



(22) Date de dépôt/Filing Date: 1999/06/14

(41) Mise à la disp. pub./Open to Public Insp.: 1999/12/18

(45) Date de délivrance/Issue Date: 2003/08/05

(30) Priorité/Priority: 1998/06/18 (60/089,778) US

(51) Cl.Int.⁶/Int.Cl.⁶ C07D 309/08, C07D 211/62,
C07C 323/60, C07C 323/09, C07C 319/14,
C07D 279/12, C07C 317/44, C07D 265/30,
C07C 323/20, C07D 207/16

(72) Inventeurs/Inventors:
CAMPBELL, JEFFREY ALLEN, US;
DVORAK, CHARLES ALOIS, US;
FISHER, LAWRENCE EMERSON, US;
MCGRANE, PAUL LEO, US

(73) Propriétaire/Owner:
F. HOFFMANN-LA ROCHE AG, CH

(74) Agent: GOWLING LAFLEUR HENDERSON LLP

(54) Titre : PROCESSUS DE PREPARATION D'UN ACIDE HYDROXAMIQUE DE SOUFRE ARYLIQUE-3

(54) Title: PROCESS FOR PREPARING 3-ARYLSULFUR HYDROXAMIC ACIDS

(57) **Abrégé/Abstract:**

This invention provides processes for the preparation of a compound of formula I: $Y-C(=O)-C(R^1)(R^2)-CH_2-S(O)_nR^3$ wherein: Y is hydroxy or XONX, where each X is independently hydrogen, lower alkyl or lower acyl; R^1 is hydrogen or lower alkyl; R^2 is hydrogen, lower alkyl, aryl, aralkyl, cycloalkyl, cycloalkylalkyl, or R^1 and R^2 together with the carbon atom to which they are attached form a cycloalkyl or heterocyclo group; and R^3 is aryl. The invention also provides novel aryl haloalkyl sulfide and aryl alkyl sulfide intermediates useful for the preparation of compounds of formula I and novel processes of preparing aryl alkyl sulfides.



ABSTRACT

This invention provides processes for the preparation of a compound of formula I:



5 wherein:

Y is hydroxy or XONX, where each X is independently hydrogen, lower alkyl or lower acyl;

R¹ is hydrogen or lower alkyl;

10 R² is hydrogen, lower alkyl, aryl, aralkyl, cycloalkyl, cycloalkylalkyl, or R¹ and R² together with the carbon atom to which they are attached form a cycloalkyl or heterocyclo group; and

R³ is aryl.

The invention also provides novel aryl haloalkyl sulfide and aryl alkyl sulfide intermediates useful for the preparation of compounds of formula I and
15 novel processes of preparing aryl alkyl sulfides.

This invention relates to processes of preparing matrix metalloprotease inhibitors, particularly 3-arylsulfur hydroxamic acids to novel aryl haloalkyl sulfide and aryl alkyl sulfide intermediates and novel processes of preparing such aryl alkyl sulfides.

5 Matrix metalloproteases ("MMPs") are a family of proteases (enzymes) involved in the degradation and remodeling of connective tissues. MMP expression is stimulated by growth factors and cytokines in the local tissue environment, where these enzymes act to specifically degrade protein components of the extracellular matrix, such as collagen, proteoglycans
10 (protein core), fibronectin and laminin. Excessive degradation of extracellular matrix by MMPs is implicated in the pathogenesis of many diseases, including rheumatoid arthritis, osteoarthritis, multiple sclerosis, bone resorptive diseases (such as osteoporosis), chronic obstructive pulmonary disease, cerebral hemorrhaging associated with stroke, periodontal disease, aberrant
15 angiogenesis, tumor invasion and metastasis, corneal and gastric ulceration, ulceration of skin, aneurysmal disease, and in complications of diabetes.

Furthermore, inhibitors of MMP also are known to substantially inhibit the release of tumor necrosis factor (TNF) from cells and therefore may be used in the treatment of conditions mediated by TNF. Such uses include, but
20 are not limited to, the treatment of inflammation, fever, cardiovascular effects, hemorrhage, coagulation and acute phase response, cachexia and anorexia, acute infections, shock states, restenosis, graft versus host reactions and autoimmune disease.

MMP inhibition is, therefore, recognized as a good target for therapeutic
25 intervention. Consequently, inhibitors of MMPs provide useful treatments for

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diseases associated with the excessive degradation of extracellular matrix and diseases mediated via TNF and several MMP inhibitors are currently being developed for such uses.

One particular class of MMP inhibitors are the 3-arylsulfur hydroxamic acids described in EP 0 780 386 A1, published June 25, 1997. This publication discloses MMP inhibitors of formula I,



where n, Y, R¹, R² and R³ are as described below.

WO 97/24117, published July 10, 1997, discloses 3-aryl sulfur hydroxamic acids of formula, HON(H)-C(=O)-C_p(R₁)(R₂)-C(R₃)(R₄)-S(O)_n-C_m(R₅)(R₆)-Ar, where p, m, n and R₁, R₂, R₃, R₄, R₅, R₆ and Ar are as described in WO 97/24117. WO 98/05635, published February 12, 1998, discloses 3-arylsulfur hydroxamic acids of formula B-S(O)_{0.2}-CHR¹-CH₂-CO-NHOH, where B and R¹ are as described in WO 98/05635. WO 98/13340, published April 2, 1998, discloses β-sulfonyl hydroxamic acids of HONHC(=O)-CHR₂-CH₂-S(O)₂R₁ where R₁ and R₂ are as described therein.

However, the processes disclosed in these publications for preparing 3-arylsulfur hydroxamic acids proceed via the nucleophilic attack of a thiol on the β-carbon of a carboxylate derivative, either displacing a leaving group at the β-carbon or performing a Michael reaction on an α,β unsaturated ester or acid. Thus, the disclosed processes are limited by the availability of the corresponding thiols and the β-substituted carboxylate derivatives and α,β unsaturated esters. Accordingly, it is an object of the present invention to provide novel processes and novel intermediates that are not dependent on the availability of the reagents used in the above publications.

More particularly, regarding the aspect of providing novel intermediates, the invention relates to novel halomethyl aryl sulfides and novel methods for their preparation. Such aryl haloalkyl sulfides are valuable intermediates in synthetic organic processes and they are commonly made by free radical

halogenation of a precursor aryl alkyl sulfide. The aryl alkyl sulfide is in turn typically available via sulfonation of a precursor aryl hydrocarbon, reduction to an aryl thiol and alkylation of the thiol. It would be useful to have methods of directly converting arylsulfonyl derivatives to aryl methyl sulfides.

5 There have been various reports of the reactions between trialkyl phosphites and aryl sulfonyl derivatives. See, for example, R.W. Hoffman, T.R. Moore and B.J. Kagan, ("The Reaction between Triethyl Phosphite and Alkyl and Aryl Sulfonyl Chlorides") J. Am. Chem. Soc., **78**:6413-6414 (1956); J.M. Klunder and K. Barry Sharpless, ("A Convenient Synthesis of
10 Sulfinate Esters from Sulfonyl Chlorides") J. Org. Chem., **52**:2598-2602 (1987); and J. Cadogan ("Oxidation of Tervalent Organic Compounds of Phosphorous") Quarterly Reviews, **16**:208-239 (1962). The reaction of benzensulfonyl chloride with triethylphosphite to yield ethyl phenyl sulfide has also been reported, T. Mukaiyama and H. Ueki, ("The Reactions of Sulfur-containing Phosphonium
15 Salts") Tetr. Lett., **35**:5429-5431 (1967). Aryl sulfonyl chlorides have also been converted to aryl methyl sulfides in three steps by treatment of an aryl sulfonyl chloride with lithium diphenylphosphide, Ph_2PLi , to afford a P-diphenyl-aryl sulfophosphamide followed by cathodic reduction and methylation of the resulting aryl thiolate, J. Pilard and J. Simonet. ("The
20 Cathodic Cleavage of the S-P Bond. Synthesis and Electrochemical Behaviour of Sulfonamide Phosphorous Analogues"), Tetr. Lett., **38**(21):3735-3738 (1997).

Definitions

As used herein, the term " (C_{p-q}) alkyl" means a linear or branched fully-saturated hydrocarbon radical having p to q carbon atoms; for example, a " C_{1-4}
25 alkyl" means a linear or branched fully saturated hydrocarbon radical having one to four carbon atoms, such as methyl, ethyl, propyl, isopropyl, butyl, or *tert*-butyl.

Unless otherwise specified, the term "lower alkyl" means a C_{1-4} alkyl radical.

As used herein, the term "(C₃₋₆) cycloalkyl" means a fully saturated cyclic hydrocarbon radical of three to six ring carbon atoms, e.g., cyclopropyl, cyclopentyl and the like.

As used herein, the term "lower acyl" refers to a group -C(=O)R, where R
5 is a (C₁₋₄)alkyl radical.

As used herein, the term "loweralkoxy" refers to a group -OR, where R is a (C₁₋₄)alkyl radical.

As used herein, the term "(C₇₋₁₀)alkoxy" refers to a group OR, where R is a (C₇₋₁₀)alkyl radical.

10 As used herein, the term "aryl" means a monovalent monocyclic or bicyclic aromatic hydrocarbon radical of 6 to 10 ring atoms, and optionally substituted independently with one, two or three substituents selected from alkyl, haloalkyl, cycloalkyl, halo, nitro, cyano, optionally substituted phenyl, -
OR (where R is hydrogen, alkyl, haloalkyl, cycloalkyl, optionally substituted
15 phenyl), acyl, -COOR (where R is hydrogen or alkyl). More specifically the term aryl includes, but is not limited to, phenyl, 1-naphthyl, 2-naphthyl, and derivatives thereof.

As used herein, the term "arylene" means a divalent monocyclic or bicyclic aromatic hydrocarbon radical of 6 to 10 ring atoms, and optionally
20 substituted independently with one, two or three substituents selected from alkyl, haloalkyl, cycloalkyl, halo, nitro, cyano, optionally substituted phenyl, -OR (where R is hydrogen, alkyl, haloalkyl, cycloalkyl, optionally substituted phenyl), acyl, -COOR (where R is hydrogen or alkyl). More specifically the term aryl includes, but is not limited to, 1,4-phenylene and 1,2 phenylene.

25 "Optionally substituted phenyl" means a phenyl group which is optionally substituted independently with one, two or three substituents selected from alkyl, haloalkyl, halo, nitro, cyano, -OR (where R is hydrogen or alkyl), -NRR' (where R and R' are independently of each other hydrogen or alkyl), -COOR

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(where R is hydrogen or alkyl) or -CONR'R" (where R' and R" are independently selected from hydrogen or alkyl).

"Heterocyclo" means a saturated monovalent cyclic group of 3 to 8 ring atoms in which one or two ring atoms are heteroatoms selected from N, O, or
 5 S(O)_n, where n is an integer from 0 to 2, the remaining ring atoms being C. The heterocyclo ring may be optionally fused to a benzene ring or it may be optionally substituted independently with one or more substituents, preferably one or two substituents, selected from alkyl, haloalkyl, cycloalkyl, cycloalkylalkyl, aryl, aralkyl, halo, cyano, acyl, monosubstituted amino,
 10 disubstituted amino, carboxy, or alkoxycarbonyl. More specifically the term heterocyclo includes, but is not limited to, pyrrolidino, piperidino, morpholino, piperazino, tetrahydropyranyl, and thiomorpholino, and the derivatives thereof.

"Leaving group" has the meaning conventionally associated with it in synthetic organic chemistry i.e., an atom or group capable of being displaced by
 15 a nucleophile and includes halogen, alkanesulfonyloxy, arenesulfonyloxy, amino, alkylcarbonyloxy, arylcarbonyloxy, such as chloro, bromo, iodo, mesyloxy, tosyloxy, trifluorosulfonyloxy, N,O-dimethylhydroxylamino, acetoxy, and the like.

The present invention will now be described in more detail below.

20 In one aspect, this invention provides a process for the preparation of a compound of formula I:



wherein:

Y is hydroxy or XONX, where each X is independently hydrogen, lower
 25 alkyl or lower acyl;

R¹ is hydrogen or lower alkyl;

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R^2 is hydrogen, lower alkyl, aryl, aralkyl, cycloalkyl, cycloalkylalkyl, or R^1 and R^2 together with the carbon atom to which they are attached form a cycloalkyl or heterocyclo group;

R^3 is aryl; and

5 n is 0, 1 or 2;

comprising the steps of:

(1) alkylating a compound of formula II,



where R is alkyl or hydrogen, with an arylmethylthio derivative of formula III,
10 $\text{ArSCH}_2\text{-Z}$, wherein Ar is an aryl group and Z is a leaving group, to provide a compound of formula IV,



(2) converting the compound of formula IV to a compound of formula I by replacing the group RO- with XONH- and optionally oxidizing the
15 ArS group. The conversion can be done as necessary in either order.

Unlike the methods disclosed in EP 0 780 386 A1, published June 25, 1997, WO 97/24117, published July 10, 1997, WO 98/05635, published February 12, 1998 and WO 98/13340, published April 2, 1998, for the synthesis of 3-arylsulfur hydroxamic acids, the processes of the present
20 invention proceed via the alkylation of the α -carbon of a carbonyl group with a halomethyl aryl sulfide. Though the processes described herein may be used to prepare a variety of 3-arylsulfur hydroxamic acids and their corresponding carboxy and ester derivatives, they are particularly useful for preparing compounds of formula I wherein the aryl group Ar is of the formula $-\text{Ar}^1\text{-A-Ar}^2$,
25 wherein Ar^1 and Ar^2 are phenyl rings, each independently optionally substituted and A is a bond, $-\text{CH}_2\text{-}$ or $-\text{O-}$.

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In a preferred embodiment the leaving group Z is halo. More particularly compounds of formula I are prepared wherein A is oxygen, Ar¹ is phenyl and Ar² is 4-chlorophenyl.

Regarding the optional oxidizing step in step (2) of the process of the present invention oxidation is preferred which provides a compound of formula I wherein n is 2.

Other useful compounds that may be made by the methods of the present invention include compounds of formula I where R¹ and R² together with the carbon atom to which they are attached form a cycloalkyl or heterocyclo group, particularly a tetrahydropyranyl group. Most preferred, the compound of formula I is 4-[4-(4-chlorophenoxy)phenylsulfonylmethyl]-4-(N-hydroxycarboxamido)-tetrahydropyranyl which is prepared by the process of the present invention.

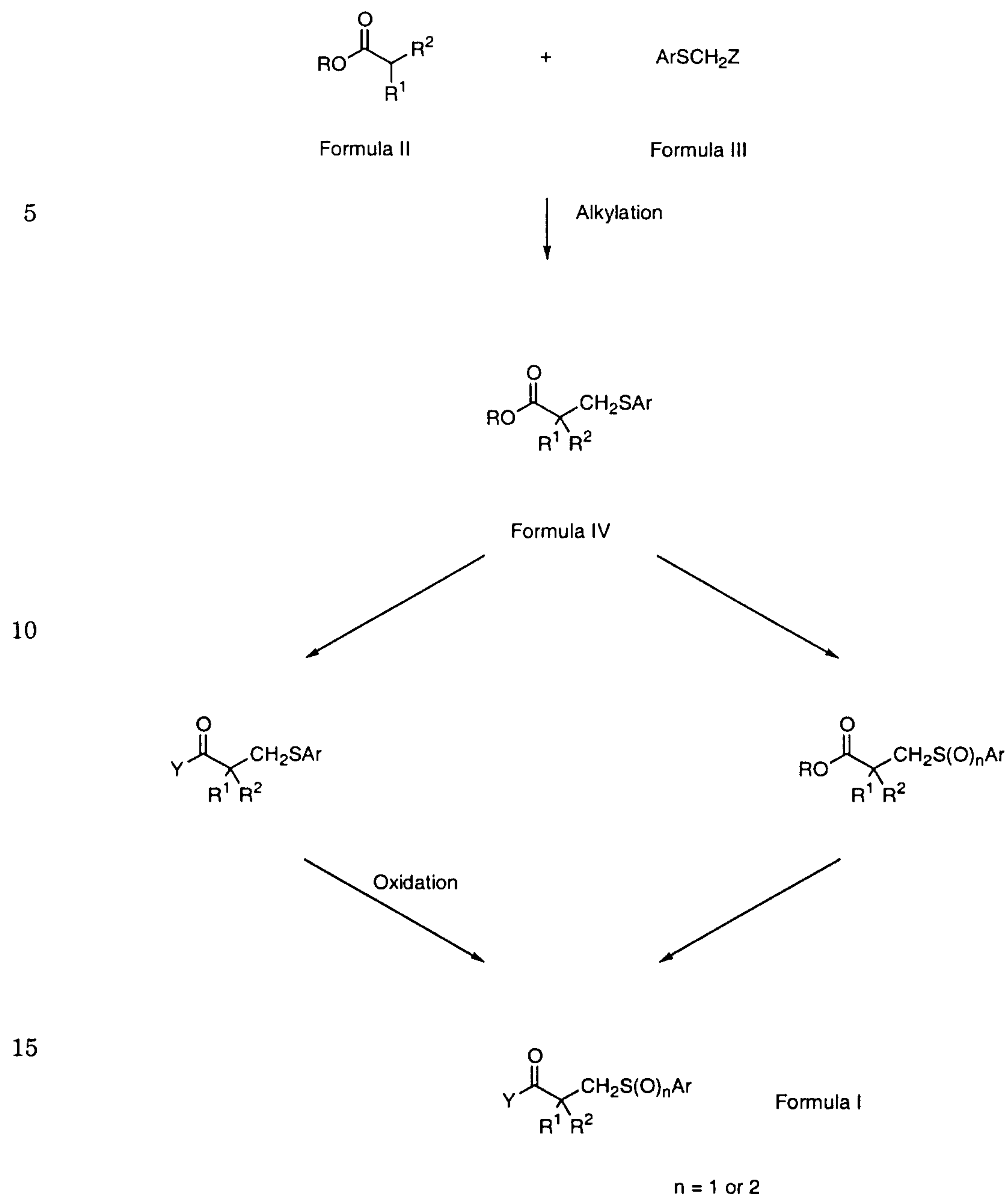
Additional useful hydroxamic acids that may be prepared include those that are α,α -disubstituted, i.e., neither R¹ nor R² are hydrogen.

In another aspect the invention also provides novel halomethyl aryl sulfides, such as chlorophenoxyphenyl chloromethyl sulfide and novel methods for their preparation. As a result compounds of formula I can be prepared by novel processes not previously available. This aspect will also be described in more detail within the description of the overall process.

Regarding the preparation of compounds of formula I these reaction processes are shown in Scheme A, below.

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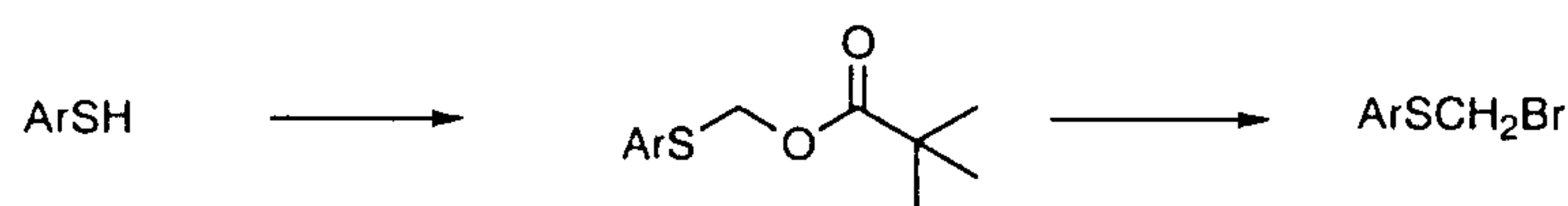
SCHEME A



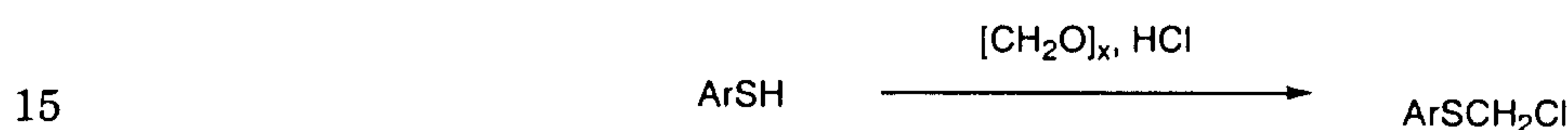
Compounds of formula II, $\text{RO}-\text{C}(=\text{O})-\text{CH}(\text{R}^1)(\text{R}^2)$, can be purchased from commercial suppliers or are readily available by published procedures known to one of skill in the art. See, for example, EP 0 780 386 A1.

Compounds of formula III, $\text{ArSCH}_2\text{-Z}$, are made by oxidation of the precursor arylmethylthioether. Compounds ArSCH_2Cl are made by oxidation with sulfonyl chloride in aprotic solvents such as methylene chloride, *t*-butylmethyl ether or hexane. The oxidation may be done at room temperature or at lower temperatures, e.g., from about 0-10°C. Other reagents, such as N-chlorosuccinimide, may also be used. Compounds ArSCH_2Br are made by oxidation with sulfonyl bromide or other reagents such as N-bromosuccinimide.

Compounds of formula III, $\text{ArSCH}_2\text{-Z}$, where Z is chloro or bromo may also be made from the corresponding thiol as shown below:



Hlasta, D. J. et al Synlett, 423, 1995



Arylmethylthioethers are generally available either from commercial vendors or published literature procedures. For example, they may be made by sulfonylating an aryl compound to the corresponding sulfonic acid, reducing the sulfonic acid to a thiol and methylating the thiol.

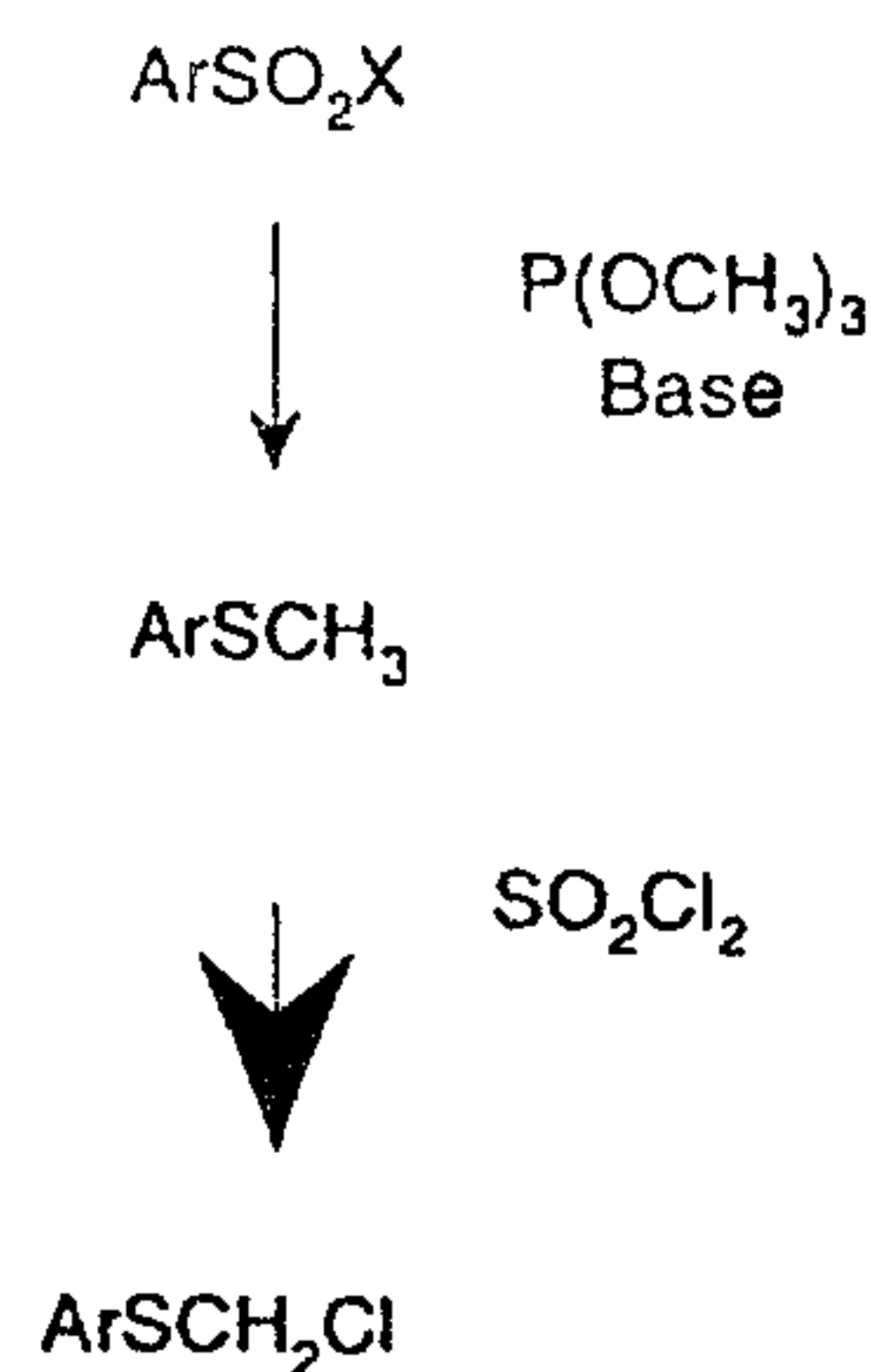
Alternatively, as shown in Scheme B, it has unexpectedly discovered that arylsulfonyl halides can be converted directly to arylmethylthioethers in one step by treatment with trimethylphosphite. The conversion proceeds best if the trimethylphosphite treatment is followed by treatment with a base. Either an organic base such as an alkylamine (e.g. triethylamine) or a hydroxylic base such as an alkali metal hydroxide or an alkaline earth metal hydroxide may be used. However, the conversion may also be accomplished, albeit in

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somewhat lower yield, without the addition of a base. In such processes, the yield of the aryl methyl sulfide may be increased by heating to elevated temperatures, e.g., as high as about 100 °C, preferably as high as about 130 °C (internal temperature).

- 5 Consequently, the invention provides in this embodiment a novel process of preparing aryl methyl sulfides by directly reducing/alkylating an arylsulfonyl halide with trimethyl phosphite (see scheme B wherein X is halo and Ar is aryl).

SCHEME B



10

- In particular, the invention provides a process of preparing a compound of formula ArSCH_3 , wherein Ar is an aryl group, by treating a compound of formula ArSO_2Cl with trimethyl phosphite and optionally, followed by
 15 treatment with a base, to form a compound of formula ArSCH_3 .

- The process is particularly useful for for forming compounds of a formula ArSCH_3 , wherein Ar has the formula $-\text{Ar}^1-\text{A}-\text{Ar}^2$, where Ar^1 and Ar^2 are phenyl rings, each independently optionally substituted, and A is a bond, CH_2 or $-\text{O}-$, and more particularly where, A is oxygen, Ar^1 is phenyl and Ar^2 is 4-
 20 chlorophenyl. This process is preferably used in connection with the above mentioned process for preparing compounds of formula I. In another

embodiment the present invention also relates to the compounds of formula ArSCH_3 themselves, especially to 4-(4'-chlorophenoxy)phenylmethyl sulfide.

Subsequent halogenation of compounds of formula ArSCH_3 then provides key intermediates of formula $\text{ArSCH}_2\text{-Z}$ where the leaving group Z is halo
5 which are also an object of the present invention. This process is characterized in general by forming the compound of formula III, $\text{Ar}^2\text{-A-Ar}^1\text{-S-CH}_2\text{-Z}$ characterized by (i) treating a compound of formula VI, $\text{Ar}^2\text{-A-Ar}^1\text{-S(O)}_2\text{Cl}$ with trimethyl phosphite; (ii) optionally followed by treatment with a base and (iii) oxidation. Preferred key intermediates of this object include those of formula
10 $\text{Z-CH}_2\text{S-Ar}^1\text{-A-Ar}^2$, wherein Ar^1 and Ar^2 are independently optionally substituted phenyl, Z is halo, A is oxygen, or CH_2 . A particularly preferred intermediate is that wherein Ar^1 is phenyl, Ar^2 is halophenyl, and A is oxygen. More preferred Ar^1 is phenyl; Ar^2 is 4-chlorophenyl; A is oxygen; R^1 and R^2 together with the carbon atom to which they are attached form a tetra-
15 hydropyranyl group; and Y is HONH ; i.e., 4-(4-chlorophenoxy)phenyl-chloromethyl sulfide.

A compound of formula III, wherein Z is halo, can be converted by known methods to the alcohol which then is converted to another leaving group e.g., a tosylate or mesylate. Such compounds may then also be used in the reaction
20 with a compound of formula II according to the process of the present invention as outlined below.

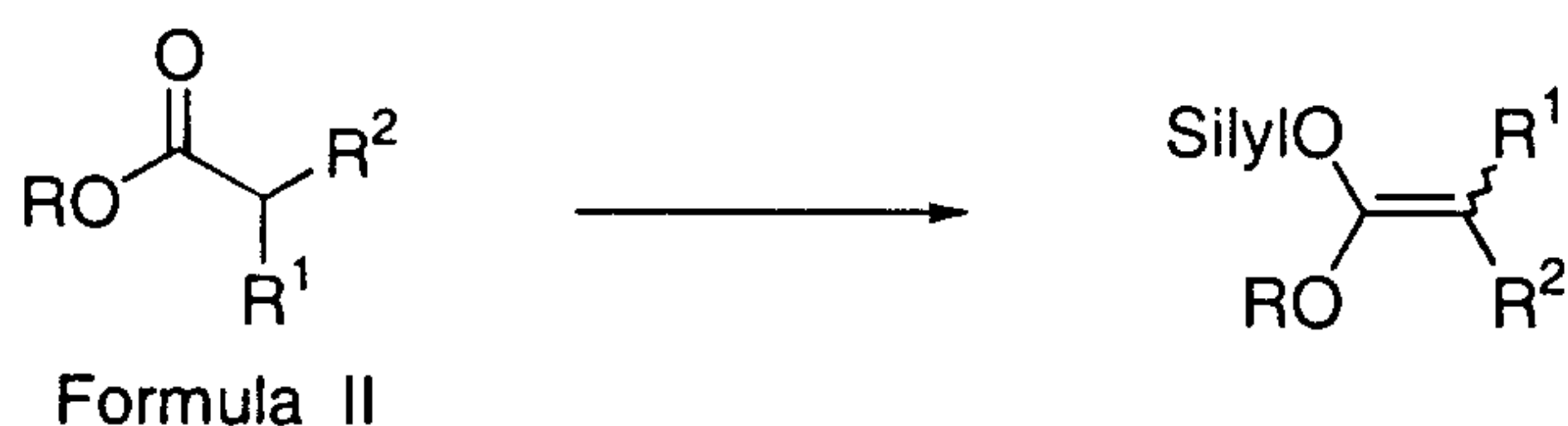
In one embodiment of the preparation of a compound of formula I alkylation of a compound of formula II with a compound of formula III according to step (1) of the process of the present invention may be
25 accomplished by conditions known to one of skill in the art such as converting a compound of formula II to an enolate or enol followed by alkylating said enolate of a compound of formula III with a compound of formula III. Other conditions include forming the dianion of the acid (i.e., compound of formula II where $\text{R}=\text{H}$) by treatment with two equivalents of a base such as lithium
30 diisopropylamide or lithium hexamethyldisilazide and alkylating with one equivalent of a compound of formula III.

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In another embodiment, step (1) is performed by converting a compound of formula II to a silylketene acetal of formula V, $\text{RO}(\text{OTMS})\text{C}=\text{CR}^1\text{R}^2$ and alkylating with a compound of formula III. More particular, a compound of formula II is converted to a silylketene acetal as shown in Reaction Scheme C (where Silyl represents a silyl group), followed by Mukaiyama coupling of the acetal with a compound of formula III. The coupling is generally done in an anhydrous aprotic solvent such as a halocarbon or hydrocarbon (methylene chloride, chloroform, benzene, toluene etc.) in the presence of a Lewis acid such as zinc chloride, zinc bromide, zinc iodide, ferric bromide or titanium tetrachloride. Silylketene acetals may be readily prepared from compounds of formula II by procedures such as those described in C. Ainsworth, F. Chen, Y. N. Kuo "Ketene Alkyltrialkylsilyl Acetals: Synthesis, Pyrolysis and NMR Studies" J. Organometallic Chem., **46**:59-87 (1972). A variety of silyl protecting groups, e.g., *t*-butyldimethylsilyl, trimethylsilyl, etc. may be used.

Silylketene acetals can be formed from either the ester ($\text{R}=\text{alkyl}$) or acids ($\text{R}=\text{H}$) of formula II. Formation of the silylketene acetal from the acid may be accomplished using two equivalents of base and quenching with two equivalents of the silylating reagent. Subsequent alkylation with a compound of formula III followed by a hydrolytic work up then directly yields a carboxylic acid of formula IV. Reagents that may be used to form the silylketene acetal include trimethylsilyl triflate, trimethylsilyl chloride or bromide, *tert*-butyldimethylsilyl chloride and bis-trimethylsilyl acetamide.

SCHEME C



Alternatively, an enolate of a compound of formula II may be directly alkylated with a compound of formula III, thus avoiding the intermediacy of the silylketene acetal. The enolate is formed under standard conditions, by treatment with a non-nucleophilic organic base such as lithium diisopropylamide or lithium hexamethyldisilazide, or a metal hydride such

potassium hydride, under anhydrous conditions, typically at room temperature, in a polar aprotic solvent such as tetrahydrofuran, dimethoxyethane or glyme and the like. Subsequent addition of a compound of a formula III followed by heating if necessary to reflux temperatures, e.g.,
5 60-80°C, provides an alkylated product of formula IV. The enolate may also be formed from the corresponding α -bromoester of a compound of formula II by treatment with zinc to form the zinc enolate which can then be alkylated.

Preferably, a compound of formula III is reacted with a compound of formula II wherein A is oxygen, Ar¹ is phenyl and Ar² is 4-chlorophenyl.

10 Compounds of formula IV may be converted to compounds of formula I by conversion of the carboxyl group to a group -C(=O)-L where L is a leaving group under nucleophilic displacement conditions followed by displacement of L with hydroxylamine (or an alkylated derivative). The resulting hydroxamic acid is then oxidized as necessary to give the desired sulfoxide or sulfone.
15 Oxidation to the sulfoxide is accomplished by treatment with mild oxidizing agents such as sodium or potassium metaperiodate or one equivalent potassium peroxymonosulfate (Oxone™). Other oxidants that may be used include peracids, (e.g. performic or peracetic acid) or sodium perborate/organic acid mixtures (e.g. performic or peracetic acid). The reaction may be halted at
20 the sulfoxide stage by limiting the quantity of reagents, temperature and reaction time. Further oxidation to the sulfone is accomplished by treatment under more vigorous conditions with organic peracids such as m-chloroperbenzoic acid or two equivalents of sodium peroxymonosulfate. Alternatively, other oxidizing agents such as perborates, e.g., sodium
25 perborate, in a carboxylic acid solvent such as formic, acetic or propionic acid may be used. These last two steps may also be reversed, i.e., oxidation of the sulfur moiety may precede conversion of the acid to the hydroxamate. However, overall yields are usually higher with the former sequence.

As described earlier the compounds made by these processes are MMP
30 inhibitors, useful in treating a variety of diseases as disclosed in EP 0 780 386

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A1, published June 25, 1997; WO 97/24117, published July 10, 1997; and WO 98/05635, published February 12, 1998.

Abbreviations used in the examples are defined as follows: "DMF" for dimethylformamide, "NaOH" for sodium hydroxide, "DMSO" for
5 dimethylsulfoxide, "PTLC" for preparatory thin layer chromatography, "EtOAc" for ethyl acetate, "LDA" for lithium diisopropylamide and "TMSCl" for trimethylsilylchloride.

EXAMPLE

10 Synthesis of 4-[4-(4-chlorophenoxy)phenylsulfonylmethyl]-4-(N-hydroxycarboxamido)tetrahydropyran

Scheme D shows a representative method of this invention for the preparation of 14, 4-[4-(4-chlorophenoxy)phenylsulfonylmethyl]-4-(N-hydroxycarboxamido)tetrahydropyran, a compound of formula I, wherein:

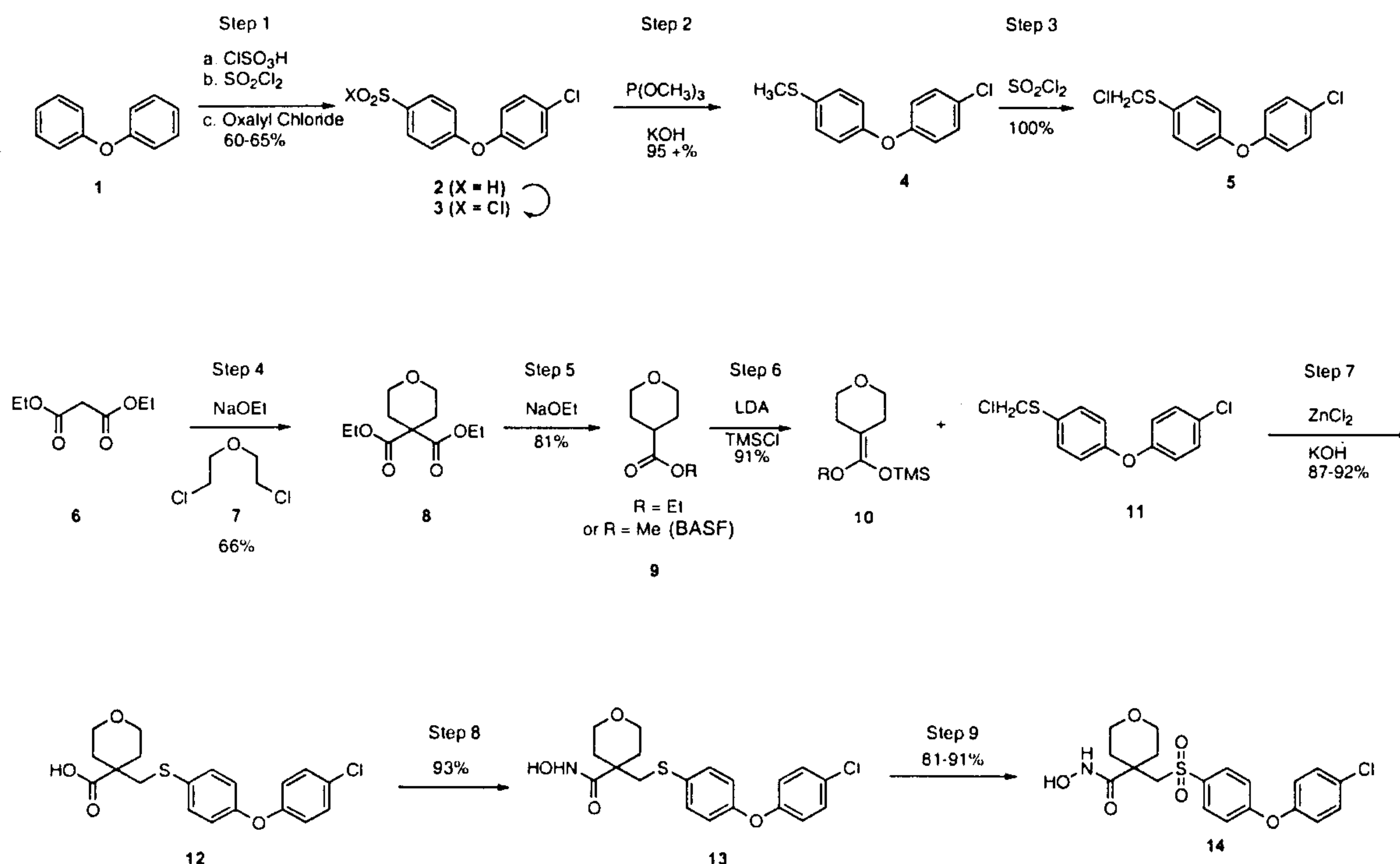
Y is NHOH;

15 R¹ and R² together with the carbon atom to which they are attached represent a tetrahydropyran-4-yl group; and

R³ is 4-chlorophenoxyphenyl.

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SCHEME D



Although Scheme D is directed towards the synthesis of a specific 3-arylsulfur hydroxamic acid, it is to be understood that a similar set of reactions can be used to prepare other arylsulfur hydroxamic acids, carboxylic acids and esters by substituting appropriate starting materials and reagents as outlined in Reaction Schemes A-C.

A. Preparation of 4-(4-Chlorophenoxy)phenyl Chloromethylsulfide

Step 1

Diphenylether **1**, is available from Aldrich (Milwaukee, Wisconsin) and can be converted to 4-(4-chlorophenoxy)phenyl sulfonylchloride, compound **3**, using known procedures, such as described in WO 97/20824.

Step 2

4-(4-chlorophenoxy)phenyl sulfonyl chloride (3.0 kg), **3**, was dissolved in three liters of toluene and the solution was added dropwise, with stirring, to

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3.6 kg of trimethyl phosphite which had been preheated to 60°C. The reaction was exothermic and the reaction was allowed to heat to 80°-90°C during the addition. Thin layer chromatography indicated a mixture of the desired thioether and two baseline products. The mixture was refluxed until the pot
5 temperature rose to ~130°C. The mixture was cooled to ~60°C and 1 liter of methanol was added. Potassium hydroxide solution (4.5 kg of 45% aqueous solution) was added dropwise, slowly, with rapid stirring to the reaction mixture. The addition was very exothermic and the pot temperature was controlled to 65°-80°C. The mixture was then refluxed for 2 hrs. More toluene
10 (6 liters) was added and the mixture cooled to ~60°C. The lower aqueous layer was separated and the organic layer washed with 3 liters of water. The organic layer was stripped to a low volume and 9 liters of isopropanol charged to the hot mixture. The solution was distilled until ~3.5 liters of distillate had been collected. The mixture was held at 45°C for several hours and was then
15 cooled to ~-10°C and stirred several hours. The white, crystalline product was collected, washed with cold isopropanol and dried to yield 1.9 kg of 4-(4-chlorophenoxy)phenylmethyl sulfide, 4 (m.p. 59-60°C).

Step 3

Into a separate reactor was charged 4-(4-chlorophenoxy)phenylmethyl
20 sulfide, 4, and CH₂Cl₂ (26 Kg). The resultant solution was cooled to less than 10 °C and then treated with SO₂Cl₂ at such a rate so that the temperature did not exceed 10 °C (30 min. required for the addition). An additional 2 Kg of CH₂Cl₂ was used to rinse in the SO₂Cl₂. After stirring for 1h, the mixture was warmed to room temperature (degassing occurs) and then further warmed to
25 reflux for 30 minutes. Upon cooling to room temperature, the product solution was washed with water (15.5 Kg) and then with brine (10.3 Kg). The stirred organic solution was then treated with a slurry of MgSO₄ (2.6 kg) in CH₂Cl₂ (5 kg). The drying was allowed to proceed overnight and the mixture was filtered to remove the drying agent. The solids were washed with CH₂Cl₂ (20.7 kg) and
30 the combined organics were concentrated to effect azeotropic drying (38 kg of distillate collected, Karl Fischer shows 0.026% water in concentrate). The

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product was treated with CH_2Cl_2 (19.8 kg) and then was reconcentrated (19.8 kg distillate, Karl Fischer now at 0.014%). HPLC analysis showed 94.7 % 4-(4-chlorophenoxy)phenyl chloromethylsulfide, 5.

B. Preparation of Silylketene acetal

5 Steps 4 and 5

Tetrahydropyran-4-carboxylic acid ethyl ester, 9, was prepared from commercially available diethylmalonate via steps 4 and 5 using known literature procedures as described in for example, U.S. Patent No. 5,412,120; 5,414,097; and EP584663 A2.

10 Step 6

To a nitrogen purged reactor was charged 26.8 kg (67.37 mole) of a solution of LDA. This was cooled to $-15\text{ }^\circ\text{C}$ and then a mixture of TMSCl (7.32 kg, 67.37 mole) and tetrahydropyran-4-carboxylic acid ethyl ester, 9, (10.32 kg, 65.3 mole) was added at such a rate that the temperature did not exceed -
15 $10\text{ }^\circ\text{C}$ (1h addition time). An additional 0.2 kg of TMSCl was added in one portion. The resultant mixture was heated to $20\text{ }^\circ\text{C}$ and, after 4h, a vacuum of 28 mm Hg was applied. The mixture was heated to $65\text{ }^\circ\text{C}$ to remove volatiles. Toluene (11.95 kg) was added and the distillation continued. When no more
20 distillate collected, the mixture was cooled to $25\text{ }^\circ\text{C}$. A slurry of celite (2.7 kg) in hexane (20.6 kg) was added. After stirring 1h, the mixture was filtered through a precoated Nutsche filter (1.5 kg of celite in 5 kg of hexane for precoat). The reactor was rinsed with hexane (11 kg), and this was used to
25 rinse the filter. The combined organics were concentrated to an oil using 19-25 mm Hg and mild heating. The concentrate was transferred to a nitrogen purged storage vessel with the aid of CH_2Cl_2 (7 kg) to give 17.5 kg of a solution of silylketene acetal 10.

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C. Preparation of 4-[4-(4-chlorophenoxy)phenylsulfonylmethyl]-4-(N-hydroxycarboxamido)tetrahydropyran

Step 7

90% of the silylketene acetal solution from Step 6 was charged to the
5 reactor containing 4-(4-chlorophenoxy)phenyl chloromethylsulfide 5, followed
directly by a slurry of ZnCl_2 (0.59 kg, 4.34 mole) in CH_2Cl_2 (5 kg). The red
reaction mixture was heated to reflux for 14h (minimal heating required
during first 1h due to exotherm), at which point HPLC showed about 10%
starting material. The remaining 10% of the ketene acetal was added and the
10 mixture was heated at reflux with collection of the CH_2Cl_2 to a pot
temperature of 68 °C. HPLC analysis of an aliquot showed <1% starting
material. Ethanol (15.5 kg), water (20.6 kg), and 45% KOH (20.3 kg) were
added to the concentrated product mixture. The two phase mixture was
stirred at 65 °C overnight (17h) and was then warmed to a pot temperature of
15 90 °C to complete the saponification and to distill the ethanol. The mixture
was cooled to 60-65 °C and hexane (41 kg) was added. After stirring 10 min.
and then allowing layer separation, the lower layer was transferred to another
reactor containing water (24 kg) and 37% HCl (21.6 kg). Simultaneous with
this transfer, EtOAc (134.5 kg) was pumped to the receiving reactor. The
20 hexane solution was washed once with 65 °C water (25 liters) which was then
transferred to the receiving reactor. This reactor now contained an EtOAc
solution of the product acid and a lower aqueous layer. The lower layer was
separated and replaced with 50 L of 65 °C water. After stirring briefly, the
layers were separated. The organic solution was concentrated as much as
25 possible using partial vacuum. CH_3CN (93.5 kg) was added and distillation
continued at atmospheric pressure to a final volume of 90 liters. The mixture
was cooled over 8h to 5 °C and was held there 8h. The solids were collected on
a filter and were washed with CH_3CN (15 kg) and hexane (15.5 kg). After
drying at 78 °C and 24mm Hg to constant mass, there was obtained 16.34 kg
30 of the product acid, 12, as a dense, slightly off-white solid. HPLC purity was
99%.

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Step 8

A clean, dry 100 gallon reactor was charged with 4-carboxy-4-[4-(4-chlorophenoxyphenyl)thiomethyl]tetrahydropyran **12** (15.45 kg, 40.7 moles). To this reactor was added dichloromethane (77.2 L, 102 kg). The suspended
5 carboxylic acid was chilled to 0-5 °C under N₂ with agitation. A catalytic amount of *N,N*-dimethylformamide (0.1 l) was charged, followed by slow addition of oxalyl chloride (5.3 kg, 3.6 L). The contents of the reactor were agitated and the internal temperature was allowed to rise to ambient over a 4-12 hour period to allow conversion to the acid chloride. Another clean, dry 100
10 gallon reactor was charged with *tert*-butanol (26.8 kg, 34.5 L), tetrahydrofuran (75.4 kg, 84 L) and hydroxylamine (50 aqueous, 17 kg, 15.8 L). The contents of this reactor were agitated at ambient temperature. The contents of the reactor containing the acid chloride were chilled to 0-5 °C. Slow addition of the hydroxylamine solution is begun. The rate of addition was regulated such
15 that the internal temperature of the acid chloride solution does not rise above 10 °C. When the addition is complete, the contents of the reactor containing the newly formed hydroxamic acid were warmed to 20-25 °. After a check for reaction completeness (HPLC or TLC), the solvent was removed *in vacuo* keeping the contents of this reactor below 45 °C. When little solvent is left to
20 distill, the reactor was charged with acetonitrile (48.6kg, 61.7 L). The contents were heated to reflux, and water (61.7 L) was added over a period of 30-50 minutes. The contents of the reactor were cooled to 0-5 °C over a period of 2-4 hours and slowly agitated for 4-14 hours. The solid hydroxamic acid **13**, was collected by filtration and washed with water. Typically, the wetcake so
25 obtained is not dried but used as is. However, drying can be accomplished *in vacuo* at ca 50 °C. The solid (21.5kg wet, 14.45 kg dry, 90.1%) was 99.8% pure by area normalization HPLC.

Step 9

A clean, dry 100-gallon reactor was charged with oxone® (potassium
30 peroxymonosulfate, 37.07 kg, 60.3 moles). Deionized water was added (88.3

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kg) and the contents of the reactor were agitated and heated (to ca. 35-40 °C) to dissolve the oxone. Another clean, dry 100 gallon reactor was charged with the hydroxamic acid 13 (21.18 kg waterdamp cake, 14.45 dry weight, 36.7 moles) and dissolved in N-methyl-2-pyrrolidinone (100.5kg) with agitation.

5 The contents of this reactor were heated to 30-35 °C. The aqueous oxone™ solution was added to the reactor containing the hydroxamic acid at such a rate that the internal temperature did not exceed 49 °C. After the addition of oxone™ was complete, the mixture was assayed by HPLC and TLC. When the reaction was complete, typically in 0 to 1 hour post addition (HPLC data area

10 normalization purity is typically >98.5% desired product) the product was treated with deionized water (25 kg) and cooled to 20 °C. Crystallization of the crude product typically occurred at 20-25 °C (22 °C in this example). The mixture was then cooled to 5 °C and stirred for 10-14 hours (12 in this example). The precipitated product was collected by filtration and washed

15 well with deionized water followed by hexanes. This wet cake (47.9kg) was charged into a clean, dry, residue free 100-gallon reactor. Ethyl acetate (140 kg) was charged to the solid followed by deionized water (120.6 kg). The contents of the reactor were agitated and heated (to ca 60°C). Agitation was stopped and the layers were allowed to separate. The aqueous layer was

20 separated. Optionally, this can be followed by an aqueous NaHCO₃ wash and water wash. The organic layer was filtered through a 5-10μ cotton filter into a clean, dry, residue free reactor. The mixture was concentrated *in vacuo* to approximately 50% (ca 50L) of the starting volume. The solid was separated and recrystallized from ethyl acetate after heating to approximately 70 °C and

25 cooling to 5 °C. The solid was collected by filtration in a clean dry filter and dried at 40-45 °C under a nitrogen stream (an agitated filter was used for this example). 11.82kg of final product, 4-[4-(4-chlorophenoxy)phenylsulfonyl-methyl]-4-(N-hydroxycarboxamido)tetrahydropyran, compound 14, was obtained in 75.6% yield (99.8% pure by area normalization HPLC) upon

30 vacuum drying.

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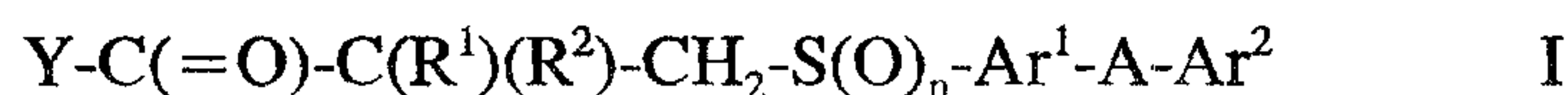
The foregoing invention has been described in some detail by way of illustration and example, for the purposes of clarity and understanding. It will be obvious to one of ordinary skill in the art that changes and modifications may be practiced within the scope of the appended claims.

- 5 Therefore, it is to be understood that the above description is intended to be illustrative and not restrictive.

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WHAT IS CLAIMED IS:

1. A process for the preparation of a compound of Formula I:



Y is hydroxy or XONX, where each X is independently hydrogen, lower alkyl or lower acyl;

R¹ is hydrogen or lower alkyl;

R² is hydrogen, lower alkyl, aryl, aralkyl, cycloalkyl, cycloalkylalkyl, or R¹ and R² together with the carbon atom to which they are attached form a cycloalkyl or heterocyclo group;

where Ar¹ and Ar² are phenyl rings, each independently optionally substituted and A is a bond, -CH₂- or -O-; and

n is 0, 1 or 2; and

wherein the term lower alkyl means C₁₋₄ alkyl radical;

the term lower acyl refers to a group -C(=O)R, where R is a (C₁₋₄)alkyl radical;

the term aryl means a monovalent monocyclic or bicyclic aromatic hydrocarbon radical of 6 to 10 ring atoms;

the term cycloalkyl means a fully saturated cyclic hydrocarbon radical of 3 to 6 ring carbon atoms;

the term heterocyclo group means a saturated monovalent cyclic group of 3 to 8 ring atoms in which one or two ring atoms are heteroatoms selected from N, O, or S(O)_n, wherein n is an integer from 0 to 2, the remaining ring atoms being C;

the term optionally substituted phenyl means a phenyl group which is optionally substituted independently with 1, 2 or 3 substituents selected from alkyl, haloalkyl, halo, nitro, cyano, -OR (where R is hydrogen or alkyl),

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-NRR' (where R and R' are independently of each other hydrogen or alkyl),
 -COOR (where R is hydrogen or alkyl) or -CONR'R'' are independently
 selected from hydrogen or alkyl);

5 comprising the steps of:

(1) alkylating a compound of Formula II, $\text{RO-C(=O)-CH(R}^1\text{)(R}^2\text{)}$,
 where R is alkyl or hydrogen, with an arylmethylthio derivative of Formula
 III, $\text{ArSCH}_2\text{-Z}$, wherein Ar is $\text{-Ar}^1\text{-A-Ar}^2$ and Z is a leaving group, to
 provide a compound of Formula IV, $\text{RO-C(=O)-C(R}^1\text{)(R}^2\text{)-CH}_2\text{SAr}$; and

10 (2) converting the compound of Formula IV to a compound of
 Formula I by replacing the group RO- with XONX- and optionally oxidizing
 the ArS group.

2. The process of Claim 1 wherein Z is halo.

15 3. The process of Claim 1 or Claim 2 wherein:
 A is oxygen; Ar^1 is phenyl; and Ar^2 is 4-chlorophenyl.

20 4. The process of any one of Claims 1-3, wherein the optional oxidation in step
 (2) provides a compound of Formula I where n is 2.

5. The process of any one of Claims 1-4, wherein R^1 and R^2 together with the
 carbon atom to which they are attached form a heterocyclo group.

25 6. The process of Claim 5, wherein the heterocyclo group formed by R^1 and R^2
 is tetrahydropyranyl.

30 7. The process of Claim 6, wherein the compound of Formula I is 4-[4-(4-
 chlorophenoxy)-phenylsulfonylmethyl]-4-(N-hydroxycarboxamido)
 tetrahydropyran.

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8. The process of Claim 1 which further comprises forming the compound of Formula III, $\text{Ar}^2\text{-A-Ar}^1\text{-S-CH}_2\text{-Z}$ characterized by (i) treating a compound of Formula VI, $\text{Ar}^2\text{-A-Ar}^1\text{-S(O)}_2\text{Cl}$ with trimethyl phosphite; (ii) optionally followed by treatment with a base; and (iii) oxidation.

5

9. The process of Claim 8, wherein:

Ar^1 is phenyl;

Ar^2 is 4-chlorophenyl;

A is oxygen;

10

R^1 and R^2 together with the carbon atom to which they are attached form a tetrahydropyranyl group; and

Y is HONH.

15

10. The process of Claim 3, wherein step (1) is performed by converting a compound of Formula II to a silylketene acetal of Formula V, $\text{RO(O-trimethylsilyl)C=CR}^1\text{R}^2$ and alkylating with a compound of Formula III.

20

11. The process of Claim 3, wherein step (1) is performed by alkylating an enolate of a compound of Formula II with a compound of Formula III.

25

12. A process of preparing a compound of Formula ArSCH_3 ,
by treating a compound of Formula ArSO_2Cl with trimethyl phosphite and optionally, followed by treatment with a base, to form a compound of Formula ArSCH_3 , wherein Ar has the Formula $\text{Ar}^1\text{-A-Ar}^2$, where Ar^1 and Ar^2 are phenyl rings, each independently optionally substituted, and A is a bond, CH_2 or -O- ,
and wherein:

30

the term optionally substituted phenyl means a phenyl group which is optionally substituted independently with 1, 2 or 3 substituents selected from alkyl, haloalkyl, halo, nitro, cyano, -OR (where R is hydrogen or alkyl),

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-NRR' (where R and R' are independently of each other hydrogen or alkyl),
-COOR (where R is hydrogen or alkyl) or -CONR'R'' are independently
selected from hydrogen or alkyl).

- 5 13. The process of Claim 12, wherein
 A is oxygen;
 Ar¹ is phenyl; and
 Ar² is 4-chlorophenyl.
- 10 14. A compound Z-CH₂S-Ar¹A-Ar², wherein:
 Ar¹ and Ar² are independently optionally substituted phenyl;
 wherein:
 the term optionally substituted phenyl means a phenyl group which is
 optionally substituted independently with 1, 2 or 3 substituents selected from
15 alkyl, haloalkyl, halo, nitro, cyano, -OR (where R is hydrogen or alkyl),
 -NRR' (where R and R' are independently of each other hydrogen or alkyl),
 -COOR (where R is hydrogen or alkyl) or -CONR¹R'' are independently
 selected from hydrogen or alkyl);
 Z is halo; and
20 A is oxygen or CH₂.
15. The compound of Claim 14, wherein:
 Ar¹ is phenyl;
 Ar² is halophenyl; and
25 A is oxygen.
16. The compound of Claim 14 or Claim 15, which is 4-(4'-chlorophenoxy),
 phenyl chloromethylsulfide.
- 30 17. 4-(4'-chlorophenoxy)phenyl methyl sulfide.