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(54) Title: PROCESS FOR THE PREPARATION OF 2-(CYCLOHEXYLMETHYL)-*N*-{2- [(2*S*)-1-METHYLPYRROLIDIN-2-YL]ETHYL}-1, 2, 3, 4- TETRAHYDROISOQUINOLINE-7-SULFONAMIDE

(57) Abstract: Industrially applicable process for preparing 2-(cyclohexylmethyl)-*N*-{2-[(2S)-1- methylpyrrolidin-2-yl]ethyl}-1,2,3,4-tetrahydroisoquinoline-7-sulfonamide, and salts thereof, comprising a) coupling (-)-2-(2-aminoethyl)-1-methylpyrrolidine with an amine-protected tetrahydroquinoline-7-sulfonyl chloride to give an amine-protected *N*-{2-[(2S)-1- methylpyrrolidin-2-yl]ethyl}-1,2,3,4-tetrahydroisoquinoline-7-sulfonamide; b) deprotecting the amine-protected *N*-{2-[(2S)-1-methylpyrrolidin-2-yl]ethyl}-1,2,3,4-tetrahydroisoquinoline-7-sulfonamide to give *N*-{2-[(2S)-1- methylpyrrolidin-2-yl]ethyl}-1,2,3,4-tetrahydroisoquinoline-7-sulfonamide or a salt thereof; c) reductively aminating *N*-{2-[(2S)-1-methylpyrrolidin-2-yl]ethyl}-1,2,3,4- tetrahydroisoquinoline-7-sulfonamide or a salt thereof with cyclohexanecarboxaldehyde to form 2-(cyclohexylmethyl)-*N*-{2-[(2S)-1-methylpyrrolidin-2-yl]ethyl}-1,2,3,4-tetrahydroisoquinoline-7-sulfonamide; d) optionally reacting 2-(cyclohexylmethyl)-*N*-{2-[(2S)-1-methylpyrrolidin-2-yl]ethyl}-1,2,3,4-tetrahydroisoquinoline-7-sulfonamide, or a hydrate or solvate thereof, with a stoichiometric amount or an excess of a salt-forming acid in a solvent to form a salt or a hydrate or solvate thereof, and e) optionally recrystallizing the product of step d).