 9-H); 7,90 (dd, J = 8,1; 1,5 Hz, 1 H, 8-H); 7,61 – 7,48 (m, 5 H, 21-H, 22-H, 23-H, 24-H, 25-H); 4,85 (s, 2 H, 18-H₂); 3,89 (s, 3 H, 27-H₃); 3,78 (s, 3 H, 15-H₃). ¹³C-NMR (126 MHz, DMSO-d₆) δ: 165,9 (C-2 + C16); 103,9 (C-3); 127,4; 128,6; 130,0; 135,4
- 25 (C-4 + C-5 + C-7 + C-20); 115,1 (C-6); 126,1 (C-8); 122,5 (C-9); 166,7 (C-10); 173,4 (C-13); 58,4 (C-15); 46,4 (C-18); 128,6 (C-21 + C-22 + C-24 + C-25); 130,5 (C-23); 52,2 (C-27). MS: m/z 386 (M+H)⁺. Anal. calcd. for C₂₀H₁₆ClNO₅: C, 62.27; H, 4.18; Cl, 9.19; N, 3.63. Found: C, 62.21; H, 4.03; Cl, 8.99; N, 3.52.

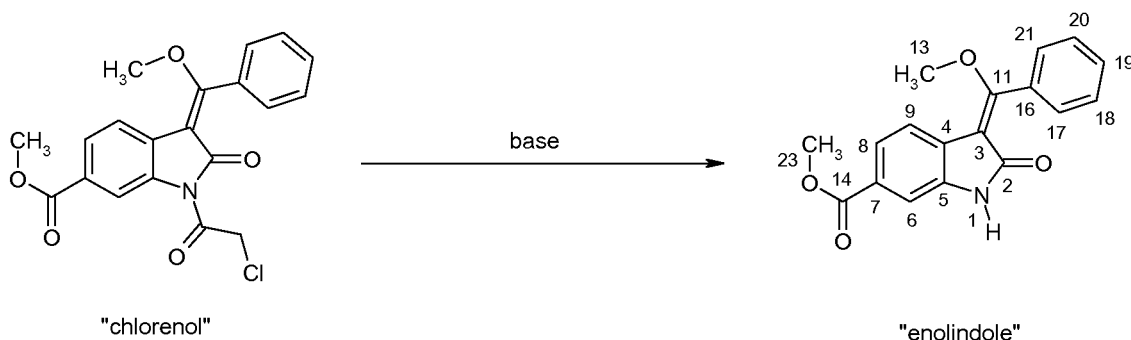
Method 2

Methyl-1-(chloroacetyl)-2-oxoindoline-6-carboxylate (12,0 g; 0,045 mol) is suspended in xylene (60 ml) at ambient temperature. Acetic anhydride (16,2 g; 0,157 mol) is added to this suspension. The mixture is heated to reflux, trimethyl orthobenzoate (20,0 g; 0,108 mol) is added within 40 min and heating is maintained for 4 h. The mixture is cooled down to 0 °C and the mother liquor is separated. The solid is subsequently washed with xylene (14 ml) and a mixture of xylene (8 ml) and ethyl acetate (8 ml). After drying 14,3 g (81,0 %) of the "chlorenol" compound are isolated as yellow crystals.

Method 3

Methyl-1-(chloroacetyl)-2-oxoindoline-6-carboxylate (12,0 g; 0,045 mol) is suspended in toluene (60 ml) at ambient temperature. Acetic anhydride (16,2 g; 0,157 mol) is added to this suspension. The mixture is heated to reflux, trimethyl orthobenzoate (20,0 g; 0,108 mol) is added within 40 min and heating is maintained for 3 h. The mixture is cooled down to 0 °C and the mother liquor is separated. The solid is subsequently washed with toluene (14 ml) and a mixture of toluene (8 ml) and ethyl acetate (8 ml). After drying 15,3 g (87,3 %) of the "chlorenol" compound are isolated as fawn crystals.

Example 4: Synthesis of the "enolindole" (methyl-3-[methoxy(phenyl)methylene]-2-oxoindoline-6-carboxylate)



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Method 1

A solution of potassium hydroxide (0,41 g, 0,006 mol) in methanol (4 ml) is added at 63 °C to a suspension of methyl-1-(chloroacetyl)-3-[methoxy(phenyl)methylene]-2-oxoindoline-6-carboxylate (8,0 g; 0,020 mol) in

methanol (32 ml). The mixture is then stirred for 30 min, cooled to 0 °C and stirring is maintained for 2 h. After filtration, the solid is washed with methanol (24 ml) and dried to afford 6,0 g (94,6 %) of the “enolindole” compound as yellow crystals. ¹H-NMR (500 MHz, CDCl₃) δ: 8.08 (s, 1 H, 1-H); 7,88 (d, J = 7,8 Hz, 1 H, 9-H); 7,75 (m, 1 H, 8-H); 7,52 – 7,56 (m, 3 H, 18-H, 19-H, 20-H); 7,40 – 7,45 (m, 3 H, 6-H, 17-H, 21-H); 3,92 (s, 3 H, 23-H₃); 3,74 (s, 3 H, 13-H₃). ¹³C-NMR (126 MHz, CDCl₃) δ: 168,8 (C-2); 107,4 (C-3); 130,8 (C-4); 138,2 (C-5); 109,4 (C-6); 128,2 and 128,3 (C-7, C-16); 123,5 (C-8); 123,1 (C-9); 170,1 (C-11); 57,6 (C-13); 167,2 (C-14); 128,7 and 128,9 (C-17, C-18, C-20, C-21); 130,5 (C-19); 52,1 (C-23). MS (m/z): 310 (M + H)⁺. Anal. calcd. for C₁₈H₁₅NO₄: C, 69.89; H, 4.89; N, 4.53. Found: C, 69.34; H, 4.92; N, 4.56.

Method 2

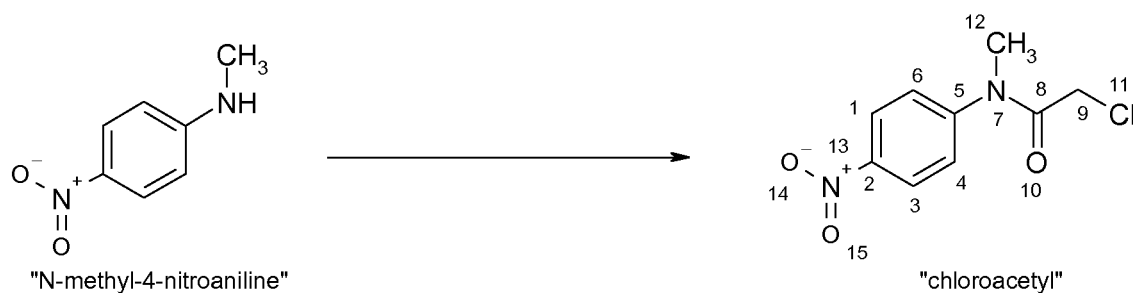
A suspension of methyl-1-(chloroacetyl)-3-[methoxy(phenyl)methylene]-2-oxoindoline-6-carboxylate (7,0 g; 0,018 mol) in methanol (28 ml) is heated to reflux. Within 3 min, a solution of sodium methoxide in methanol (0,24 g, 30 % (w/w), 0,001 mol) is added to this suspension. The mixture is then stirred for 30 min, cooled to 5 °C and stirring is maintained for 2 h. After filtration, the solid is washed with methanol (9 ml) and dried to afford 5,4 g (89,7 %) of the “enolindole” compound as yellow crystals.

Method 3

A suspension of methyl-1-(chloroacetyl)-3-[methoxy(phenyl)methylene]-2-oxoindoline-6-carboxylate (8,0 g; 0,021 mol) in methanol (32 ml) is heated to reflux. A solution of sodium methoxide in methanol (0,74 g, 30 % (w/w), 0,004 mol), further diluted with methanol (4 ml), is added dropwise to this suspension. The mixture is then stirred for 90 min, cooled to 0 °C and stirring is maintained for 2 h. After filtration, the solid is washed with methanol (24 ml) and dried to afford 5,9 g (91,2 %) of the “enolindole” compound as yellow crystals.

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Example 5: Synthesis of the “chloroacetyl” (N-(4-nitroanilino)-N-methyl-2-chloroacetamide)



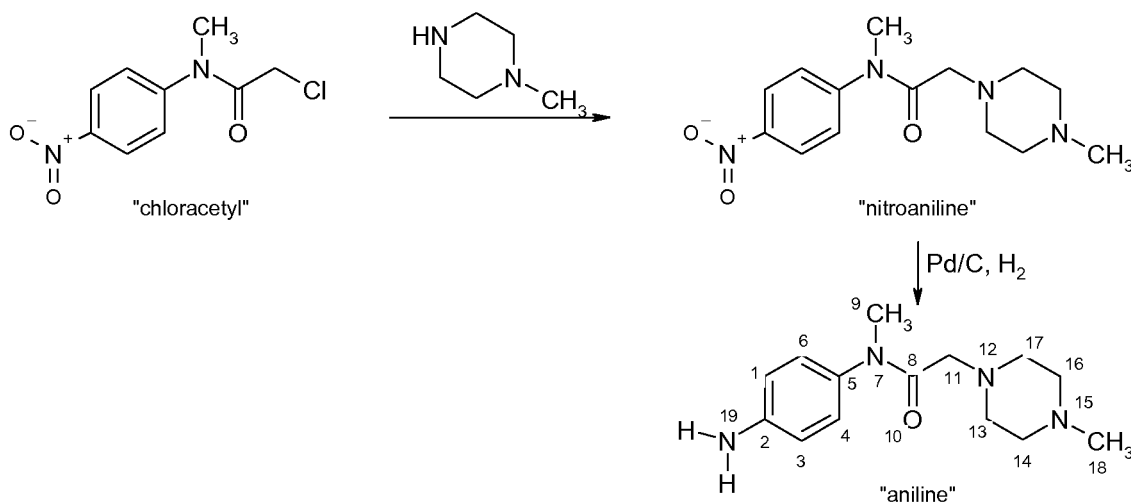
Method 1

A suspension of *N*-methyl-4-nitroaniline (140 g; 0,920 mol) in ethyl acetate (400 ml) is heated to 70 °C. Within 90 min, chloro acetylchloride (114 g; 1,009 mol) is added to this suspension. The resulting solution is then refluxed for 1 h, cooled to 60 °C and methyl cyclohexane (245 ml) is added. The suspension is further cooled down to 0 °C and stirred for 1 h. The reaction mixture is filtrated, washed with methyl cyclohexane (285 ml) and the precipitate is dried to afford 210,4 g (92,7 %) of the "chloroacetyl" compound as white crystals. ¹H-NMR (500 MHz, DMSO-d₆) δ: 8,29 (d, J = 8,5 Hz, 2 H, 1-H + 3-H); 7,69 (d, J = 8,5 Hz, 2 H, 4-H + 6-H); 4,35 (s, 2 H, 9-H₂); 3,33 (s, 3 H, 12-H₃). ¹³C-NMR (126 MHz, DMSO-d₆) δ: 124,6 (C-1 + C-3); 145,6 (C-2); 127,4 (C-4 + C-6); 148,6 (C-5); 165,6 (C-8); 42,7 (C-9); 37,2 (C-12). MS (m/z): 229 (M + H)⁺. Anal. calcd. for C₉H₉ClN₂O₃: C, 47,28; H, 3,97; N, 12,25. Found: C, 47,26; H, 3,99; Cl, 15,73; N, 12,29.

Method 2

A suspension of *N*-methyl-4-nitroaniline (20,0 g; 0,131 mol) in ethyl acetate (20 ml) is heated to 60 °C. Within 15 min, a solution of chloro acetic anhydride (26,0 g; 0,151 mol) in ethyl acetate (60 ml) is added to this suspension. The resulting solution is then refluxed for 1 h, cooled to 75 °C and methyl cyclohexane (80 ml) is added. After seeding at 60 °C, the suspension is further cooled down to 0 °C and stirred for 1 h. The reaction mixture is filtrated, washed with methyl cyclohexane (40 ml) and the precipitate is dried to afford 25,9 g (83,3 %) of the "chloroacetyl" compound as grey crystals.

Example 6: Synthesis of the "nitroaniline" (N-(4-nitrophenyl)-N-methyl-2-(4-methylpiperazin-1-yl)acetamide) and of the "aniline" (N-(4-aminophenyl)-N-methyl-2-(4-methylpiperazin-1-yl)acetamide)



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Method 1

A suspension of N-(4-nitroanilino)-N-methyl-2-chloro-acetamide (20,0 g; 0,087 mol) in toluene (110 ml) is heated to 40 °C. Within 30 min, 1-methylpiperazine (21,9 g; 0,216 mol) is added dropwise. After purging of the dropping funnel with toluene (5 ml) the reaction mixture is stirred for 2 h at 55 °C, cooled to ambient temperature and washed with water (15 ml). The organic layer is diluted with isopropanol (100 ml) and Pd/C (10%; 1,0 g) is added. After subsequent hydrogenation (H₂, 4 bar) at 20 °C the catalyst is removed. Approximately 4/5 of the volume of the resulting solution is evaporated at 50 °C. The remaining residue is dissolved in ethyl acetate (20 ml) and toluene (147 ml) heated to 80 °C, then cooled to 55 °C and seeded. The reaction mixture is further cooled to 0 °C and stirred for 3 h at the same temperature. After filtration, the solid is washed with ice cold toluene (40 ml) and dried to afford 20,2 g (88,0 %) of the "aniline" compound as white crystals.

¹H-NMR (500 MHz, DMSO-d₆) δ: 6,90 (d, J = 8,5 Hz, 2 H, 4-H + 6-H); 6,65 (d, J = 8,5 Hz, 2 H, 1-H + 3-H); 5,22 (2 H, 19-H₂); 3,04 (s, 3 H, 9-H₃); 2,79 (s, 2 H, 11-H₂); 2,32 (m, 4 H, 13-H₂ + 17-H₂); 2,23 (m, 4 H, 14-H₂ + 16-H₂); 2,10 (s, 3 H, 18-H₃). ¹³C-NMR (126 MHz, DMSO-d₆) δ: 114,0 (C-1 + C-3); 148,0 (C-2); 127,6 (C-4 + C-6); 131,5 (C-5); 168,9 (C-8); 36,9 (C-9); 58,5 (C-11); 52,4 (C-13 + C-

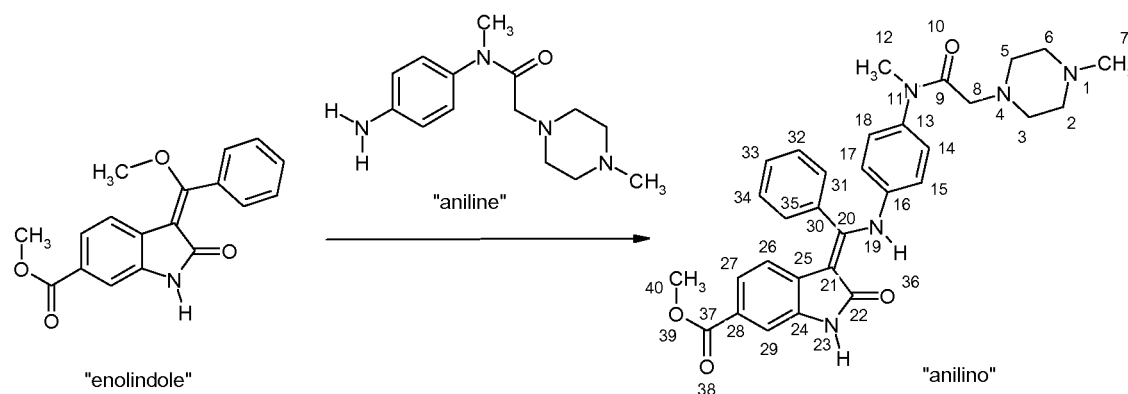
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17); 54,6 (C-14 + C-16); 45,7 (C-18). MS (m/z): 263 (M + H)⁺. Anal. calcd. for C₁₄H₂₂N₄O: C, 64.09; H, 8.45; N, 21.36. Found: C, 64.05; H, 8.43; N, 21.39.

Method 2

- 5 A suspension of N-(4-nitroanilino)-N-methyl-2-chloro-acetamide (14,5 g; 0,063 mol) in ethyl acetate (65 ml) is heated to 40 °C. Within 30 min, 1-methylpiperazine (15,8 g; 0,156 mol) is added dropwise. After purging of the dropping funnel with ethyl acetate (7 ml) the reaction mixture is stirred at 50 °C for 90 min, cooled to ambient temperature and washed with water (7 ml). The organic layer is diluted with isopropanol (75 ml) and dried over sodium sulphate. After separation of the solid, Pd/C (10%; 2,0 g) is added and the solution is hydrogenated (H₂, 5 bar) at ambient temperature without cooling. Subsequently the catalyst is removed by filtration and the solvent is evaporated at 60 °C. The remaining residue is dissolved in ethyl acetate (250 ml) and recrystallized. After filtration and drying 10,4 g (60,4 %) of the "aniline" compound are isolated as white crystals.

Example 7: Synthesis of the "anilino" (3-Z-[1-(4-(N-((4-methyl-piperazin-1-yl)-methylcarbonyl)-N-methyl-amino)-anilino)-1-phenyl-methylene]-6-methoxycarbonyl-2-indolinone)



Method 1

- A suspension of methyl-3-[methoxy(phenyl)methylene]-2-oxoindoline-6-carboxylate (10,0 g; 0,032 mol) and N-(4-aminophenyl)-N-methyl-2-(4-methylpiperazin-1-yl)acetamide (8,6 g; 0,032 mol) in a mixture of methanol (72 ml) and N,N-dimethylformamide (18 ml) is heated to reflux. After 7 h of refluxing the suspension is cooled down to 0 °C and stirring is maintained for

additional 2 h. The solid is filtered, washed with methanol (40 ml) and dried to afford 15,4 g (88,1 %) of the "anilino" compound as yellow crystals. ¹H-NMR (500 MHz, DMSO-d₆) δ: 11,00 (s, 1 H, 23-H); 12,23 (s, 19-H); 7,61 (t; J = 7,1 Hz, 1 H, 33-H); 7,57 (t, J = 7,5 Hz, 2 H, 32-H + 34-H); 7,50 (d, J = 7,7 Hz, 2 H, 31-H + 35-H); 7,43 (d, J = 1,6 Hz, 1 H, 29-H); 7,20 (dd, J = 8,3; 1,6 Hz, 1 H, 27-H); 7,13 (d, J = 8,3 Hz, 2 H, 14-H + 18-H); 6,89 (d, 8,3 Hz, 2 H, 15-H + 17-H); 5,84 (d, J = 8,3 Hz, 1 H, 26-H); 3,77 (s, 3 H, 40-H₃); 3,06 (m, 3 H, 12-H₃); 2,70 (m, 2 H, 8-H₂); 2,19 (m, 8 H, 2-H₂, 3-H₂, 5-H₂, 6-H₂); 2,11 (s, 3 H, 7-H₃). ¹³C-NMR (126 MHz, DMSO-d₆) δ: 54,5 (C-2 + C-6); 52,2 (C-3 + C-5); 45,6 (C-7); 59,1 (C-8); 168,5 (C-9); 36,6 (C-12); 140,1 (C-13); 127,6 (C-14 + C-18); 123,8 (C-17 + C-15); 137,0 (C-16); 158,3 (C-20); 97,5 (C-21); 170,1 (C-22); 136,2 (C-24); 128,9 (C-25); 117,2 (C-26); 121,4 (C-27); 124,0 (C-28); 109,4 (C-29); 131,9 (C-30); 128,4 (C-31 + C-35); 129,4 (C-32 + C-34); 130,4 (C-33); 166,3 (C-37); 51,7 (C-40). MS (m/z): 540 (M + H)⁺. Anal. calcd. for C₃₁H₃₃N₅O₄: C, 69.00; H, 6.16; N, 12.98. Found: C, 68.05; H, 6.21; N, 12.81.

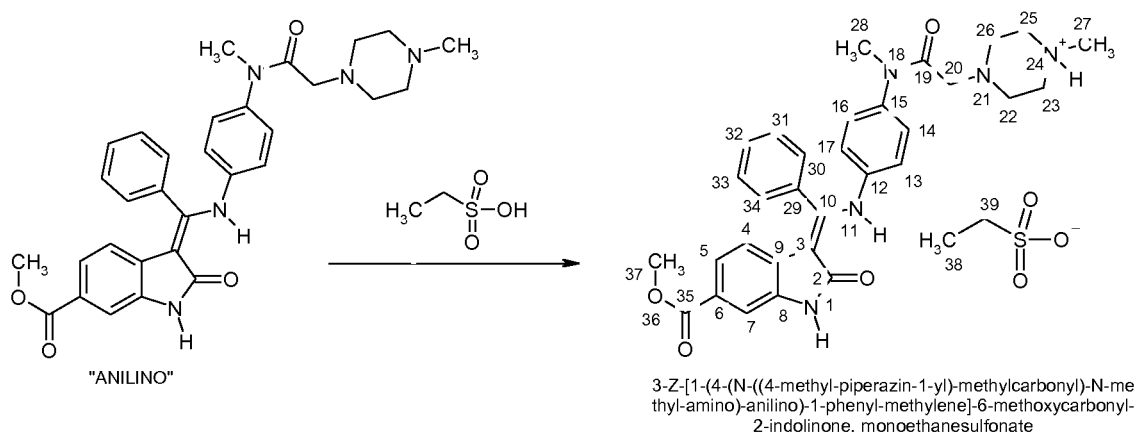
Method 2

A suspension of methyl-3-[methoxy(phenyl)methylene]-2-oxoindoline-6-carboxylate (20,0 g; 0,064 mol) and N-(4-aminophenyl)-N-methyl-2-(4-methylpiperazin-1-yl)acetamide (17,1 g; 0,065 mol) in methanol (180 ml) is heated to reflux for 7,5 h. The resulting suspension is cooled down to 10 °C within 1 h and stirring is maintained for 1 h. After filtration, the solid is washed with ice cold methanol (80 ml) and dried to afford 31,0 g (89,0 %) of the "anilino" compound as yellow crystals.

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Example 8: Synthesis of the 3-Z-[1-(4-(N-((4-methyl-piperazin-1-yl)-methylcarbonyl)-N-methyl-amino)-anilino)-1-phenyl-methylene]-6-

methoxycarbonyl-2-indolinone, monoethanesulfonate

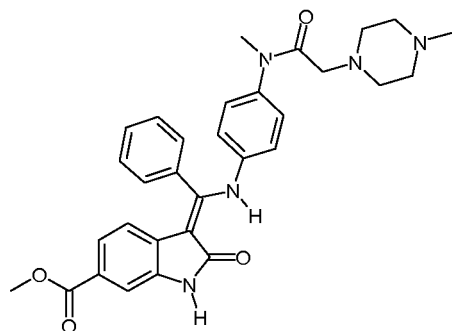


- A suspension of 3-Z-[1-(4-(N-((4-methyl-piperazin-1-yl)-methylcarbonyl)-N-methyl-amino)-anilino)-1-phenyl-methylene]-6-methoxycarbonyl-2-indolinone (30,0 g; 0,055 mol) in methanol (200 ml) and water (2,4 ml) is heated to 60 °C. Aqueous ethanesulfonic acid (70% (w/w); 8,75 g; 0,056 mol) is added to the reaction mixture. The resulting solution is cooled to 50 °C, seeded and then diluted with isopropanol (200 ml). The mixture is further cooled to 0 °C and stirred for 2 h at this temperature. The precipitate is isolated, washed with isopropanol (120 ml) and dried to furnish 35,1 g (97,3 %) of the monoethanesulfonate salt of the compound as yellow crystals. ¹H-NMR (400 MHz, DMSO-d₆) δ: 12,26 (s, 11-H); 10,79 (s, 1 H, 1-H); 9,44 (s, 1 H, 24-H); 7,64 (m, 1 H, 32-H); 7,59 (m, 2 H, 31-H + 33-H); 7,52 (m, 2 H, 30-H + 34-H); 7,45 (d, J = 1,6 Hz, 1 H, 7-H); 7,20 (dd, J = 8,2; 1,6 Hz, 1 H, 5-H); 7,16 (m, 2 H, 14-H + 16-H); 6,90 (m, 2 H, 13-H + 17-H); 5,85 (d, J = 8,2 Hz, 1 H, 4-H); 3,78 (s, 3 H, 37-H₃); 3,45 – 2,80 (broad m, 4 H, 23-H₂ + 25-H₂); 3,08 (s, 3 H, 28-H₃); 2,88 (s, 2 H, 20-H₂); 2,85 – 2,30 (broad m, 4 H, 22-H₂ + 26-H₂); 2,75 (s, 3 H, 27-H₃); 2,44 (q, J = 7,4 Hz, 2 H, 39-H₂); 1,09 (t, J = 7,4 Hz, 3 H, 38-H₃). ¹³C-NMR (126 MHz, DMSO-d₆) δ: 9,8 (C-38); 36,6 (C-28); 42,3 (C-27); 45,1 (C-39); 51,7 (C-37); 48,9 (C-22 + C-26); 52,6 (C-23 + C-25); 57,5 (C-20); 97,7 (C-3); 109,5 (C-7); 117,3 (C-4); 121,4 (C-5); 123,8 (C-13 + C-17); 124,1 (C-6); 127,7 (C-14 + C-16); 128,4 (C-30 + C-34); 128,8 (C-9); 129,5 (C-31 + C-33); 130,5 (C-32); 132,0 (C-29); 168,5 (C-9); 136,3 (C-8); 137,3 (C-12); 139,5 (C-15); 158,1 (C-10); 166,3 (C-35); 168,0 (C-19); 170,1 (C-2). MS (m/z): 540 (M_(base) + H)⁺. Anal.

calcd. for $C_{33}H_{39}N_5O_7S$: C, 60.17; H, 6.12; N, 10.63; S, 4.87. Found: C, 60.40; H, 6.15; N, 10.70; S, 4.84.

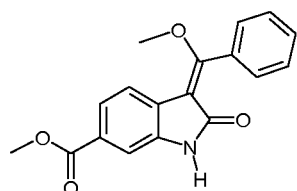
CLAIMS

1. Process for the manufacture of a compound of formula

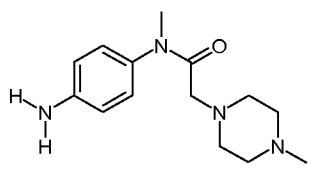


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comprising the step of reacting a compound of formula

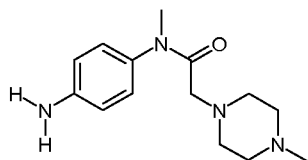


with a compound of formula

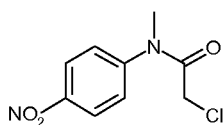


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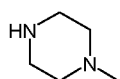
2. Process in accordance with claim 1, in which the compound of formula



is obtained by reacting a compound of formula

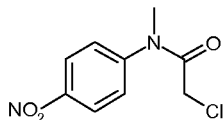


- 15 with a compound of formula

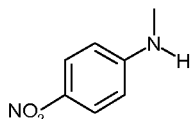


and subsequent hydrogenation of the nitro group in an amino group.

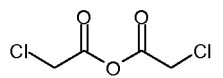
3. Process in accordance with claim 2, in which the compound of formula



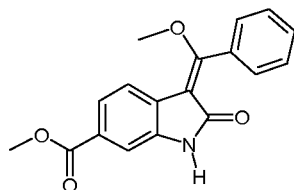
5 is obtained by reacting a compound of formula



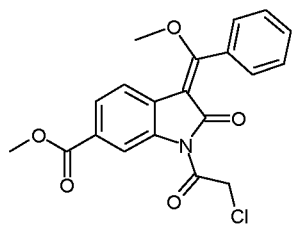
with a compound of formula



10 4. Process in accordance with any one of claims 1 to 3, in which the compound of formula

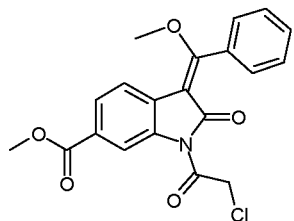


is obtained by base catalyzed dechloroacetylation of a compound of formula

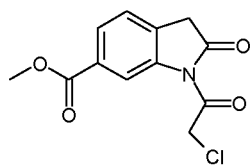


15

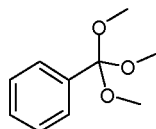
5. Process in accordance with claim 4, in which the compound of formula



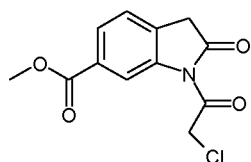
is obtained by reacting a compound of formula



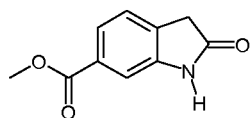
with a compound of formula



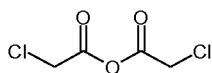
- 5 6. Process in accordance with claim 5, in which the compound of formula



is obtained by reacting a compound of formula

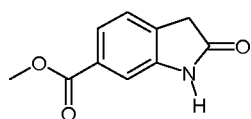


with a compound of formula



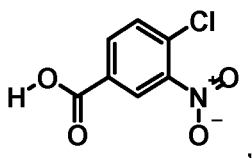
10

7. Process in accordance with claim 6, in which the compound of formula

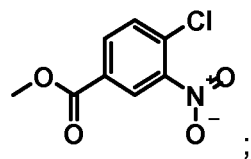


is obtained by the following steps:

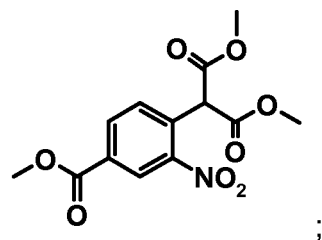
- 15 (i) esterification of a compound of formula



to obtain a compound of formula

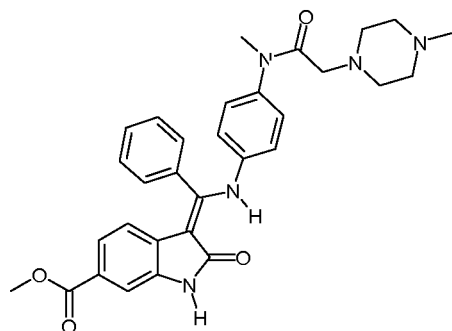


(ii) reacting the product of the reaction (i) with malonic acid dimethylester, to obtain a compound of formula



5 (iii) performing a cyclisation of the product of the reaction (ii) by a reaction of hydrogenation.

8. Process in accordance with any one of claims 1 to 7, in which the compound of formula



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is reacted with EtSO_3H in order to obtain a monoethanesulfonate salt of this compound.

9. Process in accordance with claim 8, which further comprises a step of
15 milling of the monoethanesulfonate salt of the compound.