



(86) Date de dépôt PCT/PCT Filing Date: 2000/07/25
(87) Date publication PCT/PCT Publication Date: 2003/01/27
(45) Date de délivrance/Issue Date: 2009/09/01
(85) Entrée phase nationale/National Entry: 2003/01/27
(86) N° demande PCT/PCT Application No.: MX 2000/000030
(87) N° publication PCT/PCT Publication No.: 2002/010144

(51) Cl.Int./Int.Cl. *C07H 17/00* (2006.01),
A61K 31/7052 (2006.01), *C07D 267/00* (2006.01),
C07H 17/08 (2006.01)

(72) Inventeurs/Inventors:
DE LA TORRE GARCIA, JUAN ANTONIO, MX;
FRANCO ANDRADE, FIDENCIO, MX;
LARA OCHOA, JOSE MANUEL FRANCISCO, MX

(73) Propriétaires/Owners:
LABORATORIO SILANES, S.A. DE C.V., MX;
INSTITUTO DE INVESTIGACION EN QUIMICA
APLICADA S.C., MX

(74) Agent: GOWLING LAFLEUR HENDERSON LLP

(54) Titre : METHODE DE SYNTHÈSE EN UNE ÉTAPE DE LA 7,16-DESOXY-2-AZA-10-O-CLADINOSYL-12-O-
DESOSAMINYL-4,5-DIHYDROXY-6-ETHYL-3,5,9,11,13,15-HEXAMETHYLBICYCLO(11.2.1)HEXADECA-1(2)-EN-8-
ONE ET DE PRODUCTION D'UNE NOUVELLE FORME DE 9-DESOXO-9A-METHYL-9A-AZA-9A-
HOMOERYTHROMYCINE A

(54) Title: SINGLE-STEP PROCESS FOR PREPARING 7,16-DEOXY-2-AZA-10-O-CLADINOSIL-12-O-DESOSAMINIL-
4,5-DIHYDROXI-6-ETHYL-3,5,9,11,13,15-HEXAMETHYLBICYCLE (11.2.1)HEXADECA-1(2)-EN-8-ONE, AND
OBTAINING A NEW FORM OF 9-DEOXO-9A-METHYL-9A-AZA-9A-HOMOERYTHROMYCIN A

(57) **Abrégé/Abstract:**

The invention relates to an improved method for preparing 7,16-deoxy-2-aza-10-O-cladinosil-12-O-desosaminil-4,5-dihydroxy-6-ethyl-3,5,9,11,13,15-hexamethylbicycle[11.2.1]hexa-deca-1(2)-en-8-ona from erythromycin A, wherein said compound is obtained from erythromycin A with high yields and under soft and adequate production conditions in a single-step process. Transformation of erythromycin A into an intermediate compound called 6,9-iminoether, which is obtained in a single step, is carried out by forming "in situ" mesitylenesulfonyloxime from erythromycin, which undergoes Beckmann's transposition in the presence of a base in aqueous acetone thus giving rise to the iminoether with the aid of the hydroxyl in position 6 of the macrolide ring. Said intermediate compound is transformed into the antibiotic called 9-deoxo-9a-aza-9a-methyl-9a-homoerythromycin A, which is obtained by appropriate precipitation in hexane. A novel form with an anhydrous crystalline structure and physical properties differing from those of forms known to date is thus obtained.



(12) SOLICITUD INTERNACIONAL PUBLICADA EN VIRTUD DEL TRATADO DE COOPERACIÓN
EN MATERIA DE PATENTES (PCT)

(19) Organización Mundial de la Propiedad
Intelectual
Oficina internacional



(43) Fecha de publicación internacional
7 de Febrero de 2002 (07.02.2002)

PCT

(10) Número de Publicación Internacional
WO 02/10144 A1

(51) Clasificación Internacional de Patentes⁷: C07D 267/00

Manuel, Francisco [MX/MX]; Avándaro #49, Col. Vergel de Coyoacán, Del. Tlalpan, Mexico, D.F. 14340 (MX).

(21) Número de la solicitud internacional: PCT/MX00/00030

(22) Fecha de presentación internacional:
25 de Julio de 2000 (25.07.2000)

(74) Mandatarios: LOPEZ SILANES PEREZ, Juan; Amores #1304, Col. del Valle, Mexico, D.F. 03100 etc. (MX).

(25) Idioma de presentación: español

(81) Estados designados (nacional): AE, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CR, CU, CZ, DE, DK, DM, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZW.

(26) Idioma de publicación: español

(71) Solicitantes (para todos los Estados designados salvo US):
LABORATORIO SILANES, S.A. DE C.V. [MX/MX]; Amores #1304, Col. Del Valle, Mexico, D.F. 03100 (MX).
INSTITUTO DE INVESTIGACION EN QUIMICA APLICADA S.C [MX/MX]; 54 Sur #9, Col. CIVAC, Jiutepec, Mor 62550 (MX).

(84) Estados designados (regional): patente ARIPO (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZW), patente euroasiática (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), patente europea (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), patente OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG).

(72) Inventores; e

(75) Inventores/Solicitantes (para US solamente): DE LA TORRE GARCIA, Juan Antonio [MX/MX]; Calle Coco Plumoso #83, Col. Residencial La Palma, Jiutepec, Mor 062573 (MX). FRANCO ANDRADE, Fiden-
cio [MX/MX]; Adrián Castrejón #76, Col. San Pedro Xalpa, Mexico, D.F. 02710 (MX). LARA OCHOA, José

Publicada:
— con informe de búsqueda internacional

[Continúa en la página siguiente]

(54) Title: SINGLE-STEP PROCESS FOR PREPARING 7,16-DEOXY-2-AZA-10-O-CLADINOSIL-12-O-DESOSAMINIL-4,5-DIHYDROXI-6-ETHYL-3,5,9,11,13,15-HEXAMETHYLBICYCLE (11.2.1)HEXADECA-1(2)-EN-8-ONA AND OBTAINING A NEW FORM OF 9-DESOXO-9A-METHYL-9A-AZA-9A-HOMOERYTHROMYCIN A

(54) Título: PROCESO PARA LA PREPARACION EN UN SOLO PASO DE 7,16-DIOXA-2-AZA-10-O-CLADINOSIL-12-O-DESOSAMINIL-4,5-DIHIDROXI-6-ETIL-3,5,9,11,13,15-HEXAMETILBICICLO[11.2.1]HEXA-DECA-1(2)-EN-8-ONA Y OBTENCION DE UNA FORMA NUEVA DE 9-DESOXO-9a-AZA-9a-METIL-9a-HOMOERITROMICINA A

(57) Abstract: The invention relates to an improved method for preparing 7,16-deoxy-2-aza-10-O-cladinosil-12-O-desosaminil-4,5-dihydroxi-6-ethyl-3,5,9,11,13,15-hexamethylbicycle[11.2.1]hexa-deca-1(2)-en-8-ona from erythromycin A, wherein said compound is obtained from erythromycin A with high yields and under soft and adequate production conditions in a single-step process. Transformation of erythromycin A into an intermediate compound called 6,9-iminoether, which is obtained in a single step, is carried out by forming "in situ" mesitylenesulfonyloxime from erythromycin, which undergoes Beckmann's transposition in the presence of a base in aqueous acetone thus giving rise to the iminoether with the aid of the hydroxyl in position 6 of the macrolide ring. Said intermediate compound is transformed into the antibiotic called 9-deoxo-9a-aza-9a-methyl-9a-homoerythromycin A, which is obtained by appropriate precipitation in hexane. A novel form with an anhydrous crystalline structure and physical properties differing from those of forms known to date is thus obtained.

(57) Resumen: Proceso mejorado para la preparación de 7,16-dioxa-2-aza-10-O-cladinosil-12-O-desosaminil-4,5-dihidroxi-6-etil-3,5,9,11,13,15-hexametilbiciclo[11.2.1]hexa-deca-1(2)-en-8-ona a partir de eritromicina A, la cual consiste en obtenerla en un solo paso a partir de la eritromicina A, en buen rendimiento y bajo condiciones suaves y adecuadas para su producción. La transformación de la eritromicina A, hasta un compuesto intermediario, denominado 6,9-iminoéter, el cual se obtiene en un solo paso, se realiza a través de la formación "in situ" de la mesitilensulfoniloxima de la eritromicina, la cual en presencia de una base en acetona acuosa sufre una transposición de Beckmann, dando lugar al iminoéter, por asistencia del hidroxilo en posición 6 del anillo macrólico; este intermediario, es transformado al antibiótico denominado 9-desoxo-9a-aza-9a-metil-9a-homoeritromicina A, el cual es obtenido por precipitación apropiada en hexano, lográndose así una forma novedosa correspondiente con una estructura cristalina anhidra, con características físicas diferentes a las de las formas hasta ahora conocidas.

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— con reivindicaciones modificadas y declaración

*Para códigos de dos letras y otras abreviaturas, véase la sección
"Guidance Notes on Codes and Abbreviations" que aparece al
principio de cada número regular de la Gaceta del PCT.*

SINGLE-STEP PROCESS FOR PREPARING 7, 16-DEOXY-2-AZA-10-O-
CLADINOSIL-12-O-DESOSAMINIL-4, 5-DIHYDROXI-6-ETHYL-3, 5, 9, 11, 13,
15-HEXAMETHYLBICYCLE (11.2.1) HEXADECA-1(2)-EN-8-ONE, AND
OBTAINING A NEW FORM OF 9-DEOXO-9a-METHYL-9a-AZA-9a-
HOMOERYTHROMYCIN A

FIELD OF THE INVENTION

This invention consists of forming an intermediate product called 6,9 iminoether in a single step from erythromycin, which is transformed into a new and useful form of azithromycin, which is recovered by means of precipitation in hexane.

BACKGROUND OF THE INVENTION

The antibiotic [2R-(2R*, 3S*, 4R*, 5R*, 8R*, 10R*, 11R*, 12S*, 13S*, 14R*)]-13-[(2, 6-Dideoxy-3-C-methyl-3-O-methyl- α -L-ribo-hexopyranosyl) oxy]-2-ethyl-3, 4, 10-trihydroxy-3, 5, 6, 8, 10, 12, 14-heptamethyl-11-[[3, 4, 6-trideoxy-3- (dimethylamino)- β -D-xylo-hexopyranosyl]oxy]-1-oxa-6-azacyclopentadecan-15-one, or IUPAC name 9-deoxo-9a-methyl-9a-aza-9a-homoerythromycin A, and generic name azithromycin is a broad-spectrum bactericide derived from erythromycin A. It differs structurally from erythromycin A due to the insertion of a methylated nitrogen moiety in position 9a in the lactone ring to create a 15-member macrolide. The structural modification significantly improves the antibiotic's effectiveness against defective cell wall bacteria such as *Mycoplasma pneumoniae*, *Chlamydia trachomatis*, *Chlamydia pneumoniae*, etc. or the complex *Mycobacteria avium*, and achieves higher concentrations in the organism.

Azithromycin was discovered by Kobrehel et al. and first patented in Yugoslavia under number P592/81, and subsequently in Belgium under number 892357, under the name N-methyl-11-aza-10-deoxy-10-dihydroerythromycin A. The reaction sequence reported in the literature used to transform erythromycin A (1) into azithromycin (5) includes 4 principal steps, illustrated in Figure 1, which are described in general terms below.

a) Formation of oxime (2)

The oxime is formed from erythromycin A (1) by means of reaction with hydroxylamine hydrochloride in methanol.

b) Beckmann's rearrangement of the oxime (2)

The intramolecular participation of the neighboring 6-hydroxy group is observed when Beckmann's rearrangement is carried out at 0°C with p-toluenesulfonyl chloride in aqueous acetone, producing the 6,9-iminoether (3). This iminoether (3) and the process used to obtain it have been described in worldwide patent 26,758, and European patent 0,137,132. In U.S. patent 4,328,334, this iminoether is erroneously assigned to the structure of a lactam obtained using Beckmann's rearrangement from the oxime of erythromycin A (1).

c) Reduction of the iminoether (3)

Reduction of the iminoether (3) to the secondary amine (4) with sodium borohydride in methanol (*J. Chem. Soc. Perkin Trans. 1*, 1986, 1881; *J. Org. Chem.* 1997, 62, 7479-7481) or by catalytic hydrogenation in the presence of platinum dioxide and acetic acid as solvents (*Tetrahedron Lett.* 1994, 35, 3025).

d) Reductive methylation of the secondary amine (4) to obtain azithromycin (5)

This process is described in U.S. patent 4,517,359, and in *J. Chem. Res.* 1988, 132. It consists basically of the Eschweiler-Clarke reaction and uses formaldehyde in acetic acid or formaldehyde, and formic acid in carbon tetrachloride or chloroform for methylation (Figure 1). The main difficulty with these reactions, as they are described, is the formation of certain impurities such as formamide, derived from the amine 9-deoxy-9a-aza-9a-homoerythromycin A.

Recently, an alternative method was described in which the iminoether (3) can be reduced and the product obtained subsequently submitted to reductive methylation in the presence of formaldehyde with a noble metal as catalyst, without the need to isolate the intermediary (Figure 1). Under these conditions, we obtain azithromycin with high purity and good yield in a single step from the iminoether (3) (European patent 0,879,823 A1).

Studies to elucidate the structure of azithromycin have brought to light two crystalline forms corresponding to the monohydrate and dihydrated forms (WO89/00576, and *J. Chem. Res.* 1988, 132). WO89/00576 attributes to the azithromycin patented by Kobrehel et al. (Yugoslav patent P592/81, Belgian patent 892357 and U.S. patent 4,517,359) to correspond with the amorphous form.

This invention is intended to offer an alternative to known methods, in order to form the intermediary 6,9-iminoether in a single step from erythromycin to obtain 9-deoxo-9a-methyl-9a-aza-9a-homoerythromycin A, which is an evident improvement on existing preparation methods.

A further purpose of this invention is to prepare a novel form of 9-deoxo-9a-methyl-9a-aza-9a-homoerythromycin A with physical characteristics different from those detected thus far.

DESCRIPTION OF THE INVENTION

5 All the methods reported to date for preparing azithromycin (5) involve the formation of the oxime (2) from erythromycin A (Figure 1) by treating the erythromycin in methanol with hydroxylamine hydrochloride and a base at reflux temperature for at least 10 hours. This oxime is isolated, purified and subsequently subjected to Beckmann's rearrangement to obtain the intermediary (3) (Figure 1) in aqueous acetone in the presence of p-toluenesulfonylchloride and base for 2 hours at 5°C and 2 hours more at
10 room temperature. The innovative aspect of this invention is that the iminoether (3) is prepared in a single step (Figure 2) from erythromycin A (1), which is operatively and economically more feasible than the aforementioned methods. The reaction described in this invention consists of treating an erythromycin A (1) solution in acetone with O-mesitylenesulfonylhydroxylamine (MSH), to form the mesitylenesulfonyloxime "in
15 situ" from erythromycin A, which, on being treated with an aqueous base (sodium bicarbonate) at 0°C, undergoes a Beckmann's rearrangement, giving rise to the intermediary 6-9-iminoether (3) (Figure 2). Reaction conditions are soft, with short times and the reactive used in this transformation (MSH) is easily prepared as described in *Tetrahedron lett.* No. 40, p. 4133-4135 (1972). Also, the method described in this
20 invention is scalable for industrial production. After preparing the intermediary (3) (Figure 2), it is possible to obtain azithromycin (5) by means of catalytic reduction followed by reductive methylation using common techniques described in the literature (see for example M. Hudlický, Reductions in Organic Chemistry 2nd ed., ACS monograph 188, 1996 or S.H. Pine and B.L. Sánchez, J. Org. Chem. 36, 829-832 (1971).

25 The procedure for producing the intermediate compound (3), called 7,16 deoxy-2-aza-10-O-cladinosyl-12-O-disosaminy-4, 5-dihydroxy-6-ethyl-3, 5,9,11,13,15-hexamethylbicyclo[11,2,1] hexadeca-1(2)-en-8-one is described below, using the following example:

EXAMPLE 1

5 A solution of erythromycin A (6.0 g, 0.082 mol) in 30 ml of acetone, in an N₂ atmosphere was cooled to 0°C, and 1.62g (1.05 eq) of O-(mesitylenesulfonyl) hydroxylamine (MSH) was added. Agitation was continued at 0°C for 5 minutes and the temperature was allowed to rise to room temperature, continuing agitation for one hour more. Thereafter the reaction mixture was again cooled to 0°C, and a solution of 2.75 g (0.032 mol) of sodium bicarbonate in 30 ml of water was added drop by drop, 10 maintaining the internal temperature between 0 and 5°C; the addition time was 30 minutes, and having finished adding the aforementioned solution the temperature was allowed to rise to room temperature and the mixture was agitated for additional 2 hours. Finally, the acetone was evaporated under low pressure and the aqueous residue was adjusted to a pH of 5.5 with HCl 2N. This phase was extracted twice with CH₂Cl₂ (20 15 ml). Extraction was repeated at pH of 6.0 (2 x 20 ml) and finally at pH 8.0 (3 x 20 ml). The pH 8.0 extracts were dried with potassium carbonate and evaporated to dryness, obtaining 4.48 grams (75%) of compound (3). The iminoether (3) obtained was reduced by catalytic hydrogenation in Raney nickel W6 which contains 10% to 11% aluminum, under pressure of 85 bars. The cyclic amine obtained was isolated and dissolved in 20 methylene chloride to be subjected to reductive methylation using formic acid at 88%, formaldehyde at 33% and sodium formiate (S. H. Pine and B. L. Sánchez, J. Org. Chem. 36, 829-832 (1971)). The reaction takes place at 80°C and lasts 24 hours. At the end of the reaction, pH is adjusted to 8 with NaOH and the organic phase is separated. The aqueous layer is extracted several times with methylene chloride, the extracts are 25 combined with the organic layer, the mixture is dried with a drying agent such as sodium sulfate, the methylene chloride is evaporated and the solid obtained is rinsed with water and oven dried. The solid is dissolved in hexane and, under appropriate reflux conditions, precipitates a white crystalline solid which, by means of ¹³C nuclear magnetic resonance and mass spectrometry, is identified as the compound 9-deoxo-9a-

5 methyl-9a-aza-9a-homoerythromycin A. Chemical shifts characterizing the $^{13}\text{C}(\text{CDCl}_3)$ spectrum are as follows: 178.9 ppm, 149.9 ppm, 102.8 ppm, 94.3 ppm, 83.18 ppm (the spectrum is shown in Figure 3). The molecular weight determined by mass spectrometry is 748, and the fragmentation pattern is consistent with that of a 9-deoxo-9a-methyl-9a-aza-9a-homoerythromycin A molecule (the mass spectrum is shown in Figure 4).

10 The melting point of the crystal, determined by the Fisher Jones method, is 188°C to 189°C. Using Scanning Differential Thermal Analysis, it is obtained an endotherm at 187.70°C. The corresponding graph is shown in Figure 5. Calculating specific rotation gives a value of - 0.36 (1% in CHCl_3). These parameters are clearly different from the values found for other forms of azithromycin patented to date. Thus, we find that the azithromycin reported by Kobrehel et al. (Yugoslav patent 592/81, Belgian patent 892357, U.S. patent 4,517,359, Mexican patent 9100364) has a melting point from 113°C to 115°C and its specific rotation is -37.0 (1% in CHCl_3). The azithromycin
15 patented by Bright (U.S. patent 4474768) has a melting point of 142°C (in recrystallized form), and the dihydrated crystalline azithromycin has a melting point of 125°C and a specific rotation of -41.4 (1% in CHCl_3) (WO89/00576, and Mexican patent 176627).

20 The new crystal's infrared spectrum shows four medium intensity signals in the 3000 cm^{-1} to 3700 cm^{-1} region, located at approximately 3600 cm^{-1} , 3553 cm^{-1} , 3375 cm^{-1} , and 3075 cm^{-1} . On the contrary, it does not display the intense signal reported for the dihydrated form (WO89/00576) located at 3488 cm^{-1} , or those located at 2089 cm^{-1} and 1644 cm^{-1} . In contrast, the new crystal's spectrum shows two signals
25 around 2365 cm^{-1} . The infrared spectrum of the crystal obtained is shown in Figure 6.

Calculating the amount of water present in the new crystal using Karl Fisher's method gives us a value of 0.65%. Using thermogravimetric analysis we obtain a weight loss equal to 0.6% by heating to 200°C at a rate of 30°C per minute. Figure 7 shows the

graph obtained using this method. These results indicate that the water present in the sample corresponds to moisture absorbed from the atmosphere but not hydration water (defined as water molecules that form part of the crystalline network), as the theoretical minimum corresponding to a hydration water molecule will be 2.35% of its total weight. This conclusion that the detected water correspond only to moisture is corroborated by the elemental analysis of the sample, obtaining the ratio: C 60.59%, H 10.06%, N 3.65%, O 25.77%, which coincides with condensate formula $C_{38}H_{72}N_2O_{12}$.

Based on the physical characteristics identified for the new crystal, we conclude that the new physical form is clearly different in its physical properties from the types of azithromycin patented to date. In order to confirm this conclusion, the structure was elucidated by single crystal X-ray diffraction, finding that it coincides with the anhydrous crystalline form, with a tetragonal crystal system and the space group $P4_22_12$. These and other crystallographic data from the diffraction analysis are compared with data reported for the dihydrated crystalline form in Table 1 (J. Chem. Res. 152-153 (1998)). Figure 8 shows the molecular structure of the anhydrous crystalline azithromycin, and Figure 9 illustrates the corresponding molecular packing.

TABLE 1.- CRYSTALLOGRAPHIC DATA FOR THE ANHYDROUS CRYSTALLINE FORM AND COMPARISON WITH DATA REPORTED FOR THE DIHYDRATED CRYSTALLINE FORM OF AZITHROMYCIN.

	ANHYDROUS	DIHYDRATED
CRYSTAL SYSTEM	TETRAGONAL	ORTHORHOMBIC
SPACE GROUP	$P4_22_12$	$P2_12_12_1$
CELL CONSTANTS	$A = 14.452 \text{ \AA}^0$	$a = 17.860 \text{ \AA}^0$
	$B = 14.452 \text{ \AA}^0$	$b = 16.889 \text{ \AA}^0$
	$C = 41.645 \text{ \AA}^0$	$c = 14.752 \text{ \AA}^0$

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Volume	8698 Å ³	4449.8 Å ³
Calculated density	1.144 g/cm ³	1.177 g/cm ³
λ (Cu-K α)	1.5418 Å	1.5418 Å
Number of reflections	3412	3846
R	0.0546	0.077

According to existing definitions (e.g. J.P. Glisker, Crystal Structure Analysis for Chemists and Biologists, VCH publishers, 1994, page 657, and H.G. Brittain, Physical Characteristics of Pharmaceutical Solids, Marcel Dekker, Inc., 1995, page. 108) the hydrated physical forms of azithromycin reported in U.S. patent 4474768 and WO89/00576 are pseudo-polymorphous forms of the anhydrous crystalline form obtained here, while the physical form reported by Kobrehel et al. (Yugoslav patent 592/81, Belgian patent 892357 U.S. patent 4,517,359, Mexican patent 9100364), according to WO89/00576 corresponds to the amorphous form.

In addition to its novel features, the physical form obtained has physical characteristics that make it useful in preparing pharmaceutical preparations, with significant advantages over the forms existing to date. Thus, WO89/00576 indicates that the forms reported by Kobrehel et al. (Yugoslav patent 592/81, Belgian patent 892357, U.S. patent 4,517,359, Mexican patent 9100364) and by Bright (U.S. patent 4474768) are highly hygroscopes, which significantly complicates the production of pharmaceutical preparations. In contrast, the anhydrous crystalline form obtained here, when exposed to room conditions, at an relative humidity average of 45%, for ten days, increases its moisture content by only 0.55%, while a reference sample of dihydrated azithromycin increased its moisture content by 1% in the same time. These data are indicative of anhydrous crystalline azithromycin's stability when exposed to moisture, which makes it useful in producing pharmaceutical preparations and represents a significant advantage over the more hygroscopic forms.

5 In order to test the performance of anhydrous crystalline azithromycin in producing pharmaceutical preparations, 500 mg azithromycin tablets were made with total weight of one gram. The dissolution profile of these tablets was determined, and compared with the dissolution profile of tablets made with the same preparation using dihydrated
10 azithromycin. The used solvents, and the procedure followed, were similar to those indicated for capsules in U.S. Pharmacopoeia 2000, page 186. The dissolution values obtained for the tablets made with anhydrous crystalline azithromycin were significantly higher than those obtained for the dihydrated form. This property gives the anhydrous crystalline form reported herein significant practical advantages over the dihydrated
15 forms, given that increased solubility of the pharmaceutical preparation generally implies greater bioavailability of the drug and in consequence increases its therapeutic effectiveness.

15 The two characteristics described above for the anhydrous crystalline form, of its low hygroscopic quality, and the fact that their pharmaceutical preparations have adequate dissolution, offering even higher solubility than the equivalent preparation using the dihydrated form, give the new crystalline form reported herein significant practical advantages over the forms of azithromycin reported to date.

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In one aspect, the invention provides a single-step process for preparing 7,16-deoxy-2-aza-10-O-cladinosyl-12-O-desosaminyl-4,5-dihydroxy-6-ethyl-3,5,9,11,13,15-hexamethylbicyclo [11.2.1] hexadeca-1(2)-en-8-one, an intermediate compound in the production of 9-deoxo-9a-methyl-9a-aza-9a-homoerythromycin A, comprising mixing erythromycin A in acetone with mesitylenesulfonylhydroxylamine, and treating the resulting mixture with aqueous sodium bicarbonate to obtain the intermediate compound, which is the 6,9-iminoether.

In alternative embodiments, the invention provides a single-step process for preparing 7,16-deoxy-2-aza-10-O-cladinosyl-12-O-desosaminyl-4,5-dihydroxy-6-ethyl-3,5,9,11,13,15-hexamethylbicyclo[11.2.1] hexadeca-1(2)-en-8-one, an intermediate compound in the production of 9-deoxo-9a-methyl-9a-aza-9a-homoerythromycin A as described herein, characterized by the fact that the solution of erythromycin in 30 ml of acetone under an inert atmosphere is cooled to 0°C and 1.62g (1.05 equivalents) of O-(mesitylenesulfonyl)hydroxylamine (MSH) is added; the mixture is agitated at 0°C in 5 minute intervals after which the temperature is raised continuing to agitate it for another hour.

In alternative embodiments, the invention provides a single-step process for preparing 7,16-deoxy-2-aza-10-O-cladinosyl-12-O-desosaminyl-4,5-dihydroxy-6-ethyl-3,5,9,11,13,15-hexamethylbicyclo[11.2.1] hexadeca-1(2)-en-8-one, an intermediate compound in the production of 9-deoxo-9a-methyl-9a-aza-9a-homoerythromycin A as described herein, characterized by the fact that the mixture obtained is again cooled to 0°C, adding a sodium bicarbonate solution in a concentration of 0.032 mol in 30 ml of water drop by drop over a 30 minute interval; the temperature is maintained for an interval ranging from 0 to 5°C, the temperature is increased and the mixture is agitated for additional two hours.

In alternative embodiments, the invention provides a single-step process for preparing 7,16-deoxy-2-aza-10-O-cladinosyl-12-O-desosaminyl-4,5-dihydroxy-6-ethyl-3,5,9,11,13,15-hexamethylbicyclo[11.2.1] hexadeca-1(2)-en-8-one, an intermediate compound in the production of 9-deoxo-9a-methyl-9a-aza-9a-homoerythromycin A as described herein, characterized by the fact that to arrive at the intermediate product, called iminoether, the following procedure is used: the acetone is evaporated under low pressure and the residue is adjusted to pH 5.5 with HCl 2N, this phase is extracted with CH₂Cl₂, extraction is repeated at pH 6.0 and pH 8.0; the extracts from each pH are combined, and dried with K₂CO₃, evaporating to dryness; at pH 8.0 the iminoether

9b

(3) is isolated from the intermediate compound, and finally transformed into 9-deoxo-9amethyl-9a-aza-9a-homoerythromycin A.

In alternative embodiments, the invention provides a single-step process for preparing 7,16-deoxy-2-aza-10-O-cladinosyl-12-O-desosaminy-4,5-dihydroxy-6-ethyl-3,5,9,11,13,15-hexamethylbicycle[11.2.1] hexadeca-1(2)-en-8-one, an intermediate compound in the production of 9-deoxo-9a-methyl-9a-aza-9a-homoerythromycin A as described herein by appropriate crystallization in hexane.

In another aspect, the invention provides a compound having the anhydrous crystalline form of [2R-(2R*, 3S*, 4R*, 5R*, 8R*, 10R*, 11R*, 12S*, 13S*, 14R*)]-13-[(2, 6-dideoxy-3-C-methyl-3-O-methyl- α -L-ribo-hexopyranosyl)oxy]-2-ethyl-3,4,10-trihydroxy-3, 5,6,8, 10,12, 14-heptamethyl-11-[[3,4,6-trideoxy-3-(dimethylamino)-[3-D-xylohexopyranosyl]oxy]-1-oxa-6-azacyclopentadecan- 15-one (or IUPAC name 9-deoxo-9a-methyl-9a-aza-9a-homoerythromycin A)

wherein the compound has the following physical properties:

- a) main chemical shifts determined by Nuclear Magnetic Resonance of C13 are: 178.9 ppm, 149.9 ppm, 102.8 ppm, 94.3 ppm, 83.18 ppm;
- b) the melting point is 188°C to 189°C;
- c) the scanning differential thermal analysis endotherm is at 187.7°C;
- d) specific rotation - 0.36 (1 % in CHCl₃);
- e) infrared spectroscopy main signals are: 3650 cm⁻¹, 3600 cm⁻¹, 3553 cm⁻¹, 3375 cm⁻¹, 3075 cm⁻¹, 2950 cm⁻¹, 2945 cm⁻¹, 1750 cm⁻¹;
- f) X ray diffraction shows a tetragonal crystal system, space group P4₂2₁2, with cell constants a = 14.452 Å, b = 14.452 Å, c = 41.645 Å and volume 8698 Å³.

In another aspect, the invention provides a pharmaceutical composition comprising a compound as described herein in combination with a pharmaceutically acceptable carrier.

CLAIMS

1. Single-step process for preparing 7,16-deoxy-2-aza-10-O-cladinosyl-12-O-desosaminyl-4,5-dihydroxy-6-ethyl-3,5,9,11,13,15-hexamethylbicyclo [11.2.1] hexadeca-1(2)-en-8-one, an intermediate compound in the production of 9-deoxo-9a-methyl-9a-aza-9a-homoerythromycin A, comprising mixing erythromycin A in acetone with mesitylenesulfonylhydroxylamine, and treating the resulting mixture with aqueous sodium bicarbonate to obtain the intermediate compound, which is the 6,9-iminoether.
2. Single-step process for preparing 7,16-deoxy-2-aza- 10-O-cladinosyl-12-O-desosaminyl-4,5-dihydroxy-6-ethyl-3, 5, 9,11,13,15-hexamethylbicycle[11.2.1] hexadeca-1(2)-en-8-one, an intermediate compound in the production of 9-deoxo-9a-methyl-9a-aza-9a-homoerythromycin A in accordance with claim 1, characterized by the fact that the solution of erythromycin in 30 ml of acetone under an inert atmosphere is cooled to 0°C and 1.62g (1.05 equivalents) of O-(mesitylenesulfonyl)hydroxylamine (MSH) is added; the mixture is agitated at 0°C in 5 minute intervals after which the temperature is raised continuing to agitate it for another hour.
3. Single-step process for preparing 7,16-deoxy-2-aza-10-O-cladinosyl-12-O-desosaminyl-4,5-dihydroxy-6-ethyl-3,5,9,11,13,15-hexamethylbicycle[11.2.1] hexadeca-1(2)-en-8-one, an intermediate compound in the production of 9-deoxo-9a-methyl- 9a-aza-9a-homoerythromycin A in accordance with claim 1, characterized by the fact that the mixture obtained is again cooled to 0°C, adding a sodium bicarbonate solution in a concentration of 0.032 mol in 30 ml of water drop by drop over a 30 minute interval; the temperature is maintained for an interval ranging from 0 to 5°C, the temperature is increased and the mixture is agitated for additional two hours.
4. Single-step process for preparing 7,16-deoxy-2-aza-10-O-cladinosyl-12-O-desosaminyl-4,5-dihydroxy-6-ethyl-3,5,9,11,13,15-hexamethylbicycle[11.2.1] hexadeca-1(2)-en-8-one, an intermediate compound in the production of 9-deoxo-9a-methyl- 9a-aza-9a-homoerythromycin A in accordance with claim 3, characterized by the fact that to arrive at the intermediate product, called iminoether, the following procedure is used: the acetone is evaporated under low pressure and the residue is adjusted to pH 5.5 with HCl 2N, this phase is extracted with CH₂Cl₂, extraction is repeated at pH 6.0 and pH 8.0; the extracts from each pH are combined, and dried with K₂CO₃, evaporating to dryness; at

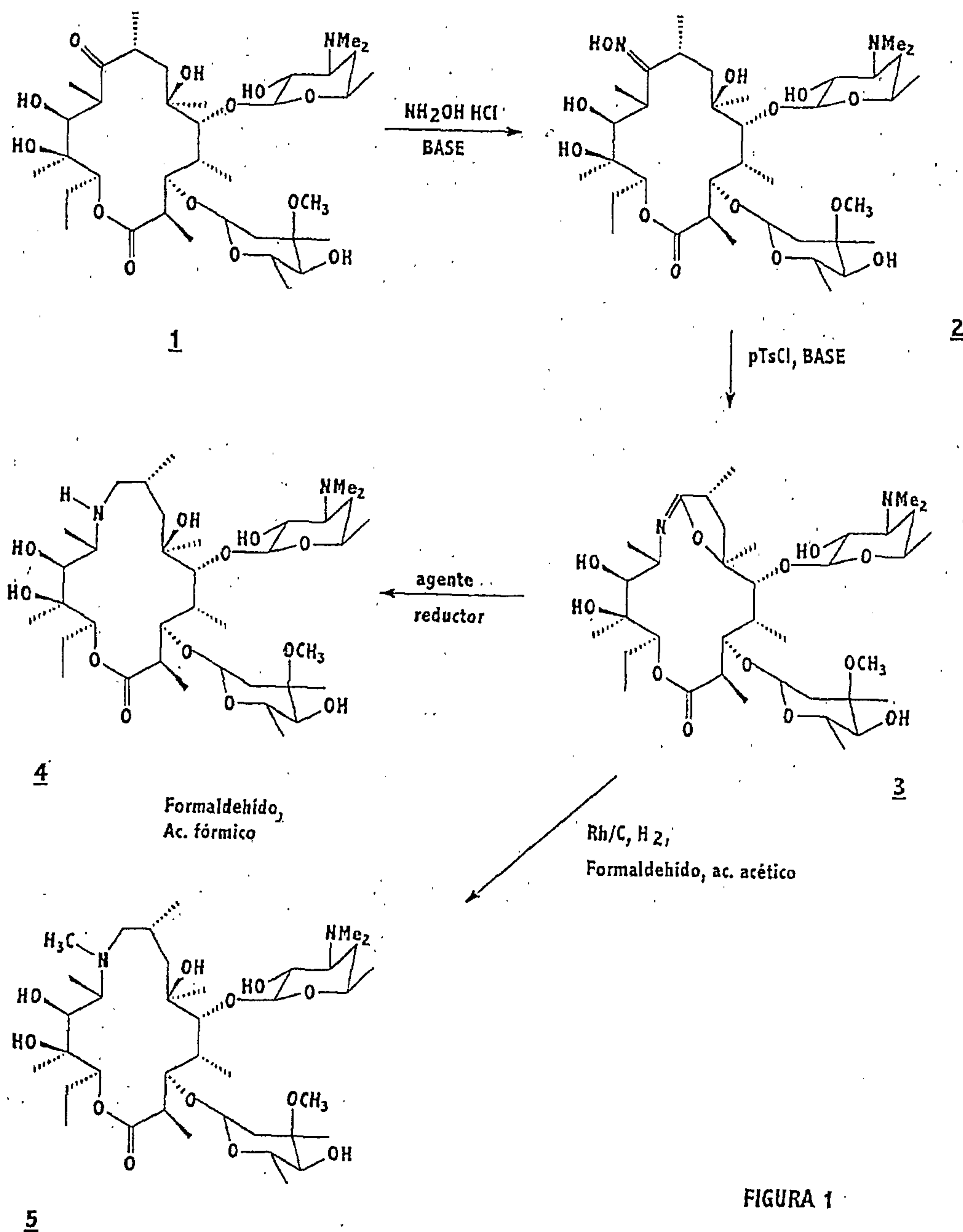
pH 8.0 the iminoether (3) is isolated from the intermediate compound, and finally transformed into 9-deoxo-9amethyl-9a-aza-9a-homoerythromycin A.

5. Single-step process for preparing 7,16-deoxy-2-aza-10-O-cladinosyl-12-O-desosaminyl-4,5-dihydroxy-6-ethyl-3,5,9,11,13,15-hexamethylbicycle[11.2.1] hexadeca-l(2)-en-8-one, an intermediate compound in the production of 9-deoxo-9a-methyl-9a-aza-9a-homoerythromycin A in accordance with claims 1 through 4 by appropriate crystallization in hexane.
6. A compound having the anhydrous crystalline form of [2R-(2R*, 3S*, 4R*, 5R*, 8R*, 10R*, 11R*, 12S*, 13S*, 14R*)]-13-[(2, 6-dideoxy-3-C-methyl-3-O-methyl-a-L-ribohexopyranosyl)oxy]-2-ethyl-3,4,10-trihydroxy-3, 5,6,8, 10,12, 14-heptamethyl-11-[[3,4,6-trideoxy-3-(dimethylamino)-[3-D-xylohexopyranosyl]oxy]-1-oxa-6-azacyclopentadecan- 15-one (or IUPAC name 9-deoxo-9a-methyl-9a-aza-9a-homoerythromycin A)

wherein the compound has the following physical properties:

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 - d) specific rotation - 0.36 (1 % in CHCl₃);
 - e) infrared spectroscopy main signals are: 3650 cm⁻¹, 3600 cm⁻¹, 3553 cm⁻¹, 3375 cm⁻¹, 3075 cm⁻¹, 2950 cm⁻¹, 2945 cm⁻¹, 1750 cm⁻¹;
 - f) X ray diffraction shows a tetragonal crystal system, space group P4₂2₁2, with cell constants a = 14.452 Å, b = 14.452 Å, c = 41.645 Å and volume 8698 Å³.
7. A pharmaceutical composition comprising a compound defined by claim 6 in combination with a pharmaceutically acceptable carrier.

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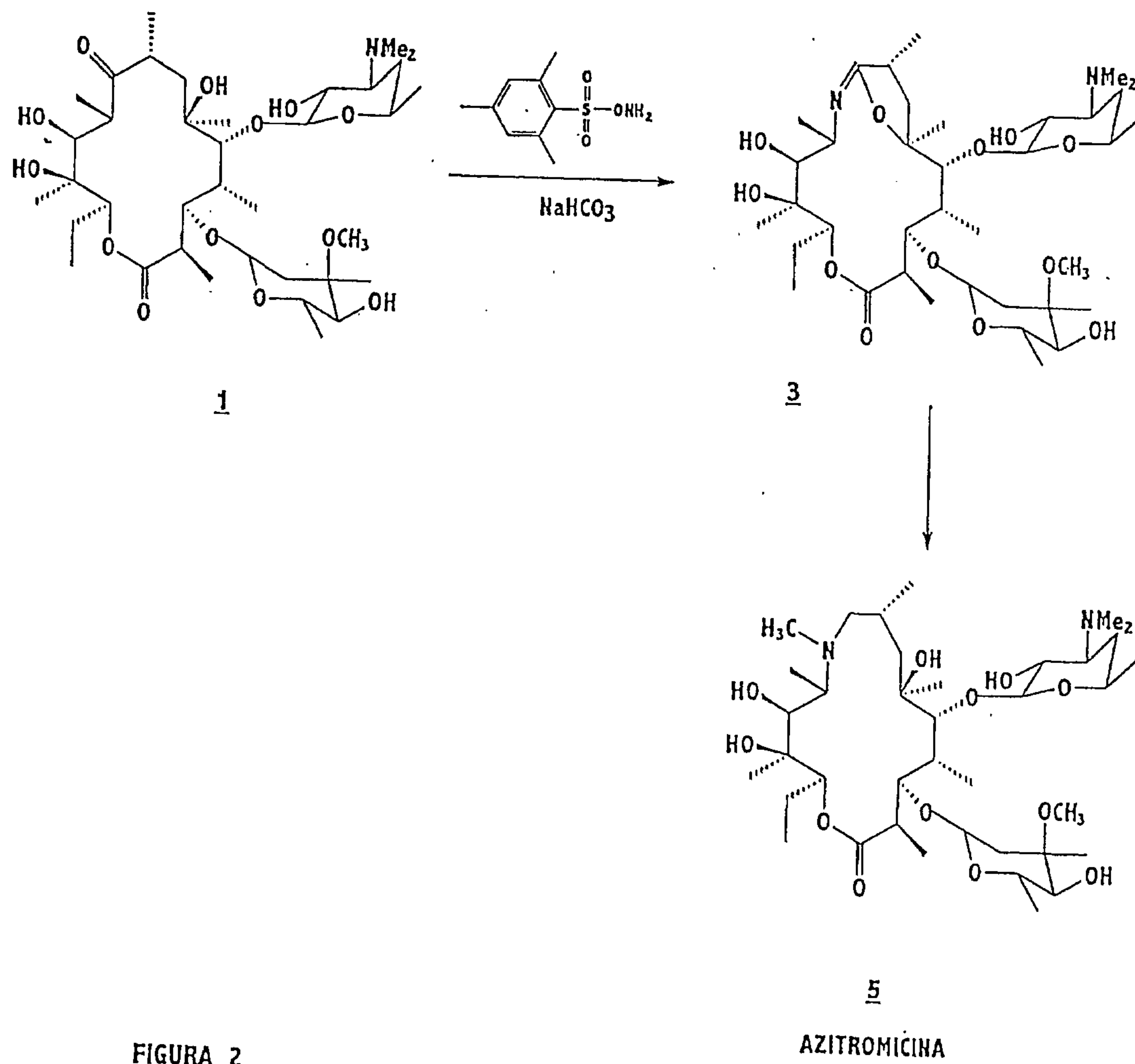


FIGURA 3

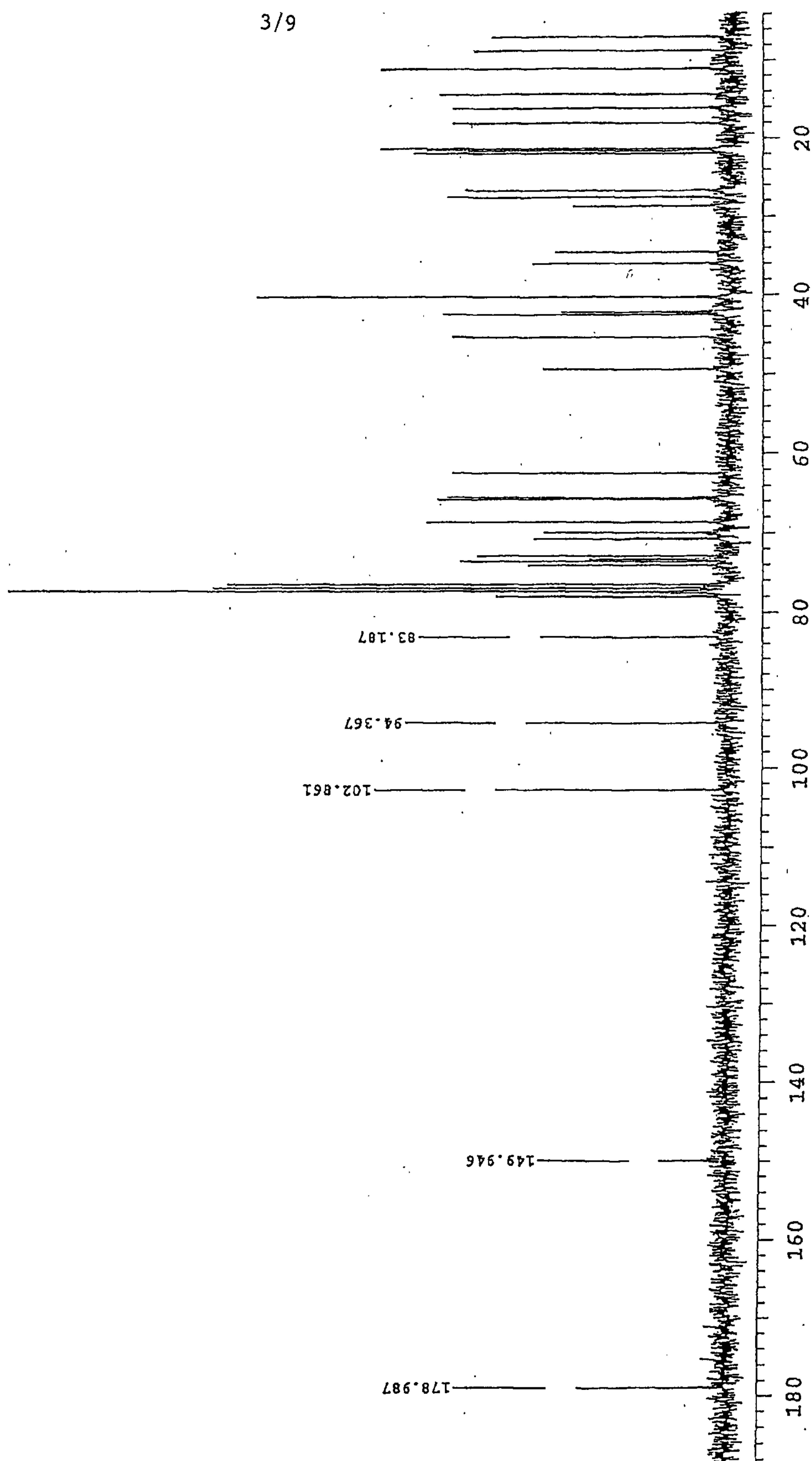
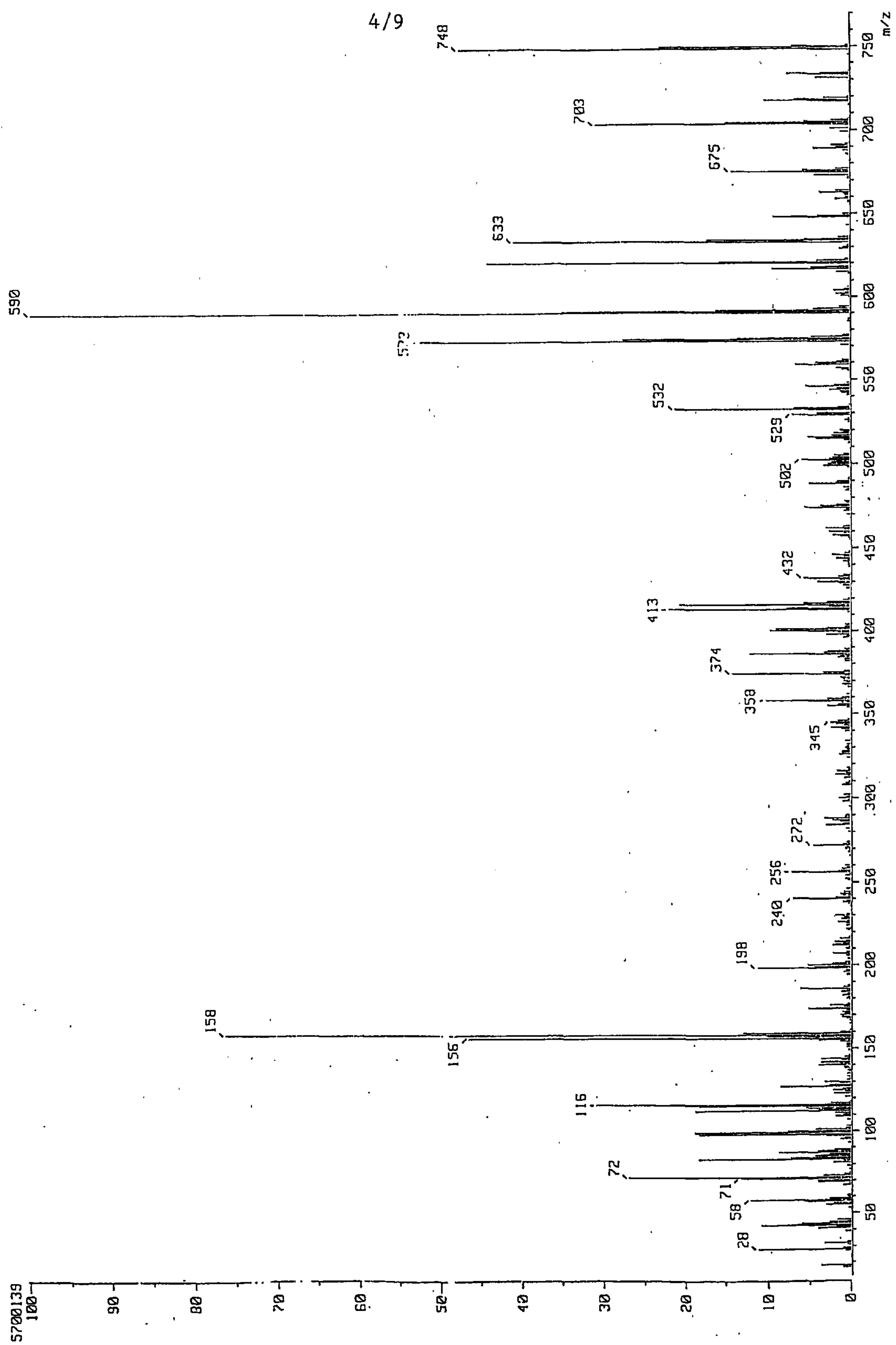
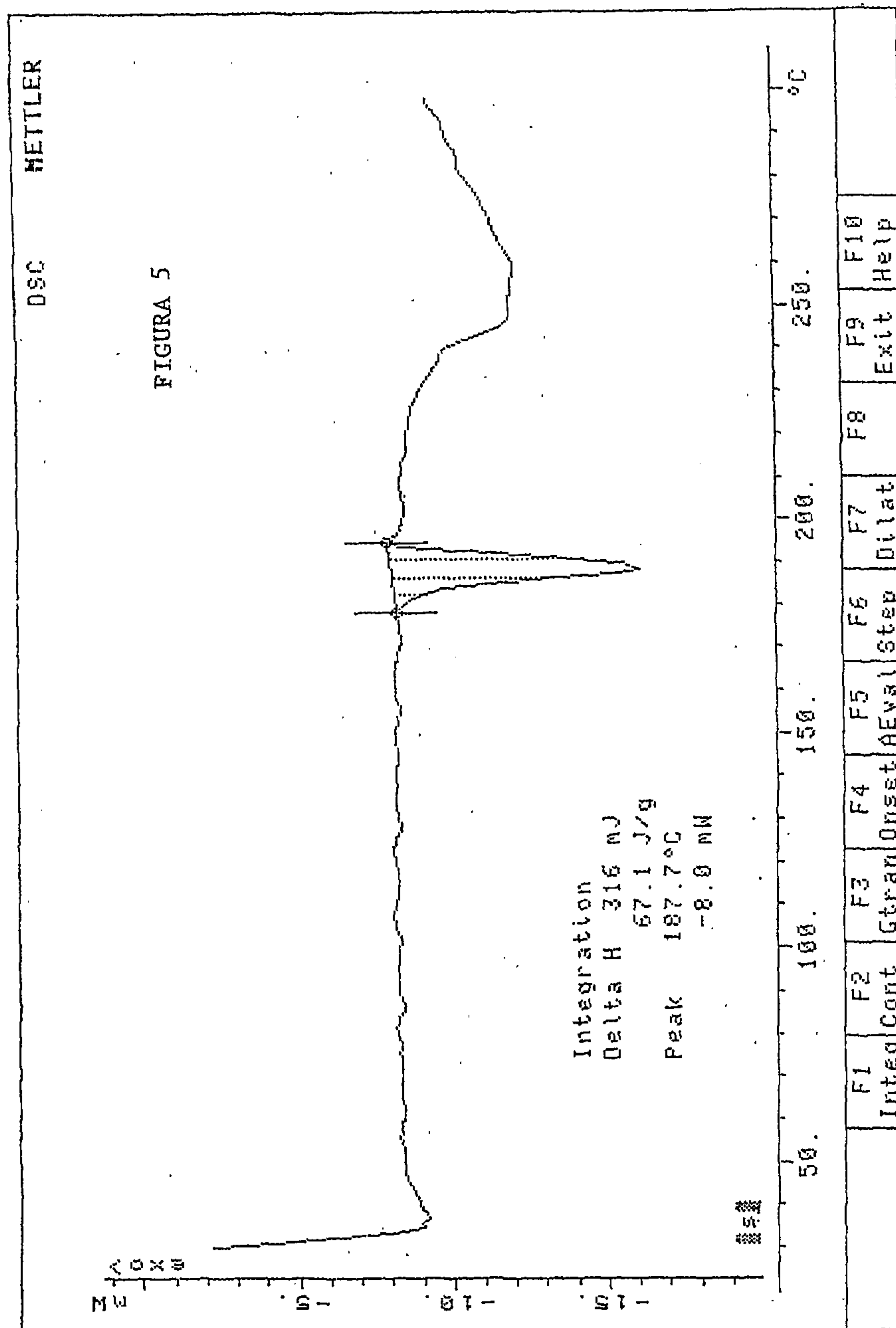


FIGURA 4

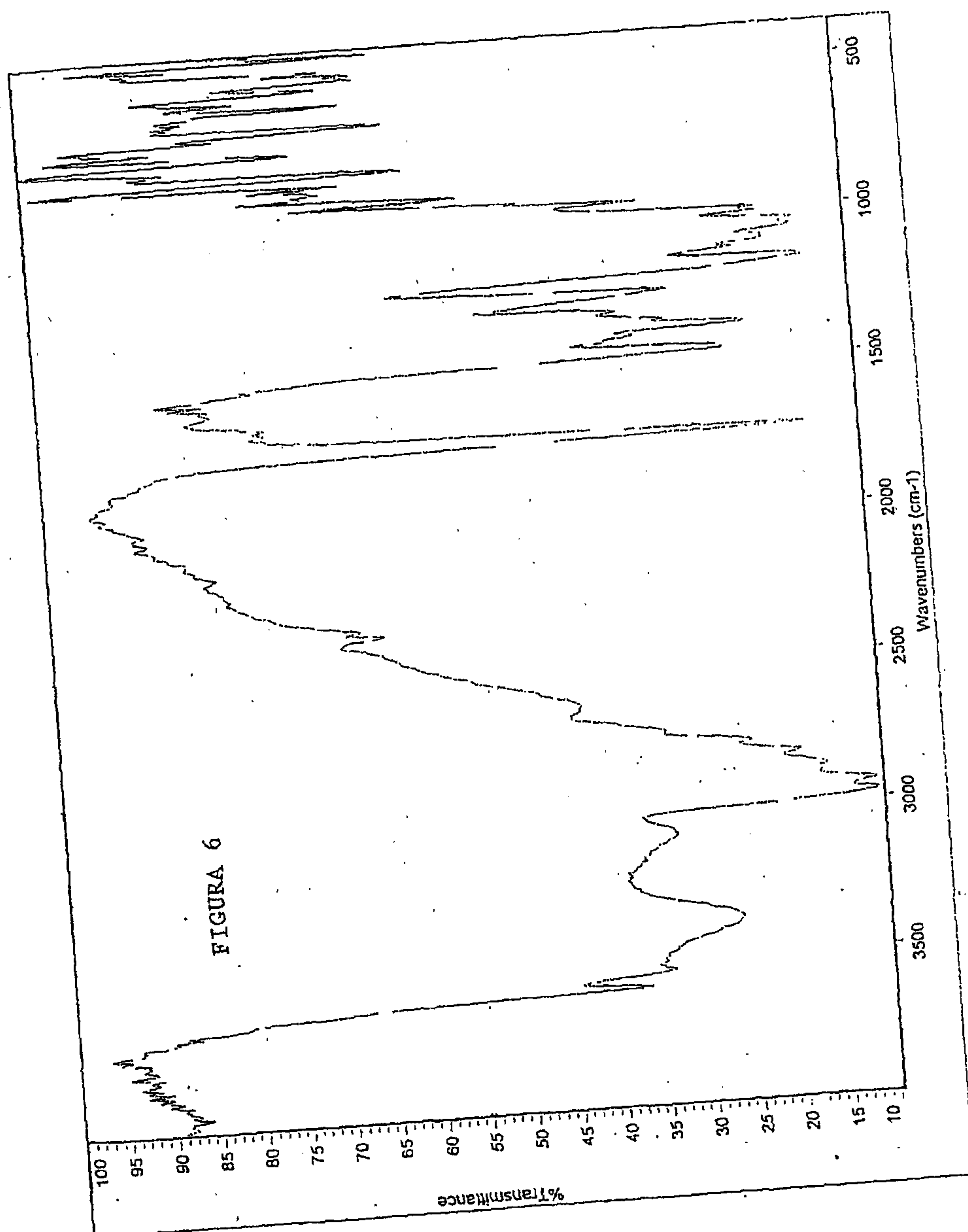


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FIGURA 7

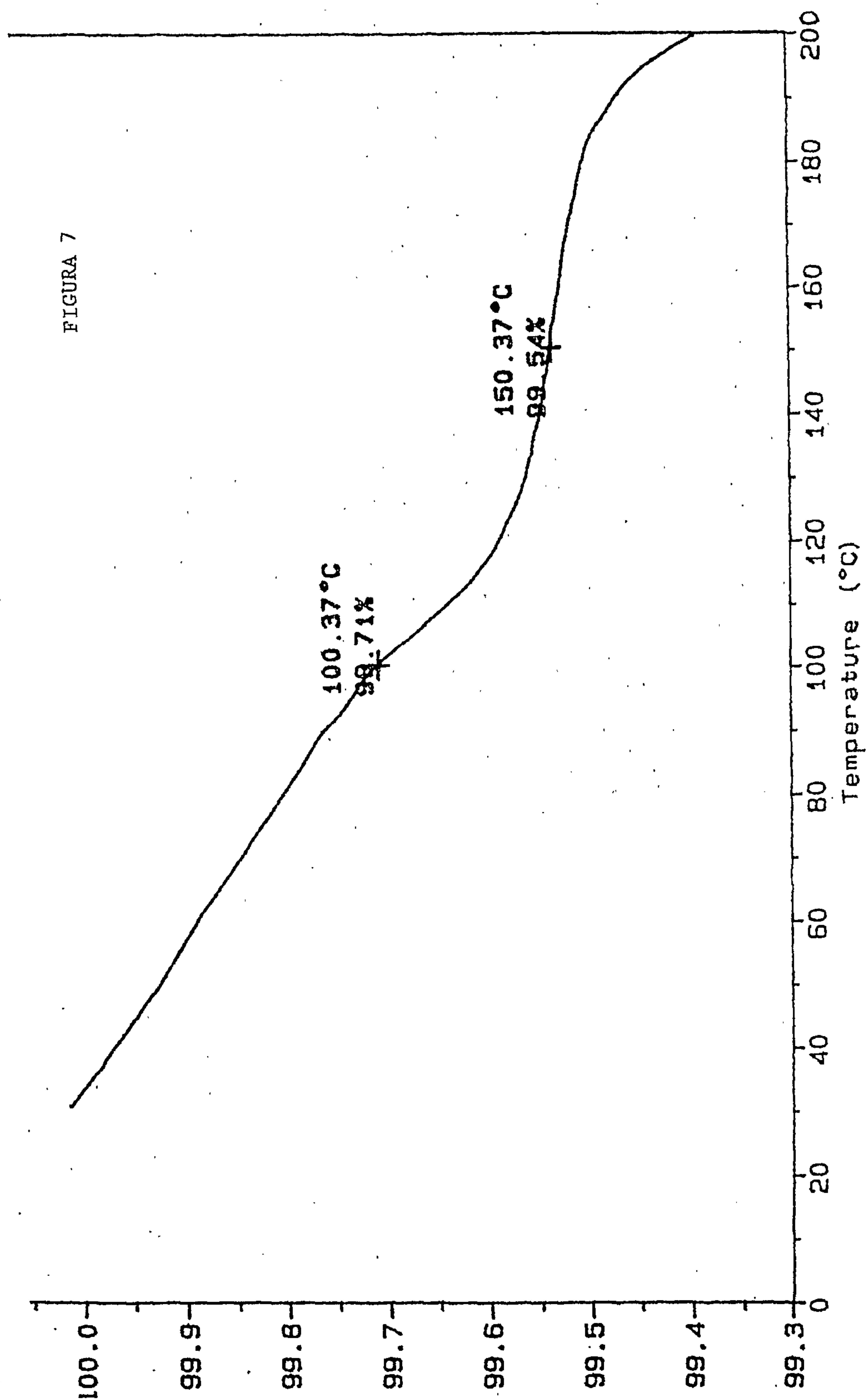


FIGURA 8

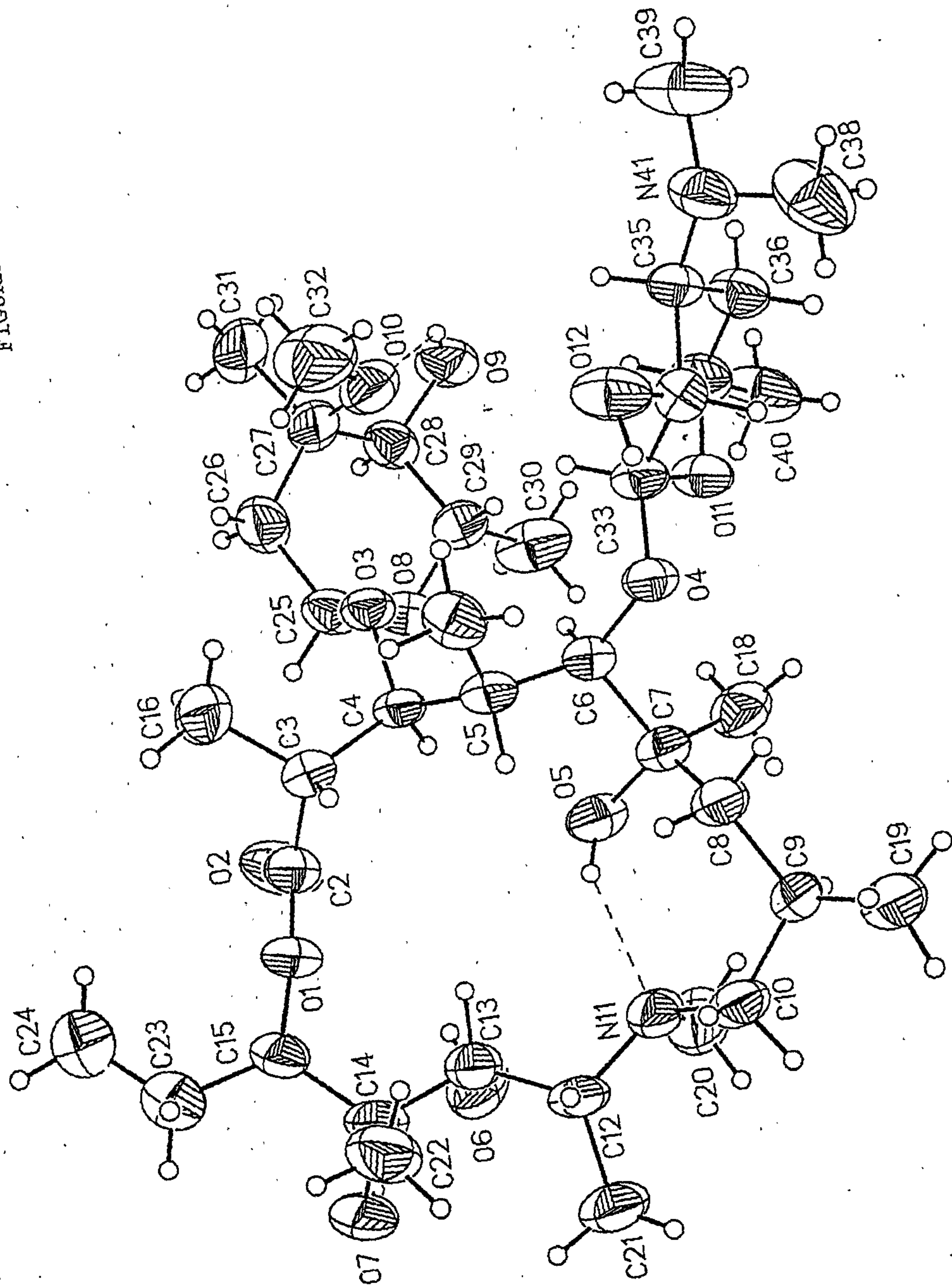


FIGURA 9

