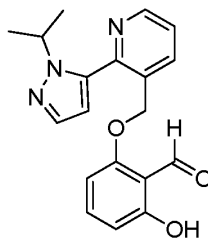


What is claimed is:

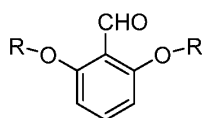
1. A process of synthesizing Compound (I):



(I)

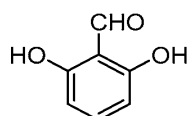
- 5 the process comprising:

Step (i): treating a compound of formula (2):



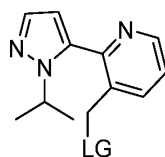
(2)

- wherein each R is $-\text{CH}(\text{CH}_2\text{R}^1)-\text{OR}^2$ or tetrahydropyran-2-yl optionally substituted with
 10 one, two, or three alkyl; and wherein R^1 is hydrogen or alkyl, and R^2 is alkyl;
 with an acid to provide compound (1):



(1)

- 15 Step (ii): reacting compound (1) with a compound of formula (3)

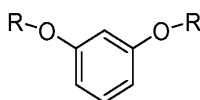


(3)

wherein LG is a leaving group under alkylation reacting conditions to provide Compound
 (I); and

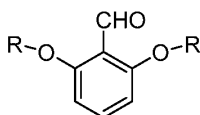
Step (iii): optionally crystallizing Compound (I) from Step (ii) from heptane and methyl *tert*-butyl ether at 45° +/- 5 °C to 55° +/- 5 °C.

2. The process of claim 1 further comprising formylating a compound of formula (4):



(4)

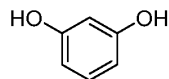
to provide the compound of formula (2):



(2)

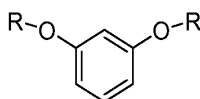
wherein each R in compound of formulae (2) and (4) is $-\text{CH}(\text{CH}_2\text{R}^1)-\text{OR}^2$ or tetrahydropyran-2-yl optionally substituted with one, two, or three alkyl; and R^1 is hydrogen or alkyl, and R^2 is alkyl.

3. The process of claim 2 further comprising reacting compound (5):



(5)

with a vinyl ether of formula $\text{CHR}^1=\text{CHOR}^2$ (wherein R^1 is hydrogen or alkyl and R^2 is alkyl), or 3,4-dihydro-2H-pyran optionally substituted with one, two or three alkyl, in the presence of a weak acid to provide the compound of formula (4):



(4)

wherein each R is $-\text{CH}(\text{CH}_2\text{R}^1)-\text{OR}^2$ (where R^1 is hydrogen or alkyl and R^2 is alkyl) or tetrahydropyran-2-yl optionally substituted with one, two, or three alkyl.

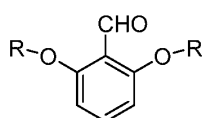
4. The process of claim 3 wherein compound (4) is treated *in situ* with a formylating agent to provide compound (2).
5. The process of claim 1 or 2 wherein compound (2) is treated *in situ* with an acid to provide compound (1).
- 5 6. The process of any one of claim 1 to 5 wherein Compound (I) is crystallized from heptane and methyl *tert*-butyl ether at 45° +/-5 °C to 55 +/-5 °C to give Compound (I) in substantially pure Form II characterized by a XRPD pattern comprising a X-ray powder diffraction peak (Cu K α radiation) at one or more of 13.37°, 14.37°, 19.95° or 23.92 $\pm$ 0.2 °2 θ .
- 10 7. The process of claim 6 wherein Compound (I) is crystallized at 45 °C to 55 °C to give Compound (I) wherein at least 95% by wt of Compound (I) is Form II.
8. The process of any one of claims 1 to 7 wherein LG is chloro-
9. The process of any one of claims 1-8 wherein R is -CH(CH₃)-O-CH₂CH₃.
10. The process of any one of claims 1-9 wherein the acid for removal of the R groups is an inorganic acid.
- 15 11. The process of claim 10 wherein the acid is hydrochloric acid.
12. The process of any one of claims 1-11 wherein LG is chloro and the alkylation reaction is carried out in N-methyl-2-pyrrolidinone in the presence of sodium bicarbonate and a catalytic amount of NaI.
- 20 13. The process of any one of claims 1-11 wherein LG is chloro and the alkylation reaction is carried out in N-methyl-2-pyrrolidinone in the presence of sodium bicarbonate and a catalytic amount of NaI and Compound (I) is crystallized from the reaction mixture by addition of water at 40 °C to 50° C to give substantially pure Form I characterized by a XRPD pattern comprising a X-ray powder diffraction peak (Cu K α radiation) at one or more of 12.82°, 15.74°, 16.03°, 16.63°, 17.60°, 25.14°, 25.82° and 26.44° $\pm$ 0.2 °2 θ .
- 25 14. The process of any one of claims 1-11 wherein LG is chloro and the alkylation reaction is carried out in N-methyl-2-pyrrolidinone in the presence of sodium bicarbonate and a catalytic amount of NaI and Compound (I) is crystallized from the reaction mixture by addition of water at 40 °C to 46° C to give Compound (I) that at least 95% by weight Form I characterized

by a XRPD pattern comprising a X-ray powder diffraction peak (Cu K α radiation) at one or more of 12.82°, 15.74°, 16.03°, 16.63°, 17.60°, 25.14°, 25.82° and 26.44° $\pm$ 0.2 °2 θ .

15. The process of any one of claims 3-14 wherein the weak acid is pyridinium tosylate.

5 16. The process of any one of claims 2-15 wherein the formylating agent is n-BuLi and DMF.

17. An intermediate of formula (2):



(2)

10 wherein each R is $-\text{CH}(\text{CH}_2\text{R}^1)\text{OR}^2$; and

wherein R¹ is hydrogen or alkyl, and R² is alkyl.