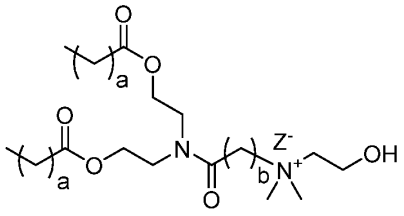
CLAIMS

WHAT IS CLAIMED IS:

1. A process for synthesizing a compound of Formula I



I

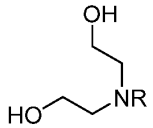
wherein **a** is an integer from 8-14;

**b** is an integer from 1-3; and

Z is a counterion

the process comprising,

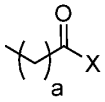
a) reacting a compound of Formula II



II

wherein R is a protecting group;

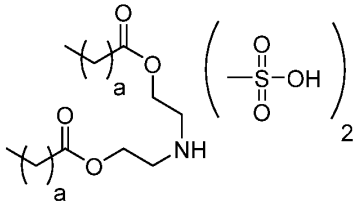
with a compound of Formula III



III

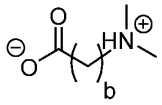
wherein X is a halogen;

to form a compound of Formula IV



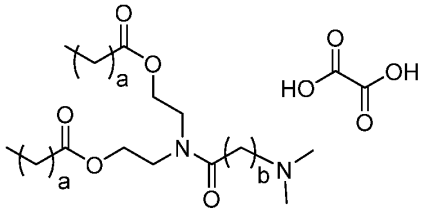
IV

b) reacting a compound of Formula IV with a compound of Formula V



V

to form a compound of Formula VI



VI

and

c) reacting a compound of Formula VI with bromoethanol under coupling conditions to form a compound of Formula I.

2. The process of claim 1 wherein **a** is 12.

3. The process of claim 1 wherein **b** is 2.

4. The process of claim 1 wherein R is selected from the group consisting of carboxybenzyl, *p*-methoxybenzyl carbonyl, *t*-butyloxycarbonyl, 9-fluorenylmetholoxycarbonyl, acetyl, trifluoroacetyl, benzoyl, benzyl, carbamate, *p*-methoxybenzyl, 3,4-dimethoxybenzyl, *p*-methoxybenzyl, tosyl, tricloroethyl chloroformate, (4-nitrophenyl)sulfonyl, methyl, ethyl, propyl, *n*-butyl, *t*-butyl, succinimide, 2,6-dimethylphenol, 2,6-diisopropylphenol, 2,6-di-*tert*-butylphenol, trimethylsilyl, allyl, 1,1-dimethylallyl, 2,2,2-trifluoro ethyl, phenyl, and 4-methoxybenzyl.

5. The process of claim 4 wherein R is *t*-butyloxycarbonyl.

6. The process of claim 1 wherein X is Cl or Br.

7. The process of claim 6 wherein X is Cl.

8. The process of claim 1 wherein Z is $Cl^-$ or $Br^-$.

9. The process of claim 8 wherein Z is $Br^-$.

10. The process of claim 1 wherein the yield of step a) is at least about 80%.

11. The process of claim 1 wherein the yield of step b) is at least about 80%.

12. The process of claim 1 wherein in step c) bromoethanol is used in between about 2 and about 4 equivalents and the compound of Formula VI is used in about 1 equivalent.

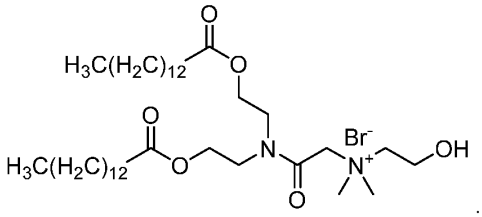
13. The process of claim 12 wherein in step c) bromoethanol is used in about 2.2 equivalents.

14. The process of claim 1 wherein the compound of Formula IV is isolated as a solid.

15. The process of claim 14 wherein the compound of Formula IV is isolated as a crystalline solid.

16. The process of claim 16 wherein the compound of Formula VI is isolated as a crystalline solid.

17. The process of claim 1 wherein the compound of Formula I is



18. The process of claim 1 wherein the compound of Formula I is produced in at least about 60% yield from the compound of Formula II.

19. A compound of Formula I prepared by the process of claim 1.

20. The compound of claim 19 that is

