



INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁶ : C07J 73/00, 1/00, C07C 59/205	A2	(11) International Publication Number: WO 99/32507 (43) International Publication Date: 1 July 1999 (01.07.99)
(21) International Application Number: PCT/US98/27136 (22) International Filing Date: 18 December 1998 (18.12.98) (30) Priority Data: 60/068,536 23 December 1997 (23.12.97) US (71) Applicant (for all designated States except US): MERCK & CO., INC. [US/US]; 126 East Lincoln Avenue, Rahway, NJ 07065 (US). (72) Inventors; and (75) Inventors/Applicants (for US only): HUMPHREY, Guy, R. [GB/US]; 126 East Lincoln Avenue, Rahway, NJ 07065 (US). MILLER, Ross, A. [US/US]; 126 East Lincoln Avenue, Rahway, NJ 07065 (US). LI, Wenjie [CN/US]; 126 East Lincoln Avenue, Rahway, NJ 07065 (US). (74) Common Representative: MERCK & CO., INC.; 126 East Lincoln Avenue, Rahway, NJ 07065 (US).		(81) Designated States: AL, AM, AU, AZ, BA, BB, BG, BR, BY, CA, CN, CU, CZ, EE, GD, GE, HR, HU, ID, IL, IN, IS, JP, KG, KR, KZ, LC, LK, LR, LT, LV, MD, MG, MK, MN, MX, NO, NZ, PL, RO, RU, SG, SI, SK, SL, TJ, TM, TR, TT, UA, US, UZ, VN, YU, ARIPO patent (GH, GM, KE, LS, MW, SD, SZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG). Published <i>Without international search report and to be republished upon receipt of that report.</i>
(54) Title: INTERMEDIATES AND PROCESS FOR THE SYNTHESSES OF 17-UNSUBSTITUTED 16.BETA.-ARYLOXY 4-AZAS-TEROIDS (57) Abstract The novel process of this invention involves the stereoselective synthesis of certain 16-substituted 4-aza-5 α -androst-1-en-3-ones, and the useful intermediates obtained therein.		

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TITLE OF THE INVENTION
INTERMEDIATES AND PROCESS FOR THE SYNTHESSES OF 17-UNSUBSTITUTED
16.BETA.-ARYLOXY 4-AZASTEROIDS

5 CROSS REFERENCE TO RELATED APPLICATIONS

The present application claims priority of U.S. provisional application Serial No. 60/068,536, filed December 23, 1997.

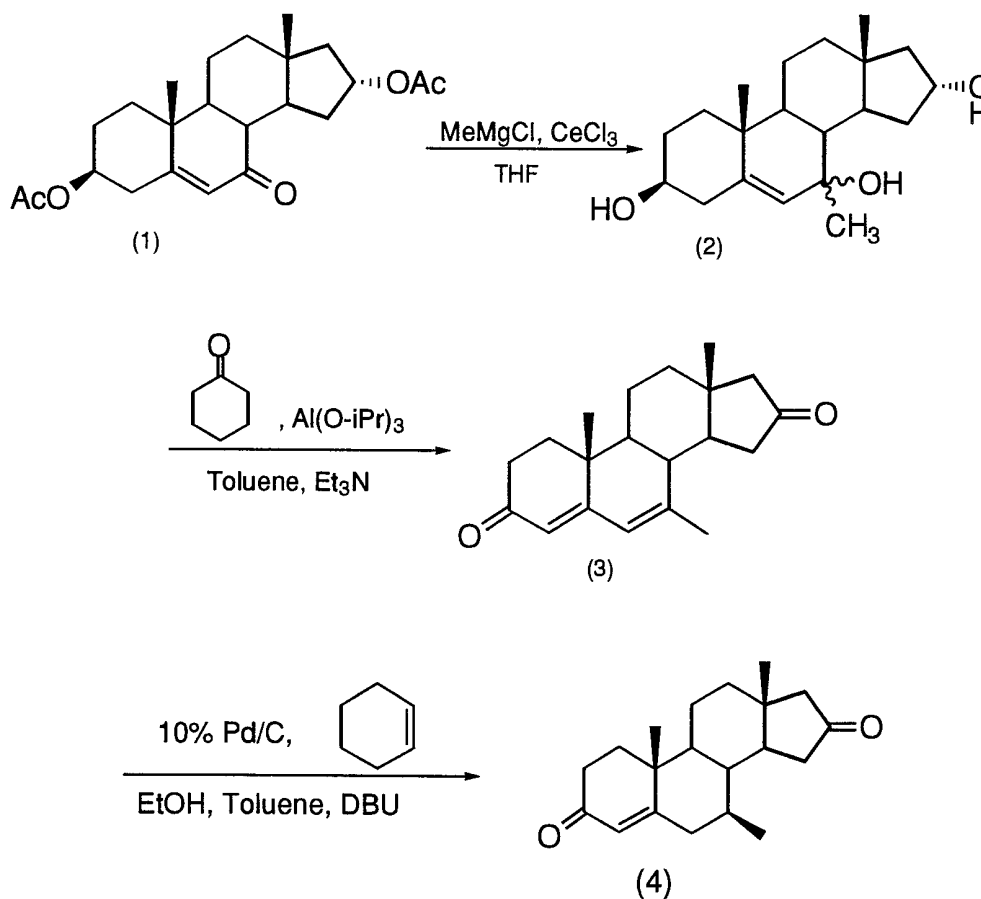
BACKGROUND OF THE INVENTION

10 The principal mediator of androgenic activity in some target organs, e.g., the prostate, is 5 α -dihydrotestosterone ("DHT"), formed locally in the target organ by the action of 5 α -reductase, which converts testosterone to DHT. Certain undesirable physiological manifestations, such as acne vulgaris, seborrhea, female hirsutism, androgenic
15 alopecia (also called androgenetic alopecia) which includes female and male pattern baldness, and benign prostatic hyperplasia, are the result of hyperandrogenic stimulation caused by an excessive accumulation of testosterone ("T") or similar androgenic hormones in the metabolic system. Inhibitors of 5 α -reductase will serve to prevent or lessen
20 symptoms of hyperandrogenic stimulation in these organs. See especially United States Patent Nos. 4,377,584, issued March 22, 1983, and 4,760,071, issued July 26, 1988, both assigned to Merck & Co., Inc. It is now known that a second 5 α -reductase isozyme exists, which interacts with skin tissues, especially in scalp tissues. See, e.g., G.
25 Harris, *et al.*, *Proc. Natl. Acad. Sci. USA*, Vol. 89, pp. 10787-10791 (Nov. 1992). The isozyme that principally interacts in skin tissues is conventionally designated as 5 α -reductase 1 (or 5 α -reductase type 1), while the isozyme that principally interacts within the prostatic tissues is designated as 5 α -reductase 2 (or 5 α -reductase type 2).
30 U.S. 5,237,064 describes a process for producing 7 β -substituted 5 α -androstan-3-ones. U.S. 5,470,976 describes the stereoselective hydrogenation of the delta-5 double bond of a 17-substituted azasteroid. U.S. 5,120,847 and U.S. 5,021,575 relate to the insertion of a double bond at the 1,2 position of a 4-azasteroid.

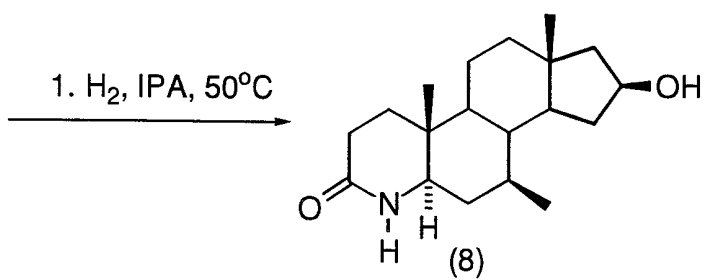
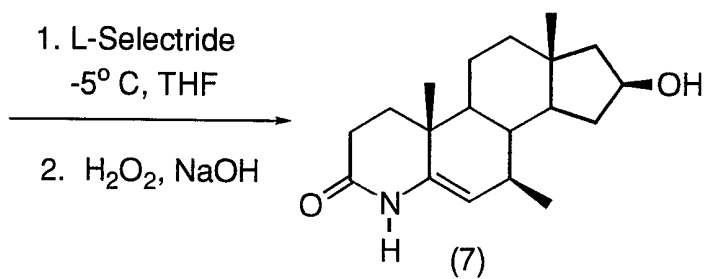
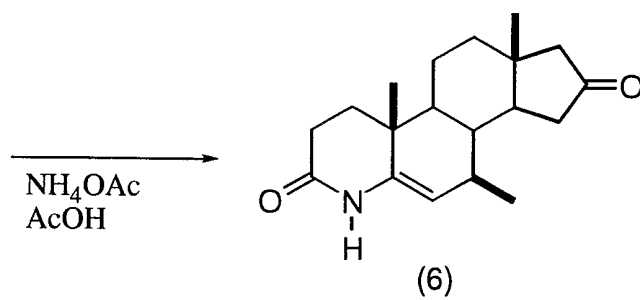
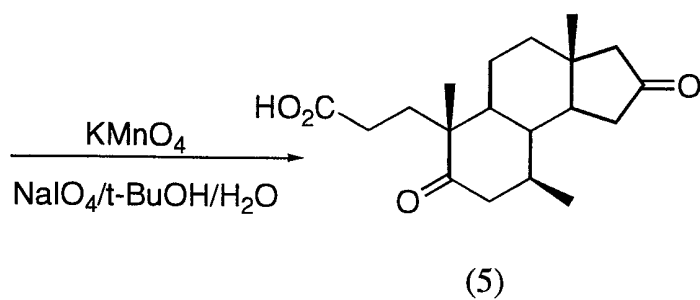
The instant invention provides an improved process for the synthesis of 16-substituted 7- β -methyl-4-aza-5 α -androst-1-en-3-ones. 16 β -substituted 7- β -methyl-4-aza-5 α -androst-1-en-3-ones are described in PCT publication WO 95/11254. Also provided by the present invention are
5 intermediates useful in the present process.

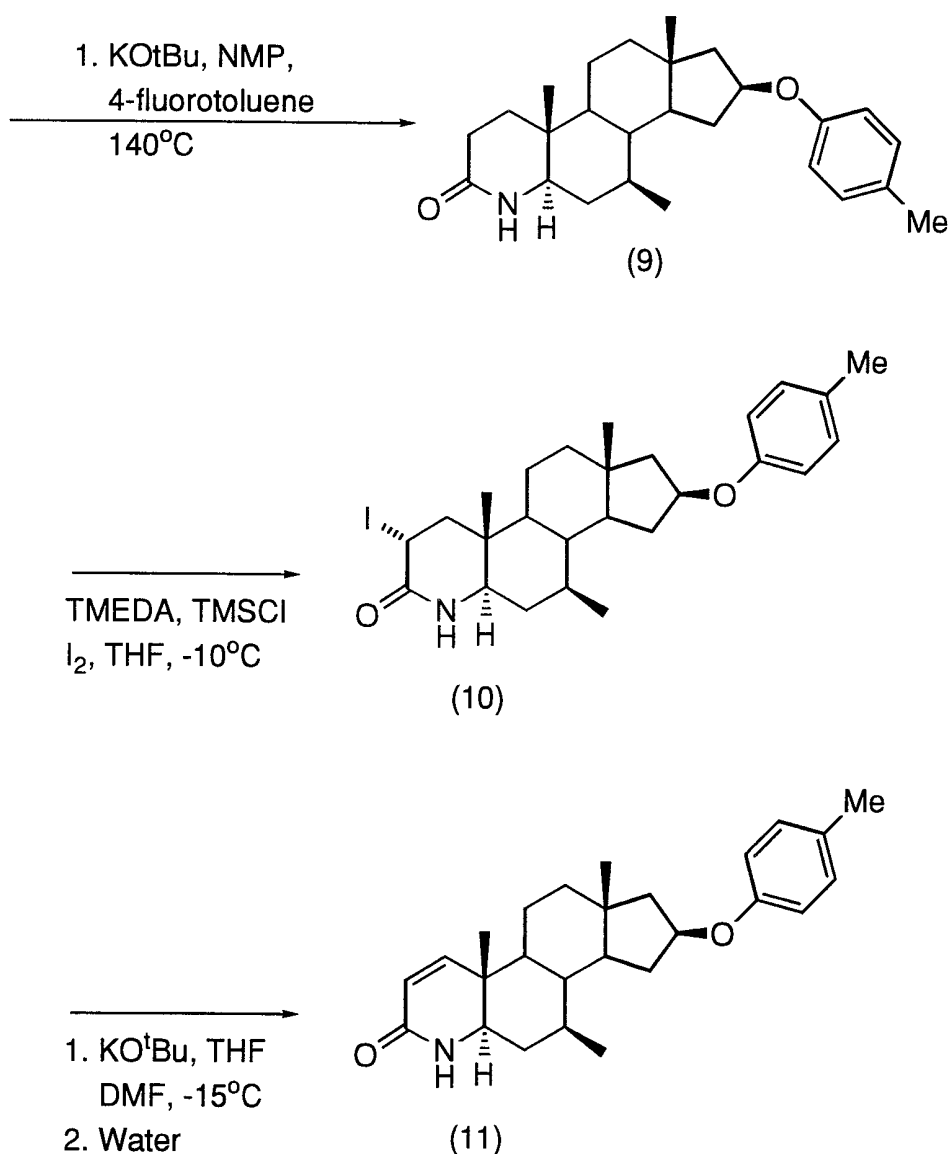
SUMMARY OF THE INVENTION

The novel process of this invention involves the stereoselective synthesis of certain 16-substituted 4-aza-5 α -androst-1-en-3-ones, and the useful intermediates obtained therein. These novel
10 intermediates and this novel process can be exemplified in the following embodiment.



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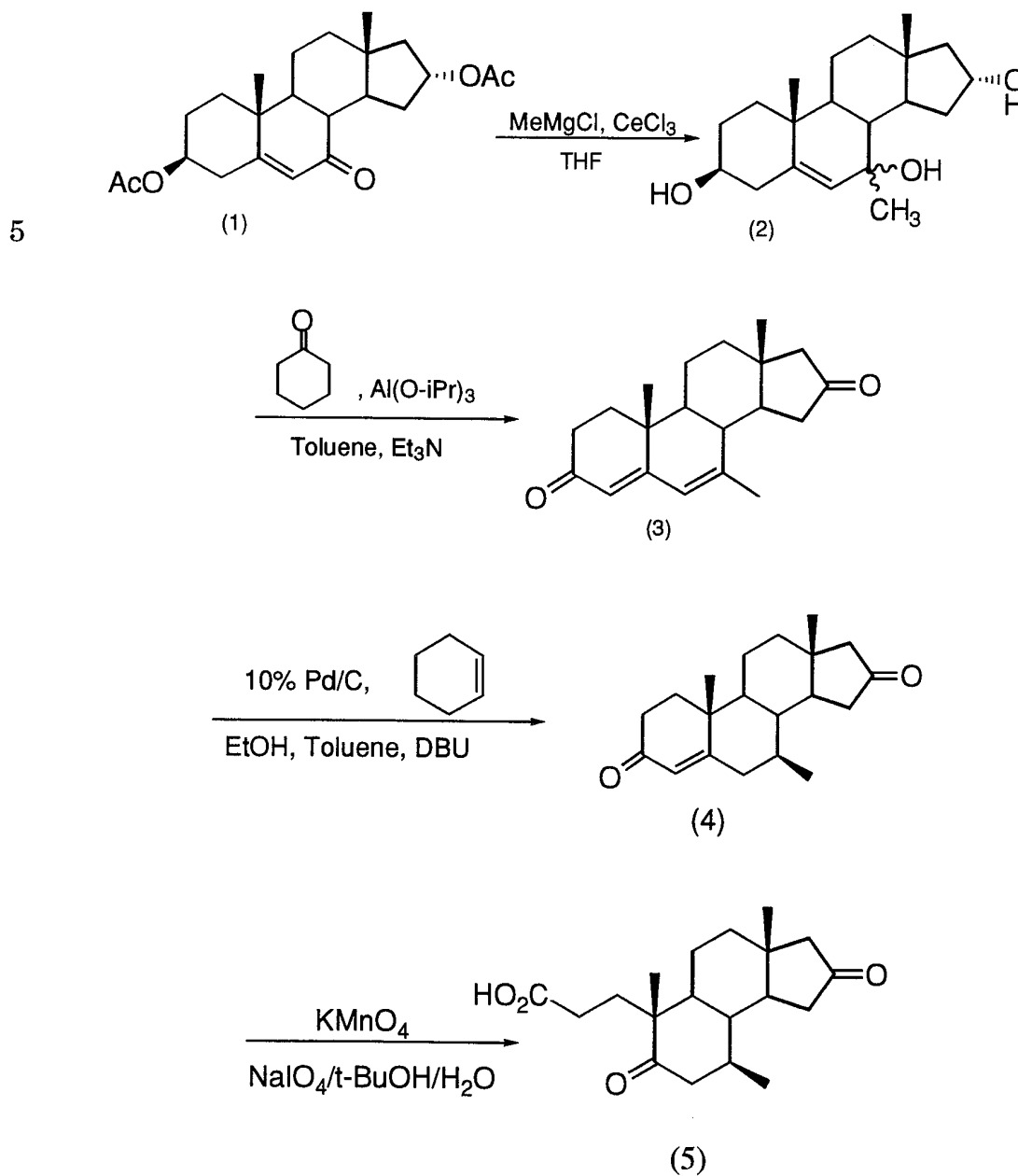


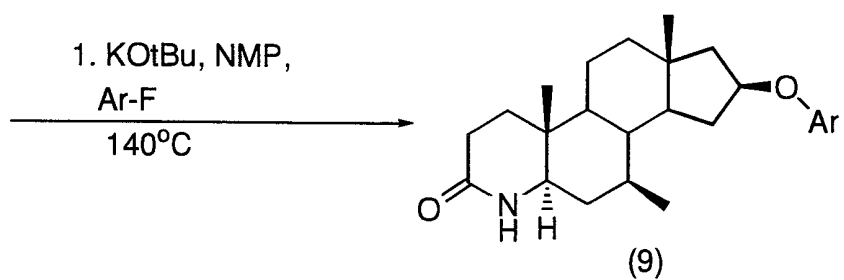
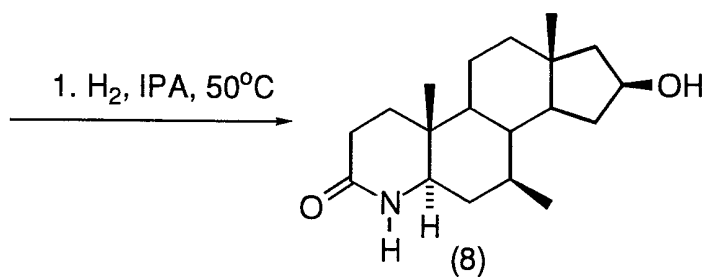
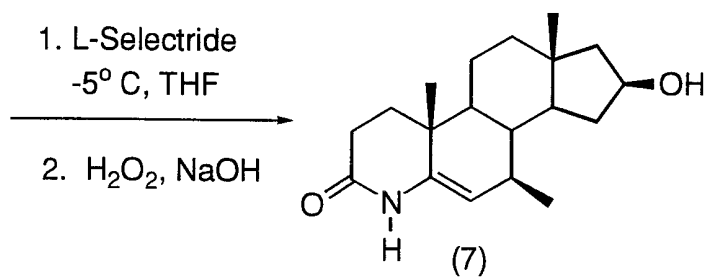
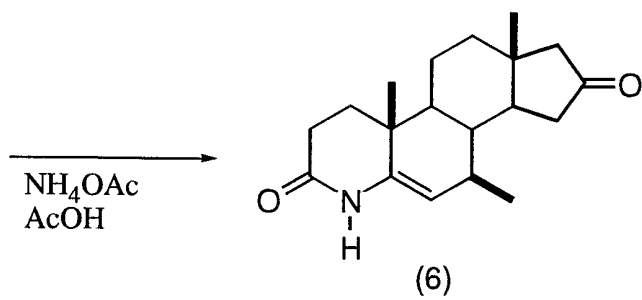
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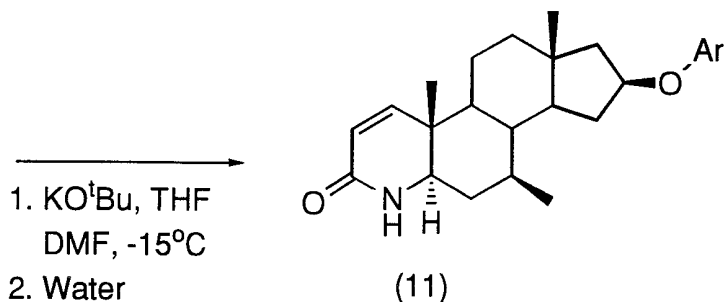
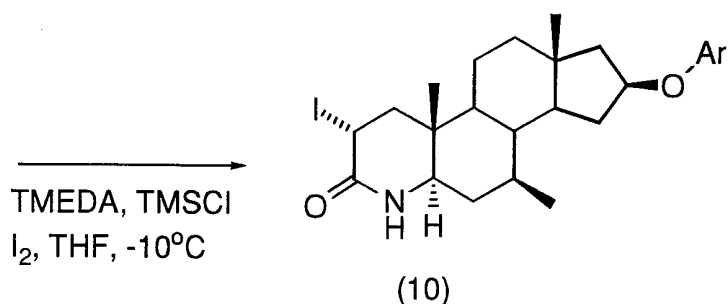
The products of the present process are useful as inhibitors of 5 α -reductase, particularly 5 α -reductase type 1. 5 α -reductase inhibitors are useful in the treatment of hyperandrogenic disorders such as benign prostatic hyperplasia, acne vulgaris, seborrhea, female hirsutism, androgenic alopecia (androgenetic alopecia), including male pattern baldness, and the prevention and treatment of prostatic carcinoma.

DETAILED DESCRIPTION OF THE INVENTION

A general procedure for the process of the present invention is shown below:







wherein Ar is:

- unsubstituted or mono- or di-substituted phenyl,
 5 naphthyl, or 5, 6 or 7 membered heteroaromatic ring containing at least one member selected from the group consisting of: one ring oxygen atom, one ring sulfur atom, 1-4 ring nitrogen atoms, or combinations thereof; in which the heteroaromatic ring can also be fused with one benzo or heteroaromatic ring.

10 When Ar is heteroaryl, the heteroaryl ring may be attached within structural formula I or substituted on any carbon atom in the ring which results in the creation of a stable structure.

The substituents on the aryl and heteroaryl groups named above are independently selected from:

- 15 i) halo; hydroxy; cyano; nitro; mono-, di- or trihalomethyl; mono-, di- or trihalomethoxy; C₂₋₆ alkenyl; C₃₋₆ cycloalkyl; formyl; hydrosulfonyl; carboxy; ureido;
 ii) C₁₋₆ alkyl; hydroxy C₁₋₆ alkyl; C₁₋₆ alkyloxy; C₁₋₆ alkyloxy C₁₋₆alkyl; C₁₋₆ alkylcarbonyl; C₁₋₆ alkylsulfonyl; C₁₋₆ alkylthio; C₁₋₆
- 20

- alkylsulfinyl; C₁₋₆ alkylsulfonamido; C₁₋₆ alkylarylsulfonamido; C₁₋₆ alkyloxy-carbonyl; C₁₋₆ alkyloxycarbonyl C₁₋₆alkyl; R_bR_cN-C(O)-C₁₋₆alkyl; C₁₋₆ alkanoylamino C₁₋₆ alkyl; aroylamino C₁₋₆ alkyl; wherein the C₁₋₆ alkyl moiety is unsubstituted or substituted with 1-3 of: halo; C₁₋₄alkoxy; or trifluoromethyl;
- 5
- iii) aryl; aryloxy; arylcarbonyl; arylthio; arylsulfonyl; arylsulfinyl; arylsulfonamido; aryloxycarbonyl; wherein the aryl moiety is unsubstituted or substituted with 1-3 of: halo; C₁₋₄alkyl; C₁₋₄alkoxy; or trifluoromethyl;
- 10
- iv) -C(O)NR_bR_c; -O-C(O)-NR_bR_c; -N(R_b)-C(O)-R_c; -NR_bR_c; R_b-C(O)-N(R_c)-; where R_b and R_c R_b and R_c are independently H, C₁₋₆ alkyl, aryl, or arylC₁₋₆alkyl; wherein the alkyl moiety is unsubstituted or substituted with 1-3 of: halo; C₁₋₄alkoxy; or trifluoromethyl; and the aryl moiety can be substituted with 1-3 of: halo; C₁₋₄alkyl; C₁₋₄ alkoxy; or trifluoromethyl; and -N(R_b)-C(O)-OR_g, wherein R_g is C₁₋₆alkyl or aryl, in which the alkyl moiety is unsubstituted or substituted with 1-3 of: halo; C₁₋₄alkoxy; or trifluoromethyl, and the aryl moiety is unsubstituted or substituted with 1-3 of: halo; C₁₋₄alkyl; C₁₋₄ alkoxy, or trifluoromethyl; -N(R_b)-C(O) NR_cR_d, wherein R_d is selected from H, C₁₋₆ alkyl, and aryl; in which said C₁₋₆alkyl and aryl is unsubstituted or substituted as described above in (f) for R_b and R_c;
- 15
- 20
- 25
- 30
- iv) a heterocyclic group, wherein the heterocyclic ring can be fused with a benzo ring, and wherein said heterocyclic ring is unsubstituted or substituted with one to three substituents, as

defined above for *i*), *ii*), *iii*) and *iv*), excluding *iv*)
a heterocyclic group.

Preferably, Ar is selected from: unsubstituted or mono- or
di-substituted phenyl, naphthyl, pyridyl, furyl, pyrrolyl, thienyl,
5 isothiazolyl, imidazolyl, benzimidazolyl, tetrazolyl, pyrazinyl, pyrimidyl,
quinolyl, isoquinolyl, benzofuryl, isobenzofuryl, benzothienyl, pyrazolyl,
indolyl, isoindolyl, purinyl, carbazolyl, isoxazolyl, thiazolyl, oxazolyl,
benzthiazolyl, and benzoxazolyl.

In another embodiment, Ar is selected from: unsubstituted
10 or mono- or di-substituted phenyl, naphthyl, pyridyl, pyrrolyl, pyrazinyl,
pyrimidyl, and oxazolyl.

Preferably, the aryl and heteroaryl substituents are selected
from:

- 15 *v*) halo; cyano; nitro; trihalomethyl; trihalomethoxy; C₁-
6 alkyl; aryl; C₁-6 alkylsulfonyl; C₁-6 alkyl-
arylsulfonamino;
- vi*) -NR_bR_c; R_b-C(O)-N(R_c)-; wherein R_b and R_c are
independently H, C₁-6 alkyl, aryl, or arylC₁-6alkyl;
wherein the alkyl moiety is unsubstituted or
20 substituted with 1-3 of: halo; C₁-4alkoxy; or
trifluoromethyl; and the aryl moiety is unsubstituted
or substituted with 1-3 of: halo; C₁-4alkyl; C₁-4 alkoxy;
or trifluoromethyl;
- 25 *vii*) a heterocyclic group, which is a 5 membered
aromatic ring, containing one ring nitrogen atom, or
one ring oxygen and one ring nitrogen atom.

The starting material for the process is produced according
to the procedures in Miller et al., Tetrahedron Letters 37(20) 3429-3432
(1996) and those in PCT publication WO 95/32215, and is generally known
30 and available in the art.

Addition of methyl magnesium chloride to the 7-keto-3,16
bis acetate starting material (1) cleaves the 3 and 16 acetates with
concurrent addition to the 7-ketone to produce (2). Anhydrous cerium
trichloride, in the proper needle form, was added to the Grignard before
35 addition to the 7-ketone and improved the yield of the reaction by >15%.

The triol (2) can be carried on to the next step without purification, or it may be isolated.

Oxidation of the triol (2) to the dienedione (3) was carried out under Oppenauer conditions with 2-butanone, aluminum isopropoxide, and triethylamine. Concurrent hydrolysis of the aluminum salts and elimination of the 7-OH occurred upon aging with concentrated HCl. Butanone dimers can be removed from the reaction mixture by a water distillation before carrying on to the next step, or the dienedione (3) may be isolated.

A chemo- and stereoselective reduction of the dienone (3) to the 7- β methyl enone (4) was achieved under transfer hydrogenation conditions using 10% Pd/C and cyclohexene as the hydrogen donor. Careful front run of the reaction and frequent monitoring ensured little overreduction and a high yield of enone.

The oxidative cleavage of the enone (4) to the seco acid (5) was carried using sodium periodate and catalytic potassium permanganate with sodium carbonate.

Introduction of the nitrogen atom into the A ring occurs in refluxing acetic acid with ammonium acetate. BHT was added as a radical inhibitor to prevent decomposition of enolactam ketone(6).

Chemo- and stereoselective reduction of the crude enolactam ketone (6) was carried out with L-Selectride at -5°C. After an oxidative workup to convert the trialkylboron by-products to boric acid, the enolactam alcohol (7) is crystallized from acetonitrile. Running this reaction under more dilute conditions and reducing the level of toluene improves yield.

Hydrogenation of the enolactam alcohol (7) is critical because enolactam left behind does not crystallize away from the NH lactam alcohol (8) and impacts on the purity of the final product.

Arylation of the NH lactam alcohol (8) was carried out using potassium t-butoxide in N-methyl-pyrrolidinone to give (9). The isomeric purity of the fluoro-substituted aryl reagent is of key concern in this reaction because both the ortho and meta isomers of the fluorotoluene also react to give the corresponding isomeric products.

Complete iodination in forming (10) is important since the NH lactam alcohol is not easily removed from the iodide or final bulk drug by recrystallization. The level of NH lactam alcohol in the iodide is typically controlled at less than 0.2wt%. Care must be taken to carry out the quench at low temperature (less than 5°C) in order to avoid reduction of the iodide to the starting material.

Formation of the 1,2-double bond by dehydroiodination forms the product (11).

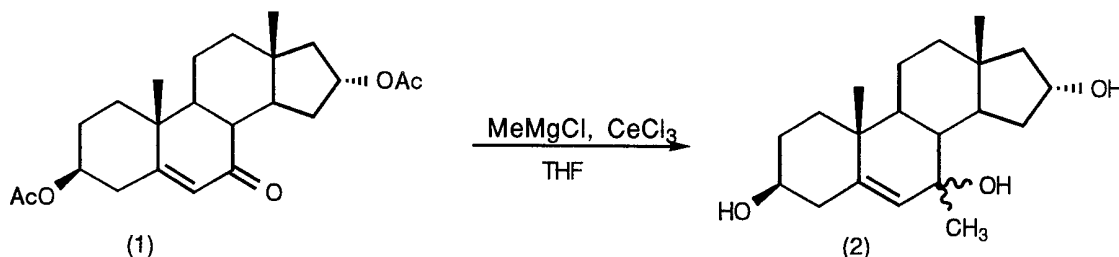
Representative experimental procedures utilizing the novel process are detailed below. These procedures are exemplary only and should not be construed as being limitations on the novel process of this invention.

Abbreviations: ACN is acetonitrile; BHT is 2,6-t-butyl-4-methylphenol; *ca* is *circa*; DBU is (1,8-diazabicyclo[5.4.0]undec-7-ene; IPA is isopropyl alcohol; L-Selectride® is lithium tri-sec-butylborohydride; MEK is methyl ethyl ketone; NMP is 1-methyl-2-pyrrolidinone; THF is tetrahydrofuran; TMEDA is N,N,N',N'-Tetramethylethylenediamine; TMSCl is chlorotrimethylsilane.

20

EXAMPLE 1

Preparation of 3,6,16-Triol (2)



Cerium chloride (3.96kg) was charged as a solid to the reaction vessel. THF (35kg) was charged using vacuum, then water (20mL) was added via the charge port and the mixture aged at 35°C for 1 hr. A sample was taken and examined by microscopy to ensure that conversion to the required crystal form had occurred.

(Amorphous cerium chloride stirred in THF converts to a fine rod-like crystalline form. This crystalline form is necessary to

obtain the stereo-selectivity in the Grignard reaction. Previous experience had shown that the water content of the THF/cerium chloride should be less than 1000ppm in order to get the required crystal form. Wetter slurries were found to irreversibly form another crystal form that
5 did not exhibit the same specificity in the Grignard reaction. However, the THF used in this instance was extremely dry (<50ppm) and stirring the amorphous cerium chloride in it did not produce the required conversion and the solid remained amorphous. It was demonstrated that a small amount of water is necessary for the conversion to take
10 place, and water was added to the batch to give a total water content of ca 500ppm.)

After cooling the batch to 25°C, 3M methyl magnesium chloride in THF (80.46kg) was added to the vessel. The mixture was cooled to 0-5°C and aged for 30 minutes. The 7-ketone starting material
15 (1) (9.2 kg) was slurried in THF (50L) and added to the Grignard reagent slurry over 75 minutes, maintaining a temperature of <20°C.

The batch was sampled and reaction completion confirmed by HPLC: <0.1A% (1) detected. The Grignard reaction mixture was slowly added to a quenching solution formed by the addition of toluene
20 (70 kg) to a solution of water (146L) and solid citric acid (43.9kg). Care was made to maintain the temperature at <20°C. The reaction vessel and transfer lines were rinsed with THF (10kg).

The mixture was stirred for 15 minutes then settled for 30 minutes. Both phases were cut to drums and the aqueous layer
25 returned to was back extracted with 39 kg of ethyl acetate (agitated for 10 mins, settled for 30 mins). The aqueous layer was cut to waste drums and the THF batch layer was combined with the ethyl acetate layer. 20% sodium carbonate solution (49.2kg) was added to the stirred solution over 15 minutes then the mixture settled for 30 minutes and the aqueous
30 phase cut to waste.

The batch layer was washed with 51.5kg of 20% sodium chloride solution (agitated for 10 mins, settled for 30 minutes) and the aqueous phase cut to waste. Triethylamine (4.8kg) was added and the solution concentrated *in vacuo* to ca 100L. Toluene was added and
35 distillation continued, until the level of THF/ethyl acetate had dropped to

<0.5vol% by GC. The final volume was made up to 275L, with toluene and the slurry held was used in Example 2.

HPLC Conditions:

5	Column	YMC J-Sphere ODS H80 250 x 4.6 mm I.D.
	Eluent A	ACN
	Eluent B	Unbuffered water
	Gradient	30% A to 80% A in 25 min; hold for 5 min
	Inj vol	20 µl
10	Detection	UV at 200nm
	Flow	1.5 ml/min
	Column temp	35°C
	Sample preparation	100x dilution with acetonitrile; waste aq layers diluted 50x

15

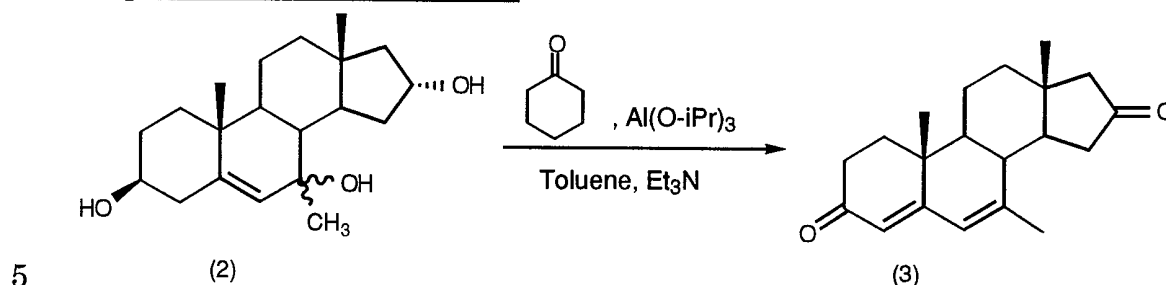
<u>Compound</u>	<u>Retention Times</u>	<u>Response Factor(area counts/wt)</u>
Triols	4.6, 6.4	0.71
7-ketone	14.6	1
20 Toluene	16.4	
BHT	29.5	

GC conditions

25	Column	Chrompack plot fused silica 25mx0.53mm
	coating	poraplot Q
	Oven temperature	250°C Isothermal
	Inj temp	275°C
	Det temp	275°C
	Sample preparation	40x dilution with MeOH

30

<u>Compound</u>	<u>Retention</u>	<u>Relative Response Factor</u>
MeOH	2.0 min	
THF/EtOAc	2.8,3.2 min	1
35 Toluene	4.5 min	1.5

EXAMPLE 2Preparation of Diene-Dione (3)

To a slurry of triol in toluene (7.59 kg in 275L) was added triethylamine (3.8kg) and aluminium isopropoxide (10kg) followed by 2-butanone (100kg). The mixture was heated at reflux for 6 hrs, cooled slightly, a sample was taken, and reaction completion confirmed by HPLC(<5A% 16-OH's dienone relative to 16-keto-diene-dione). The batch was cooled to 20°C, then allowed to stand overnight.

A mixture of water (62.5L) and 12N hydrochloric acid (73.7kg) was transferred to the reaction mixture. The reaction mixture was heated to 58-60°C and aged for 4 hrs. A sample was taken and the disappearance of 7-OH enone intermediate confirmed by HPLC. The batch was cooled to 20°C, allowed to settle for 15 mins and the aqueous phase cut to waste.

2.5% sodium bicarbonate solution (100L) was added to the toluene layer, stirred for 15 mins, settled for 30 mins and the aqueous phase cut to waste. This procedure was repeated with 100L of water.

The organic phases from the two batches prepared as described above were combined and concentrated in vacuo to a volume of 100L. Water was fed in under vacuum then distillation continued at atmospheric pressure until the level of 2-butanone dimers in the batch had dropped to <3A% relative to diene-dione; a total of 70L of water was distilled. Toluene (100L) was added to the residue, the mixture agitated for 5 mins then settled for 15 mins. The organic layer was saved. The aqueous phase returned was extracted with toluene (40L). The organic

layers were combined and concentrated in vacuo to a final volume of ca 60L. The solution was held for Example 3.

HPLC Conditions

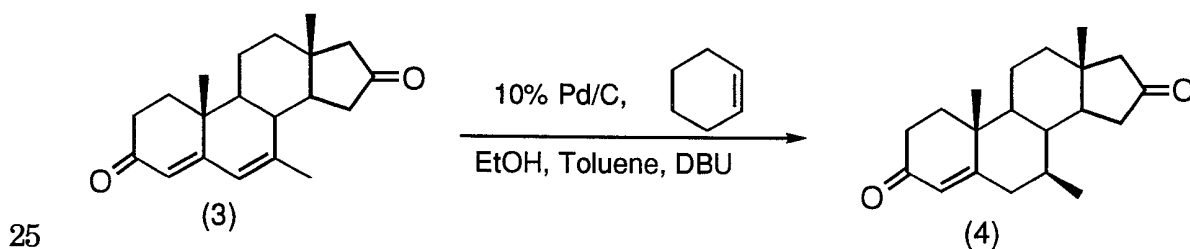
	Column	YMC J-Sphere ODS H80 250 x 4.6 mm I.D.
5	Eluent A	ACN
	Eluent B	Unbuffered water
	Gradient	30% A to 80% A in 25 min; hold for 5 min
	Flow	1.5 ml/min
	Inj vol	20 µl
10	Detection	UV at 200nm for triols, 240nm for 7-OH enone and
	MEK by-product	removal, 290 nm for dienone assays
	Column temp	35°C
	Sample preparation	100x dilution with acetonitrile; waste aq layers diluted 25-50x

15

<u>Compound</u>	<u>Retention Times</u>	<u>λ</u>
Triols	4.6, 6.4	200nm
7-OH enone	6.6	240nm
Dienedione	13.1	290nm
20 Toluene	16.4	200nm
BHT	29.5	200nm

EXAMPLE 3

Preparation of Enone (4)



Diene-dione (3) (12.9 kg) was converted to enone (4) (11.69 assay kg, 90.0% yield) in one batch. The enone was not isolated but carried through for use in Example 4 as a solution in t-butanol.

To the reaction vessel was added 10% Pd/C (5.32kg, 51.5% water wet), followed by the toluene solution of diene-dione obtained as a product of Example 2, (12.9kg in 70L), ethanol (38.1L), and cyclohexene (64.9L). The mixture was agitated and DBU (1.28kg) was added.

5 A sample was taken and the mixture warmed to reflux. The reaction was sampled periodically and heating continued (6 hrs) until the diene-dione level, measured by HPLC fell below 1.0mg/ml.

(As benzene is produced as a by-product of the reaction, care was taken to use local extraction when sampling.)

10 After cooling to 25°C, the batch was filtered through a 45cm plate filter set with a polypropylene cloth, card, and Solka Floc diatomaceous earth (1.5kg).

The filter became blocked after about 50% of the slurry had passed through and had to be dismantled and reset.

15 The vessel, lines and filter pad were rinsed with toluene (20L) and the combined filtrates allowed to stand overnight. 1N hydrochloric acid (44L) was added to the filtrate. The mixture was agitated for 5 mins, settled for 15 mins and the lower aqueous phase cut to waste. This wash procedure was repeated with 5% sodium chloride
20 solution (42L).

The organic phase was concentrated *in vacuo* to ca 50L then transferred to a reaction vessel via a 0.5m cotton cartridge filter and distillation continued to ca 22L. The solvent was switched to t-butanol. t-Butanol (total of 144kg) was charged and distilled in vacuo (30L distilled)
25 until the required removal of the previous solvents was achieved (toluene <15mg/ml, cyclohexene, 0.05mg/ml). The batch (11.69kg of enone in 136.2kg of solution) was held for further reaction in Example 4.

(Because t-Butanol freezes at 26°C, all drums of pure solvent and batch solutions were stored on a heating pad to maintain a
30 temperature of ca 40°C.)

HPLC Conditions

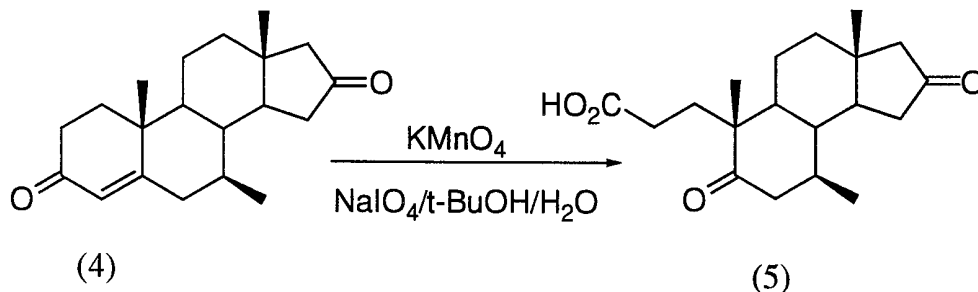
Column	Zorbax SB Phenyl 250 x 4.6 mm I.D.
Eluent A	ACN
Eluent B	Aqueous 0.1v/v% H ₃ PO ₄
35 Gradient	30% A to 80% A in 25 min; hold for 5 min

	Flow	1.5 ml/min
	Inj vol	20 μ l
	Detection	UV at 192nm (benzene, cyclohexene), 245nm(enone), 295nm(dienone)
5	Column temp	35°C
	Sample preparation	100x - 1000x dilution with acetonitrile; waste aq layers diluted 10x-25x (non-linearity for dienedione, enone)

10	<u>Compound</u>	<u>Retention Times</u>
	Benzene	7.7
	Toluene	10.0
	Cyclohexene	10.9
	Dienedione	13.9
15	Enone	14.9

EXAMPLE 4

Preparation of Seco acid (5)



20

Enone (4) (11.69 assay kg) was converted to seco acid (10.3 assay kg) in 83% yield in two batches. The product was not isolated but held as a solution in ethyl acetate for Example 5.

25 The oxidizing solution was made up first. Water (150L), sodium periodate (25.54kg) and potassium permanganate (0.47kg) were added to the reaction vessel and the mixture warmed to 65°C until all the solids had dissolved (ca 30 minutes).

A solution of enone (4) (5.9 kg) in t-butanol (70 kg) was added to a second reaction vessel and rinsed in with t-butanol (16 kg). A

solution of sodium carbonate (2.10 kg) in water (80 L) was added to the enone solution and stirred at 55°C. The oxidant was added over 1 hr, maintaining the temperature at 60°C.

The batch was aged at 60°C for 30 mins then sampled and
5 assayed for starting material (0.07mg/ml, 99% complete), and then
heated at 80°C for 30 mins to decompose excess oxidant. The resulting
brown slurry was cooled to 12-15°C, aged for 15 mins then filtered
through a 65cm filter fitted with a polypropylene cloth. The vessel and
filter pad were rinsed with aqueous t-butanol (water 70L, t-butanol 35L).
10 The filter removed the bulk of the inorganic solids but some fine brown
material passed through.

The liquors were returned to the reaction vessel via a 0.5m
cotton cartridge filter, then the pH of the solution was measured at 9.
The cartridge filter became blocked with the fine brown inorganic solid
15 and required changing several times during the transfer. If the pH had
been <9, it would have been adjusted by addition of sodium carbonate
solution.

Hexane (30kg) was added. The mixture was agitated for 15
minutes, settled for 15 mins then the aqueous layer cut to drums and the
20 hexane layer cut to waste. The aqueous phase was returned to the
reaction vessel together with ethyl acetate (41kg), then the pH of the
batch adjusted to 1-2 by addition of 12N hydrochloric acid solution,
maintaining the temperature at 15-20°C. The mixture was stirred for 15
mins, settled for 30 mins and both phases cut to plastic lined drums.
25 The aqueous phase was returned to the vessel and extracted with ethyl
acetate (26kg). This extraction was repeated, and then all the organic
phases combined in the reaction vessel, and washed with 10% brine
solution (27L). The aqueous phase was cut to waste and the organic
phase drummed and assayed.

30 HPLC Conditions

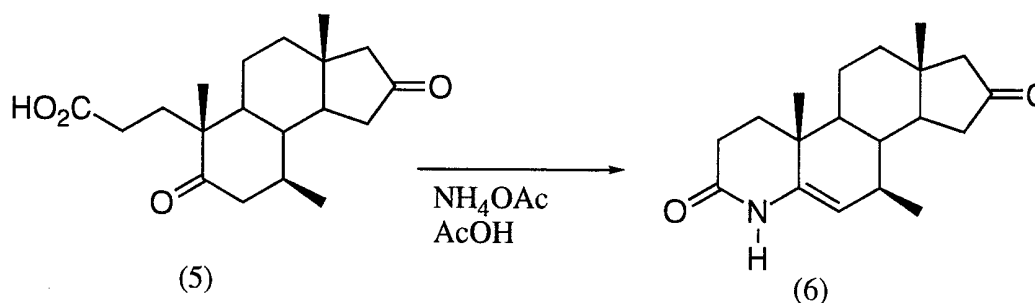
Column	Zorbax SB Phenyl 250 x 4.6 mm I.D.
Eluent A	ACN
Eluent B	Aqueous 0.1v/v% H ₃ PO ₄
Gradient	30% A to 80% A in 25 min; hold for 7 min
35 Flow	1.5 ml/min

Inj vol 20 μ l
 Detection UV at 192nm (seco acid), 245nm (enone)
 Column temp 35°C
 Sample preparation 100x dilution with acetonitrile; waste aq,
 5 hexane layers diluted 10x-25x

<u>Compound</u>	<u>Retention Times</u>
Acetic acid	2.1
Ethyl acetate	3.6
10 Seco acid	8.1
Toluene	10.0
Enone	14.9

EXAMPLE 5

15 Preparation of Enelactam Ketone (6)



Seco-acid (9.8kg) was converted to ene lactam ketone
 20 (9.07kg) in a single batch. The product was not isolated, but instead
 carried through to Example 6 as a toluene solution.

A solution of seco-acid (10.3kg) in ethyl acetate (282kg) was
 added to a reaction vessel and concentrated in vacuo to a minimum
 stirred volume of ca 35L. The solvent was then switched to acetic acid in
 25 vacuo. A total of 80kg of acetic acid was added, and 60L distilled to
 achieve an ethyl acetate concentration of <1mg/ml in a final volume of
 76L (seco-acid concentration: 124.9g/L). A portion of this solution (4L,
 containing 500g of seco-acid) was removed for other studies.

The remaining solution (9.8kg in 72L) was diluted with acetic acid to a total volume of 150L, then BHT (0.1kg) and ammonium acetate (23.7kg) were added via the charge port and the mixture warmed to reflux. Acetic acid (60L) was distilled and then reflux continued for a total of 5 hrs. The progress of the reaction was monitored by HPLC and the reaction was considered complete when the concentration of seco-acid fell to <0.5mg/ml.

The batch was cooled to 20°C, then toluene (100L) and water (100L) added, the solution stirred for 20 mins, settled for 20 mins and both phases cut to plastic lined drums. The aqueous phase was returned to the reaction vessel and extracted with toluene (50L). The organic phases were combined, washed with 5% aqueous sodium chloride solution (50L) and assayed (total volume 160L, 56.7g/L for 98.5% yield). The solution was concentrated in vacuo to give a thick slurry (37L) of ene-lactam ketone.

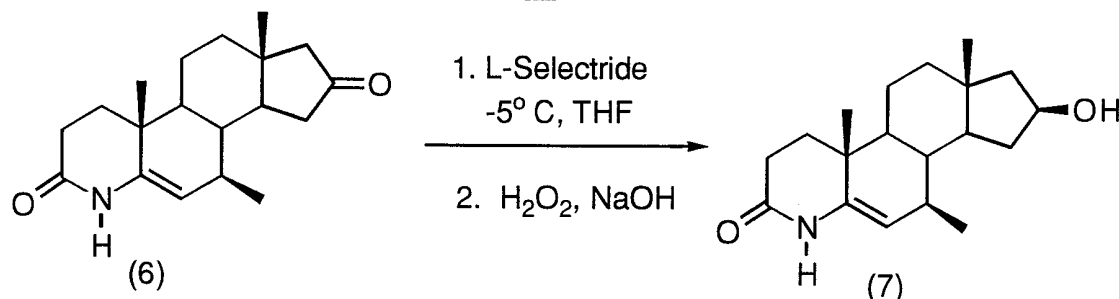
HPLC Conditions

Column	Zorbax SB Phenyl 250 x 4.6 mm I.D.
Eluent A	ACN
Eluent B	Aqueous 0.1v/v% H ₃ PO ₄
Gradient	30% A to 80% A in 20 min; hold for 15 min
Flow	1.5 ml/min
Inj vol	20 µl
Detection	UV at 192nm (seco acid), 240nm (enelactam)
Column temp	35°C
Sample preparation	100x dilution with acetonitrile; waste aq layers diluted 25x

<u>Compound</u>	<u>Retention Times</u>
Acetic acid	2.1
Ethyl acetate	3.5
Seco acid	8.5
Toluene	9.4
Enelactam ketone	9.9
BHT	17.1

EXAMPLE 6

Preparation of Enelactam Alcohol (7)



5 The slurry of ene-lactam ketone (9.07kg) in toluene (35L) in the reaction vessel was diluted with THF (89kg) and cooled to -5°C . L-Selectride (34.5kg of 1M solution) was added to the slurry over 1 hr, maintaining the temperature between -5°C and 0°C . The batch was aged at 0°C for 20 mins then sampled. HPLC analysis showed that 11.7 mol% still remained. Further L-Selectride (3.4kg) was added then aged for 40 minutes at 0°C and sampled. HPLC analysis showed that 9.9 mol% still remained.

15 The reaction was quenched by addition of 20% aqueous sodium hydroxide solution (37.4kg), maintaining the temperature at $<20^{\circ}\text{C}$, followed by 27% hydrogen peroxide (19.8kg) at $<30^{\circ}\text{C}$. The mixture was stirred at $15-20^{\circ}\text{C}$ for 1 hr then excess peroxide confirmed using a Merckoquant test strip (E. Merck).

 The nitrogen purge rate was increased to 15L/min during the hydrogen peroxide addition.

20 10% aqueous sodium sulfite solution (129kg) was added, and the batch aged for 15 mins. The absence of peroxide was confirmed, and then the batch was settled for 15 mins and the aqueous phase cut to waste. 10% aqueous sodium chloride solution (58kg) was added, the mixture agitated for 5 mins, settled for 15 mins and the aqueous phase
25 cut to waste. The brine wash was repeated.

 The organic phase (128.3kg) was transferred to another reaction vessel via a 0.5m cotton cartridge filter. The batch was concentrated to ca 40L at atmospheric pressure then the solvent was switched to acetonitrile. A total of 200kg of acetonitrile was charged and

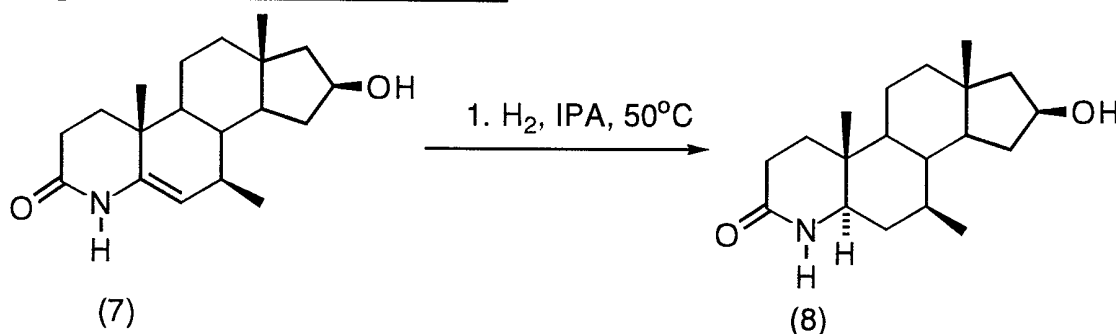
the mixture distilled to a final volume of 65L. A sample was taken and toluene level (spec-200mg/ml, measured-0.7mg/ml) and KF(spec-400mg/L, measured-73mg/L) measured.

- 5 The batch was allowed to cool to room temperature slowly overnight with gentle agitation, and then cooled to 5°C over 1 hr and aged for 30 minutes. The solid was collected on a 33cm stainless steel filter, washed with acetonitrile, then dried at ambient temperature in vacuo overnight. The dry solid was bagged.

HPLC Conditions:

- | | | |
|----|--------------------|---|
| 10 | Column | Zorbax SB Phenyl 250 x 4.6 mm I.D. |
| | Eluent A | ACN |
| | Eluent B | Aqueous 0.1v/v% H ₃ PO ₄ |
| | Gradient | 30% A to 80% A in 20 min; hold for 15 min |
| | Flow | 1.5 ml/min |
| 15 | Inj vol | 20 µl |
| | Detection | UV at 240nm (enelactam ketone, enelactam alcohol) |
| | and | 200nm (BHT, toluene) |
| | Column temp | 35°C |
| 20 | Sample preparation | 100x dilution with acetonitrile; waste aq layers, filtrate and washes diluted 25x |

	<u>Compound</u>	<u>Retention Times</u>
	Enelactam 16-β alcohol	8.7
	Toluene	9.5
25	Enelactam ketone	9.9
	BHT	17.1

EXAMPLE 7Preparation of Lactam Alcohol (8)

5 Ene-lactam alcohol (750g) was dissolved in a mixture of IPA (10L) and water (1.6L) by warming to 30-40°C in a 20L flask. BHT(3g) and 50% wet 10%Pd/C (375g) was added and the mixture charged using vacuum via the dip-leg to a 20L autoclave, and then rinsed in with IPA (1L). The slurry was stirred under an atmosphere of hydrogen (60psig) at 50°C for 6 hours then at 68°C for 16 hrs. The batch was sampled via the dip-leg and checked for completion by HPLC (spec<0.05A% starting material). If the end point had not been reached, stirring under hydrogen was continued.

15 The hydrogenation was carried out at 50°C for the first few half-lives and then warmed to 68°C. Meeting the end of reaction specification is important as ene-lactam alcohol is carried through to the final product.

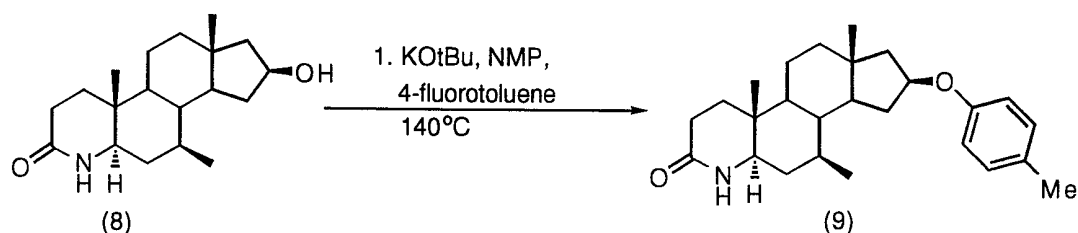
20 The batch was cooled to 30-40°C, flushed with nitrogen several times, then transferred from the autoclave and filtered through Solka Floc (1kg). The autoclave and filter pad were washed with 1:10 water/IPA (2L), and the combined filtrates stored.

25 The procedure above was repeated 10 times and the 10 batches of filtrate were combined and concentrated at atmospheric pressure to a volume of ca 25L. After cooling to room temperature, water (42L) was added over 45 minutes and the batch cooled to 5°C and aged for 1 hr. The solid was collected on a 33cm filter fitted with a polypropylene cloth and then washed with 4:1 water/IPA (10L). The

damp solid was transferred to trays and dried in vacuo at 35°C overnight to give the lactam alcohol (8).

EXAMPLE 8

5 Preparation of Aryl-NH-Lactam (9)



To the lactam-alcohol (8)(3.1 kg) in NMP (46.5 L) at 20°C was added
 10 KOtBu (4.74 Kg). The mixture was aged at 20°C for 20 min. 4-
 Fluorotoluene (2.21 Kg) was added in one portion. The slurry was heated
 to 140°C until less than 0.5A% starting material remained by HPLC
 analysis.

15 Sample preparation, 100µl diluted to 10ml with ACN

HPLC Conditions :

	Column	YMC JSphere ODS 80H 4.6mm x 25cm
	Eluent A	CH ₃ CN
20	Eluent B	Aqueous 0.1M H ₃ PO ₄
	Gradient	50% A ramp to 80% A over 7 min hold for 33 min.
	Flow rate	1.2ml/min ⁻¹
	Inj vol	20µl
25	Detection	UV at 200nm.
	Temp	20°C

	Retention times:	NH Lactam	3.3 min
		Fluorotoluene	9.2 min
30		ANHL	22.1 min

Ortho isomer 24.2 min

Meta isomer 21.4 min

16-Alpha isomer 19.0 min

5-Beta isomer

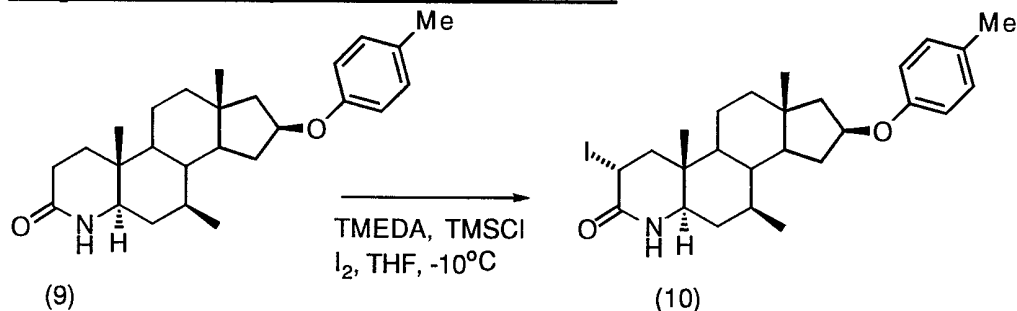
- 5 The reaction mixture was cooled to 20°C and water (46.5L) was added over 1h maintaining temperature 20-30°C. The slurry was stirred at 20°C for 1h.

The slurry was filtered, washed with water (10 L) and dried using nitrogen stream overnight.

10

EXAMPLE 9

Preparation of Aryl-NH-Iodo-Lactam (10)



- 15 To a solution of arylated NH lactam (9) (3.3 Kg) in THF (66 L) at -5°C was added TMEDA (3.76 L) and TMSCl (2.64 L). The white slurry was stirred at -5°C for 15 minutes. Iodine (4.24 Kg) was added to the slurry in three portions over 20 min.

HPLC Conditions for Reaction:

- 20 Column Zorbax SB Phenyl 4.6mm x 25cm
 Eluent A CH₃CN
 Eluent B Aqueous 0.1M H₃PO₄
 Isocratic 70% A, 30% B
 Inj vol 20μl
 25 Detection UV at 200nm.
 Temp 20°C

Retention times: Iodolactam 8.2
 Arylated NHL 10.5

The reaction mixture was stirred at 0°C for 3h until lactam SM was less than 0.1A% vs product (200nm). The reaction mixture was cooled to -10°C and a cold (5°C) freshly prepared solution of sodium sulfite in water (1.65 Kg in 33 L) was added to the reaction mixture over 20 min maintaining the quench temperature <5°C.

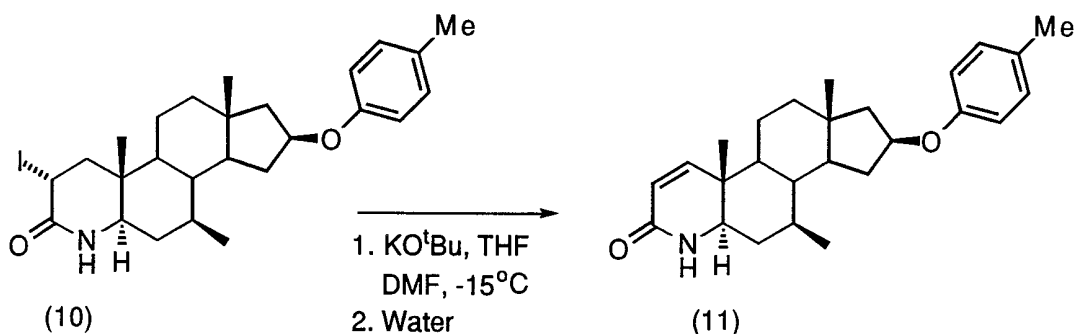
A color change to pale yellow from dark brown was observed.

The mixture was seeded with iodide (10 gm) and water (66 L) added over 1h at 5°C. The resultant slurry was aged at 5°C for 1h.

The slurry was filtered, washed with water (33 L) and dried in a nitrogen stream on the filter funnel overnight to yield pure (10).

EXAMPLE 10

15 Preparation of 4-aza-7β-methyl-16β-(4-methylphenoxy)-5α-androst-1-en-3-one(11)



To a solution of potassium t-butoxide (6.8 Kg) in dry DMF (19.8 L) at -15°C under a nitrogen atmosphere was added a slurry of iodo-lactam (3.95 Kg) in dry THF (19.8 L) over approx 1h. THF (1 L) was used as vessel and line rinse. The reaction temperature was maintained <-15 to -10°C during addition.

After a 15 min age a sample was taken for analysis by HPLC.

HPLC Conditions :

Column Zorbax SB Phenyl 4.6mm x 25cm

	Eluent A	CH ₃ CN	
	Eluent B	Aqueous 0.1M H ₃ PO ₄	
	Isocratic	70% A, 30% B	
	Inj vol	20μl	
5	Detection	UV at 200nm.	
	Temp	20°C	
	Retention times:	Iodolactam	8.2
		(11)	8.9
10		Arylated NHL	10.2

Water (45 L) was added over 20 min maintaining the temperature <10°C. The resultant slurry was aged at 5°C for 2h. The slurry was filtered and washed with water (15 L). The cake was dried in air to <15wt% water.

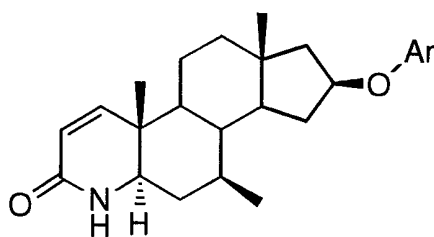
The wet cake was dissolved in THF (30 L) at room temperature and filtered through a 5 micron in-line filter into a 50L vessel. The glassware and line were washed with THF (1 L). The filtrates were concentrated at reduced pressure to about 10L. N-Butyl acetate (20L) was added and concentration continued at atmospheric pressure to a final volume of about 10L.

The hot (120°C) solution was cooled to 80°C and seeded with product (11) (2 gm). The resultant slurry was aged at 80°C for 30 min then cooled to -5°C over 2h.

The slurry was filtered and the cake washed with cold n-butyl acetate (1 L) and dried in a nitrogen stream overnight.

EXAMPLE 11

According to the procedures outlined in Examples 1-10, the following compounds of structural formula below are prepared



(11)

Compound

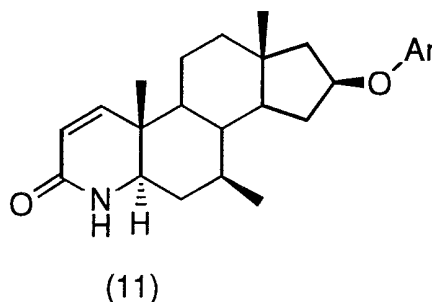
Ar

	12	phenyl
5	13	4-chlorophenyl

While the foregoing specification teaches the principles of the present invention, with examples provided for the purpose of illustration, it will be understood that the practice of the invention encompasses all of the usual variations, adaptations, and modifications, as come within the scope of the following claims and its equivalents.

WHAT IS CLAIMED:

1. A process for producing a compound of structural formula (11):

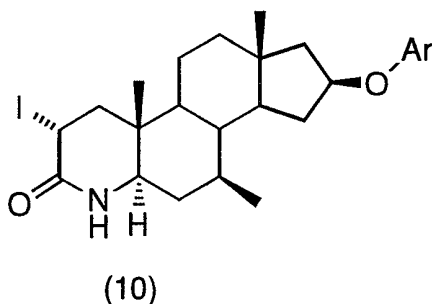


5 wherein:

Ar is an unsubstituted or mono- or di-substituted phenyl, naphthyl, or 5, 6 or 7 membered heteroaromatic ring containing at least one member selected from the group consisting of: one ring oxygen atom, one ring sulfur atom, 1-4 ring nitrogen atoms, or combinations thereof; in which the heteroaromatic ring can also be fused with one benzo or heteroaromatic ring;

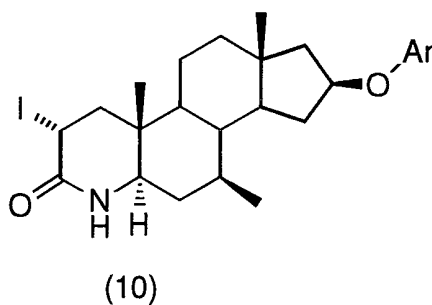
produced by:

treating a compound of structural formula (10):

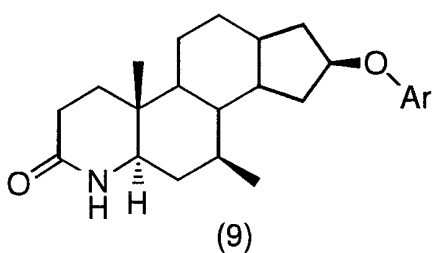


with potassium t-butoxide, and isolating the resulting product (11).

2. The process of Claim 1 additionally comprising the step of producing a compound of structural formula (10):

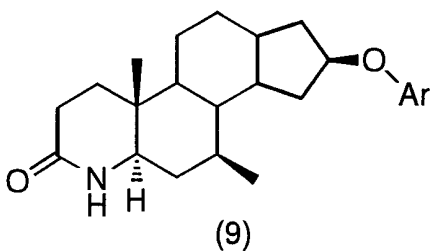


by treating a compound of structural formula (9):

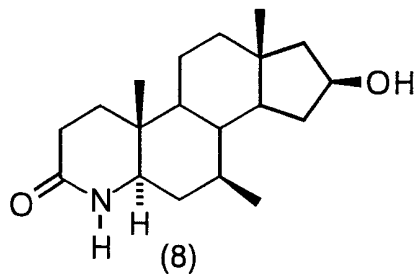


5 with trimethylsilyl chloride in the presence of an organic base and adding iodine, and isolating the resulting product (10).

3. The process of Claim 2 additionally comprising the step of producing a compound of structural formula (9) :

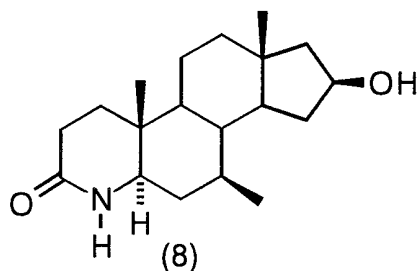


10 by treating a compound of structural formula (8):

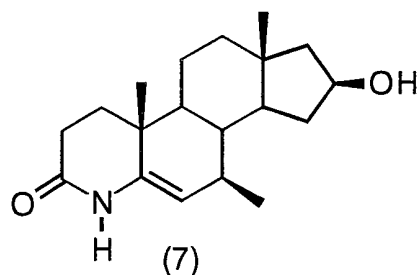


with potassium t-butoxide and adding Ar-F, and isolating the resulting product (9).

4. The process of Claim 3 additionally comprising the
 5 step of producing a compound of structural formula (8):



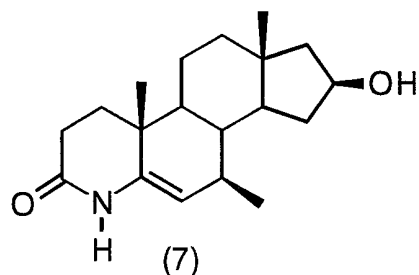
by hydrogenating a compound of structural formula (7):



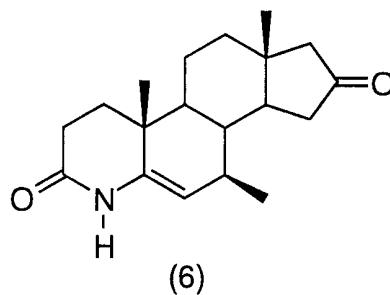
and isolating the resulting product (8).

10

5. The process of Claim 4 additionally comprising the
 step of producing a compound of structural formula (7):

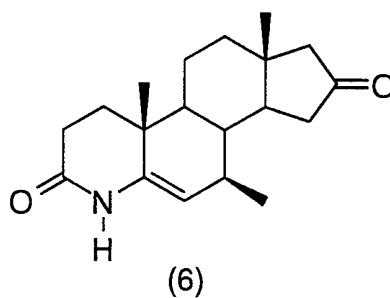


by treating a compound of structural formula (6):

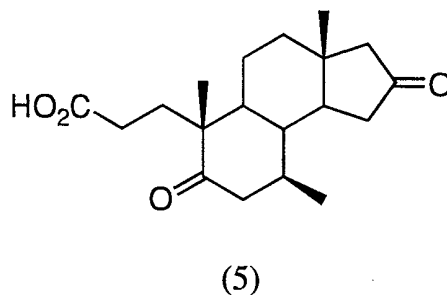


with lithium tri-sec-butylborohydride, followed by an oxidative workup, and isolating the resulting product (7).

- 5 6. The process according to Claim 5, additionally comprising the step of producing a compound of structural formula (6):

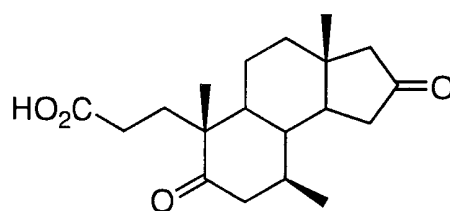


by treating a compound of structural formula (5):



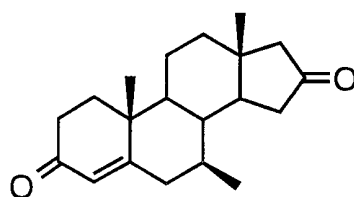
10 with ammonium acetate in refluxing acetic acid, and isolating the resulting product (6).

- 15 7. The process according to Claim 6, additionally comprising the step of producing a compound of structural formula (5)



(5)

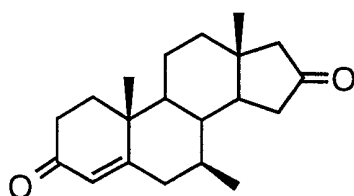
by treating a compound of structural formula (4):



(4)

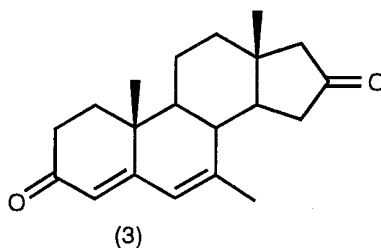
5 with sodium periodate and catalytic potassium permanganate
and sodium carbonate, and isolating the resulting product
(5).

8. The process according to Claim 7, additionally
comprising the step of producing a compound of structural formula (4):



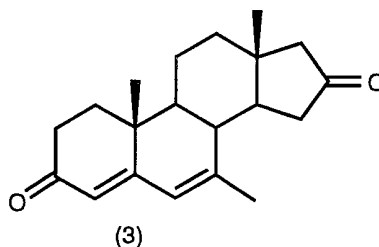
(4)

10 by treating a compound of structural formula (3):

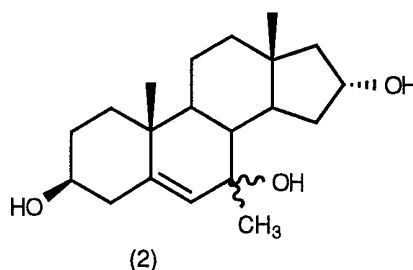


with 10% Pd/C, cyclohexene, and ethanol in an organic solvent,
and isolating the resulting product (4).

- 5 9. The process according to Claim 8, additionally
comprising the step of producing a compound of structural formula (3):

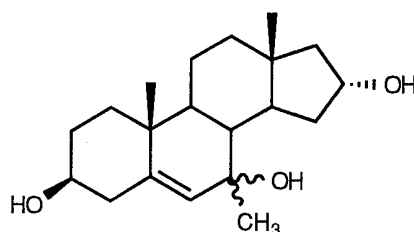


by treating a compound of structural formula (2):



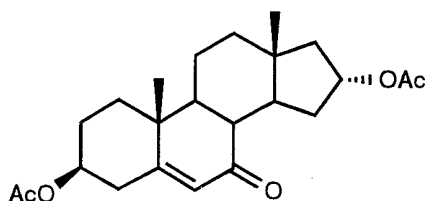
- 10 with aluminum isopropoxide and 2-butanone in the presence of
organic base in an organic solvent, followed by addition of
aqueous acid to the solution, neutralization with aqueous
base and isolation of (3) as a solution in the organic solvent.

- 15 10. The process according to Claim 9, additionally
comprising the step of producing a compound of structural formula (2):



(2)

by treating a compound of structural formula (1):



(1)

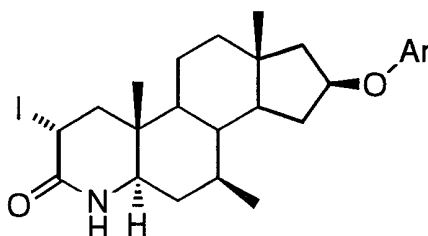
with methyl magnesium chloride in the presence of cerium
chloride in an organic solvent.

5

11. The process according to Claim 1 wherein Ar is
selected from: unsubstituted or mono- or di-substituted phenyl,
naphthyl, pyridyl, furyl, pyrrolyl, thienyl, isothiazolyl, imidazolyl,
10 benzimidazolyl, tetrazolyl, pyrazinyl, pyrimidyl, quinolyl, isoquinolyl,
benzofuryl, isobenzofuryl, benzothienyl, pyrazolyl, indolyl, isoindolyl,
purinyl, carbazolyl, isoxazolyl, thiazolyl, oxazolyl, benzthiazolyl, and
benzoxazolyl.

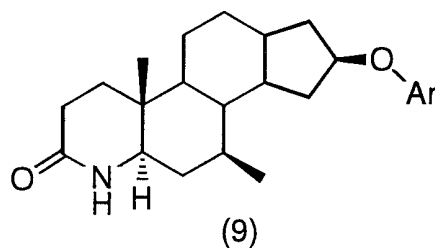
15

12. The process according to Claim 11 additionally
comprising the step of producing a compound of structural formula (10):



(10)

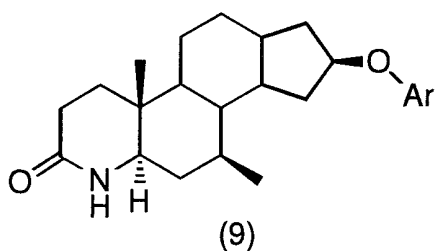
by treating a compound of structural formula (9):



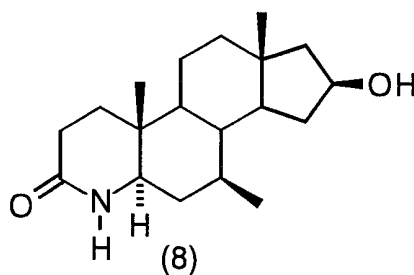
with trimethylsilyl chloride in the presence of an organic base and adding iodine, and isolating the resulting product (10).

5

13. The process according to Claim 12 additionally comprising the step of producing a compound of structural formula (9) :



by treating a compound of structural formula (8):

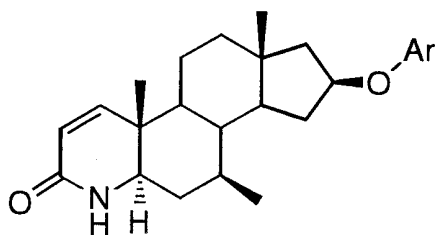


10

with potassium t-butoxide and adding Ar-F, and isolating the resulting product (9).

14. A process for producing a compound of structural formula (11):

15



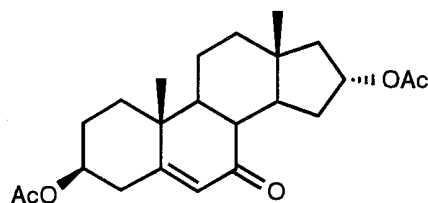
(11)

wherein:

Ar is an unsubstituted or mono- or di-substituted phenyl,
 naphthyl, or 5, 6 or 7 membered heteroaromatic ring
 containing at least one member selected from the group
 consisting of: one ring oxygen atom, one ring sulfur atom,
 1-4 ring nitrogen atoms, or combinations thereof; in which
 the heteroaromatic ring can also be fused with one benzo or
 heteroaromatic ring;

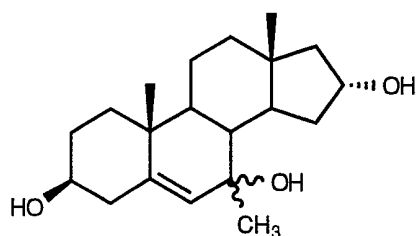
comprising:

(a) by treating a compound of structural formula (1):



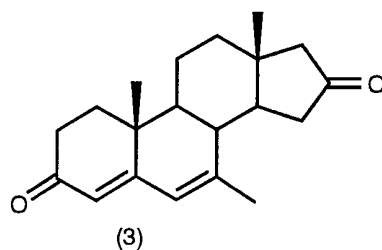
(1)

with methyl magnesium chloride in the presence of cerium
 chloride in an organic solvent to produce (2):

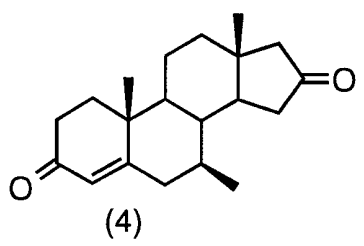


(2)

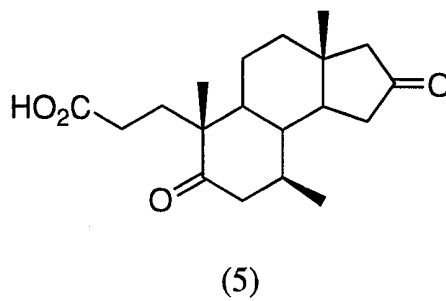
- 5 (b) treating the compound of structural formula (2) with aluminum isopropoxide and 2-butanone in the presence of organic base in an organic solvent, followed by addition of aqueous acid to the solution, neutralization with aqueous base and isolation (3) as a solution in the organic solvent:



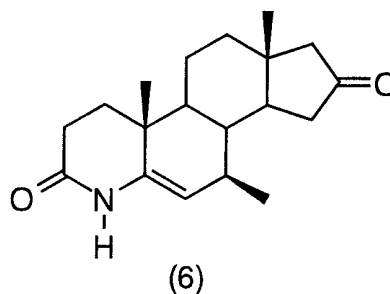
- (c) treating the compound of structural formula (3) with 10% Pd/C, cyclohexene, and ethanol in an organic solvent, and isolating the resulting product (4):



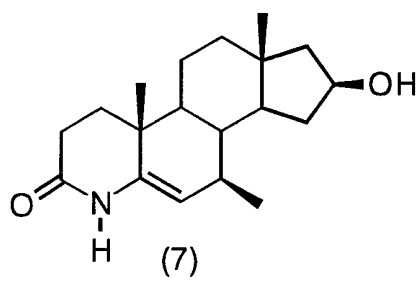
- (d) treating the compound of structural formula (4) with sodium periodate and catalytic potassium permanganate and sodium carbonate, and isolating the resulting product (5):



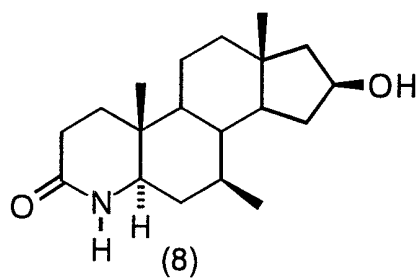
- (e) treating the compound of structural formula (5) with ammonium acetate in refluxing acetic acid, and isolating the resulting product (6):



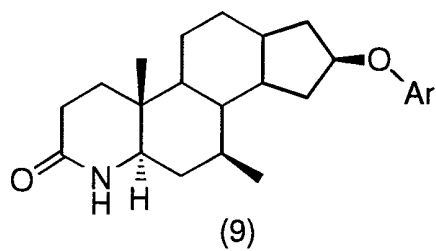
- 5 (f) treating the compound of structural formula (6) with lithium tri-sec-butylborohydride, followed by an oxidative workup, and isolating the resulting product (7):



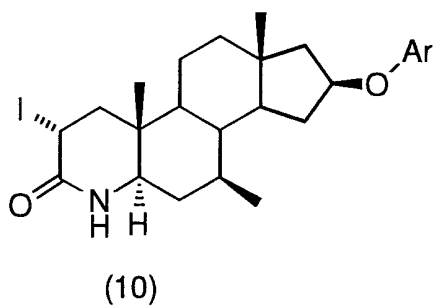
- 10 (g) hydrogenating the compound of structural formula (7) and isolating the resulting product (8):



- (h) treating the compound of structural formula (8) with potassium t-butoxide, adding Ar-F, and isolating the resulting product (9):



- (i) treating the compound of structural formula (9) with trimethylsilyl chloride in the presence of an organic base and adding iodine, and isolating the resulting product (10):

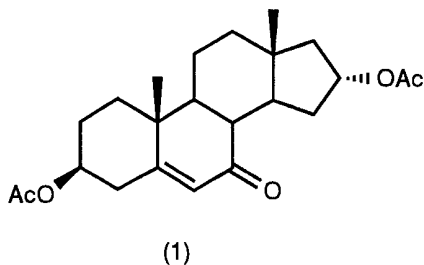


- (i) treating the compound of structural formula (10) with potassium t-butoxide, and isolating the resulting product (11).

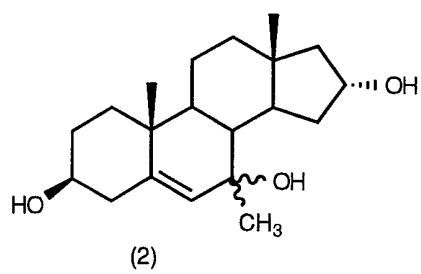
15. The process of Claim 14 wherein Ar is 4-methylphenyl.

16. A compound selected from:

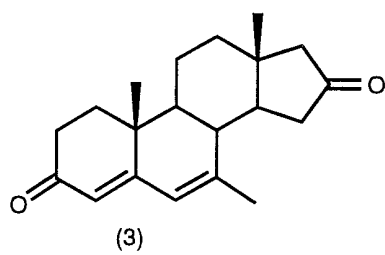
(a)



(b)

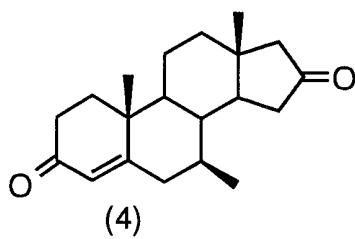


(c)

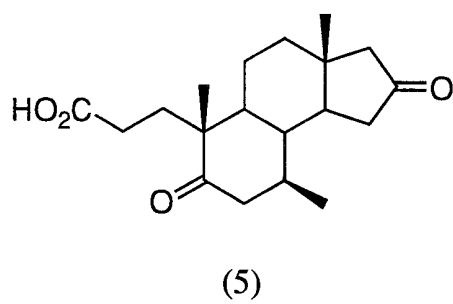


(d)

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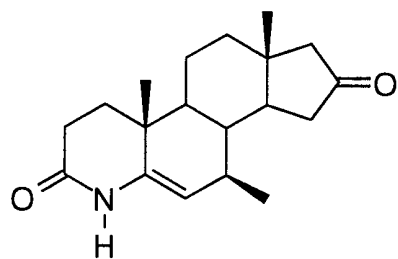


(e)



(f)

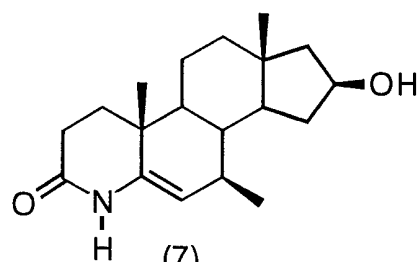
10



(6)

;

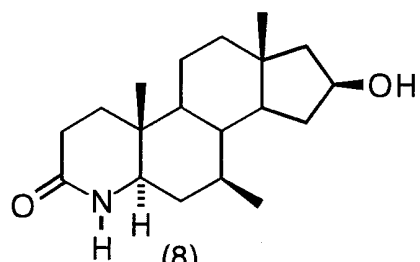
(g)



(7)

;

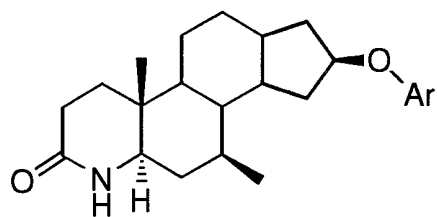
(h)



(8)

;

(i)

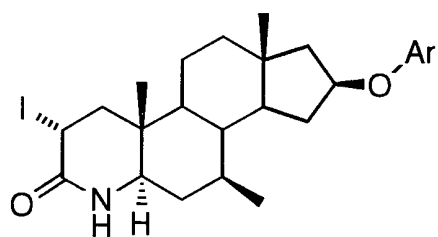


(9)

; and

(j)

5



(10)