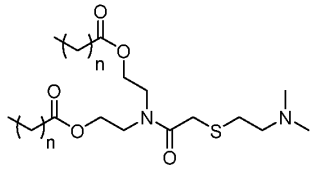
CLAIMS

WHAT IS CLAIMED IS:

1. A process for synthesizing a compound of Formula I

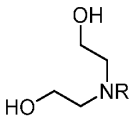


I

wherein n is an integer from 8-16,

the process comprising,

a) reacting a compound of Formula II



II

wherein R is a protecting group;

with a compound of Formula III

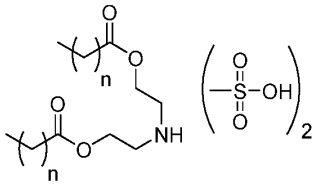


III

wherein n is an integer from 8-16,

and X is a halogen;

followed by treatment with methane sulfonic acid, to form a compound of Formula IV



IV

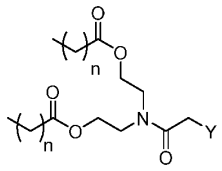
b) reacting a compound of Formula IV with a compound of Formula V



V

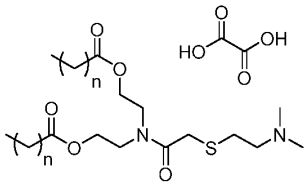
wherein each Y is independently a halogen;

to form a compound of Formula VI



VI

c) reacting a compound of Formula VI under coupling conditions with 2-(dimethylamino)ethanethiol HCl, followed by treatment with oxalic acid, to form a compound of Formula VII



VII

d) reacting a compound of Formula VII with a base to produce a compound of Formula I.

2. The process of claim 1, wherein the coupling conditions of step b) comprise reacting a compound of Formula IV with a base.

3. The process of claim 2, wherein the base is triethylamine.

4. The process of claim 1, the coupling conditions of step c) comprise reacting a compound of Formula VI with a base.

5. The process of claim 4, wherein the base is triethylamine.

6. The process of claim 1, wherein n is 12.

7. 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.

8. The process of claim 7 wherein R is *t*-butyloxycarbonyl.

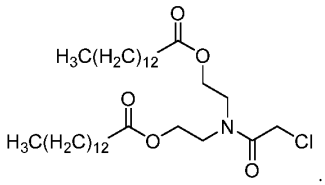
9. The process of claim 1 wherein each Y is independently selected from Cl, Br, and I.

10. The process of claim 9 wherein each Y is Cl.

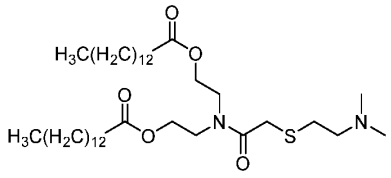
11. The process of claim 1 wherein X is selected from Cl, Br, and I.

12. The process of claim 11 wherein X is Cl.

13. The process of claim 1 wherein the compound of Formula VI is the compound



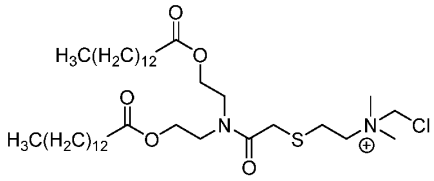
14. The process of claim 1, wherein the compound of Formula I is the compound



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

16. 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.

17. The process of claim 1 wherein a compound VIII



VIII

is present in the product from step d) in a concentration of less than 100 ppm.

18. The process of claim 1 wherein the compound of Formula VII is isolated as a crystalline solid.

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

20. The compound of claim 19 that is

