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(54) Title: PROCESS FOR MANUFACTURING 3(R)-(2-HYDROXY-2,2-DITHIEN-2-YLACETOXY)-1-(3- PHENOXYPROPYL)-1 -AZONIABICYCLO[2.2.2]OCTANE BROMIDE

(57) Abstract: This invention is directed to a process for manufacturing 3(R)-(2-hydroxy-2,2- dithien-2-ylacetoxy)-1-(3-phenoxypropyl)-1-azoniabicyclo[2.2.2]octane bromide by reacting 2-hydroxy-2,2-dithien-2-ylacetic acid 1 -azabicyclo[2.2.2]oct-3(R)yl ester and 3-phenoxypropyl bromide, wherein the reaction takes place in a solvent or mixtures of solvents having a boiling point between 50 and 210°C and selected from the group consisting of ketones and cyclic ethers.