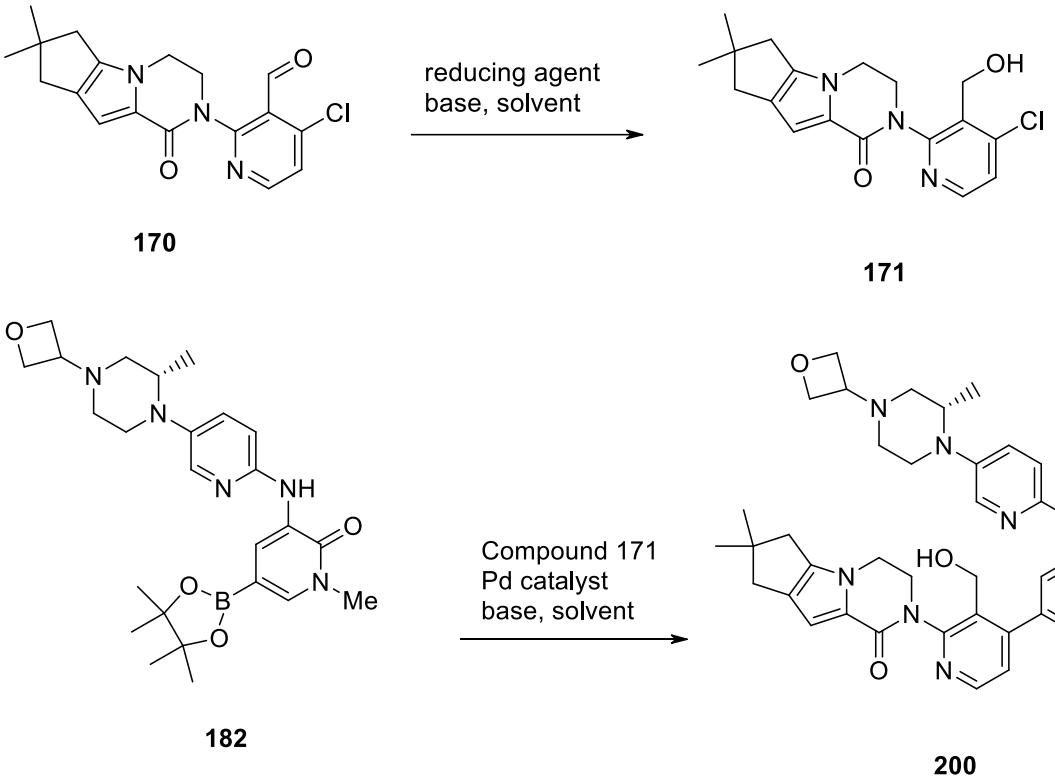


170 **171**

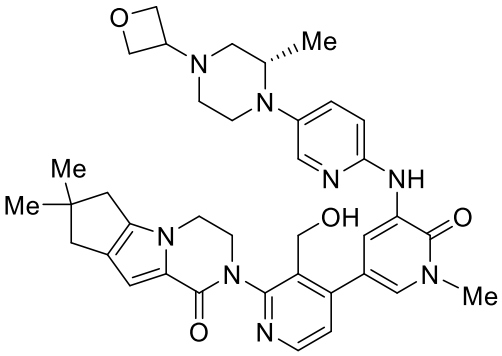
182 **200**

,

wherein the reducing agent in step (i) is $NaBH_4$, and wherein the ratio of compound 182 to compound 171 is greater than 1:1.

WHAT IS CLAIMED IS:

1. A method of preparing compound 200, or salt thereof,



200

,

the method comprising:

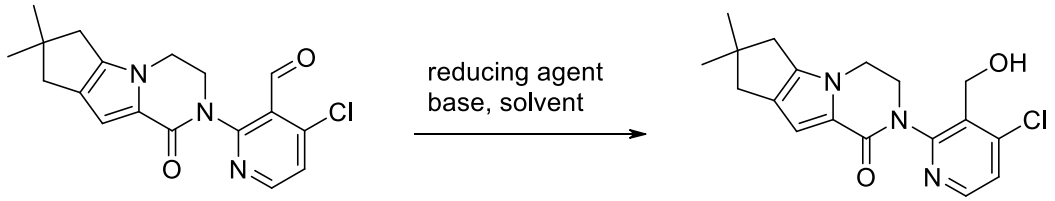
(i) (1) forming a first reaction mixture comprising compound 170, a reducing agent, a base and a solvent, to reduce the aldehyde moiety of compound 170 to form compound 171, and

(2) isolating compound 171 from the first product mixture,

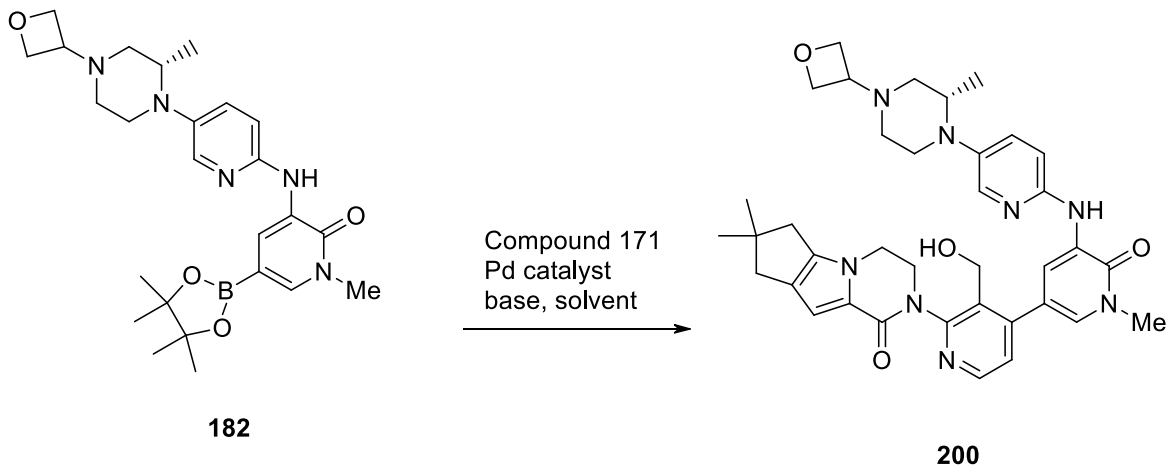
(ii) (1) forming a second reaction mixture comprising compound 171, compound 182, a palladium catalyst, a solvent system comprising water, and a base, to form compound 200, and

(2) isolating compound 200, or salt thereof, from the second product mixture,

according to the following scheme:



170 **171**



182 200

,

wherein the reducing agent in step (i) is $NaBH_4$, and wherein the ratio of compound 182 to compound 171 is greater than 1:1.

2. The method of claim 1, wherein the base in step (i) is K_2HPO_4.

3. The method of claim 1 or 2, wherein the solvent in step (i) is THF.

4. The method of any of claims 1 to 3, wherein the Pd catalyst in step (ii) is $Pd(PCy_3)_2$.

5. The method of any of claims 1 to 4, wherein the base in step (ii) is K_3PO_4, Et_3N or di-isopropylethylamine.

6. The method of any of claims 1 to 5, wherein the equivalent ratio of the Pd catalyst to compound 171 is less than 0.05:1.

7. The method of any of claims 1 to 6, wherein: the base in step (i) is K_2HPO_4; and the solvent in step (i) is THF.

8. The method of any of claims 1 to 7, wherein: the base in step (ii) is K_3PO_4, Et_3N or di-isopropylethylamine; and the equivalent ratio of the Pd catalyst to compound 171 is less than 0.05:1.

9. The method of any of claims 1 to 8, wherein:

the base in step (i) is K_2HPO_4;

the solvent in step (i) is THF;

the Pd catalyst in step (ii) is $Pd(PCy_3)_2$;

the base in step (ii) is K_3PO_4, Et_3N or di-isopropylethylamine; and

the equivalent ratio of the Pd catalyst to compound 171 is less than 0.05:1.