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(71) Applicants *(for all designated States except US)*: **PFIZER PRODOUCTS, INC** [US/US]; Eastern Point Road, Groton, CT 06340 (US). **DSM PHARMACEUTICALS, INC.** [US/US]; 5900 N.W. Greenville Boulevard, Greenville, NC 27834 (US).

(72) Inventors; and

(75) Inventors/Applicants *(for US only)*: **NUGENT, Thomas, C.** [US/US]; 1526 48th Avenue, San Francisco, CA 94122 (US). **SEEMAYER, Robert** [US/US]; CV Therapeutics, 3172 Porter Drive, Palo Alto, CA 94304 (US).

(74) Agents: **RICHARDS, John** et al.; Ladas & Parry, 26 West 61st Sreet, New York, NY 10023 (US).

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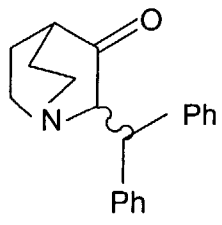
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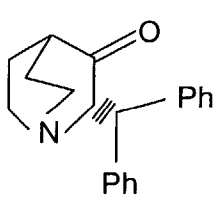
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(54) Title: PROCESS FOR THE PREPARATION OF (S,S)-CIS-2-BENZHYDRYL-3-BENZYLAMINOQUINUCLIDINE





(57) Abstract: A process for preparing (S,S)-cis-2-benzhydryl-3-benzylaminoquinuclidine. The process includes the steps of contacting a compound containing a mixture of R- and S-isomers and having Formula (I), with an effective amount of a chiral organic acid in the presence of an organic solvent and an effective amount of an organic carboxylic acid for converting the R-isomer into an acid salt of the S isomer, wherein the organic solvent is capable of solubilizing the compound containing the mixture of R- and S-isomers, while precipitating the acid salt and the organic carboxylic acid is different from the chiral organic acid; neutralizing the acid salt with a base to provide an S-isomer of a chiral ketone of Formula (II), and reacting the chiral ketone with an organic amine in the presence of a Lewis acid to provide the corresponding imine and reducing the imine.