



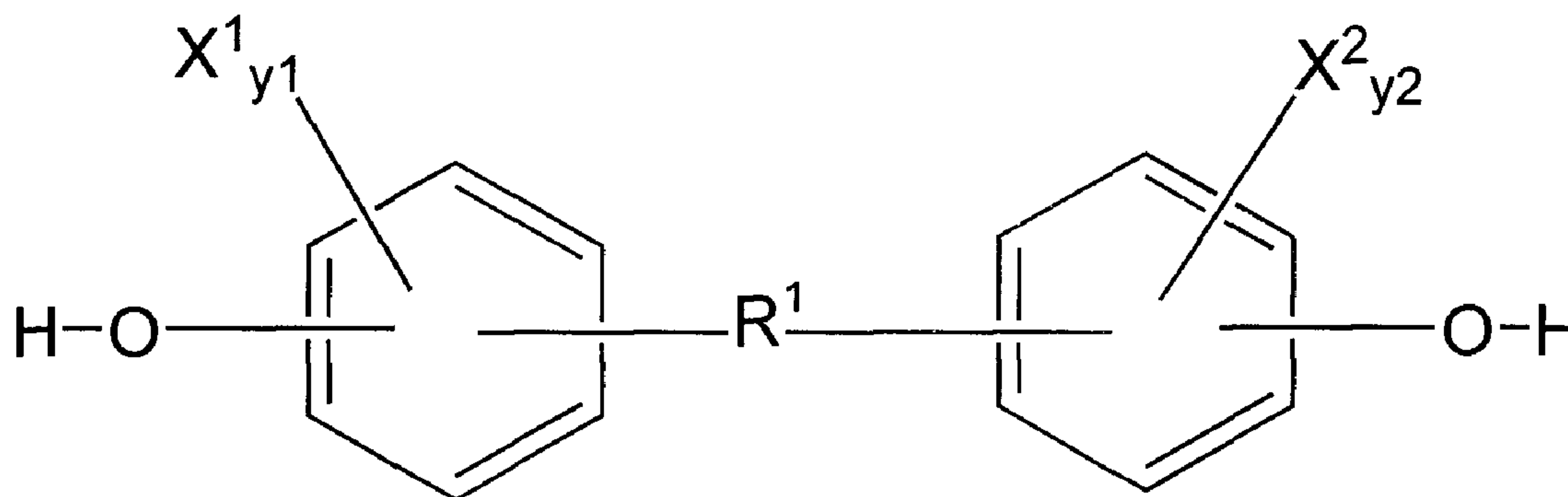
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(54) **Titre : COMPOSES DE DIPHENOL COMPRENANT UN AMIDE SUBSTITUE EN N**
 (54) **Title: DIPHENOL COMPOUNDS COMPRISING A N-SUBSTITUTED AMIDE**



(57) **Abrégé/Abstract:**

Biocompatible, bioresorbable polymers comprising a plurality of monomeric repeating units containing an amide group, wherein said amide groups are N-substituted and the N-substituent and degree of N-substitution is effective to lower the melt viscosity, the solution viscosity, or both, compared to the same polymer without N-substitution.

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(54) Title: N-SUBSTITUTED MONOMERS AND POLYMERS

(57) Abstract: Biocompatible, bioresorbable polymers comprising a plurality of monomeric repeating units containing an amide group, wherein said amide groups are N-substituted and the N-substituent and degree of N-substitution is effective to lower the melt viscosity, the solution viscosity, or both, compared to the same polymer without N-substitution.

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DIPHENOL COMPOUNDS COMPRISING A N-SUBSTITUTED AMIDE

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BACKGROUND OF THE INVENTION

Field of the Invention

10 This invention relates to N-substituted monomers and polymers, methods of making such monomers and polymers, and methods of using them in various applications, such as medical devices.

Description of the Related Art

15 The tyrosine-derived monomers of U.S. Patent No. 5,099,060 polymerize to form polymers with higher melt or solution viscosities that may result in poor processibility. As a result, the fabrication of the polymers requires higher temperatures, higher pressures, or both, that are less economical and may also degrade the polymer or any additives (such as biological or pharmaceutical moieties).

20 Such higher melt or solution viscosities can occur with tyrosine-derived polymers such as the polyiminocarbonates of U.S. Patent No. 4,980,449, the polycarbonates of US Pat. 5,099,060, the polyarylates of U.S. Patent No. 5,216,115, the poly(alkylene oxide) block copolymers of U.S. Patent No. 5,658,995, the phosphorous-containing polymers of U.S. Patent Nos. 5,912,225 and 6,238,687, the anionic polymers of U.S. Patent No. 6,120,491, the

poly(amide carbonates) and poly(ester amides) of U.S. Patent No. 6,284,862, the radio-opaque polymers of US 6,475,477, and the polyethers of U.S. Patent No. 6,602,497.

There exists a need for polymers with lower melt viscosities that are capable of being
5 melt-processed and/or solution processed with greater ease, lower temperatures and/or pressures.

SUMMARY OF THE INVENTION

This need is met by the present invention. It has now been discovered that the amide
10 bonds present in tyrosine-derived polycarbonates and other biocompatible polymers are involved in inter-chain hydrogen bonding, which can interfere in the thermal processibility of the polymer because hydrogen bonding between polymer chains increases melt or solution viscosity. In turn this has lead to the discovery that the effect due to hydrogen bonding in monomers and polymers with peptide linkages can be significantly reduced by replacing the
15 hydrogen atom on the amide nitrogen with methyl or other alkyl groups.

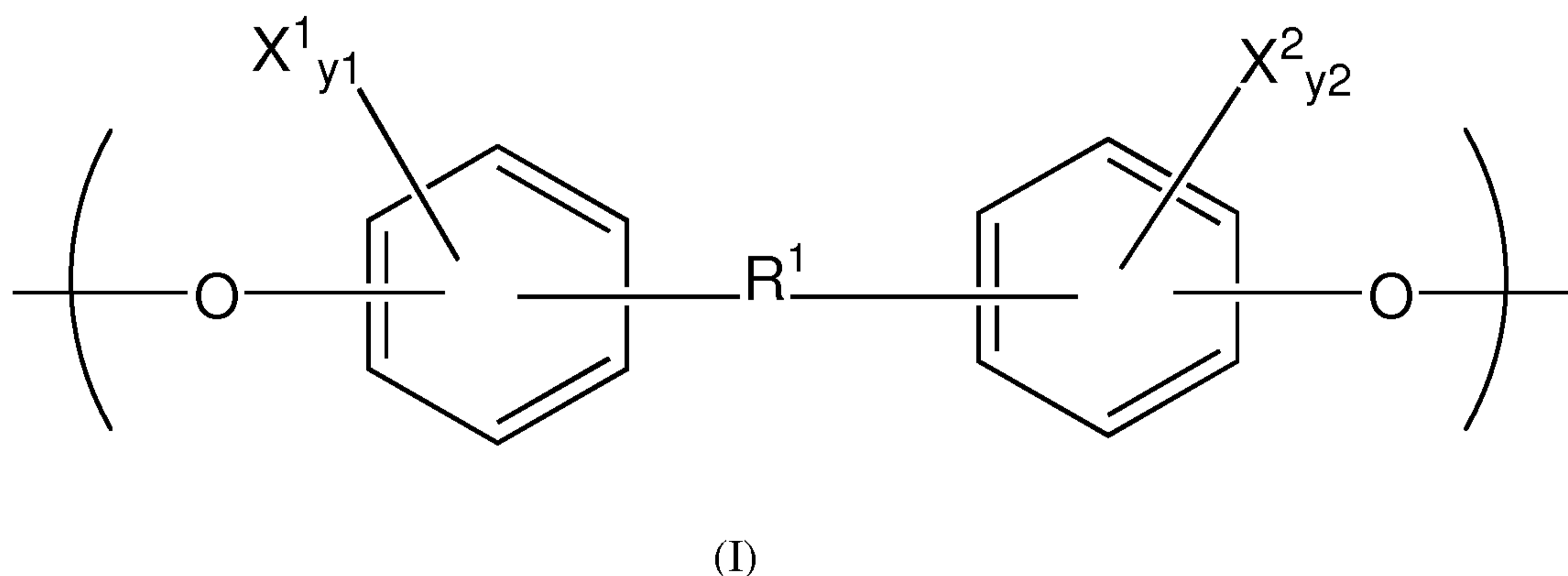
It has surprisingly been discovered that replacing the amide hydrogen with a non-hydrogen-bonding substituent eliminates or greatly reduces this source of intermolecular interaction to a degree such that polymer solubility in organic solvents increases, melt viscosity decreases, and the polymer glass transition likewise decreases. These changes in
20 polymer properties can be so profound that some polymers that were initially non-processible can now be processed by a variety of fabrication technologies, including solvent casting, wet and melt spinning, compression molding, extrusion, and injection molding.

Consequently, an N-substituted version of the polymer may be processed at lower temperatures (e.g., relative to the polymer glass transition temperature or T_g) with less
25 thermal/oxidative degradation. This opens the temperature processing window for the

polymer, e.g., higher T_g polymers can be processed at existing process temperatures and similar T_g polymers may be processed at lower temperatures.

Likewise, polymers solvated in relatively non-polar solvents, such as dichloromethane, can be processed at higher solids concentrations with lower solution
5 viscosities.

Therefore, according to one aspect of the present invention, biocompatible, bioresorbable polymers are provided comprising a plurality of monomeric repeating units containing an amide group, wherein the amide groups are N-substituted and the N-substituent and degree of N-substitution is effective to lower the melt viscosity, the solution viscosity, or
10 both compared to the same polymer without N-substitution. According to one embodiment, the N-substituents and degree of N-substitution are effective to reduce the melt viscosity, the solution viscosity, or both, at least about 5%, and in another embodiment the reduction is at least about 10%. According to another embodiment, the N-substituents are $C_1 - C_6$ alkyl groups. According to yet another embodiment, the N-substituent is a methyl group.
15 According to another embodiment, the present invention includes polymers with one or more recurring units of formula (I):

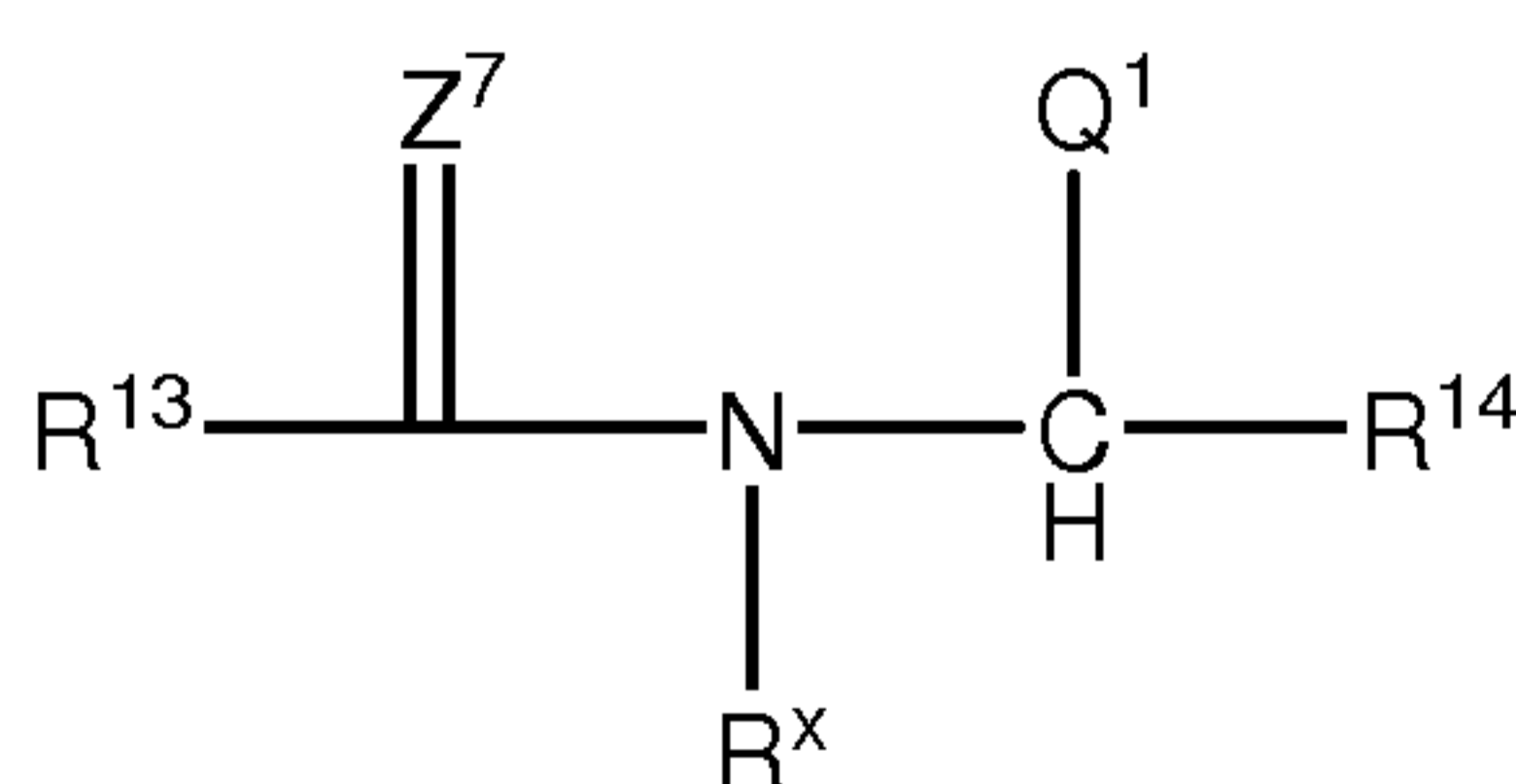


wherein X^1 and X^2 in formula (I) are each independently selected from Br and I; y_1 and
20 y_2 in formula (Ia) are each independently zero or an integer in the range of 1 to 4, and R^1 is selected from substituted or unsubstituted, saturated or unsaturated, straight chain or branched

aliphatic groups containing up to 48 carbon atoms, substituted or unsubstituted aromatic groups containing up to 48 carbon atoms, and substituted or unsubstituted araliphatic groups containing up to 48 carbon atoms in which the aliphatic portions are straight chain or branched and saturated or unsaturated, and R^1 contains from 2 to 8 heteroatoms selected from O, S and N, in which two of the heteroatoms form a polymer backbone amide group that is N-substituted. Additional heteroatoms are present when the R^1 group contains poly(alkylene oxide) groups.

Unless otherwise defined for a specific embodiment, N-substituted amines are substituted with a substituted or unsubstituted, straight or branched, saturated or unsaturated aliphatic group containing up to 30 carbon atoms, a substituted or unsubstituted aromatic group containing up to 30 carbon atoms, and a substituted or unsubstituted araliphatic group containing up to 30 carbon atoms in which the aliphatic portion is straight chain or branched and saturated or unsaturated. According to one embodiment, R^1 groups contain between about 18 and about 36 carbon atoms. According to another embodiment, the N-substituents are $C_1 - C_6$ alkyl groups. According to yet another embodiment, the N-substituent is a methyl group.

According to one embodiment, R^1 has a pendant carboxylic acid group or a pendant carboxylic acid ester or N-substituted amide. According to an embodiment R^1 has a pendant N-substituted tertiary amine. According to one embodiment, R^1 has both a pendant carboxylic acid group or a pendant carboxylic acid ester or N-substituted amide and a pendant N-substituted tertiary amine. According to another embodiment, R^1 in formula (I) is:



(II)

in which R^{13} and R^{14} each independently contain from 0 to 8 carbons atoms, inclusive, and are independently selected from $(-\text{CHR}^1)_e - \text{CH} = \text{CH} - (\text{CHR}^1)_e$ and $(-\text{CHR}^1)_f (-\text{CHNQ}^2)_g (-\text{CHR}^1)_f$,

wherein R^1 is H or lower alkyl, each e independently ranges between 0 and 6, inclusive, each f independently ranges between 0 and 8, inclusive and g is 0 or 1; R^x is selected from optionally substituted branched or unbranched C_1 – C_{30} alkyl and optionally substituted C_6 – C_{30} aryl; Q^1 is $C(=Z^5)-R^8$, wherein Z^5 is O or S; Q^2 is $-N(R^x)_2$ or $N(R^xQ^1)$; R^8 is selected from H, a therapeutically active moiety, a poly(alkylene oxide), X_3 - C_1 - C_{18} alkyl, X_3 -alkenyl, X_3 -alkynyl, $-X_5$ -cycloalkyl, $-X_5$ -heterocyclyl, $-X_5$ -aryl and $-X_5$ -heteroaryl;

X_3 is selected from a bond, O, S, and N-alkyl; X_4 is selected from O, S and N-alkyl; and X_5 is selected from a bond, lower alkyl, O, S and N-alkyl.

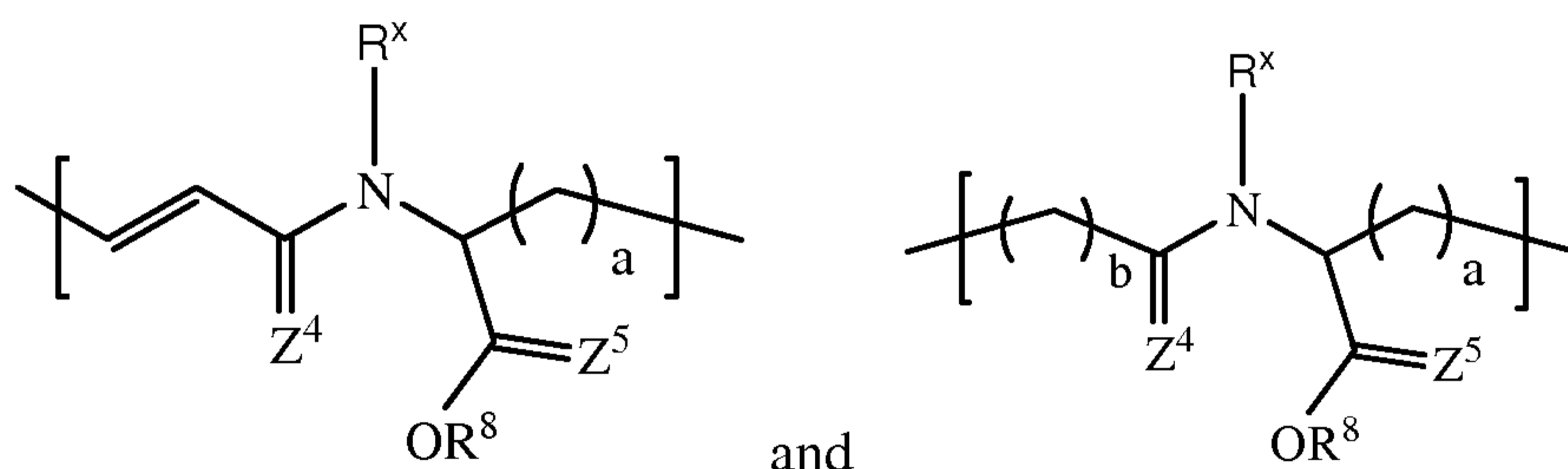
Alkyl, alkenyl, alkynyl, cycloalkyl, heterocyclyl, aryl and heteroaryl groups, except when otherwise defined, contain up to 30 carbon atoms. According to an embodiment, the groups contain up to 18 carbon atoms. Lower alkyl groups, except when otherwise defined, are straight or branched and contain up to 6 carbon atoms. Alkyl, alkenyl and alkynyl, groups are also straight or branched and contain from 0 to eight heteroatoms, and lower alkyl groups also contain 0, 1 or 2 heteroatoms. Heteroatoms are independently selected from O, S and N-lower alkyl. Heterocyclyl and heteroaryl groups also contain from one to eight heteroatoms selected from O, S and N-lower alkyl.

According to one embodiment the poly(alkylene oxide) R^8 groups include alkyl-terminated poly(alkylene oxides) of molecular weight 100 to 10,000, examples of which include methoxy-terminated poly(ethylene glycols) (PEG), methoxy-terminated poly(propylene glycols) (PPG), and methoxy-terminated block copolymers of PEG and PPG. According to another embodiment poly(alkylene oxide) groups have a molecular weight between about 400 and about 4000. According to another embodiment the poly(alkylene oxides) are poly(ethylene glycols) with molecular weights between about 1000 and about 2000.

According to another embodiment, one or both aromatic rings may be substituted with from 1 to 4 groups independently selected from halogen, lower alkyl, carboxyl, nitro, thioether, sulfoxide and sulfonyl as long as the substitution patterns are chemically feasible. Any combination of substituents containing more than two nitro substituents is potentially

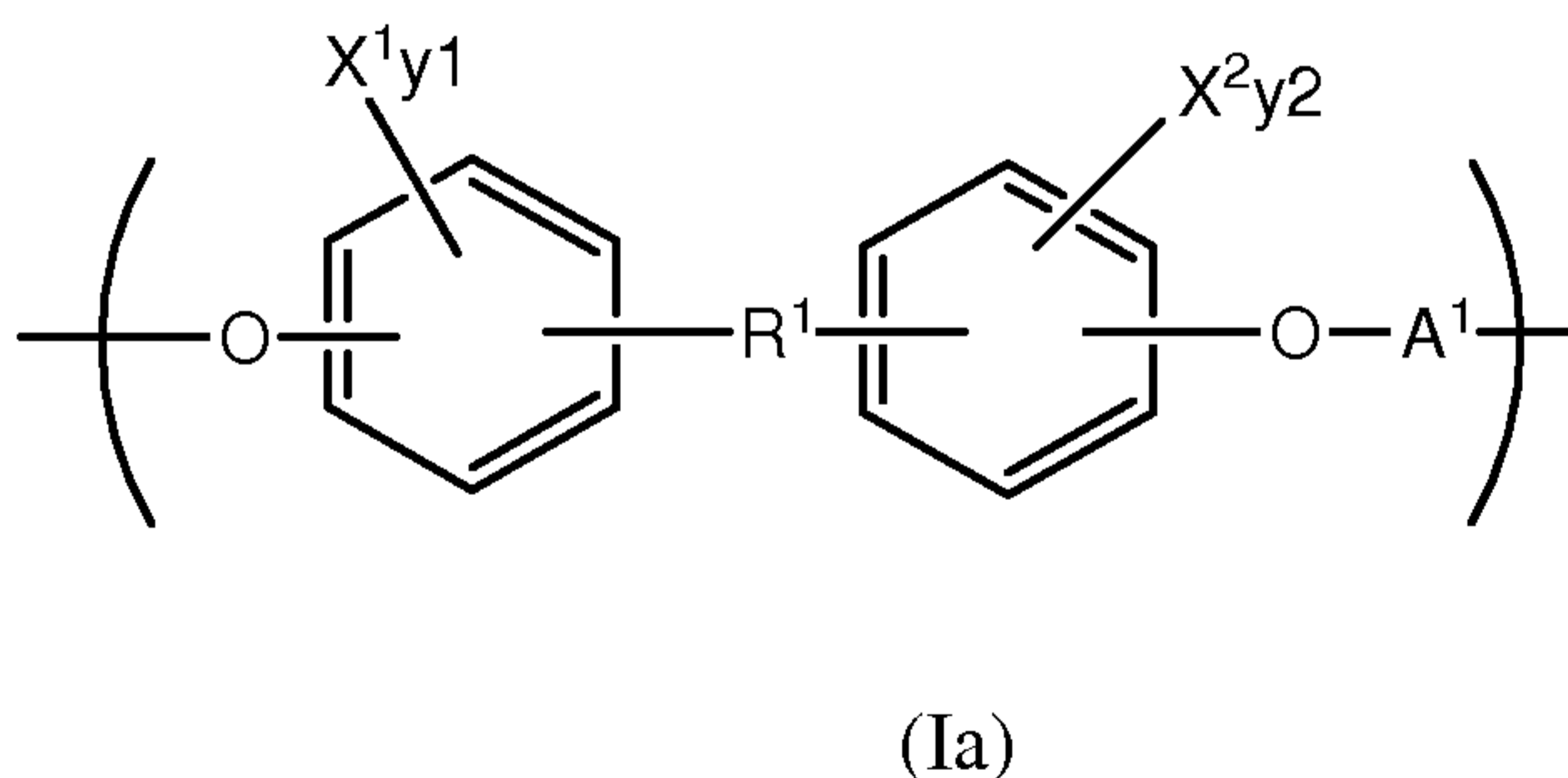
explosive and expressly excluded from these teachings. Monomers and polymers with a sufficient number of aromatic rings sufficiently substituted with bromine or iodine are inherently radio-opaque. In preferred radio-opaque monomers and polymers, at least one monomeric aromatic ring is substituted with iodine, so that the sum of y_1 and y_2 in formula (I) is greater than zero, preferably on at least one and more preferably on both ring positions ortho to the phenolic oxygen. Preferably both aromatic rings are iodine-substituted at both ortho positions.

According to yet another embodiment, R^1 in formula (I) is selected from:

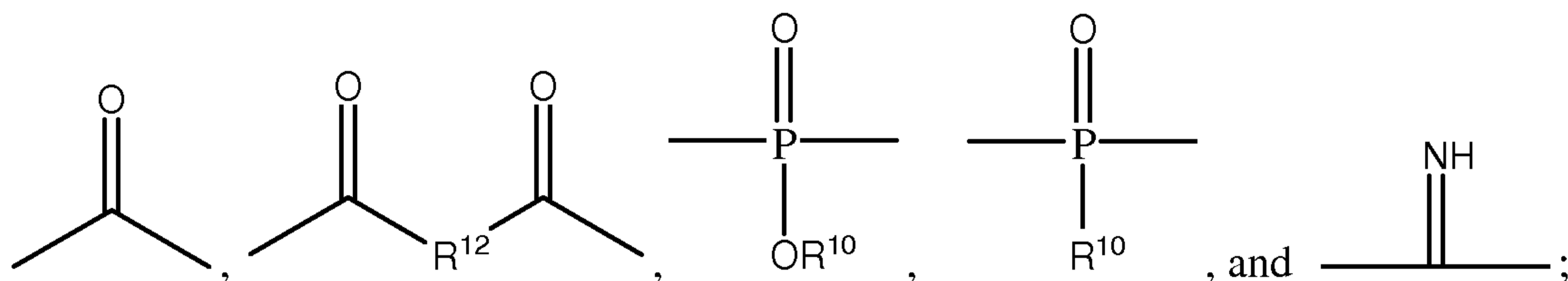


10 wherein R^x and R^8 are the same as described above with respect to formula II; a and b range from 0 and 8, inclusive, and Z^4 and Z^5 are each independently O or S. According to more specific embodiments, $a = 1$ and $b = 2$.

15 Polymers according to the present invention include polycarbonates, polyarylates, polyiminocarbonates, polyphosphazenes and polyphosphoesters having the structure of formula (Ia),

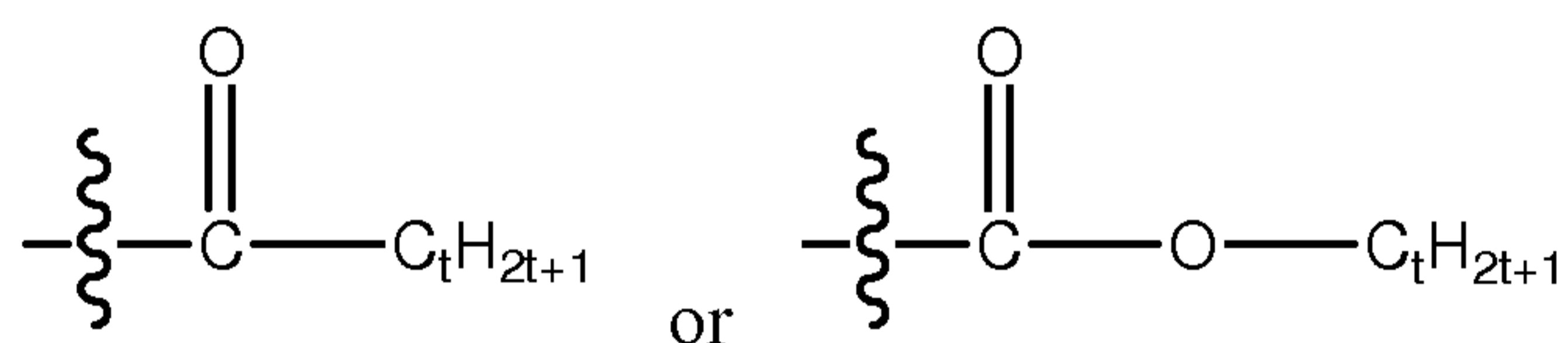


wherein X^1 , X^2 , y_1 , y_2 and R^1 , and the embodiments thereof, are the same as described above with respect to formula (I) and A^1 is selected from:



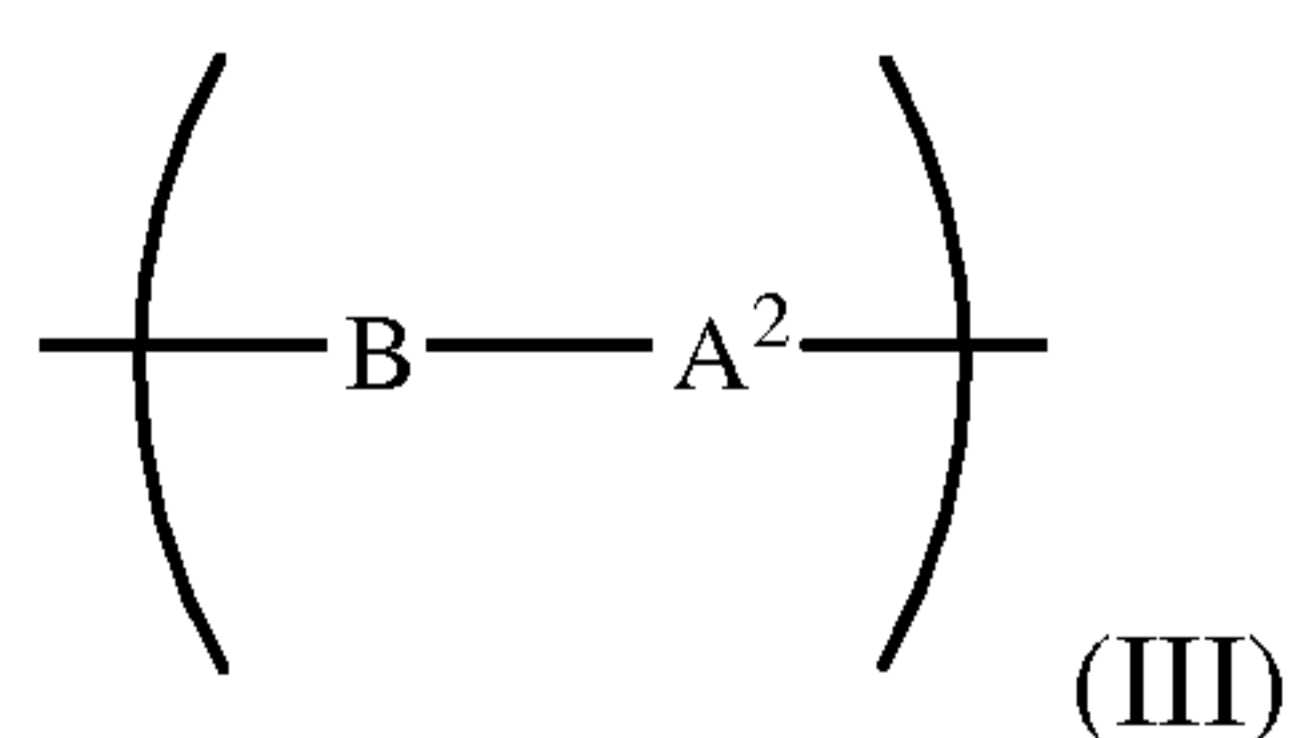
wherein R^{10} is selected from H, $C_1 - C_{30}$ alkyl, alkenyl or alkynyl and $C_2 - C_{30}$ hetero-
 5 alkyl; heteroalkenyl or heteroalkynyl, and R^{12} is selected from $C_1 - C_{30}$ alkyl, alkenyl or
 alkynyl, $C_1 - C_{30}$ heteroalkyl; heteroalkenyl or heteroalkynyl, $C_5 - C_{30}$ heteroalkylaryl,
 heteroalkenylaryl or heteroalkynylaryl, $C_6 - C_{30}$ alkylaryl, alkenylaryl or alkynylaryl, and $C_5 -$
 C_{30} heteroaryl.

In an embodiment, R^x is a branched or unbranched $C_1 - C_6$ alkyl. In a specific
 10 embodiment, R^x is methyl. In an embodiment, Q^1 is a group having the structure:



wherein t in the above groups is independently in the range of zero to about 18.

A polymer comprising a recurring unit of formula (I) can be copolymerized with any
 number of other recurring units. In an embodiment, the polymer comprising a recurring unit
 15 of formula (I) further comprises a recurring polyalkylene oxide block units of the formula
 (III):

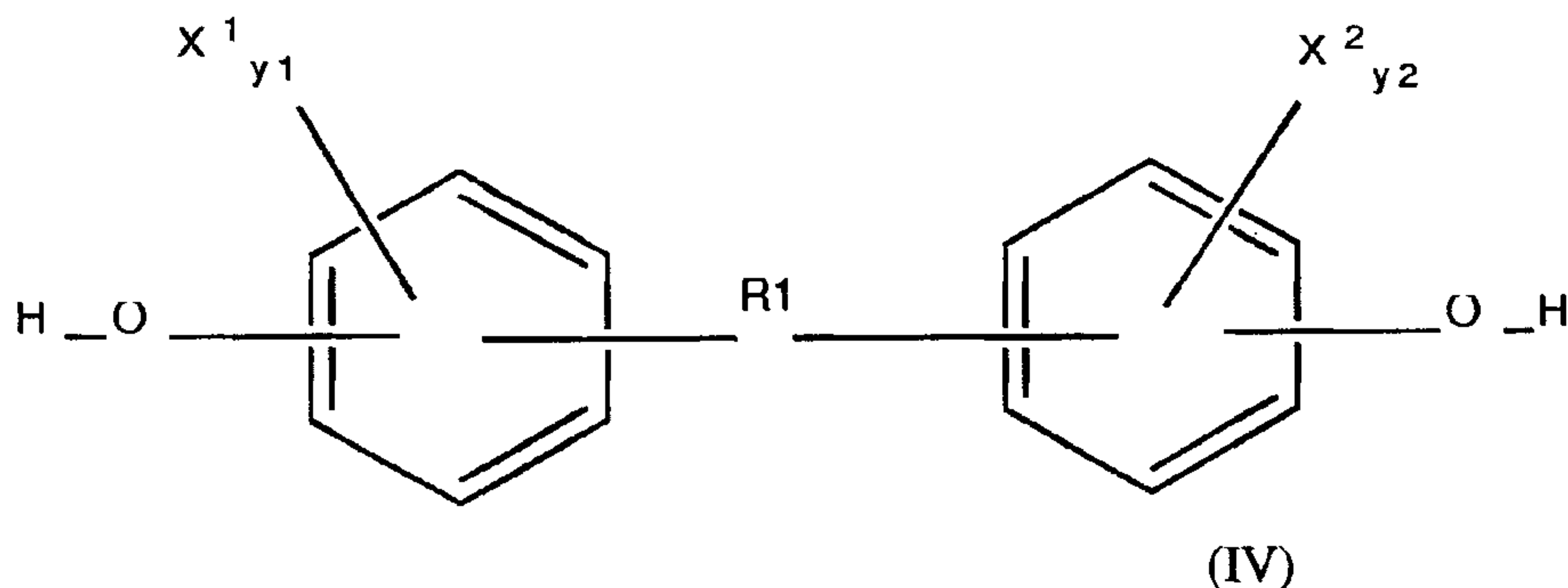


wherein B is $-O-((CHR^6)_p-O)_q-$; each R^6 is independently H or C_1 to C_3 alkyl; p is an integer ranging between about one and about four; q is an integer ranging between about five and about 3000; and A^2 is the same as A^1 in formula (Ia). One block copolymerized polymer embodiment contains a molar fraction of alkylene oxide between about 0.1 and about 25%.
 5 Another embodiment contains a molar fraction of alkylene oxide between about 0.5 and about 10%. Yet another embodiment contains a molar fraction of alkylene oxide between about 1 and about 5%.

N-substituted polymers according to the present invention are polymerized from diphenols corresponding to the structure of formula (I) prepared according to the methods
 10 disclosed by the above-referenced U.S. Patent No. 5,099,060.

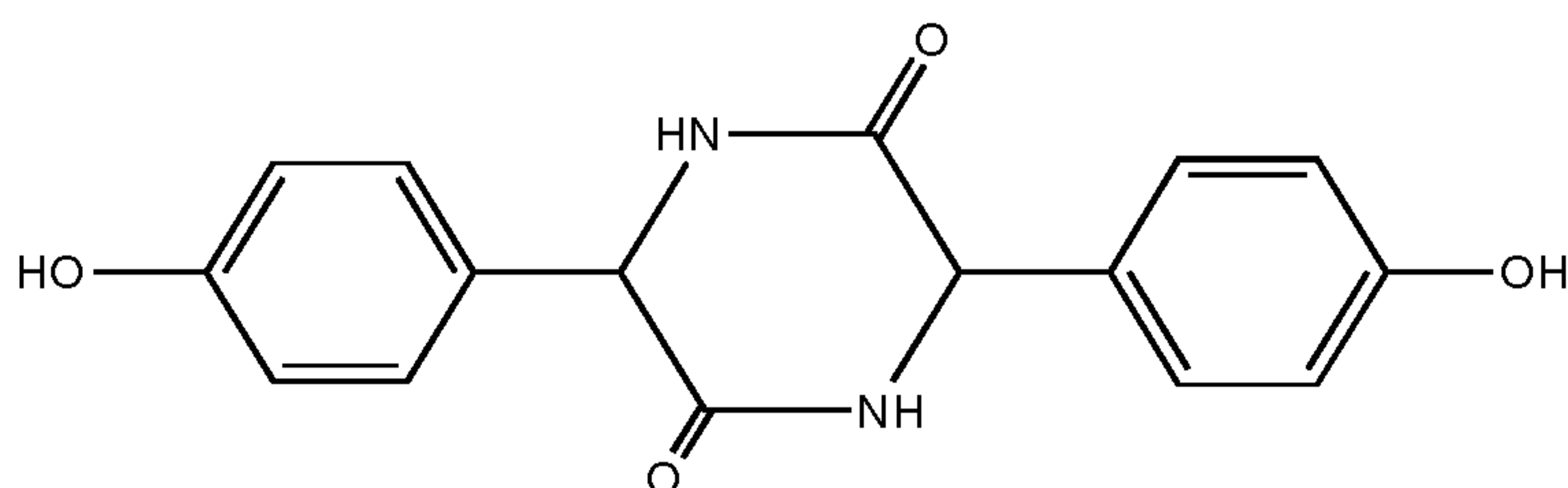
The polymers can be copolymerized with diphenols that are not N-substituted. Polymers according to the present invention contain embodiments in which the molar fraction of N-substituted monomer is between about 1 and about 50%. Another embodiment provides polymers with a molar fraction of N-substituted monomer
 15 between about 5 and about 25%. Yet another embodiment provides polymers with a molar fraction of N-substituted monomer between about 7.5 and about 12.5%.

N-substituted diphenol compounds thus represent new and useful compounds according to the present invention. The present invention therefore also includes diphenol compounds with amide groups that are N-substituted. One embodiment includes diphenol
 20 compounds in which the N-substituent is a $C_1 - C_6$ alkyl group. Another embodiment includes diphenol compounds having the structure of formula (IV):

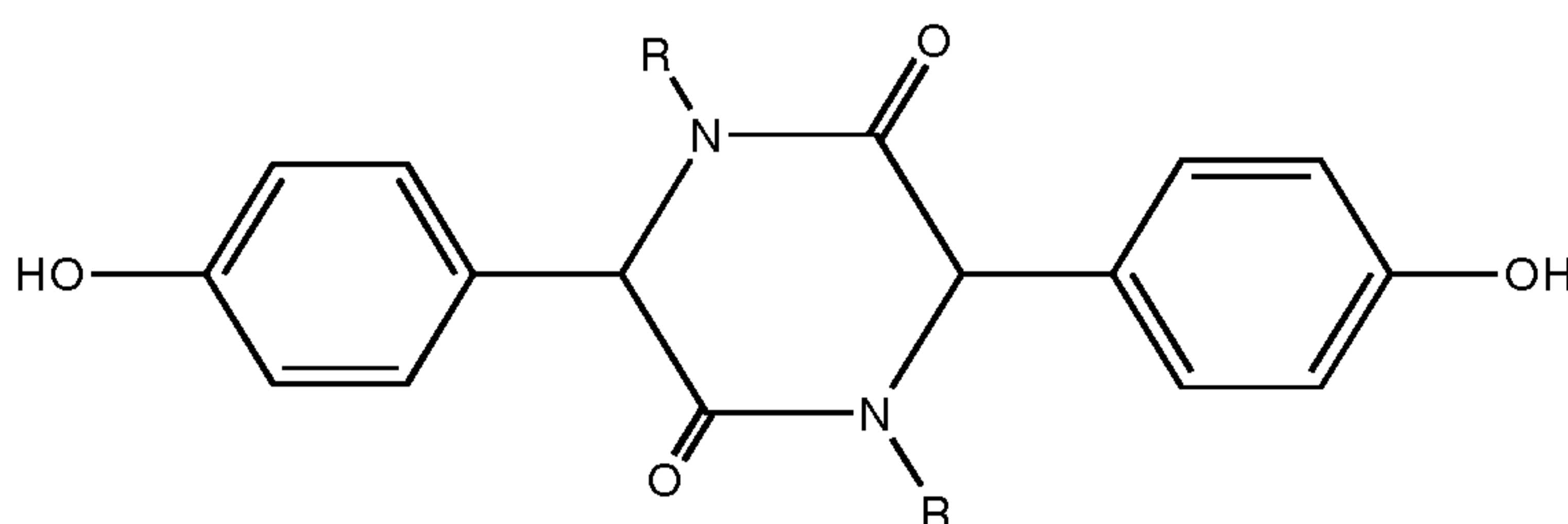


wherein X^1 , X^2 , y_1 , y_2 and R^1 , and the embodiments thereof, are the same as described above with respect to formula (I).

According to one diphenol embodiment, R^1 is selected so the Formula IV monomer is an N-substituted dityrosine such as the N,N-dimethyl dityrosine depicted below formed by N-
5 methylation of the dityrosine depicted below:



Di-tyrosine



Di-alkyl Dityrosine

Dityrosines and their preparation are reported in the literature, and dityrosines can be N-substituted by the procedures disclosed herein. The present invention also includes Formula I and Formula Ia polymers polymerized from the N-substituted dityrosines of the
10 present invention.

In general, polymers according to the present invention possess excellent physical properties and melt processability and can be shaped into different three-dimensional structures for specific uses by conventional polymer-forming techniques such as extrusion and injection molding. The solvent-casting and compression molding techniques described in

earlier patents disclosing polymers polymerized from tyrosine-derived diphenol compounds can also be used. Therefore, according to another aspect of the present invention, blood-contacting or tissue-implantable medical devices are provided, formed from the polymers of the present invention. Preferably, the devices are formed by thermal fabrication. Such
5 devices include hernia repair devices.

According to one embodiment of this aspect of the invention, the medical device is a stent for treatment of a body lumen. Preferred stents are formed from or coated with radio-opaque polymers according to the present invention, so that fluoroscopic imaging can be used to guide positioning of the device. A preferred radio-opaque, bioresorbable stent according to
10 one embodiment of the present invention is formed from a bioresorbable polymer with sufficient halogen atoms to render the stent inherently visible by X-ray fluoroscopy during stent placement.

According to another aspect of this embodiment of the present invention, the medical device is an embolotherapy product. Embolotherapy products according to the present
15 invention are particulate formulations of biocompatible, bioresorbable polymers according to the present invention. In a preferred embodiment, the polymer contains a sufficient number of halogen atoms to render the embolotherapy product inherently radio-opaque.

Other specific applications for which the polymers of the present invention are also particularly useful include scaffolds for tissue engineering on which isolated cell populations
20 may be transplanted in order to engineer new tissues. The polymers are formed into porous devices as described by Mikos et al., *Biomaterials*, 14, 323-329 (1993) or Schugens et al., *J. Biomed. Mater. Res.*, 30, 449-462 (1996) or U.S. Patent No. 6,103,255 to allow for the attachment and growth of cells as described in *Bulletin of the Material Research Society, Special Issue on Tissue Engineering (Guest Editor: Joachim Kohn)*, 21(11), 22-26 (1996).
25 Therefore, another aspect of the present invention provides a tissue scaffold having a porous structure for the attachment and proliferation of cells either in vitro or in vivo formed from polymers according to the present invention.

Another specific application includes implantable drug delivery devices where a pharmaceutically active moiety is admixed within the polymeric matrix for slow release, including devices for ophthalmic drug delivery. Therefore, in one embodiment of the present invention, the polymers are combined with a quantity of a biologically or pharmaceutically active compound sufficient to be therapeutically effective as a site-specific or systemic drug delivery system as described by Gutowska et al., *J. Biomater. Res.*, 29, 811-21 (1995) and Hoffman, *J. Controlled Release*, 6, 297-305 (1987). Furthermore, another aspect of the present invention provides a method for site-specific or systemic drug delivery by implanting in the body of a patient in need thereof an implantable drug delivery device containing a therapeutically effective amount of a biologically or a physiologically active compound in combination with a polymer of the present invention.

Polymers in accordance with the present invention may be prepared having good film-forming properties. An important phenomena observed for the polymers of the present invention having poly(alkylene oxide) block copolymer segments is the temperature dependent phase transition of the polymer gel or the polymer solution in aqueous solvents. As the temperature increases, the gel of the polymers undergo a phase transition to a collapsed state, while polymer solutions precipitate at a certain temperature or within certain temperature ranges. The polymers of the present invention having poly(alkylene oxide) segments, and especially those that undergo a phase transition at about 30 to 40° C. on heating can be used as biomaterials for drug release and clinical implantation materials. Specific applications include films and sheets for the prevention of adhesion and tissue reconstruction.

Therefore, in another embodiment of the present invention, poly(alkylene oxide) block copolymers of polymers according to the present invention may be formed into a sheet or a coating for application to exposed injured tissues for use as barrier for the prevention of surgical adhesions as described by Urry et al., *Mat. Res. Soc. Symp. Proc.*, 292, 253-64 (1993). There-fore, another aspect of the present invention provides a method for preventing the formation of adhesions between injured tissues by inserting as a barrier between the

injured tissues a sheet or a coating of the radio-opaque poly(alkylene oxide) block copolymers of polymers according to the present invention.

The poly(alkylene oxide) segments decrease the surface adhesion of the polymers of the present invention. As the molar fraction of poly(alkylene oxide) increases, the surface
5 adhesion decreases. Polymer coatings containing poly(alkylene oxide) segments according to the present invention may thus be prepared that are resistant to cell attachment and are useful as non-thrombogenic coatings on surfaces in contact with blood. Such polymers also resist bacterial adhesion in this and in other medical applications as well. The present invention therefore includes blood contacting devices and medical implants having surfaces coated with
10 the poly(alkylene oxide) block copolymers of the present invention.

The coated surfaces are preferably polymeric surfaces. Methods according to the present invention include implanting in the body of a patient a blood-contacting device or medical implant having a surface coated with the polymers of the present invention containing poly(alkylene oxide) block copolymer segments.

15 By varying the molar fraction of poly(alkylene oxide) segments in the block copolymers of the present invention, the hydrophilic/hydrophobic ratios of the polymers can be attenuated to adjust the ability of the polymer coatings to modify cellular behavior. Increasing levels of poly(alkylene oxide) inhibits cellular attachment, migration and proliferation, while increasing the amount of pendent free carboxylic acid groups promotes
20 cellular attachment, migration and proliferation. Therefore, according to yet another aspect of the present invention, a method is provided for regulating cellular attachment, migration and proliferation by contacting living cells, tissues, or biological fluids containing living cells with the polymers of the present invention.

Through pendant free carboxylic acid groups, derivatives of biologically and
25 pharmaceutically active compounds, including drugs, can be attached to the polymer backbone by covalent bonds linked to the carboxylic acid pendent chain. This provides for the sustained release of the biologically or pharmaceutically active compound by means of

hydrolysis of the covalent bond between the drug and the polymer backbone. The present invention therefore also includes polymer embodiments in which R is a biologically or pharmaceutically active compound covalently attached to the polymer backbone.

In addition, polymers of the present invention with pendent carboxylic acid groups
5 have a pH dependent dissolution rate. This further enables the polymers to be used as coatings in gastrointestinal drug release carriers to protect some biologically and pharmaceutically active compounds such as drugs from degrading in the acidic environment of the stomach. The copolymers of the present invention having a relatively high concentration of pendent carboxylic acid groups are stable and water insoluble in acidic environments but
10 dissolve/degrade rapidly when exposed to neutral or basic environments. By contrast, copolymers of low acid to ester ratios are more hydrophobic and will not degrade/resorb rapidly in either basic or acidic environments. Therefore, another aspect of the present invention provides a controlled drug delivery system in which a biologically or pharmaceutically active agent is physically coated with a polymer of the present invention
15 having free carboxylic acid groups.

Other features of the present invention will be pointed out in the following description and claims, which disclose the principles of the invention and the best modes which are presently contemplated for carrying them out.

20 DETAILED DESCRIPTION OF PREFERRED EMBODIMENTS

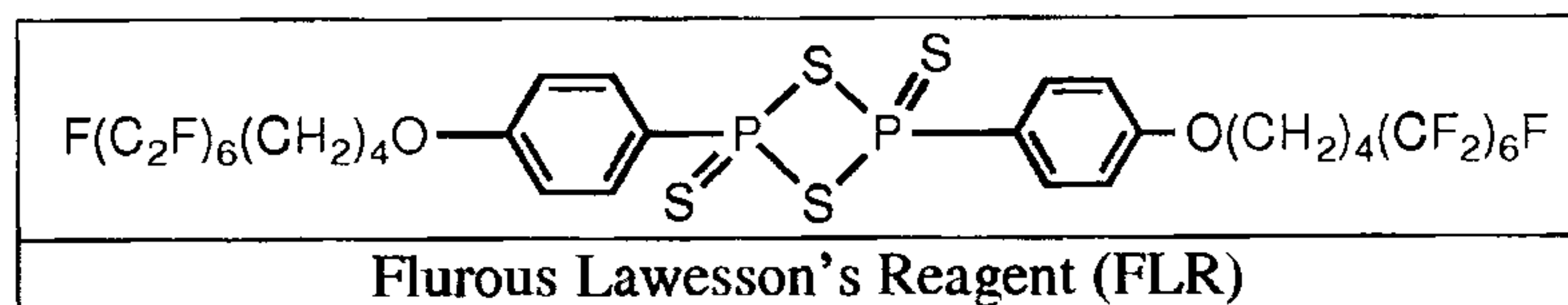
The present invention introduces a novel class of monomers and copolymers polymerized therefrom in which amino acids or amino acid structural derivatives are linked together to form new monomers are then polymerized to form the new, useful polymers depicted in formula (I). The diphenol monomers of formula IV are prepared following
25 standard procedures of peptide chemistry such as disclosed in J. P. Greenstein and M. Winitz, Chemistry of the Amino Acids, (John Wiley & Sons, New York 1961) and Bodanszky, Practice of Peptide Synthesis (Springer-Verlag, New York, 1984).

Specifically, carbodiimide-mediated coupling reactions in the presence of hydroxybenzotriazole according to the procedure disclosed in U.S. 5,587,507 and U.S. 5,670,602. Suitable

carbodiimides are disclosed therein. The preferred carbodiimide is 1-ethyl-3-(3-dimethylamino-propyl) carbodiimide hydro-chloride (EDCI.HCl). The crude monomers can be recrystallized twice, first from 50% acetic acid and water and then from a 20:20:1 ratio of ethyl acetate, hexane and methanol, or, alternatively, flash chromatography on silica gel is used, employing a 100:2 mixture of methylene chloride:methanol as the mobile phase.

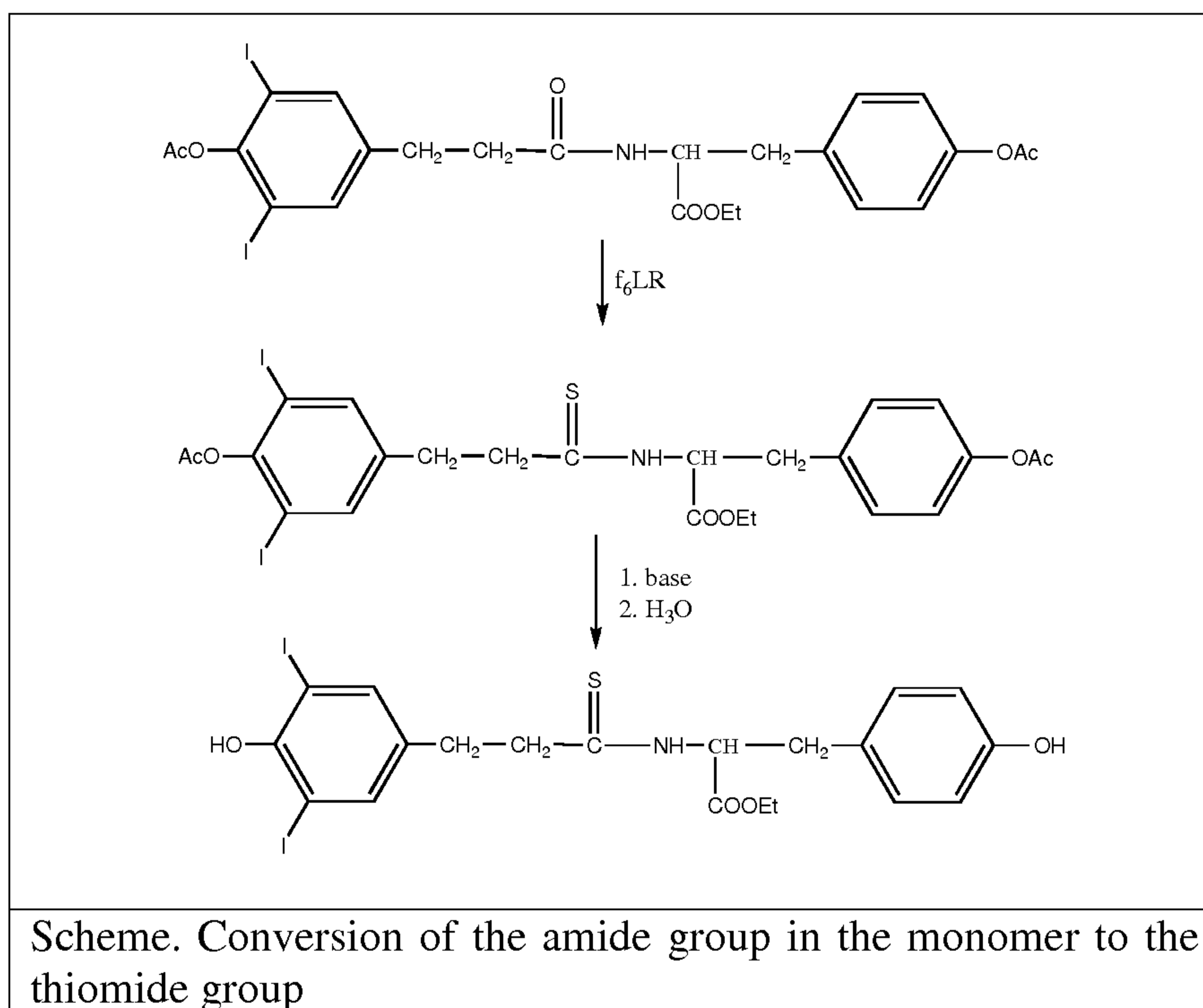
Thioamide monomers ($Z^5 = S$) can be prepared using the method described by A. Kjaer (Acta Chemica Scandinavica, 6, 1374-83 (1952)). The amide group in the monomers or polymers can also be converted to thioamide groups using the fluorous analog of the Lawesson's reagent (f_6LR) whose structure appears below (Kaleta, Z., et al., Org. Lett., 8(8), 1625-1628 (2006)). The second method is preferable, since it allows the formation of the monomer first then allows the conversion of the amide group to the thioamide group.

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Treatment of an amide with this reagent in 1:1 molar ratio in THF gives the corresponding thioamide in >88% yield after purification by chromatography or other means.

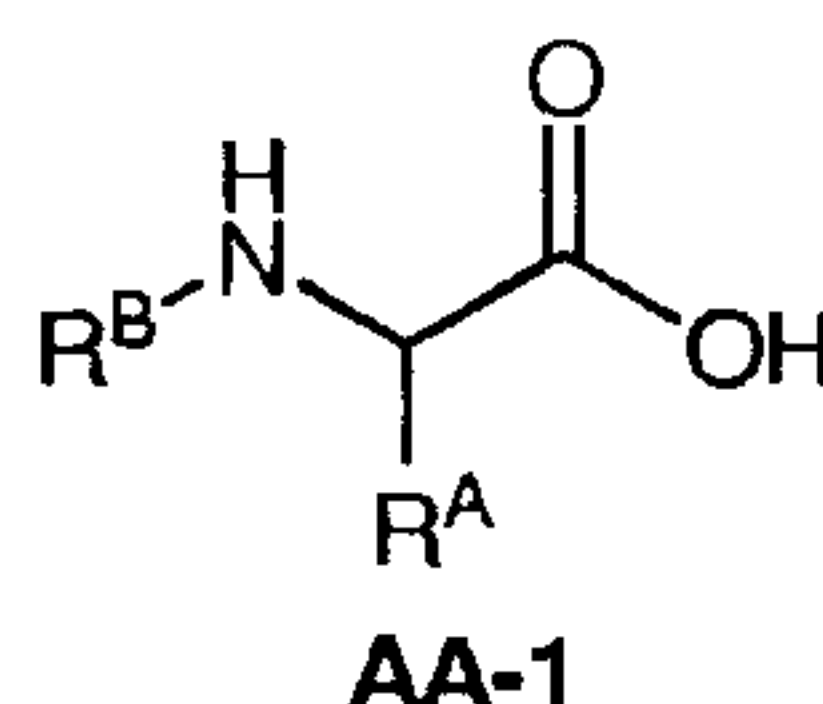
For the conversion of the tyrosine derived amide monomers to the corresponding thioamides, the phenolic groups of the monomers are first protected by converting them to the diacetyl esters as shown for I₂DTE by treating with Ac₂O/pyridine. The O-protected I₂DTE is then reacted with f_6LR followed by base hydrolysis to the thioamide- I₂DTE as shown in the scheme. The transformation can also be carried out on the polymer using similar procedure.



The N-substituted monomers and polymers of the present invention can be prepared by substituting commercially-available N-substituted starting materials for the starting materials of monomers containing amide groups, such as the monomers disclosed by U.S. Pat. No. 5,099,060, or by N-substituting monomers containing amide groups, such as the monomers prepared according to U.S. Patent No 5,099,060 using non-N-substituted starting materials. There are several methods described in the scientific literature that accomplishes such conversions. For example, the acidic hydrogens of amide groups can be replaced by alkyl groups in the monomer by reacting the monomer or polymer with paraformaldehyde followed by hydrogenation using Pd/C/H₂ or using sodium cyanoborohydride.

Provided herein is a method for making N-alkyl/N-aryl monomer precursors of formula AA-1. Those having ordinary skill in the art, guided by the disclosure herein, can use the N-alkylation/N-arylation steps of forming a monomer precursor described herein to create any N-alkylated/N-arylated monomer that corresponds to the polymers described above.

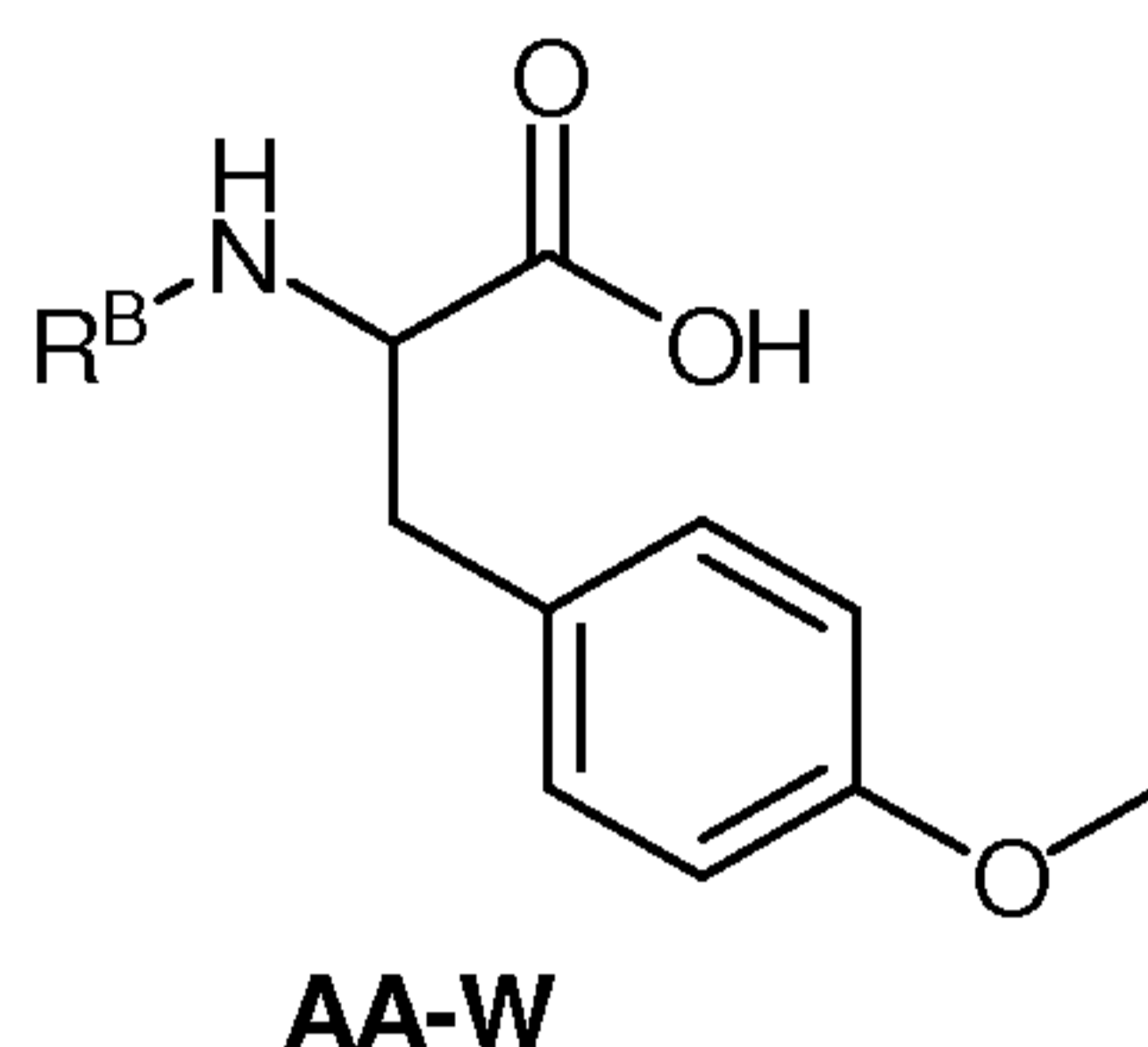
N-Substituted Monomer Preparation



The monomer precursors of formula AA-1 are readily prepared via several divergent synthetic routes with the particular route selected relative to the ease of compound preparation, the commercial availability of starting materials, and the like. In some
 5 embodiment, the compounds of formula AA-1 can be synthesized as disclosed in U.S. Pat. No. 6,096,782 to Audia et al.; Aurelio *et al.* (Aurelio *et al.* "Synthetic Preparation of N-Methyl- α -amino Acids", *Chem. Rev.*, 2004, 5823-5846); Fukuyama *et al.* (Fukuyama *et al.* "2,4-Dinitrobenzenesulfonamides: A Simple and Practical Method for the Preparation of a
 10 Variety of Secondary Amines and Diamines", *Tet. Lett.*, 1997, 5831-5834); and Ma *et al.* (Ma *et al.*, "CuI-Catalyzed Coupling Reaction of β -Amino Acids or Esters with Aryl Halides at Temperature Lower Than That Employed in the Normal Ullmann Reaction. Facile Synthesis of SB-214857", *Org. Lett.*, 3 (16), 2001, 2583-2586).

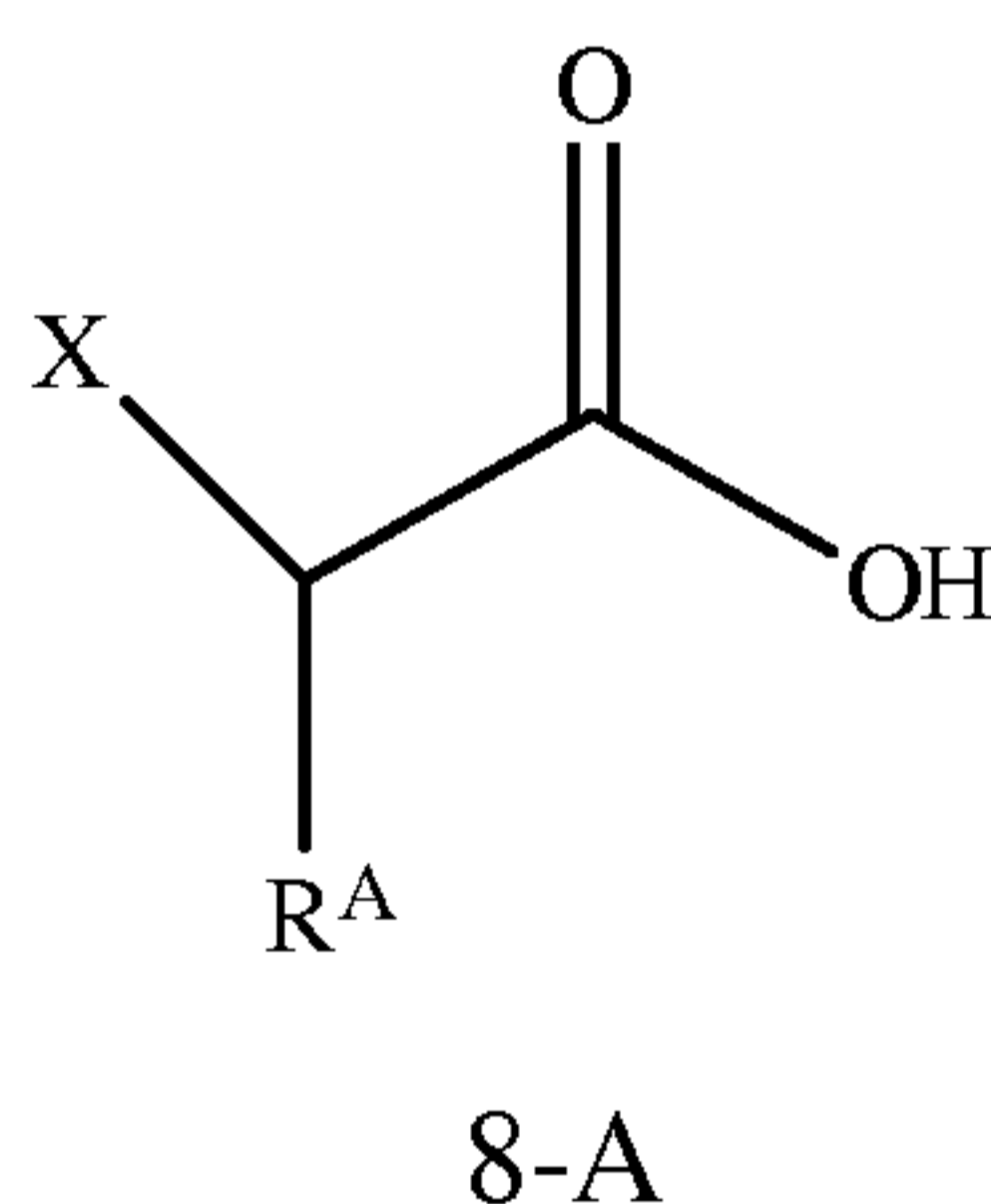
For example, the monomer precursors of
 15 formula AA-1 can be synthesized as shown in Schemes 8 and 9 below. Other non-limiting methods for synthesizing the precursors of formula AA-1 are shown below. The ubiquitousness of modified amino acids in the literature will lead one of skill in the art to a variety of additional methods to prepare *N*-modified amino acids.

In an embodiment, in monomer precursor of formula AA-1, variable R^A can be a
 20 protected or unprotected side chain of an amino acid. For example, R^A can be the side chain of Alanine, Cysteine, Glycine, Histidine, Isoleucine, Phenylalanine, Serine, Threonine, Tryptophan, Tyrosine, and Valine. In an exemplary embodiment, R^A can be the side chain of Tyrosine where the phenolic hydroxy is protected. For example, the phenolic hydroxy group of Tryptophan can be protected as a methyl ether as shown in the precursor of formula AA-W
 25 below.



In an embodiment, in the monomer precursor of formula AA-1, variable R^B can be an optionally substituted alkyl or aryl substituent. For example, R^B can be branched or unbranched C₁ – C₃₀ alkyl or optionally substituted C₆ – C₃₀ aryl.

5 In an embodiment, a monomer precursor for formula AA-1 is given by 8-A:



wherein variable X can be Cl, Br, I, tosylate, mesylate, triflate and the like.

Synthetic Schemes: N-alkyl monomer precursors

10 Scheme 8 route 1

In an embodiment, a method of introducing the N substituent R^B of monomer precursor AA-1 via a substitution reaction, wherein R^A and R^B is defined as above, and X can be Cl, Br, tosylate, or mesylate defined as above, can be accomplished as shown in Scheme 8 route 1. For example, in compound 8-A the variable X is a good leaving group and can be substituted with the appropriate aryl or alkyl amine (8-B) to afford monomer precursor AA-1

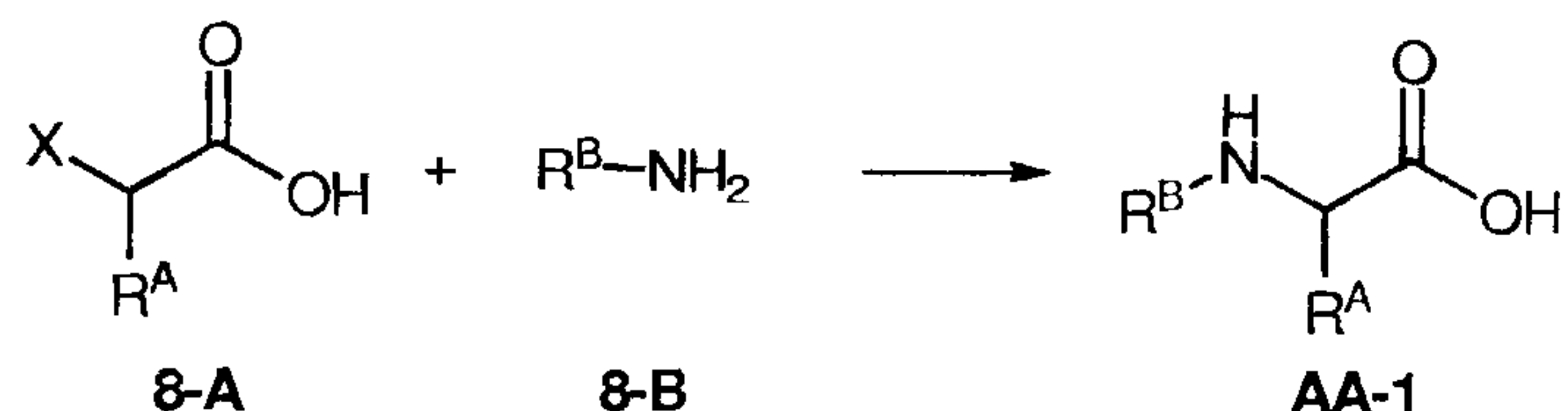
15

as described in U.S. Pat. No. 3,598,859.

Additionally, suitable ester derivatives of 8-A can be used with this method.

Scheme 8

Route 1



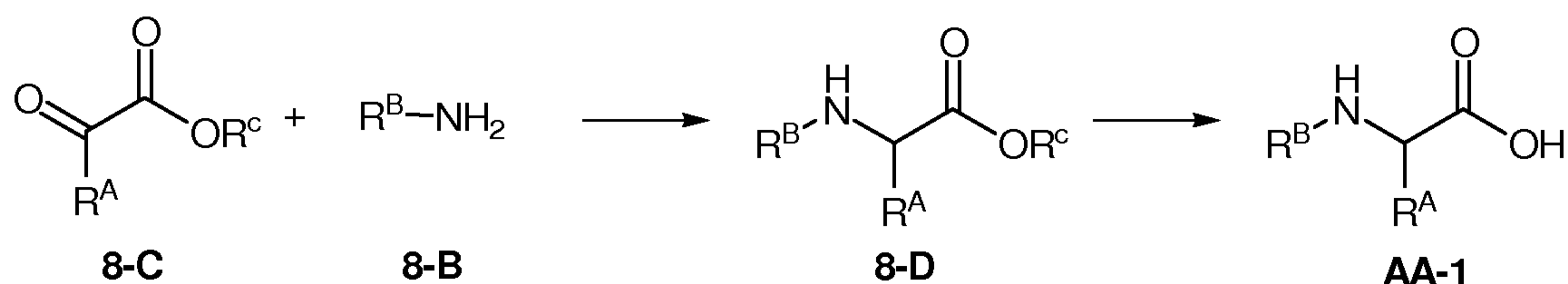
In some embodiments, coupling of 8-A with a primary, aryl, or heteroarylamine of the
 5 formula 8-B under appropriate conditions can provide AA-1. This reaction is described by,
 for example, U.S. Pat. No. 3,598,859. In an embodiment, the reaction proceeds by combining
 approximately stoichiometric equivalents of 8-A, wherein X is Cl, Br, or I, with 8-B in a
 suitable inert diluent such as water, dimethylsulfoxide (DMSO), or the like. The reaction
 employs an excess of a suitable base such as sodium bicarbonate, sodium hydroxide, etc. to
 10 scavenge the acid generated by the reaction. The reaction is preferably conducted at from
 about 25°C to about 100°C until reaction completion which typically occurs within 1 to about
 24 hours. Upon reaction completion, AA-1 can be isolated by conventional methods, such as,
 precipitation, chromatography, filtration and the like.

Scheme 8 route 2

15 In one embodiment, a method of introducing the N substituent R^B of monomer
 precursor AA-1 can be accomplished via a reductive amination reaction, as shown in Scheme
 8 route 2, wherein R^A, R^B, and X are defined as above. The α-ketoester 8-C can be treated
 with the appropriate aryl or alkyl amine (8-B) under reductive amination conditions to afford
 AA-1 as described in U.S. Pat. No. 3,598,859.

Scheme 8

Route 2

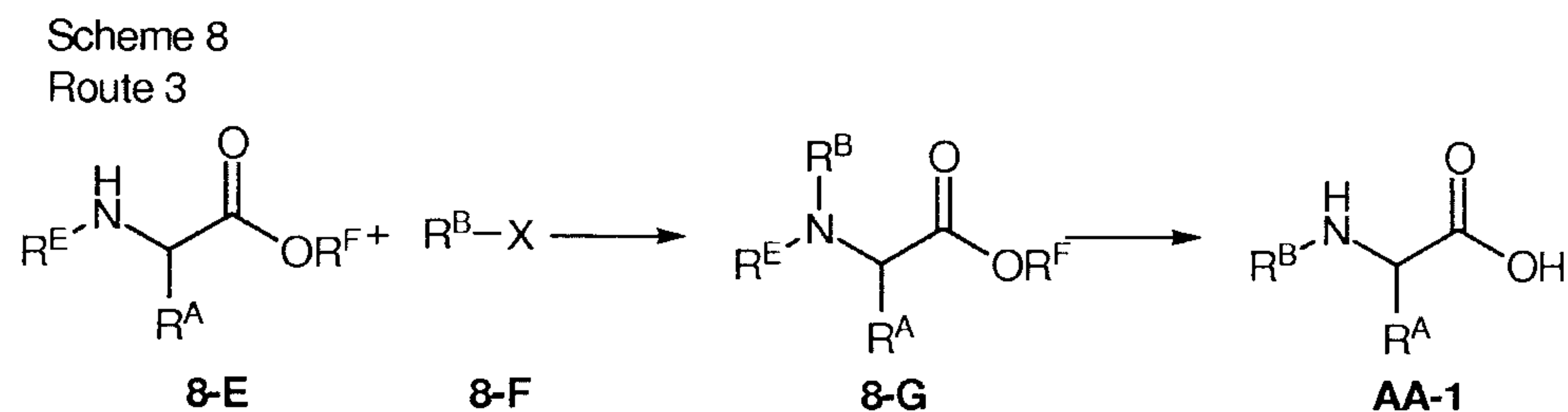


For example, in an exemplary embodiment, approximately stoichiometric amounts of an α -ketoester of formula 8-C and an alkyl or aryl amine of the formula 8-B can be combined in a solvent such as methanol, ethanol and the like and reacted under conditions which provide for imine formation (not shown). The *in situ* formed imine can be then reduced under conventional conditions by a suitable reducing agent, such as sodium cyanoborohydride, H₂/palladium on carbon and the like to form the N-aryl or N-alkyl amino acid ester 8-D. In a typical embodiment, the reducing agent is H₂/palladium on carbon which is incorporated into the initial reaction medium which permits imine reduction *in situ* in a one pot procedure to provide for the N-aryl or N-alkyl amino acid ester 8-D. Subsequent hydrolysis of ester 8-D can afford the monomer precursor AA-1. For example, the ester can be hydrolyzed using wet basic methanol.

Scheme 8 route 3

In one embodiment, a method of introducing the N substituent R^B of monomer precursor AA-1 can be accomplished via an alkylation reaction of a compound of the formula 8-E and subsequent transformation as shown in Scheme 8 route 3. In some embodiments, R^A and X are defined as above, R^B can be branched or unbranched C₁ – C₃₀ alkyl or optionally substituted C₆ – C₃₀ aryl, R^F can be H, C₁-C₆ alkyl or aryl(CH₂)-, and R^E can be selected from the group consisting of CF₃C(O)-, Cbz- (Carbobenzyloxy), Boc- (tert-Butoxycarbonyl), tosyl- (toluenesulfonyl) or Nosyl- (2-nitrobenzenesulfonyl or 2-nitrobenzenesulfonyl) group, 2,4-dinitrobenzenesulfonyl, and the like.. The N-substituted compound of formula 8-E can be treated with an alkylating agent (8-B) under the appropriate

conditions to afford 8-G, and the subsequent transformation of 8-G can afford monomer precursor AA-1, as shown below.



5 For example, in an exemplary embodiment, Aurelio *et al.* discloses methods of preparing *N*-methyl amino acids, these methods can be generally used to prepare additional *N*-substituted amino acids, such as *N*-methyl, *N*-ethyl, *N*-benzyl and the like.

In an embodiment, treatment of 8-E, wherein R^E is Cbz- or Boc-; R^F is H; and R^A is Me or -CH₂Phenyl, with methyl iodide in the presence of Ag₂O in DMF affords 8-E, wherein R^B is methyl and R^F is methyl. Subsequent hydrolysis of the methyl ester and removal of the carbamate type protecting group affords the *N*-methyl amino acid AA-1. This method can be modified to use ethyl iodide in place of methyl iodide to afford the *N*-ethyl amino acids of formula AA-1. Additionally, this method can be applied to polymers following the procedure of Das *et al.* (Das, *et al.*, "*N*-methylation of *N*-acyl oligopeptides", *Biochem. Biophys. Res. Commun.* 1967,29,211),
 15 to afford *N*-methyl polymers.

In one embodiment, treatment of 8-E, wherein R^E is Cbz- or Boc-; R^F is H; and R^A is Me or -CH₂Phenyl with sodium hydride followed by addition of methyl iodide in DMF/THF at 80°C for 24 h affords 8-E, wherein R^B is methyl and R^F is methyl. Subsequent hydrolysis
 20 of the methyl ester with sodium hydroxide in methanol/THF and then removal of the carbamate type protecting group affords the *N*-methyl amino acid AA-1. This method can be modified to use ethyl iodide in place of methyl iodide to afford the *N*-ethyl amino acids of

formula AA-1. In another embodiment this same procedure can be used to alkylate 8-E wherein R^F is methyl.

In an embodiment, following the procedure of Belagali *et al.* (Belagali *et al.* "A Highly Efficient Method of N-Methylation For The Amino-Acid Derivatives", Indian J. Chem. Sect. B, 1995, 34(1), 45),

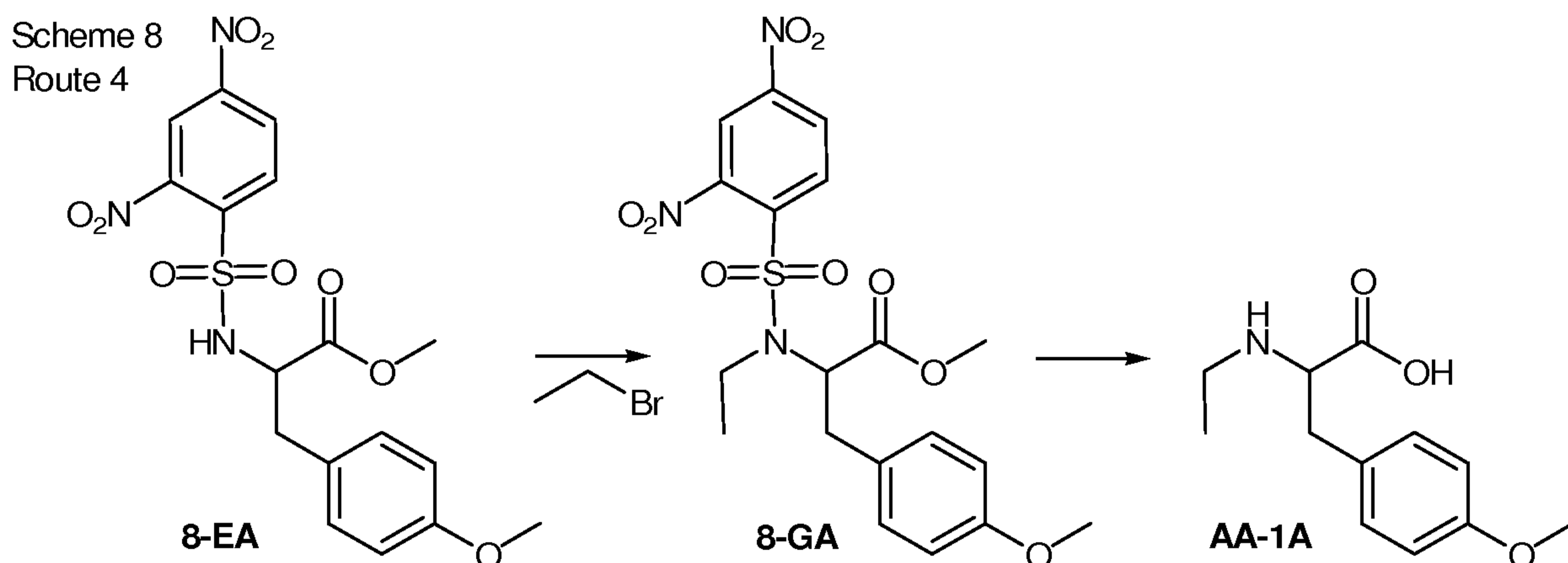
5 treatment of 8-E, wherein R^E is Boc-; R^F is H; and R^A is Me or -CH₂PhenylOH, with sodium hexamethyldisilazane in THF followed by addition of methyl iodide affords 8-E, wherein R^B is methyl and R^F is methyl. Subsequent hydrolysis of the methyl ester and then removal of the carbamate type protecting group affords the N-methyl
10 amino acid AA-1. This method can be modified to use ethyl iodide in place of methyl iodide to afford the N-ethyl amino acids of formula AA-1. In another embodiment this same procedure can be used to alkylate 8-E wherein R^F is methyl.

In an embodiment, following the procedure of Fukuyama *et al.*, treatment of 8-E, wherein R^E is Nosyl; R^F is Methyl; and R^A is -CH₂Phenyl, with K₂CO₃ in DMF followed by
15 addition of R^B-X, wherein R^B-X is propyl iodide, affords 8-E, wherein R^B is propyl and R^F is methyl. Subsequent hydrolysis of the methyl ester and then removal of the carbamate type protecting group can afford the N-propyl amino acid AA-1. This method can be modified to use ethyl iodide in place of propyl iodide to afford the N-ethyl amino acids of formula AA-1.

Scheme 8 route 4

20 In a typical embodiment, following the procedure of Fukuyama *et al.*, a DMF solution of the amino acid ester of the formula (8-EA) can be treated with ethyl bromide in the presence of K₂CO₃ to afford 8-GA. Subsequently, the 2,4-dinitrobenzenesulfonyl group can be removed and the ester group can be hydrolyzed to afford AA-1A. For example, the 2,4-dinitrobenzenesulfonyl group of can be removed by treatment of 8-GA with thiophenol and
25 K₂CO₃ in DMF followed hydrolysis of the methyl ester with NaOH in methanol/THF to afford AA-1A. The N-substituted β-amino acid (AA-1A) can be converted to the N-

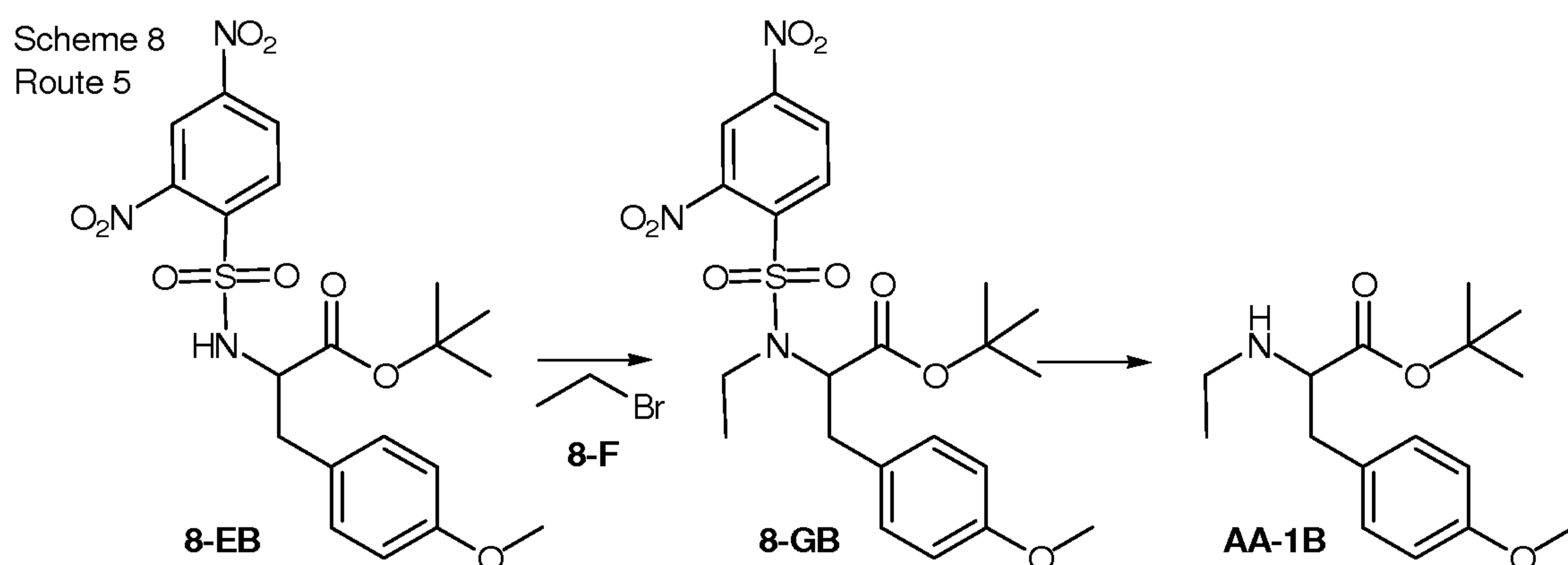
substituted β -amino ester by methods known to one of skill in the art. For example, the N-substituted β -amino acid can be treated with HCl in a solvent such as ethanol or methanol to afford the corresponding ethyl or methyl N-aryl β -amino esters.



5 Scheme 8 route 5

Alternatively, in an exemplary embodiment, a DMF solution of the tert-butyl amino acid ester of the formula (8-EB) can be treated with ethyl bromide in the presence of K_2CO_3 to afford 8-GB. Subsequently, the 2,4-dinitrobenzenesulfonyl group can be removed to afford the tert-butyl ester AA-1B. For example, the 2,4-dinitrobenzenesulfonyl group of can be removed by treatment of 8-GB with thiophenol and K_2CO_3 in DMF to afford AA-1B.

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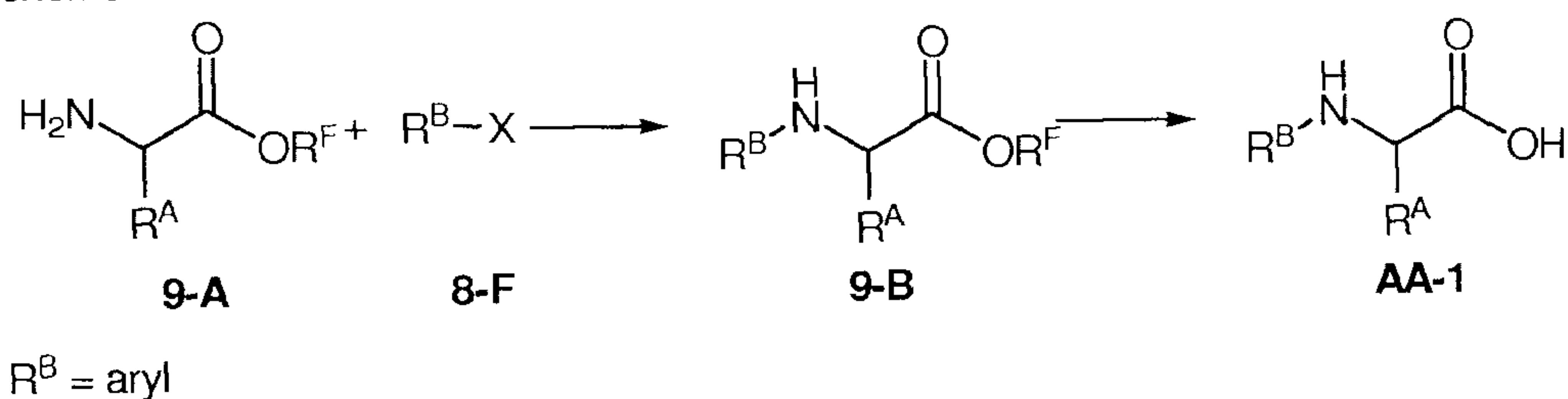


N-aryl monomer precursors

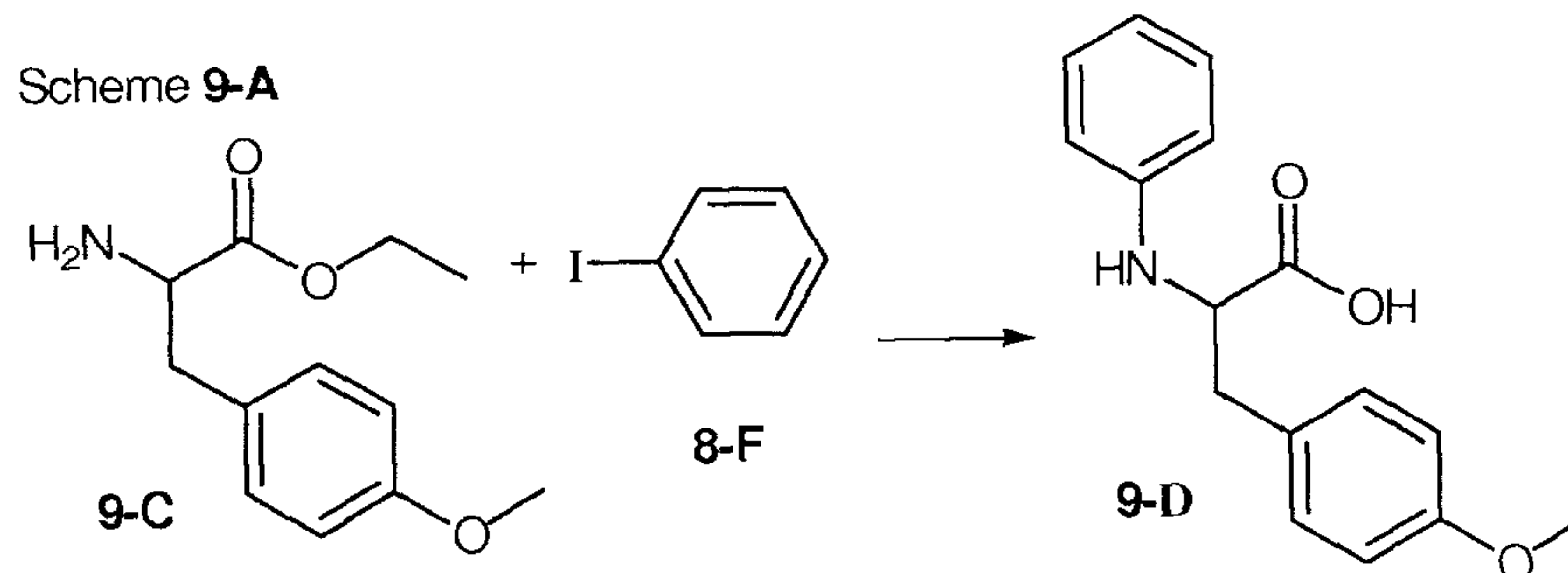
Scheme 9

In one embodiment, monomer precursor AA-1 can be synthesized, wherein R^B is an aryl group, such as and X is chloride, bromide, or iodide as shown in Scheme 9. For example, the monomer precursor of formula AA-1 can be synthesized by an Ullmann reaction, such as the procedure of Ma *et al.*, ("CuI-Catalyzed Coupling Reaction of β-Amino Acids or Esters with Aryl Halides at Temperature Lower Than That Employed in the Normal Ullmann Reaction. Facile Synthesis of SB-214857", *Org. Lett.*, 3 (16), 2001, 2583-2586).

Scheme 9



In an exemplary embodiment, the amino ester 9-A can be converted to 9-B, as shown in Scheme 9. For example in the presence of phenyl iodide, CuI and K₂CO₃ in DMF at 100°C. In one embodiment, the amino ester 9-C can be treated with phenyl iodide (8-F), CuI and K₂CO₃ in DMF at 100°C to afford 9-D, as shown in Scheme 9-A. The N-aryl β-amino acid (9-D) can be converted to the N-aryl β-amino ester by methods known to one of skill in the art. For example, the N-aryl β-amino acid can be treated with HCl in a solvent such as ethanol or methanol to afford the corresponding ethyl or methyl N-aryl β-amino esters.



In these synthetic methods, the starting materials can contain a chiral center (e.g., alanine) and, when a racemic starting material is employed, the resulting product is a mixture of diastereomers or R,S enantiomers. Alternatively, a chiral isomer of the starting material can be employed and, if the reaction protocol employed does not racemize this starting material, a
5 chiral product is obtained. Such reaction protocols can involve inversion of the chiral center during synthesis.

Accordingly, unless otherwise indicated, the products of this invention are a mixture of diastereomers (if two or more chiral centers are present) or R,S enantiomers (if only one chiral center is present). Preferably, however, when a chiral product is desired, the chiral
10 product corresponds to the L-amino acid derivative. Alternatively, chiral products can be obtained via purification techniques which separates diastereomers or enantiomers from a R,S mixture to provide for one or the other stereoisomer. Such techniques are well known in the art.

Polymers according to the present invention contain a plurality of monomeric
15 repeating units containing an amide group, wherein the amide groups are N-substituted, and the N-substituents and degree of N-substitution are effective to render the polymer processable by a desired processing method. Preferably, the minimum amount of N-substituted monomer is used. This can range from one to three mole percent to render a non-soluble polymer soluble in a given solvent to up to about 25 mole percent to make the same
20 polymer injection moldable. This can be readily determined by one of ordinary skill in the art without undue experimentation.

N-alkyl substituents with one to six carbon atoms are preferred, with N-methyl substituents being more preferred.

The monomer compounds are then polymerized to form tissue compatible bioerodable
25 polymers for medical uses. The diphenol monomers can be used in any conventional polymerization process using diphenol monomers, including those processes that synthesize polymers traditionally considered hydrolytically stable and non-biodegradable.

This includes polyesters, polycarbonates, polyiminocarbonates, polyarylates, polyurethanes, polyphosphazine polyphosphonates and polyethers, as well as random block copolymers of these polymers with poly(alkylene oxides) as described in U.S. Pat. No. 5,658,995.

5 It is also understood that the presentation of the various polymer formulae that polymer structures represented may include homopolymers and heteropolymers, which include stereoisomers. Homopolymer is used herein to designate a polymer comprised of all the same type of monomers. Heteropolymer is used herein to designate a polymer comprised of two or more different types of monomer, which is also called a co-polymer. A
10 heteropolymer or co-polymer may be of a kind known as block, random and alternating. Further with respect to the presentation of the various polymer formulae, products according to embodiments of the present invention may be comprised of a homopolymer, heteropolymer and/or a blend of such polymers.

Polyiminocarbonates are synthesized from dihydroxy and diphenol monomers via one
15 of the appropriate methods disclosed by U.S. Pat. No. 4,980,449.

According to one method, part of the dihydroxy or diphenol compound is converted to the appropriate dicyanate, then, equimolar quantities of the dihydroxy or diphenol compound and the dicyanate are polymerized in the presence of a strong base catalyst such as a metal alkoxide or metal hydroxide.

20 The monomers compounds of Formula I may also be reacted with phosgene to form polycarbonates with -O-C(=O)-O- linkages. The method is essentially the conventional method for polymerizing diols into polycarbonates. Suitable processes, associated catalysts and solvents are known in the art and are taught in Schnell, Chemistry and Physics of Polycarbonates, (Interscience, New York 1964).

25

Other methods adaptable for use to prepare polycarbonate polymers of the present invention are disclosed in U.S. Patent Nos. 6,120,491, and 6,475,477.

Polycarbonates may also be prepared by dissolving the Formula I monomer in methylene chloride containing 0.1M pyridine or triethylamine. A solution of phosgene in toluene at a concentration between about 10 and about 25 wt%, and preferably about 20 wt%, is added at a constant rate, typically over about two hours, using a syringe pump or other means. The reaction mixture is quenched by stirring with tetrahydrofuran (THF) and water, after which the polymer is isolated by precipitation with isopropanol (IPA). Residual pyridine (if used) is then removed by agitation of a THF polymer solution with a strongly acidic resin, such as AMBERLYSTTM 15.

The monomer compounds of formula IV may also be directly reacted with aliphatic or aromatic dicarboxylic acids in the carbodiimide mediated process disclosed by U.S. Pat. No. 5,216,115 using 4-(dimethylamino) pyridinium-p-toluene sulfonate (DPTS) as a catalyst to form the aliphatic or aromatic poly(ester amides).

Dicarboxylic acids according to one embodiment of the present invention have the structure of Formula V:



in which, for the aliphatic copolymers, R₅ is selected from saturated and unsaturated, substituted and unsubstituted alkyl groups containing up to 18 carbon atoms, and preferably from 2 to 12 carbon atoms, and optionally may also include up to eight N, O, P or S atoms. For the aromatic copolymers, R₃ is selected from aryl and alkylaryl groups containing up to 24 carbon atoms and preferably from 13 to 20 carbon atoms, and optionally may also include up to eight N, O, P or S atoms. The N-heteroatoms may be N-substituted to reduce polymer T_g and melt viscosity.

The process forms polymers with -O-C(=O)-R₅-C(=O)-O- linkages. R₅ may be selected so that the dicarboxylic acids employed as the starting materials are either important naturally-occurring metabolites or highly biocompatible compounds. Aliphatic dicarboxylic acid starting materials therefore include the intermediate dicarboxylic acids of the cellular

respiration pathway known as the Krebs Cycle. The dicarboxylic acids include α -ketoglutaric acid, succinic acid, fumaric acid and oxaloacetic acid (R_5 of formula III is $-\text{CH}_2\text{-CH}_2\text{-C(=O)-}$, $-\text{CH}_2\text{-CH}_2\text{-}$, $-\text{CH=CH-}$ and $-\text{CH}_2\text{-C(=O)-}$, respectively).

Another naturally-occurring aliphatic dicarboxylic acid is adipic acid (R_5 is $(-\text{CH}_2\text{-})_4$),
 5 found in beet juice. Still yet another biocompatible aliphatic dicarboxylic acid is sebacic acid (R_5 is $(-\text{CH}_2\text{-})_8$), which has been studied extensively and has been found to be nontoxic as part of the clinical evaluation of poly(bis(p-carboxy-phenoxy)propane-co-sebacic acid anhydride) by Laurencin et al., J. Biomed. Mater. Res., 24, 1463-81 (1990).

Other biocompatible aliphatic dicarboxylic acids include oxalic acid (R_5 is a bond),
 10 malonic acid (R_5 is $-\text{CH}_2\text{-}$), glutaric acid (R_5 is $(-\text{CH}_2\text{-})_3$), pimelic acid (R_5 is $(-\text{CH}_2\text{-})_5$), suberic acid (R_5 is $(-\text{CH}_2\text{-})_6$) and azelaic acid (R_5 is $(-\text{CH}_2\text{-})_7$). R_5 can thus represent $(-\text{CH}_2\text{-})_Q$, wherein Q is between 0 and 8, inclusive. Among the suitable aromatic dicarboxylic acids are terephthalic acid, isophthalic acid and bis(p-carboxy-phenoxy) alkanes such as bis(p-carboxy-phenoxy) propane.

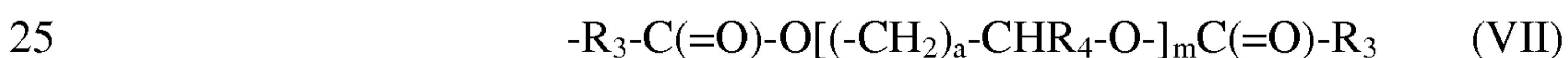
15 R_5 can also have the structure of formula VI:



wherein wherein a is from 1 to 3, inclusive, m is from 1 to 500,000, inclusive, and R_4 is hydrogen or a lower alkyl group containing from one to four carbon atoms. R_4 is preferably hydrogen, a is preferably 1, and m is preferably between about 10 and about 100, and more
 20 preferably between about 10 and about 50.

The diacids of formula VI are formed by the oxidation of poly(alkylene oxides) according to well-known methods. One example of such a compound is bis(carboxymethyl) poly(ethylene glycol), which is commercially available.

R_5 can also have the structure of formula VII:



wherein a, m and R₄ and the preferred species thereof are the same as described above with respect to formula VI. R₃ is selected from a bond or straight and branched alkyl and alkylaryl groups containing up to 18 carbon atoms.

The dicarboxylic acids of formula VII are poly(alkylene oxides) bis-functionalized with dicarboxylic acids having the structure of formula V wherein R₅ is the same as described above for formula V and preferably contains up to 12 carbon atoms.

The poly(alkylene oxides) of formula VII that are bis-functionalized with dicarboxylic acid are prepared by the reaction of a non-functionalized poly(alkylene oxide) with an excess of either the dicarboxylic acid (mediated by a coupling agent such as dicyclohexyl carbodiimide), the anhydride (e.g. succinic anhydride) in the presence of pyridine or triethylamine, or a dicarboxylic acid chloride (e.g. adipoyl chloride) in the presence of an acid acceptor like triethylamine.

Polymers prepared from the formula IV monomeric starting materials of the present invention with at least one bromine- or iodine-substituted aromatic ring are radio-opaque, such as the polymers prepared from radiopaque diphenol compounds prepared according to the disclosure of U.S. Patent No. 6,475,477, as well as the disclosure of co-pending and commonly-owned U.S. Patent Application Serial No. 10/952,202.

The iodinated and brominated diphenol monomers of the present invention can also be employed as radio-opacifying, biocompatible non-toxic additives for other polymeric biomaterials.

Bromine and iodine substituted aromatic monomers of the present invention are prepared by well-known iodination and bromination techniques that can be readily employed by those of ordinary skill in the art guided by the above referenced granted patent and pending application (now published) without undue experimentation. The halogenated aromatic compounds from which the halogenated aromatic monomers of the present invention are prepared undergo ortho-directed halogenation. The term, "ortho-directed", is used herein to designate orientation of the halogen atom(s) relative to the phenoxy alcohol group.

Random or block copolymers of the formula I polymers of the present invention with a poly(alkylene oxide) may be prepared according to the method disclosed in U.S. Patent No. 5,658,995.

The poly(alkylene oxide) is preferably a poly(ethylene glycol) block/unit typically having a molecular weight of less than about 10,000 per unit. More typically, the poly(ethylene glycol) block/unit has a molecular weight less than about 4000 per unit. The molecular weight is preferably between about 1000 and about 2000 per unit.

The molar fraction of poly(ethylene glycol) units in block copolymers may range from greater than zero to less than 1, and is typically greater than zero up to about 0.5, inclusive. More preferably, the molar fraction is less than about 0.25 and yet more preferably, less than about 0.1. In a more preferred variations, the molar fraction may vary from greater than about 0.001 to about 0.08, and most preferably, between about 0.025 and about 0.035.

Unless otherwise indicated, the molar fractions reported herein are based on the total molar amount of poly(alkylene glycol) and non-glycol units in the polymers

Applicants have also recognized that the polymer glass transition temperature increases as the degree of halogenation and the molar fraction of free carboxylic acid units increases. Higher weight percentages of poly(alkylene oxide) are typically used in polymers with higher levels of iodination and/or with higher molar fractions of free carboxylic acid units to maintain the polymer glass transition temperature within a desired range for the end use application. N-alkylation provides an alternative means for lowering the polymer glass transition temperature so that the amount of poly(alkylene oxide) may be lowered or eliminated without adversely affecting the polymer melt properties. The present invention thus places more tools at the disposal of the polymer chemist for fine-tuning the physico-mechanical properties of the inventive polymers.

The formula I polymers having weight-average molecular weights above about 20,000, and preferably above about 80,000, calculated from gel permeation chromatography

(GPC) relative to polystyrene standards using tetrahydrofuran (THF) as the eluent without further correction.

The polymers of the present invention are defined as including polymers polymerized from formula IV monomers having pendent free carboxylic acid groups ($R_8 = OH$). However, it is not possible to polymerize polymers having pendent free carboxylic acid groups from corresponding monomers with pendent free carboxylic acid groups without cross-reaction of the free carboxylic acid group with the co-monomer. Accordingly, polymers in accordance with the present invention having pendent free carboxylic acid groups are prepared from homopolymers and copolymers of benzyl and tert-butyl ester monomers of the present invention having the structure of formula IV in which R_8 is a benzyl or tert-butyl group.

The benzyl ester homopolymers and copolymers may be converted to corresponding free carboxylic acid homopolymers and copolymers through the selective removal of the benzyl groups by the palladium catalyzed hydrogenolysis method disclosed by co-pending and commonly owned U.S. Patent No. 6,120,491.

15

The tert-butyl ester homopolymers and copolymers may be converted to corresponding free carboxylic acid homopolymers and copolymers through the selective removal of the tert-butyl groups by the acidolysis method disclosed by the above-referenced U.S. Patent Application Serial No. 10/952,202.

The catalytic hydrogenolysis or acidolysis is necessary because the lability of the polymer backbone prevents the employment of harsher hydrolysis techniques.

Applicants have recognized that the molar fraction of free carboxylic acid units in the polymers of the present invention can be adjusted according to the present invention to likewise adjust the degradation/resorbability of devices made from such polymers. For example, applicants have recognized that while poly(DTE-co-35mol%DT carbonate), (a tyrosine-derived polycarbonate comprising about 35% free carboxylic acid units) is 90% resorbed in about 15 days, polycarbonates with lower amounts of free carboxylic acid will

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have desirably longer lifetimes in the body. Furthermore, by otherwise adjusting the amount of free carboxylic acid in the polymers across the range of preferred molar fraction, the resulting polymers can be adapted for use in various applications requiring different device lifetimes. In general, the higher the molar fraction of free carboxylic acid units, the shorter
5 the lifetime of the device in the body and more suitable such devices are for applications wherein shorter lifetimes are required. In certain embodiments where lifetimes of 6 months or more are required, polymers of the presently preferred ranges of free carboxylic acid units tend to be desirable.

The present invention also includes N-substituted versions of the monomers and
10 polymers of Pacetti, U.S. Pat. Application Pub. No. 2006-0115449,
prepared according to the N-substitution methods disclosed herein.

After polymerization, appropriate work up of the polymers in accordance with preferred embodiments of the present invention may be achieved by any of a variety of known methods commonly employed in the field of synthetic polymers to produce a variety of useful
15 articles with valuable physical and chemical properties, all derived from tissue compatible monomers. The useful articles can be shaped by conventional polymer-forming techniques such as extrusion, compression molding, injection molding, solvent casting, spin casting, wet spinning, combinations of two or more thereof, and the like. Shaped articles prepared from the polymers are useful, inter alia, as degradable biomaterials for medical implant
20 applications. Such applications include the use of shaped articles as vascular grafts and stents.

Stent fabrication processes may further include two-dimensional methods of fabrication such as cutting extruded sheets of polymer, via laser cutting, etching, mechanical cutting, or other methods, and assembling the resulting cut portions into stents, or similar
25 methods of three-dimensional fabrication of devices from solid forms. In certain other embodiments, the polymers are formed into coatings on the surface of an implantable device, particularly a stent, made either of a polymer of the present invention or another material, such as metal. Such coatings may be formed on stents via techniques such as dipping, spray

coating, combinations thereof, and the like. Further, stents may be comprised of at least one fiber material, curable material, laminated material, and/or woven material. Details of stent products and fabrication in which the polymers of the present invention may be employed are disclosed in co-pending and commonly-owned U.S. Patent Application Serial No. 10/952,202
5 filed September 27, 2004. Stents are preferably fabricated from the radiopaque polymers of the present invention, to permit fluoroscopic positioning of the device.

The highly beneficial combination of properties associated with the preferred polymers in accordance with embodiments of the present invention are well-suited for use in
10 producing a variety of medical devices besides stents, especially implantable medical devices that are preferably radiopaque, biocompatible, and have various times of bioresorption. For example, applicants have recognized that, in certain embodiments, the polymers are suitable for use in producing implantable devices for orthopedics, tissue engineering, dental applications, wound closure, gastric lap bands, drug delivery, cancer treatment, other
15 cardiovascular applications, non-cardiovascular stents such as biliary, esophagus, vaginal, lung-trachea/bronchus, and the like. In addition, the polymers are suitable for use in producing implantable, radiopaque discs, plugs, and other devices used to track regions of tissue removal, for example, in the removal of cancerous tissue and organ removal, as well as, staples and clips suitable for use in wound closure, attaching tissue to bone and/or cartilage,
20 stopping bleeding (homeostasis), tubal ligation, surgical adhesion prevention, and the like. Applicants have also recognized that the polymers of the present invention are well-suited for use in producing a variety of coatings for medical devices, especially implantable medical devices.

Furthermore, in some preferred embodiments, the present polymers may be
25 advantageously used in making various orthopedic devices including, for example, radiopaque biodegradable screws (interference screws), radiopaque biodegradable suture anchors, and the like for use in applications including the correction, prevention,

reconstruction, and repair of the anterior cruciate ligament (ACL), the rotator cuff/rotator cup, and other skeletal deformities.

Other devices, which can be advantageously formed from the polymers of the present invention, include devices for use in tissue engineering. Examples of suitable devices include
5 tissue engineering scaffolds and grafts (such as vascular grafts, grafts or implants used in nerve regeneration). The present polymers may also be used to form a variety of devices effective for use in closing internal wounds. For example, biodegradable sutures, clips, staples, barbed or mesh sutures, implantable organ supports, and the like, for use in various surgery, cosmetic applications, and cardiac wound closures can be formed.

10 Various devices finding use in dental applications may advantageously be formed according to preferred aspects of the present invention. For example, devices for guided tissue regeneration, alveolar ridge replacement for denture wearers, and devices for the regeneration of maxilla-facial bones may benefit from being radiopaque so that the surgeon/dentist can ascertain the placement and continuous function of such implants by
15 simple X-ray imaging.

The present polymers are also useful in the production of gastric lap bands for use in the treatment of obesity. The production of radiopaque lap bands allows for more effective monitoring of the devices in the human body, and more effective treatment of obesity.

In addition to intravascular stents and non-cardiovascular stents, the present polymers
20 are useful in a number of other cardiovascular and vascular devices. For example, valves, chordae tendinea replacements, annuloplasty rings, leaflet repair patches, vascular grafts, vascular tubes, patches for septal defects, arterial and venous access closure devices (plugs), and the like can be formed for use in replacement repair of heart valves, tubes, and the like. In addition, portions of an artificial heart, such as the rough surface/fibroid layer (bellow
25 pumps) may be formed from the polymers of the instant invention.

The polymers of the present invention are also useful in the production of bioresorbable, inherently radiopaque polymeric embolotherapy products for the temporary

and therapeutic restriction or blocking of blood supply to treat tumors and vascular malformations, e.g., uterine fibroids, tumors (i.e., chemoembolization), hemorrhage (e.g., during trauma with bleeding) and arteriovenous malformations, fistulas and aneurysms delivered by means of catheter or syringe. Details of embolotherapy products and methods of fabrication in which the polymers of the present invention may be employed are disclosed in
5 co-pending and commonly-owned U.S. Patent Application Serial No. 10/952,274 filed September 27, 2004. Embolotherapy treatment method are by their very nature local rather than systemic and the products are preferably fabricated from the radiopaque polymers of the present invention, to permit
10 fluoroscopic monitoring of delivery and treatment.

The present polymers are further useful in the production of a wide variety of therapeutic agent delivery devices. Such devices may be adapted for use with a variety of therapeutics including, for example, pharmaceuticals (i.e., drugs) and/or biological agents as previously defined and including biomolecules, genetic material, and processed biologic
15 materials, and the like. Any number of transport systems capable of delivering therapeutics to the body can be made, including devices for therapeutics delivery in the treatment of cancer, intravascular problems, dental problems, obesity, infection, and the like.

In certain embodiments, any of the aforementioned devices described herein can be adapted for use as a therapeutic delivery device (in addition to any other functionality
20 thereof). Controlled therapeutic delivery systems may be prepared, in which a therapeutic agent, such as a biologically or pharmaceutically active and/or passive agent, is physically embedded or dispersed within a polymeric matrix or physically admixed with a polymer of the present invention. Controlled therapeutic agent delivery systems may also be prepared by direct application of the therapeutic agent to the surface of an implantable medical device
25 such as a bioresorbable stent device (comprised of at least one of the present polymers) without the use of these polymers as a coating, or by use of other polymers or substances for the coating.

The Q¹ pendant groups of the polymers of the present invention may also be derivatized by the covalent attachment of a therapeutic agent. Depending upon whether Q¹ defines a free carboxylic acid, a carboxylic acid amide, a hydroxyl group, or the like, and depending upon the moieties present on the underivatized therapeutic agent, the covalent bond may be an amide bond or an ester bond. Typically, the therapeutic agent is derivatized at a primary or secondary amine, hydroxyl, ketone, aldehyde or carboxylic acid group. Chemical attachment procedures are described by U.S. Patent Nos. 5,219,564 and 5,660,822; Nathan et al., *Bio. Cong. Chem.*, 4, 54-62 (1993) and Nathan, *Macromolecules*, 25, 4476 (1992). The therapeutic agent may first be covalently attached to a monomer, which is then polymerized, or the polymerization may be performed first, followed by covalent attachment of the therapeutic agent.

Hydrolytically stable conjugates are utilized when the therapeutic agent is active in conjugated form. Hydrolyzable conjugates are utilized when the therapeutic agent is inactive in conjugated form.

Therapeutic agent delivery compounds may also be formed by physically blending the therapeutic agent to be delivered with the polymers of the present invention using conventional techniques well-known to those of ordinary skill in the art. For this therapeutic agent delivery embodiment, it is not essential that the polymer have pendent groups for covalent attachment of the therapeutic agent.

The polymer compositions of the present invention containing therapeutic agents, regardless of whether they are in the form of polymer conjugates or physical admixtures of polymer and therapeutic agent, are suitable for applications where localized delivery is desired, as well as in situations where a systemic delivery is desired. The polymer conjugates and physical admixtures may be implanted in the body of a patient in need thereof, by procedures that are essentially conventional and well-known to those of ordinary skill in the art.

Implantable medical devices may thus be fabricated that also serve to deliver a therapeutic agent to the site of implantation by being fabricated from or coated with the

therapeutic agent delivery system of the present invention in which a polymer of the present invention has a therapeutic agent physically admixed therein or covalently bonded thereto, such as a drug-eluting stent. Embolotherapeutic particles may also be fabricated for delivery of a therapeutic agent.

5 Examples of biologically or pharmaceutically active therapeutic agents that may be covalently attached to the polymers of the present invention include acyclovir, cephadrine, malphalen, procaine, ephedrine, adriamycin, daunomycin, plumbagin, atropine, quinine, digoxin, quinidine, biologically active peptides, chlorin e.sub.6, cephadrine, cephalothin, proline and proline analogs such as cis-hydroxy-L-proline, malphalen, penicillin V, aspirin
10 and other non-steroidal anti-inflammatories, nicotinic acid, chemodeoxycholic acid, chlorambucil, anti-tumor and anti-proliferative agents, including anti-proliferative agents that prevent restenosis, hormones such as estrogen, and the like. Biologically active compounds, for the purposes of the present invention, are additionally defined as including cell attachment mediators, biologically active ligands, and the like.

15 The invention described herein also includes various pharmaceutical dosage forms containing the polymer-therapeutic agent combinations of the present invention. The combination may be a bulk matrix for implantation or fine particles for administration by traditional means, in which case the dosage forms include those recognized conventionally, e.g. tablets, capsules, oral liquids and solutions, drops, parenteral solutions and suspensions,
20 emulsions, oral powders, inhalable solutions or powders, aerosols, topical solutions, suspensions, emulsions, creams, lotions, ointments, transdermal liquids and the like.

 The dosage forms may include one or more pharmaceutically acceptable carriers. Such materials are non-toxic to the recipients at the dosages and concentrations employed, and include diluents, solubilizers, lubricants, suspending agents, encapsulating materials,
25 penetration enhancers, solvents, emollients, thickeners, dispersants, buffers such as phosphate, citrate, acetate and other organic acid salts, anti-oxidants such as ascorbic acid, preservatives, low molecular weight (less than about 10 residues) peptides such as polyarginine, proteins such as serum albumin, gelatin, or immunoglobulins, other hydrophilic polymers such as

poly(vinylpyrrolidinone), amino acids such as glycine, glutamic acid, aspartic acid, or arginine, monosaccharides, disaccharides, and other carbohydrates, including cellulose or its derivatives, glucose, mannose, or dextrans, chelating agents such as EDTA, sugar alcohols such as mannitol or sorbitol, counterions such as sodium and/or nonionic surfactants such as
5 tween, pluronics or PEG.

The therapeutic agents to be incorporated in the polymer conjugates and physical admixtures of this invention may be provided in a physiologically acceptable carrier, excipient stabilizer, etc., and may be provided in sustained release or timed release formulations supplemental to the polymeric formulation prepared in this invention. Liquid
10 carriers and diluents for aqueous dispersions are also suitable for use with the polymer conjugates and physical admixtures.

Subjects in need of treatment, typically mammalian, using the polymer-therapeutic agent combinations of this invention, can be administered dosages that will provide optimal efficacy. The dose and method of administration will vary from subject to subject and be
15 dependent upon such factors as the type of mammal being treated, its sex, weight, diet, concurrent medication, overall clinical condition, the particular compounds employed, the specific use for which these compounds are employed, and other factors which those skilled in the medical arts will recognize. The polymer-therapeutic agent combinations of this invention may be prepared for storage under conditions suitable for the preservation of
20 therapeutic agent activity as well as maintaining the integrity of the polymers, and are typically suitable for storage at ambient or refrigerated temperatures.

Aerosol preparations are typically suitable for nasal or oral inhalation, and may be in powder or solution form, in combination with a compressed gas, typically compressed air. Additionally, aerosols may be used topically. In general, topical preparations may be
25 formulated to enable one to apply the appropriate dosage to the affected area once daily, and up to three to four times daily, as appropriate.

Depending upon the particular compound selected, transdermal delivery may be an option, providing a relatively steady delivery of the drug, which is preferred in some circumstances. Transdermal delivery typically involves the use of a compound in solution, with an alcoholic vehicle, optionally a penetration enhancer, such as a surfactant, and other optional ingredients. Matrix and reservoir type transdermal delivery systems are examples of suitable transdermal systems. Transdermal delivery differs from conventional topical treatment in that the dosage form delivers a systemic dose of the therapeutic agent to the patient.

The polymer-drug formulations of this invention may also be administered in the form of liposome delivery systems, such as small unilamellar vesicles, large unilamellar vesicles and multilamellar vesicles. Liposomes may be used in any of the appropriate routes of administration described herein. For example, liposomes may be formulated that can be administered orally, parenterally, transdermally, or via inhalation. Therapeutic agent toxicity could thus be reduced by selective delivery to the affected site. For example, if the therapeutic agent is liposome encapsulated, and is injected intravenously, the liposomes used are taken up by vascular cells and locally high concentrations of the therapeutic agent could be released over time within the blood vessel wall, resulting in improved action of the therapeutic agent. The liposome encapsulated therapeutic agents are preferably administered parenterally, and particularly, by intravenous injection.

Liposomes may be targeted to a particular site for release of the therapeutic agent. This would obviate excessive dosages that are often necessary to provide a therapeutically useful dosage of a therapeutic agent at the site of activity, and consequently, the toxicity and side effects associated with higher dosages.

The therapeutic agents incorporated into the polymers of this invention may desirably further incorporate agents to facilitate their delivery systemically to the desired target, as long as the delivery agent meets the same eligibility criteria as the therapeutic agents described above. The active therapeutic agents to be delivered may in this fashion be incorporated with

antibodies, antibody fragments, growth factors, hormones, or other targeting moieties, to which the therapeutic agent molecules are coupled.

The polymer-therapeutic agent combinations of this invention may also be formed into shaped particles, such as valves, stents, tubing, prostheses, and the like.

5 Therapeutically effective dosages may be determined by either in vitro or in vivo methods. For each particular compound of the present invention, individual determinations may be made to determine the optimal dosage required. The range of therapeutically effective dosages will naturally be influenced by the route of administration, the therapeutic objectives, and the condition of the patient. For the various suitable routes of administration, the
10 absorption efficiency must be individually determined for each drug by methods well known in pharmacology. Accordingly, it may be necessary for the therapist to titer the dosage and modify the route of administration as required to obtain the optimal therapeutic effect. The determination of effective dosage levels, that is, the dosage levels necessary to achieve the desired result, will be within the ambit of one skilled in the art. Typically, applications of
15 compound are commenced at lower dosage levels, with dosage levels being increased until the desired effect is achieved. The release rate from the formulations of this invention are also varied within the routine skill in the art to determine an advantageous profile, depending on the therapeutic conditions to be treated.

A typical dosage might range from about 0.001 mg/k/g to about 1,000 mg/k/g,
20 preferably from about 0.01 mg/k/g to about 100 mg/k/g, and more preferably from about 0.10 mg/k/g to about 20 mg/k/g. Advantageously, the compounds of this invention may be administered several times daily, and other dosage regimens may also be useful.

In practicing the methods of this invention, the polymer-therapeutic agent combinations may be used alone or in combination with other therapeutic or diagnostic
25 agents. The compounds of this invention can be utilized in vivo, ordinarily in mammals such as primates such as humans, sheep, horses, cattle, pigs, dogs, cats, rats and mice, or in vitro.

One major advantage of using the radiopaque, bioresorbable polymers of the instant invention in therapeutic agent delivery applications is the ease of monitoring the release of a therapeutic agent and the presence of the implantable therapeutic delivery system. Because the radiopacity of the polymeric matrix is due to covalently attached halogen substituents, the level of radiopacity is directly related to the residual amount of the degrading therapeutic agent delivery matrix still present at the implant site at any given time after implantation. In preferred embodiments, the rate of therapeutic release from the degrading therapeutic delivery system will be correlated with the rate of polymer resorption. In such preferred embodiments, the straightforward, quantitative measurement of the residual degree of radio-opacity will provide the attending physician with a way to monitor the level of therapeutic release from the implanted therapeutic delivery system.

The following non-limiting examples set forth herein below illustrate certain aspects of the invention. All parts and percentages are by mole percent unless otherwise noted and all temperatures are in degrees Celsius unless otherwise indicated. All solvents were HPLC grade and all other reagents were of analytical grade and were used as received, unless otherwise indicated.

EXAMPLES

Example 1 – N-alkyl substitution

In a pressure vessel compound 8-EB is dissolved in DMF with K_2CO_3 (2 equiv) at room temperature and then treated with ethyl bromide (1.1 equiv.) dropwise via syringe. The pressure vessel is then sealed and the reaction is heated to $60^\circ C$, at 30 min intervals the reaction is allowed to cool to room temperature and the progress is checked by TLC (thin layer chromatography) or LC/MS. The reaction is quenched with water and the aqueous layer is extracted. The organic layer is dried over Na_2SO_4 , filtered and the solvent removed under reduced pressure to afford 8-GB. The intermediate 8-GB is dissolved in DMF in the presence

of excess K_2CO_3 , then thiophenol is added and the mixture is stirred at room temperature until the completion of the reaction as indicated by TLC. The solid is removed by filtration and the solvent is removed under reduced pressure. The crude mixture is then dissolved in wet methanol/THF in the presence of catalytic NaOH, upon completion of the hydrolysis of the ester the solvent is removed under reduced pressure. The residue was dissolved in water, acidified to pH 5, and extracted with ethyl acetate to afford AA-1B.

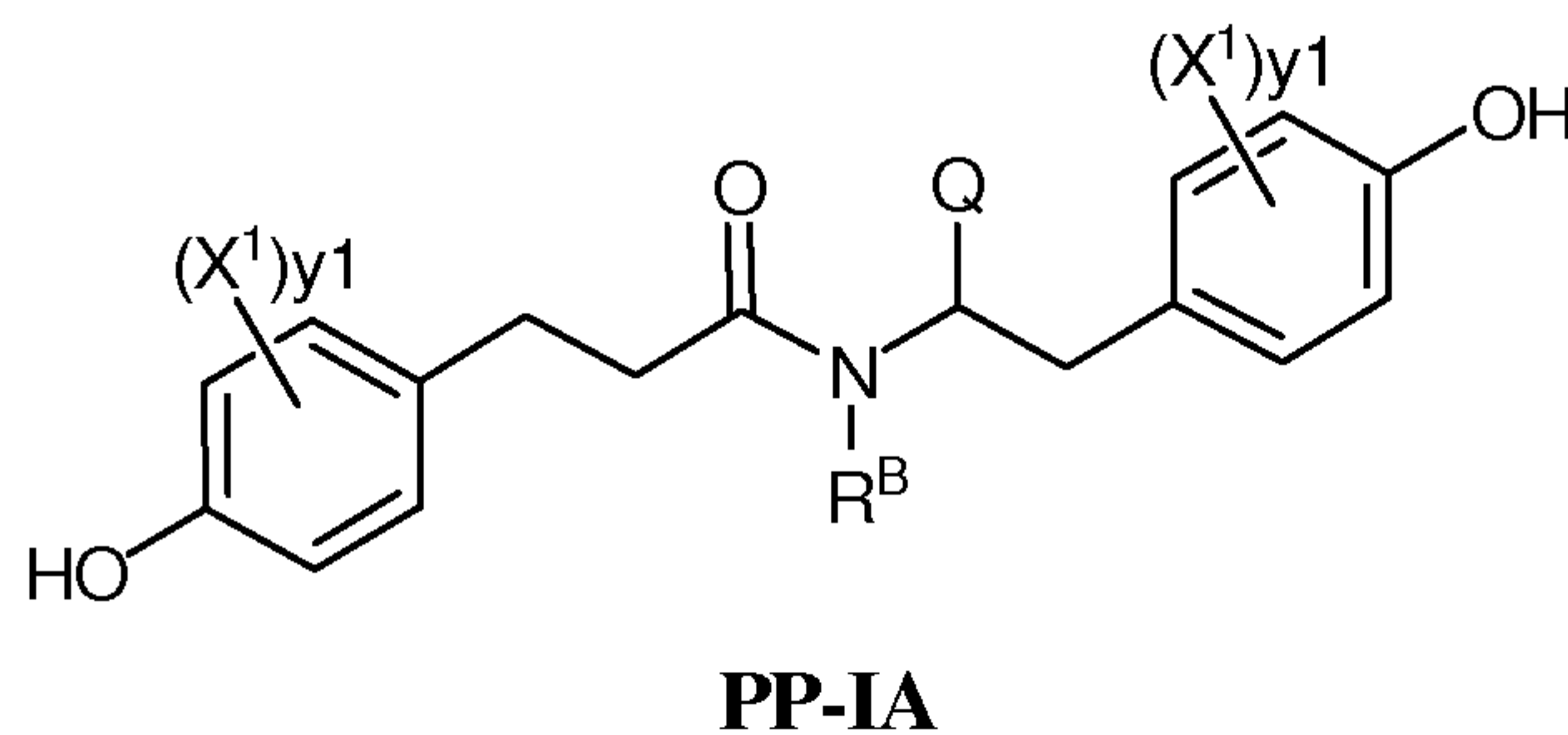
Example 2 – N-aryl substitution

To a solution of phenyl iodide (1 mmol) and β -amino ester (9-C) (1 mmol) in DMF (5 mL) is added potassium carbonate (2.5 mmol), 0.1 mL of water, and CuI (0.1 mmol) under nitrogen. After the mixture is stirred at 100°C for 48 h under nitrogen atmosphere, the cooled solution is concentrated in vacuo. The residue is dissolved in water, acidified to pH 5, and extracted with ethyl acetate. The combined organic layers are concentrated and purified by chromatography to afford the corresponding N-aryl β -amino acid (9-D).

The N-aryl β -amino acid (9-D) can be converted to the N-aryl β -amino acid by methods known to one of skill in the art. For example, the N-aryl β -amino acid can be treated with HCl in a solvent such as ethanol or methanol to afford the corresponding ethyl or methyl N-aryl β -amino esters.

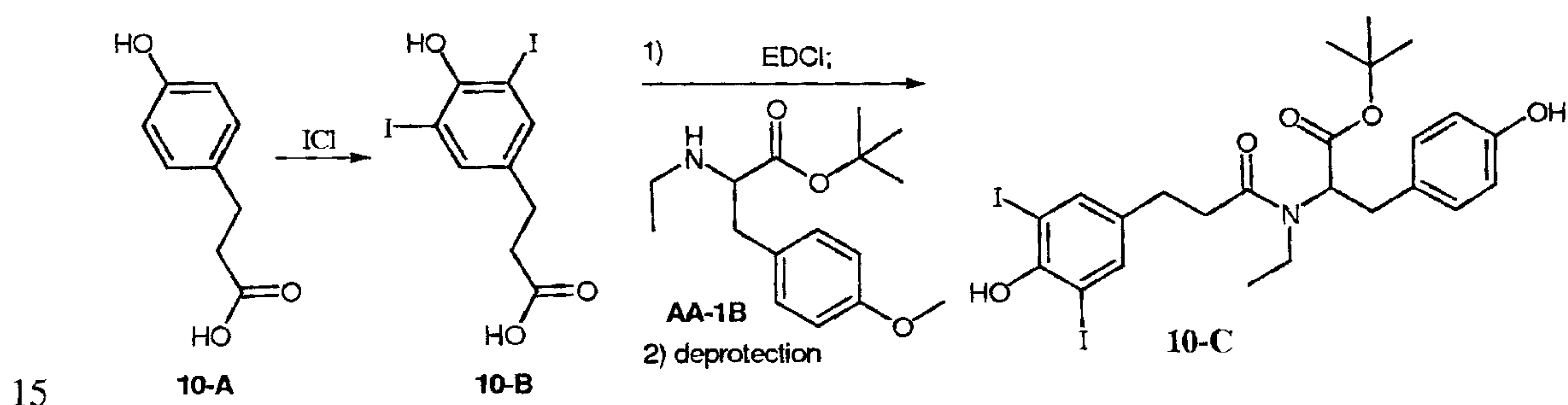
Example 3 - N-substituted monomers

Monomer PP-IA:



can be synthesized from the monomer precursor of formula AA-1. In a typical embodiment, as shown in Scheme 10, the polymerization precursor 10-C can be synthesized from AA-1B. Iodination of 3-(4-hydroxyphenyl) propionic acid (10-A) affords 3-(4-hydroxy-3,5-diodophenyl)propanoic acid. Subsequent coupling of 10-B with AA-1B followed by removal of the phenol protecting group afford the polymerization precursor 10-C. For example, treatment of 3-(4-hydroxyphenyl) propionic acid (10-A) with chloroiodide affords 3-(4-hydroxy-3,5-diodophenyl)propanoic acid (10-B). Coupling of 10-B with AA-1B using N-(3-Dimethylaminopropyl)-N'-ethylcarbodiimide hydrochloride (EDCI) followed by deprotection of the phenol protecting group can afford the polymerization precursor 10-C. The removal of the methyl protecting group can be accomplished using boron tribromide (BBr₃) in methylene chloride (DCM). The polymerization precursor 10-C can be converted into polymeric form following the methods disclosed in synthetic scheme 1-6. Additional monomer subunits can be synthesized from monomer precursors of formula AA-1 following the method of Scheme 10 with appropriate modifications readily apparent to one of skill in the art.

Scheme 10



Example 4 - Preparation of di-iodinated aromatic hydroxy acids.

20 A 2 M solution of KICl₂ was prepared using a literature procedure. In a 2 L beaker were stirred place 166.2 g (1.0 mole) of DAT and 800 mL 2-propanol. To the resulting solution was added 158 g (2.0 mole) of pyridine and 1 L (2.0 moles) of 2 M solution of KICl₂. After 1 h of stirring 3 L of water was added to the reaction mixture, and the product that precipitated was collected by filtration and washed with water. For further purification the

crude product was dissolved in 4 L of water containing 80 g (2.0 mol) of sodium hydroxide and filtered. The filtrate was cooled to room temperature and acidified with acetic acid to a pH of 5.5. The product was isolated by filtration and washed with several portions of water and then dried under vacuum for constant weight which gave 375 g (90% yield) of 3-(3,5-diiodo-4-hydroxyphenyl) propionic acid (I₂DAT). Using similar procedures 4-hydroxyphenyl acetic acid and 4-hydroxy benzoic acid were iodinated to the corresponding di-iodinated compounds.

Example 5 - Synthesis of I₂DAT-NMeTyr-OMe monomer

A diphenolic monomer was prepared by coupling the 3-(3,5-diiodo-4-hydroxyphenyl) propionic acid (I₂DAT) of Example 4 with N-methyl tyrosine methyl ester HCl salt (NMeTM.HCl) (Bache Biosciences, Inc. King of Prussia, PA) using 1-(3-dimethylaminopropyl)-3-ethyl carbodiimide hydrochloride (EDC) as the coupling agent. In particular, 1.6 g (3.8 mmol) of I₂DAT, 0.99 g (4.02 mmol) of NMeTM.HCl 54 mg (0.40 mmol) of hydroxybenzotriazole and 20 mL of tetrahydrofuran was stirred in a 50 mL round-bottomed flask at 0-5 °C. To the flask was then added EDC (0.81 g, 4.2 mmol).

The reaction mixture was stirred at 0 to 5 °C for 1 h and then at room temperature for 3 h. Most of the THF was evaporated off and the reaction mixture was stirred with 50 mL of ethyl acetate and 50 mL 0.2 M HCl. The layers were separated using a separatory funnel. The organic layer was washed with 3 X 25 mL of 0.2 M HCl, 3 X 25 mL of 5% sodium bicarbonate solution and 25 mL of 20% NaCl. The organic layer was then concentrated when an oil was obtained. The product was identified as N-methyl I₂DTE by ¹H NMR and elemental analysis. HPLC gave a peak with expected retention time along with a minor byproduct which is normally present even when simple tyrosine esters are used.

Example 6 - Polymerization of NMe-I₂DTE.

The diphenolic monomer NMe-I₂DTE of Example 5 was polymerized to form a polycarbonate using the standard phosgenation procedure disclose by U.S. Patent No. 5,099,060.

Example 7 - Synthesis of monomers of N-alkyl tyrosine esters

Preparation of diphenolic monomers from N-alkyl tyrosine esters is exemplified by the synthesis of N-ethyl I₂DTE. In particular, 1.6 g (3.8 mmol) of I₂DAT, 1.10 g (4.02 mmol) of N-ethyl tyrosine ethyl ester HCl salt (NEtTE.HCl - prepared by the method disclosed by Aureilo, et al., Chem. Rev., 104, 5823 - 46 (2004),

5 54 mg (0.40 mmol) of hydroxybenzotriazole and 20 mL of tetrahydrofuran is stirred in a 50 mL round-bottomed flask at 0-5 °C. To the flask is then added EDC (0.81 g, 4.2 mmol). The reaction mixture is stirred at 0 to 5 °C for 1 h and then at room temperature for 3 h. Most of the THF is evaporated off and the reaction mixture is
10 stirred with 50 mL of ethyl acetate and 50 mL 0.2 M HCl. The layers are separated using a separatory funnel. The organic layer is washed with 3 X 25 mL of 0.2 M HCl, 3 X 25 mL of 5% sodium bicarbonate solution and 25 mL of 20% NaCl. The organic layer is then concentrated when an oil is obtained. The product is characterized by ¹H NMR, elemental analysis and HPLC.

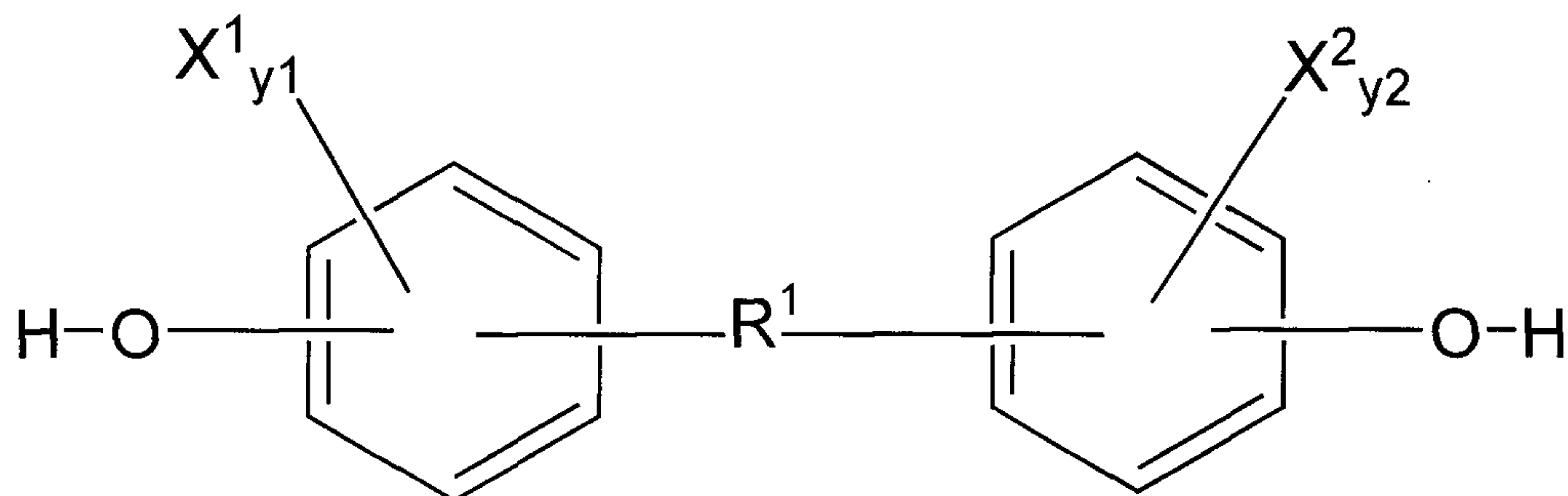
15 Example 8 – Thioamide synthesis and N-alkylation

In a Schlenk tube are placed diacetyl-I₂DTE (693 mg , 1.0 mmol), f₆LR (1.13 g, 1.0 mmol), and 20 mL of THF. The Schlenk tube is heated in an oil bath 55 °C for 4 h. To the reaction mixture is then added 10 g of alumina and the solvent was removed by evaporation. The crude product is purified by short column packed with fluoruous reverse phase silica. The
20 product is then subjected to hydrolysis with dilute sodium hydroxide followed by acidification to give the I₂DTE-thioamide. The compound is then N-methylated according to Aureilo, et al., Chem. Rev., 104, 5823 - 46 (2004).

The scope of the claims should not be limited by the preferred embodiments set forth in the examples, but should be given the broadest interpretation consistent with the
25 description as a whole.

WHAT IS CLAIMED IS:

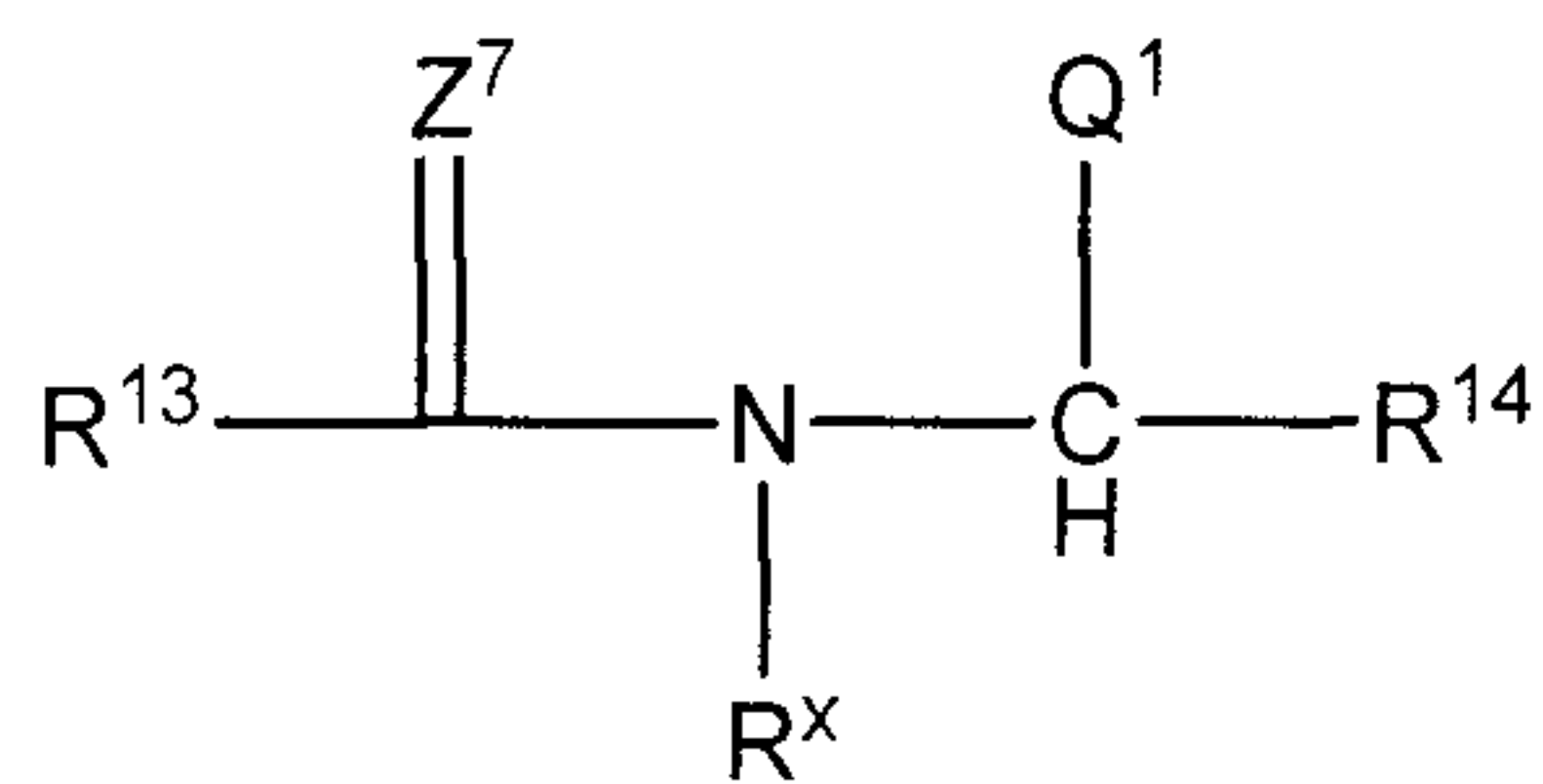
1. An N-substituted diphenol compound having the structure:



wherein X^1 and X^2 are each independently selected from Br and I; y_1 and y_2 are each
 5 independently zero or an integer in the range of 1 to 4, and R^1 is selected from the group
 consisting of substituted or unsubstituted, saturated or unsaturated, straight chain or branched
 aliphatic groups, substituted or unsubstituted aromatic groups, and substituted or
 unsubstituted araliphatic groups in which the aliphatic portions are straight chain or branched
 and saturated or unsaturated, and R^1 contains from 2 to 8 heteroatoms selected from O, S and
 10 N, in which two of the heteroatoms form an amide or thioamide group that is N-substituted
 with a $C_1 - C_6$ alkyl group,

wherein R^1 contains between 18 and 36 carbon atoms.

2. The diphenol compound of claim 1, wherein R^1 is of the formula:

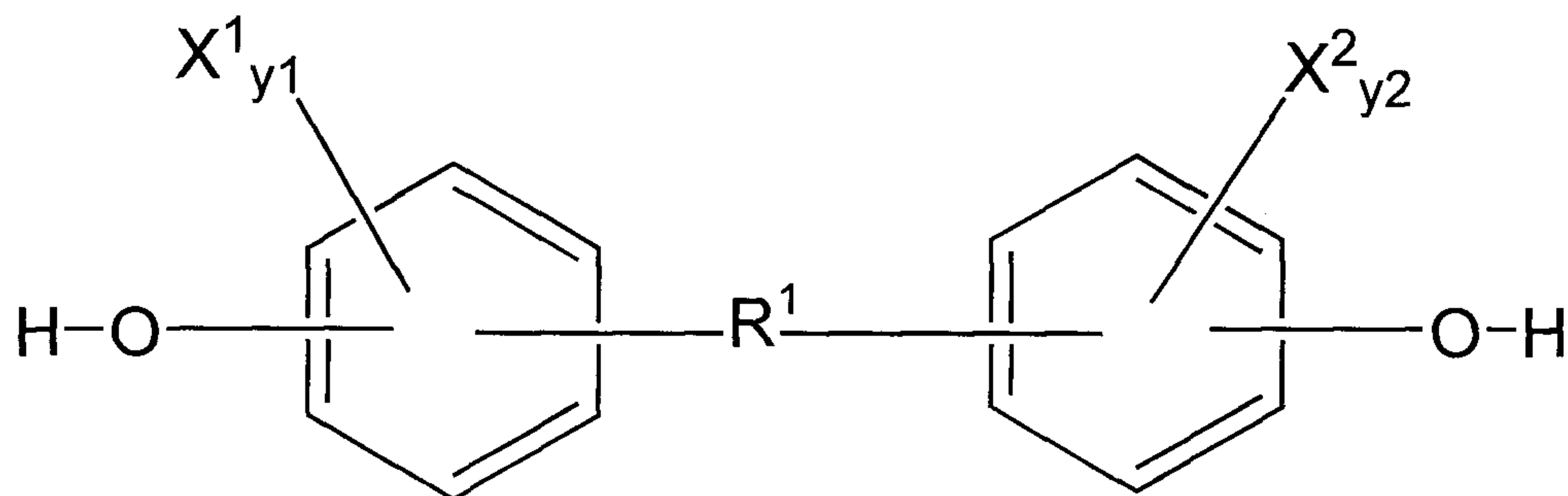


15 in which R^{13} and R^{14} each independently contain between 0 and 8 carbons atoms, inclusive,
 and are independently selected from $(-CHR')_e-CH=CH-(CHR')_e$ and $(-CHR')_f(-CHNQ^2)_g(-$
 $CHR')_f$, wherein R' is H or lower alkyl, each e independently ranges between 0 and 6,
 inclusive, each f independently ranges between 0 and 8, inclusive and g is 0 or 1; R^x is a $C_1 -$
 C_6 alkyl group; Q^1 is $C(=Z^5)-R^8$, wherein Z^5 is O or S; Q^2 is $-N(R^x)_2$ or $-N(R^xQ^1)$ and R^8 is
 20 selected from the group consisting of OH, H, a therapeutically active moiety, $-X_3$ -alkyl, $-X_3$ -
 alkenyl, $-X_3$ -alkynyl, $-X_5$ -cycloalkyl, $-X_5$ -heterocyclyl, $-X_5$ -aryl and $-X_5$ -heteroaryl;

X_3 is selected from a bond, O, S, and N-alkyl; and X_5 is selected from a bond, lower alkyl, O, S and N-alkyl; and

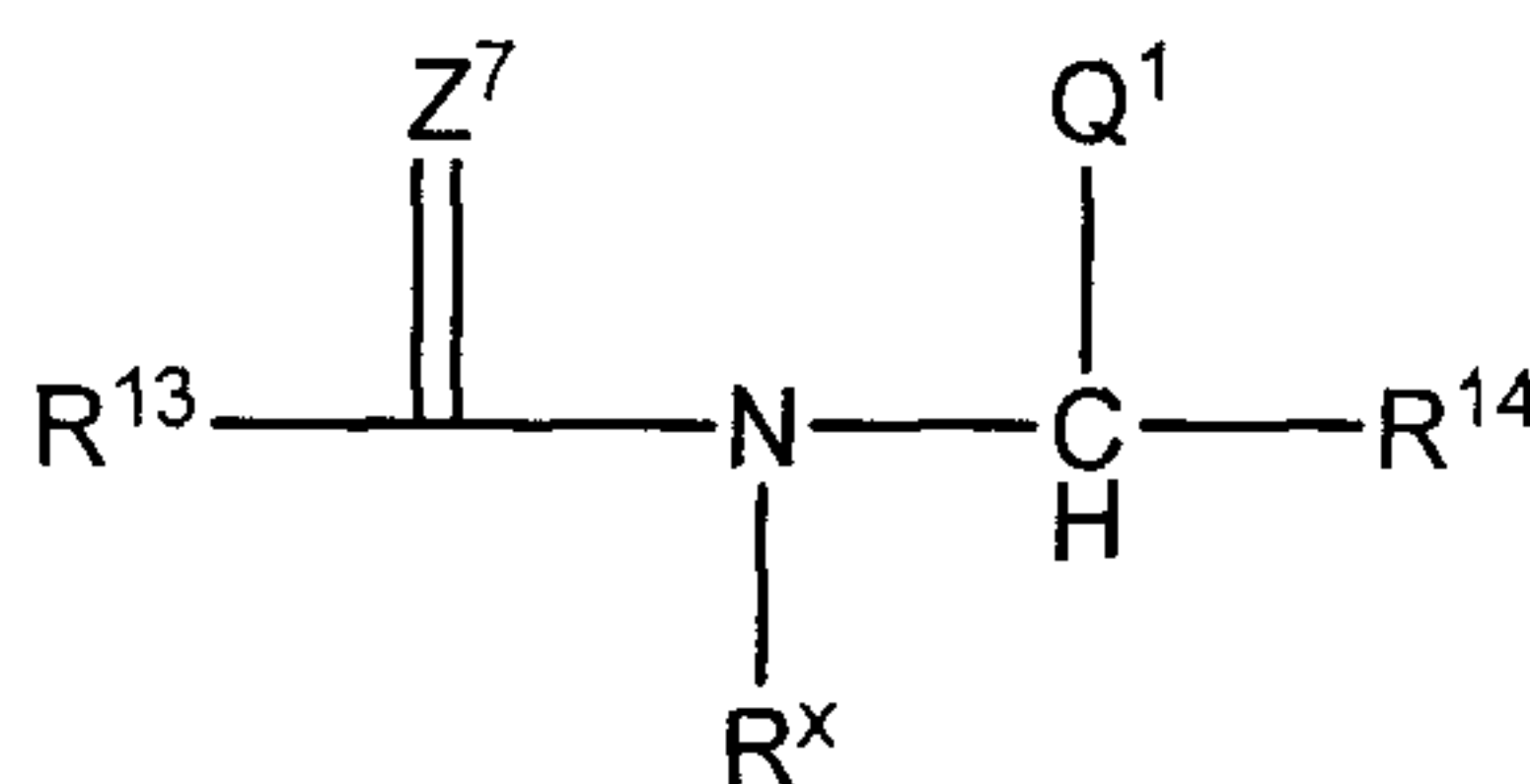
Z^7 is oxygen or sulfur.

3. An N-substituted diphenol compound having the structure:



5

wherein X^1 and X^2 are each independently selected from Br and I; y_1 and y_2 are each independently zero or an integer in the range of 1 to 4, and R^1 is of the formula:



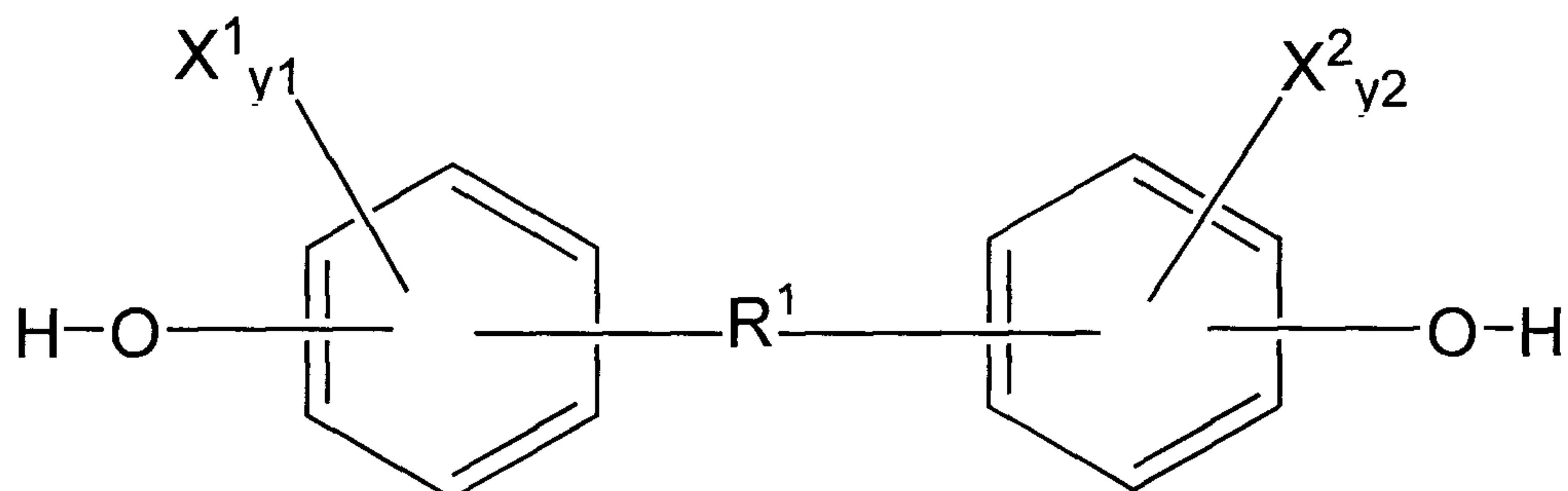
10 in which R^{13} and R^{14} each independently contain between 0 and 8 carbons atoms, inclusive, and are independently selected from $(-CHR')_e-CH=CH-(CHR')_e$ and $(-CHR')_f(-CHNQ^2)_g(-CHR')_f$, wherein R' is H or lower alkyl, each e independently ranges between 0 and 6, inclusive, each f independently ranges between 0 and 8, inclusive and g is 0 or 1; R^x is a $C_1 - C_6$ alkyl group; Q^1 is $C(=Z^5)-R^8$, wherein Z^5 is O or S; Q^2 is $-N(R^x)_2$ or $-N(R^xQ^1)$;

Z^7 is oxygen or sulfur; and

15 R^8 is an alkyl-terminated poly(alkylene oxide) selected from the group consisting of methoxy-terminated poly(ethylene glycols) (PEG) of molecular weight 100 to 10,000, methoxy-terminated poly(propylene glycols) (PPG) of molecular weight 100 to 10,000 and methoxy-terminated block copolymers of PEG and PPG of molecular weight 100 to 10,000.

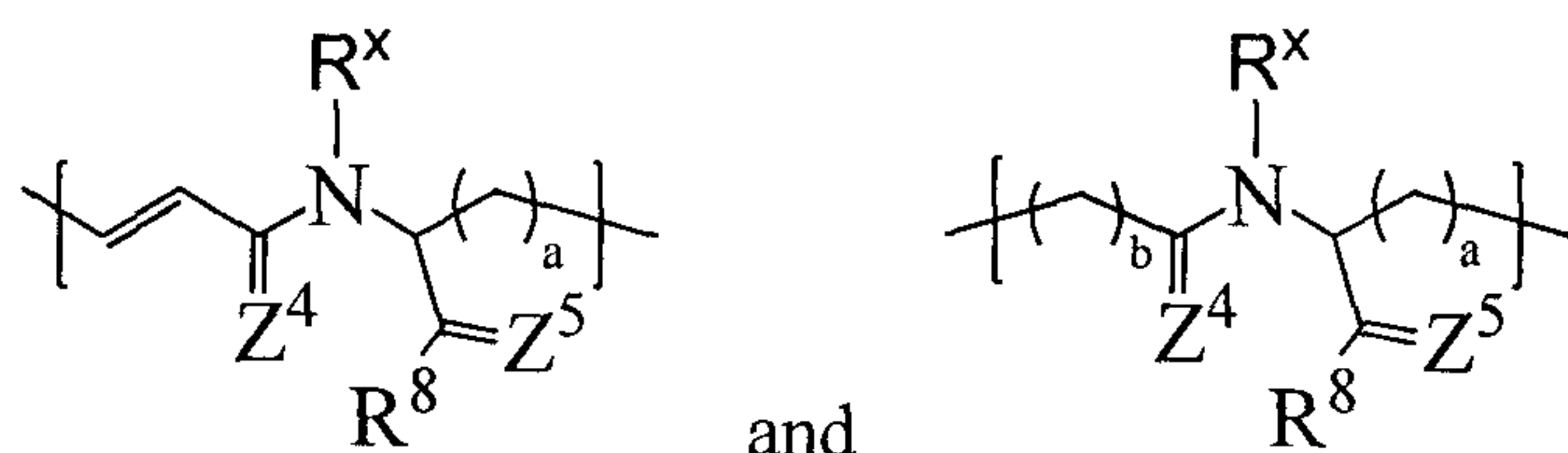
20 4. The diphenol compound of claim 3, wherein R^8 is a poly(ethylene glycol) with molecular weight between about 1000 and about 2000.

5. An N-substituted diphenol compound having the structure:



wherein X^1 and X^2 are each independently selected from Br and I; y_1 and y_2 are each independently zero or an integer in the range of 1 to 4, and

- 5 R^1 is selected from:

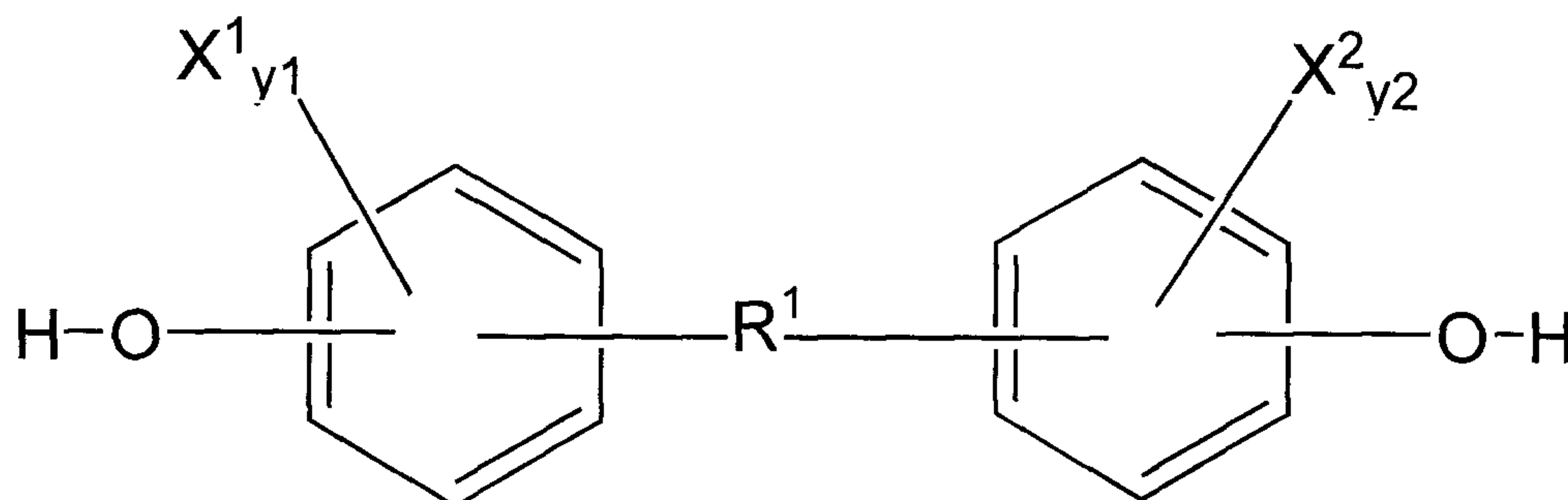


wherein R^x is a $C_1 - C_6$ alkyl group; Z^4 and Z^5 are each independently O or S; a and b independently range between 0 and 8, inclusive; R^8 is selected from the group consisting of OH, H, a therapeutically active moiety, a poly(alkylene oxide), $-X_3-C_1-C_{18}$ alkyl, $-X_3$ -alkenyl, $-X_3$ -alkynyl, $-X_5$ -cycloalkyl, $-X_5$ -heterocyclyl, $-X_5$ -aryl and $-X_5$ -hetero-aryl;

X_3 is selected from a bond, O, S, and N-alkyl; and X_5 is selected from a bond, lower alkyl, O, S and N-alkyl.

6. The diphenol compound of claim 5, wherein $a = 1$ and $b = 2$.

7. An N-substituted diphenol compound having the structure:



wherein X^1 and X^2 are each independently selected from Br and I; y_1 and y_2 are each independently zero or an integer in the range of 1 to 4, and wherein R^1 is selected so that the diphenol compound is an N,N-disubstituted dityrosine.

8. The diphenol compound of any one of claims 1 to 7 wherein the N-substituent
5 is methyl.

