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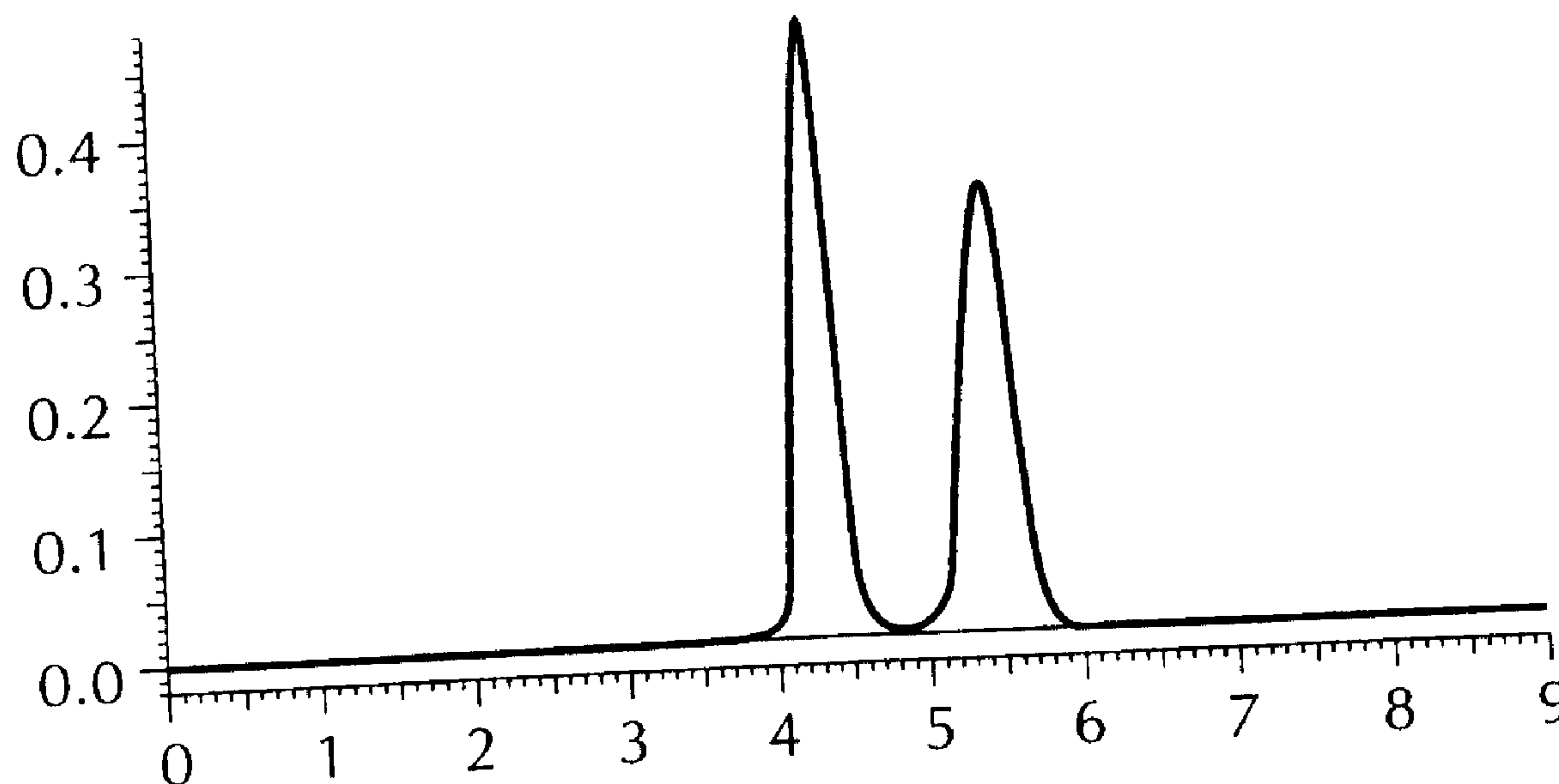
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(54) Titre : PROCEDE RELATIF A LA PRODUCTION DE SERTRALINE-TETRALONE ENANTIOMERIQUEMENT PURE
OU ENRICHEE OPTIQUEMENT, VIA UNE CHROMATOGRAPHIE CONTINUE

(54) Title: PROCESS FOR THE PRODUCTION OF ENANTIOMERICALLY PURE OR OPTICALLY ENRICHED
SERTRALINE-TETRALONE USING CONTINUOUS CHROMATOGRAPHY



(57) Abrégé/Abstract:

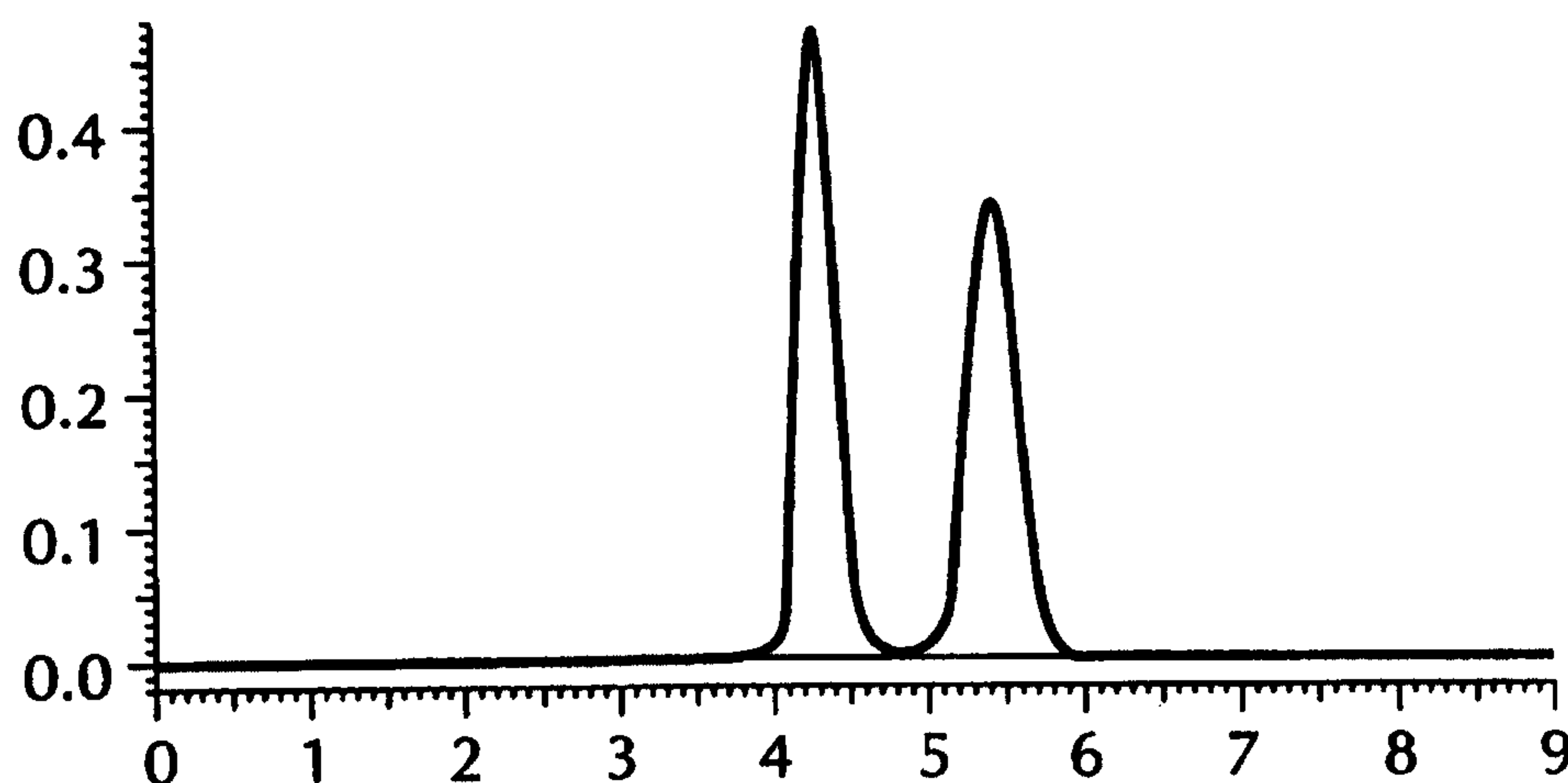
A process for the production of enantiomerically pure or optically enriched sertraline-tetralone from a mixture containing two enantiomers using continuous chromatography. The chromatography comprises a liquid mobile phase comprising at least one polar solvent and a solid chiral stationary phase comprising a derivatized polysaccharide that is selected from the amylosic, cellulosic, chitosan, xylan, curdlan, dextran, and inulan class of polysaccharides.

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(21) International Application Number: PCT/US99/09037 (22) International Filing Date: 27 April 1999 (27.04.99) (30) Priority Data: 60/083,851 1 May 1998 (01.05.98) US (71) Applicant (for all designated States except US): PFIZER PRODUCTS INC. [US/US]; Eastern Point Road, Groton, CT 06340 (US). (72) Inventors; and (75) Inventors/Applicants (for US only): DAPREMONT, Oliver [FR/FR]; 4, rue Murner, F-67210 Obernai (FR). GEISER, Fiona [US/US]; 287 A Wilson Avenue, Glenn Mills, PA 19342 (US). ZHANG, Tong [CN/FR]; 6, rue de Boston, F-67000 Strasbourg (FR). GUHAN, Subramanian, S. [US/US]; 48 Laurel Hill Drive, Niantic, CT 06357 (US). GUINN, Robert, M. [US/US]; 32 Bruggeman Place, Mystic, CT 06355 (US). QUALLICH, George, J. [US/US]; 349 Norwich-Westerly Road, P.O. Box 42, North Stonington, CT 06359 (US). (74) Agents: ABRAMS, Samuel, B. et al.; Pennie & Edmonds LLP, 1155 Avenue of the Americas, New York, NY 10036 (US).		(81) Designated States: BR, CA, JP, US, European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE). Published <i>With international search report.</i>

(54) Title: PROCESS FOR THE PRODUCTION OF ENANTIOMERICALLY PURE OR OPTICALLY ENRICHED SERTRALINE-TETRALONE USING CONTINUOUS CHROMATOGRAPHY

**(57) Abstract**

A process for the production of enantiomerically pure or optically enriched sertraline-tetralone from a mixture containing two enantiomers using continuous chromatography. The chromatography comprises a liquid mobile phase comprising at least one polar solvent and a solid chiral stationary phase comprising a derivatized polysaccharide that is selected from the amylosic, cellulosic, chitosan, xylan, curdlan, dextran, and inulan class of polysaccharides.

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PROCESS FOR THE PRODUCTION OF ENANTIOMERICALLY
PURE OR OPTICALLY ENRICHED SERTRALINE-TETRALONE
USING CONTINUOUS CHROMATOGRAPHY

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Background of the Invention

This invention relates to the process for the production of enantiomerically pure or optically enriched sertraline-tetralone from a mixture containing two enantiomers using continuous chromatography or single column
10 high performance chromatography. Some examples of continuous chromatography are liquid chromatography technologies known by the names cyclojet, and simulated moving bed chromatography (SMB). The concept of SMB was described in the late 1950's (U.S. Patents 2,957,927 and
15 2,985,589) and has long been used in the petrochemical and sugar industries, Nicoud, R. M., LC-GC Intl, 5 (5), 43 (1992). Further reference can be made to U.S. Patents 3,205,166; 3,291,726; and 3,310,486. A high efficiency continuous separation process using SMB is
20 disclosed in U.S. Patent 4,402,832; 5,518,625; 5,434,298; 5,434,299; 5,498,752; and Re 35,919. In addition, "Chiral Discrimination on Polysacchride Derivatives". Yashima and Okamoto, Bull. Chem. Soc. Jpn., 68, 3289-3307 (1995) discusses separation characteristics useful in chiral
25 chromatography phases. Further discussion by Okamoto et al. are included in The Journal of Chromatography, Part A, Volume 694, pp 101-109 (1995).

Sertraline-tetralone is the starting raw material in the synthesis of Zoloft (sertraline hydrochloride), a
30 drug currently marketed for the treatment of depression as disclosed in U.S. Patent Nos. 4,536,518; 5,196,607; 5,442,116; and 4,777,288. Current processes for preparing

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this compound as described in the above patents resolve the racemic mixture at a late stage. This late stage resolution requires the undesired enantiomer to be carried through several steps. A significant benefit is obtained if an
5 enantiomerically pure sertraline-tetralone is used as the starting material.

SMB combines the high resolution power of high performance liquid chromatography (HPLC) with the lower costs of classical separation processes such as
10 crystallization. The costs of the SMB process can be reduced even further, if it is combined with a racemization step converting the inactive enantiomer into the racemic form which could then be recycled back into the process.

Summary of the Invention

15 A process for chromatographically resolving an enantiomerically pure or optically enriched sertraline-tetralone from a mixture containing two enantiomers uses continuous chromatography or single column high performance chromatography. The continuous chromatography comprises a
20 liquid mobile phase comprising at least one polar solvent and a solid chiral stationary phase comprising a derivatized polysaccharide that is selected from the amylosic, cellulosic, chitosan, xylan, curdlan, dextran and inulan class of polysaccharides.

Some examples of the continuous chromatography methods are the cyclojet process or simulated moving bed chromatography process. The simulated moving bed chromatography process is preferred. The process uses a chiral stationary phase which is a member of the amylosic or cellulosic class of polysaccharides selected from cellulose tribenzoate, cellulose tricinamate, amylose tricinamate, amylose tris[(S) α -methyl benzyl carbamate], amylose 3, 4-substituted phenyl carbamate and amylose 4-substituted phenyl-carbamate. Preferably the chiral stationary phase is an analog of amylose (3, 4-substituent phenyl carbamate) wherein the substituent is selected from 3-chloro-4-methyl, 3-methyl-4-chloro or 3-fluoro-4-methyl. The chiral stationary phase can also preferably be a cellulose tricinamate polysaccharide analog. The mobile phase comprises a solvent that is selected from heptane, hexane, isopropyl, ethanol, methanol, methyl acetate, acetonitrile, methylene chloride, ethyl acetate and/or mixtures thereof. Preferably the mobile phase is selected from acetonitrile and/or a mixture of acetonitrile and methanol or ethanol and/or a mixture of ethanol and ethyl acetate. In one embodiment the chiral stationary phase is cellulose tricinamate with a mobile phase of ethanol/ethyl acetate wherein the percentage of ethanol in the mobile phase mixture is greater than 50%. Preferably the chiral stationary phase is amylose (3-chloro-4-methylphenyl carbamate) and the mobile phase is acetonitrile/methanol wherein the percentage of acetonitrile in the mobile phase mixture is greater than 50%. The chromatographic retention times are increased or decreased by varying the mobile phase components. The separation affords at least one of the enantiomers a recovery of greater than or equal to 90 percent. The temperature range is about 5 to 45°C, preferably 20 to 40°C. The separation factor α is about 1.2 to 5.0. Using a temperature of about 40°C takes advantage of an increased solubility of sertraline tetralone in the mobile phase. The chiral stationary phase polysaccharide derivative can also be immobilized on silica gel, zirconium, alumina, ceramics and other silicas.

Brief Description of The Drawings

Figure 1 shows an analytical chromatogram of the sertraline-tetralone enantiomers in which the separation factor α is between 1 and 2.

Figure 2 shows the experimental profiles measured in the SMB at half-time period in the steady state.

Detailed Description of the Invention

The process of the invention can be applied to any continuous chromatographic method capable of separating the chiral tetralone. One example is the cycloject method described in United States Patent No. 5,630,943. Another continuous chromatographic method of separating the chiral tetralone is by Simulated Moving Bed Chromatography as described in United States Patent Nos. 5,470,464; 5,705,061; 5,422,077; 5,456,825 and EPO 586,385.

The Simulated Moving Bed (SMB) Chromatography for the production of enantiomerically pure or optically enriched sertraline-tetralone from a mixture containing two enantiomers is described below. The purification is achieved using SMB comprising a set of columns packed with a chromatographic chiral stationary phase [CSP] capable of chiral recognition; ports for the continuous introduction of solvent desorbent (mobile phase) and feed; ports for the continuous removal of raffinate (solution containing the less strongly retained enantiomer) and extract (solution containing the more strongly retained enantiomer); and a means of recycling fluid through the system, if necessary. The columns are connected such that the outlet of each column is connected to the inlet of the next column also with the outlet of the last column being connected to the inlet of the first column.

Examples of suitable CSP and mobile phases for the setraline tetralone are shown in the Table 1 below.

Table 1

<u>CLASS</u>	<u>SPECIFIC CHIRAL SELECTOR</u>	<u>MOBILE PHASE</u>	<u>TEMP °C</u>	<u>UV wavelength (nm)</u>	<u>α</u>
Cellulose esters	Cellulose tribenzoate	Hexane/ Isopropanol (96/4 v/v)	40	280	1.65
Cellulose esters	Cellulose tricinnamate	Ethanol/Ethyl Acetate (85/15 v/v)	25	280	1.33
Amylose esters	Amylose tricinnamate	Ethanol/Methyl Acetate (80/20 v/v)	20	230	1.5
Amylose aralkylcarbamate	Amylose tris[(S)- α -methylbenzyl carbamate]	Hexane/ Isopropanol (96/4 v/v)	25	254	1.34
Amylose phenylcarbamates	Amylose 3,4-substituted phenylcarbamate derivative	1. Acetonitrile/ Methanol (90/10 v/v) 2. acetonitrile 3. acetonitrile/ alcohol mixtures	25-40	230 at 25°C	2.13 at 25°C
Amylose phenylcarbamates	Amylose 4-substituted phenylcarbamate derivative	Heptane/ Isopropanol 96/4 v/v)	25	280	1.45

The UV Wavelength represents the detector wavelength used to monitor the elution of the two enantiomers. α represents the separation factor for the sertraline tetralone separation single column which is 4.6 mm ID x 250 mm.

General Procedure For Experimental Examples

Separation on a SMB system was examined on a CSP column. In this example, the enantiomer of interest was less retained and would be recovered in the raffinate stream. This separation was used to optimize the SMB parameters and is shown in Figure 1.

- 5 In Figure 1. The X-axis denotes the retention time in minutes and the Y-axis denotes the concentration of the component. The analytical chromatogram shows that the separation is difficult, having a separation factor α [described above] of between $1.2 < \alpha < 5$. The experimental conditions were as follows: chiral stationary phase: CSP 20 μ m. eluent and derivatives thereof: acetonitrile/methanol 90/10 (v/v), column: 25 cm length, 0.46 cm I.D.,
10 temperature: 25°C, feed concentration: 1 g/l - Volume injected: 20 μ l - Flow-rate: 1 ml/min.

The optimization of the operating conditions of a SMB is preferably done using a simulation tool, a methodology based on the modeling/simulation of non-linear chromatography as described in Charton F., and Nicoud, R. M., J. Chrom, 702,97-112 (1995).

- 15 If racemization of the undesired enantiomer is considered, then the undesired isomer is chemically racemized with NaOH in acetonitrile using catalytic amounts of methanol as described herein below in Example 4. The yields after solvent evaporation were above 90%.

There are two options available if racemization is desired:

Option 1: The less retained enantiomer is mostly recovered in the raffinate and the solution to be racemized contains almost exclusively the more retained enantiomer.

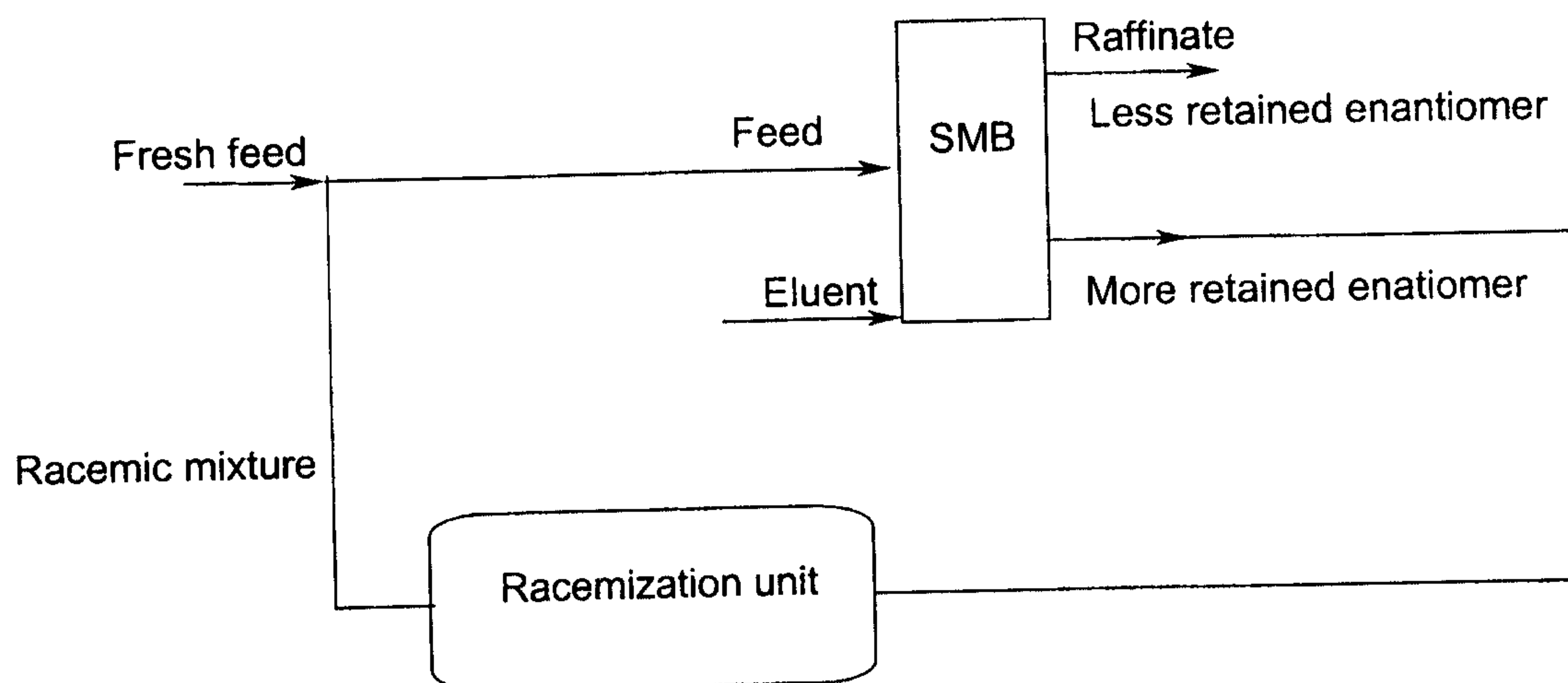
- 20 Option 2: The less retained enantiomer is partly recovered in the raffinate and the solution to be racemized contains a significant amount of both enantiomers.

When option 1 is chosen, the amount of sertraline-tetralone to be racemized is minimized, but when option 2 is chosen it is possible to increase the SMB throughput and consequently, to decrease its size.

- 25 The two options were studied first by numerical simulations which allow one to make a fast parametric study of the process. In the case of option 2, the recovery yield of the less retained enantiomer in the raffinate was an additional parameter that could be varied to achieve optimum performance. It was found that a recovery yield of above 90% leads to a good compromise between the improvement of the SMB performance and the increase of the
30 amount of sertraline-tetralone to be racemized.

- In the case of large scale enantiomeric separations by SMB, the cost of the purification is mainly linked to the productivity, the influence of the eluent consumption being secondary. Consequently, in the present case where racemization is expected to be relatively inexpensive, Option 2 would have a clear advantage in increasing the SMB
35 throughput.

A schematic depicting the SMB purification and racemization step is shown below:



The less retained enantiomer may be recovered at the required optical purity (95-99.9%) in the raffinate stream whereas the more retained enantiomer may be collected in the extract stream. It may be possible to recycle the stream enriched in the undesired enantiomer through a racemization unit which would decrease the necessary amount of new racemic feed required.

The SMB parameters were optimized using Option 2 and the results obtained after the experimental optimization are given in the table below.

Example 1

Table 2:

SMB performances at the pilot scale.

Less retained enantiomer purity (%)	99.2
Less retained enantiomer recovery yield (%)	91.8
Calculated volume of eluent necessary (l/g enantiomer)	0.40
Productivity (kg enantiomer/year/kg Chiral Stationary Phase)	2.88
Amount of feed to be processed (g/g enantiomer recovered)	2.18
Amount of product to be racemized (g/g enantiomer recovered)	1.18

The main operating parameters for the pilot scale tests are given in Table 2a below:

The experimental profiles measured in the SMB at half-time period at steady state are shown in Figure 2. The y-axis denotes the concentration of the material in mg/ml and the x-axis denotes the individual columns in the SMB unit. In this figure, the feed is introduced in Column #4 (designated as #4 in Figure 2), the eluent is introduced at Column #1 and the raffinate and extract are removed at Columns #6 and #2 respectively.

Table 2a:

Operating parameters

Column: (CSP)	amylose (3-chloro-4-methyl phenylcarbamate)
Mobile Phase:	acetonitrile 100%
Column Length:	10.7 cm
Column I.D.:	2.6 cm
Number of Columns:	6 columns
Feed Concentration	30 gms/liter
Eluent Flow-rate	23 ml/min
Feed Flow Rate:	9.3 ml/min
Flow Rate in Zone I:	97.5 ml/min
Extract Flow Rate:	26.1 ml/min.
Raffinate Flow Rate	12.2 ml/min.
Period	0.32 min
Temperature	25°C
Operating pressure	25 bars

Example 2Table 3:

5	<u>SMB performances at the pilot scale.</u>	
	Less retained enantiomer purity (%)	98.2
	Less retained enantiomer recovery yield (%)	82
	Calculated volume of eluent necessary (liter/gm enantiomer)	1.25
	Productivity (kg enantiomer per year per Kg CSP)	56
	Amount of feed to be processed (Kg per Kg enantiomer recovered)	2.44
	Amount of product to be racemized (Kg per Kg enantiomer recovered)	1.44

The main operating parameters for the pilot scale tests are given in Table 3a below:

Table 3a:

10

Operating parameters

Type of Chiral Column:	Cellulose tricinnamate
Mobile Phase:	85/15 v/v ethanol/ethyl acetate

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# Columns	6
Column Length:	10 cm
Column I.D.:	2.6 cm
Feed Concentration (glitter)	20
Feed Flow Rate: (ml/min)	2.85
Eluent Flow-rate (ml/min)	26.3
Flow Rate in Zone I	65 ml/min
Extract Flow Rate: (ml/min)	22.9
Raffinate flow rate (ml/min)	6.3
Period	1.65
Temperature	25
Pressure (bar)	40

Example 3Table 4:SMB performances at the pilot scale.

Less retained enantiomer purity (%)	99.7
Less retained enantiomer recovery yield (%)	98.4
Calculated volume of eluent necessary (liter/gm enantiomer)	0.4
Productivity (kg enantiomer per year per Kg CSP)	371
Amount of feed to be processed (Kg per Kg enantiomer recovered)	2.03
Amount of product to be racemized (Kg per Kg enantiomer recovered)	1.03

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The main operating parameters for the pilot scale tests are given in Table 4a below:

Table 4a: Operating parameters

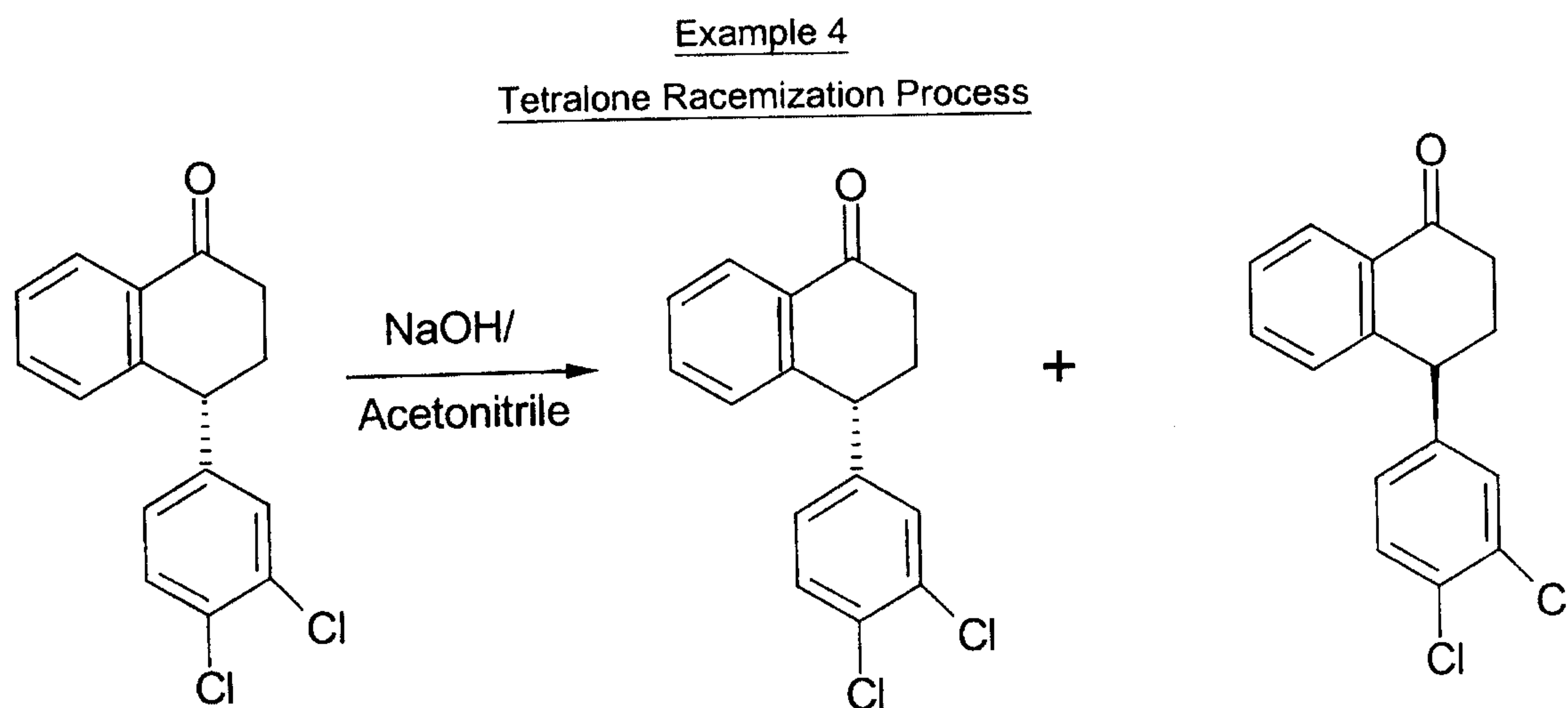
Type of Chiral Column:	Amylose (3-chloro-4-methylphenyl) carbamate
Mobile Phase:	90/10 v/v acetonitrile/MeOH
# Columns	6
Column Length	9.9 cm
Column I.D.:	4.8 cm
Feed Concentration (glitter)	30

Feed Flow Rate: (ml/min)	37
Eluent Flow Rate (ml/min)	186
Flow Rate in Zone 1	388 ml/min
Extract Flow Rate: (ml/min)	147
Raffinate flow rate (ml/min)	76
Temperature	25
Pressure (bar)	25

As seen from Example 2 in Table 3 and Example 3 in Table 4 there is a 7.39 fold increase in productivity by changing the CSP and the mobile phase.

A chemical racemization process for the tetralone is given in Example 4 below.

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- 10 In a nitrogen purged reaction vessel equipped with a mechanical stirrer lubricated with mineral oil with a bubbler nitrogen inlet and a reflux condenser, 100 grams of (-)-tetralone, 1000.00ml of acetonitrile, 0.8 grams sodium hydroxide pellets and 0.5 ml of methanol were combined. The resulting slurry was heated to 50°C and stirred at this temperature for 6 hrs. The reaction was monitored by chiral HPLC until complete racemization was achieved. The
- 15 reaction mixture was diluted with 2000 ml of acetonitrile and the pH was adjusted to 6-8 using methanolic HCl. The methanolic HCl is made by charging 100 grams of methanol in a separate round bottom flask and cooling the methanol to 0°C and then adding 15 grams of HCl. The reaction mixture was agitated for 30 minutes and the resulting NaCl salts were filtered using a filter acid. Using a rotovap the solvent was evaporated to afford 97% of
- 20 racemic tetralone.

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It should be understood that the invention is not limited to the particular embodiments described herein, but that various changes and modification may be made without departing from the spirit and scope of this novel concept as defined by the following claims.

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CLAIMS:

1. A process for chromatographically resolving enantiomerically pure or optically enriched sertraline-tetralone from a mixture containing two enantiomers using
5 continuous chromatography, the continuous chromatography comprising a liquid mobile phase comprising at least one polar solvent and a solid chiral stationary phase comprising a derivatized polysaccharide that is selected from the amylosic, cellulosic, chitosan, xylan, curdlan, dextran, and
10 inulan class of polysaccharides.
2. The process according to claim 1 wherein the chromatographic method employed is a cyclojet process.
3. A process for chromatographically resolving enantiomerically pure or optically enriched
15 sertraline-tetralone from a mixture containing two enantiomers using single column high performance chromatography comprising a liquid mobile phase comprising at least one polar solvent and a solid chiral phase comprising a derivatized polysaccharide that is selected
20 from the amylosic, cellulosic, chitosan, xylan, curdlan, dextran, and inulan class of polysaccharides.
4. A process for the production of enantiomerically pure or optically enriched sertraline-tetralone from a mixture containing two enantiomers using simulated moving
25 bed chromatography, the moving bed chromatography comprising a liquid mobile phase comprising at least one polar solvent and a solid chiral stationary phase comprising a derivatized polysaccharide that is selected from the amylosic, cellulosic, chitosan, xylan, curdlan, dextran, and inulan
30 class of polysaccharides.

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5. The process of claim 4 wherein the chiral stationary phase is a member of the amylosic or cellulosic class of polysaccharides that is selected from cellulose tribenzoate, cellulose tricinamate, amylose tricinamate, amylose tris[(S) α -methyl benzyl carbamate] amylose 3, 4-substituted phenyl carbamate and amylose 4-substituted phenyl-carbamate.

6. The process of claim 5 wherein the chiral stationary phase is an analog of amylose (3, 4 substituted phenyl carbamate) wherein the substituent is selected from 3-chloro-4-methyl, 3-methyl-4 chloro, and 3-fluoro-4 methyl.

7. The process of claim 5 wherein the chiral stationary phase is a cellulose tricinamate polysaccharide analog.

8. The process of any one of claims 4 to 7, wherein the mobile phase comprises a solvent that is selected from heptane, hexane, isopropanol, ethanol, methanol, methyl acetate, acetonitrile, methylene chloride, ethyl acetate and mixtures thereof.

9. The process of claim 8, wherein the mobile phase is acetonitrile and/or a mixture of acetonitrile and methanol or ethanol and/or a mixture of ethylacetate and ethanol.

10. The process of any one of claims 4 to 9, wherein the polysaccharide derivative is immobilized on silica gel, zirconium, alumina, a ceramic or another silica.

11. The process of claim 4, using an amylose 3, 4-substituted phenyl carbamate derivative polysaccharide analog with a mobile phase of acetonitrile and/or a mixture of acetonitrile and methanol.

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12. The process of claim 11, using an amylose (3-chloro-4-methyl-phenyl carbamate) with a mobile phase of acetonitrile/methanol wherein the percentage of acetonitrile in the mobile phase mixture is greater than 50 percent (v/v).

13. The process of claim 4, using cellulose tricinamate with a mobile phase of ethanol/ethyl acetate wherein the percentage of ethanol in the mobile phase mixture, is greater than 50% (v/v).

14. The process of any one of claims 4 to 10, wherein retention times are increased or decreased by varying the mobile phase components.

15. The process of any one of claims 4 to 14, wherein the separation affords at least one of the enantiomers a recovery of greater than or equal to 90%.

16. The process of any one of claims 4 to 15, using a temperature range of about 5 to 45°C.

17. The process of claim 16, using a temperature range of about 20 to 40°C.

18. The process of any one of claims 4 to 17, wherein the separation factor α is about 1.2 to 5.0.

19. The process of claim 17, wherein using a temperature of about 40°C takes advantage of increased solubility of sertraline-tetralone in the mobile phase.

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FIG. 1

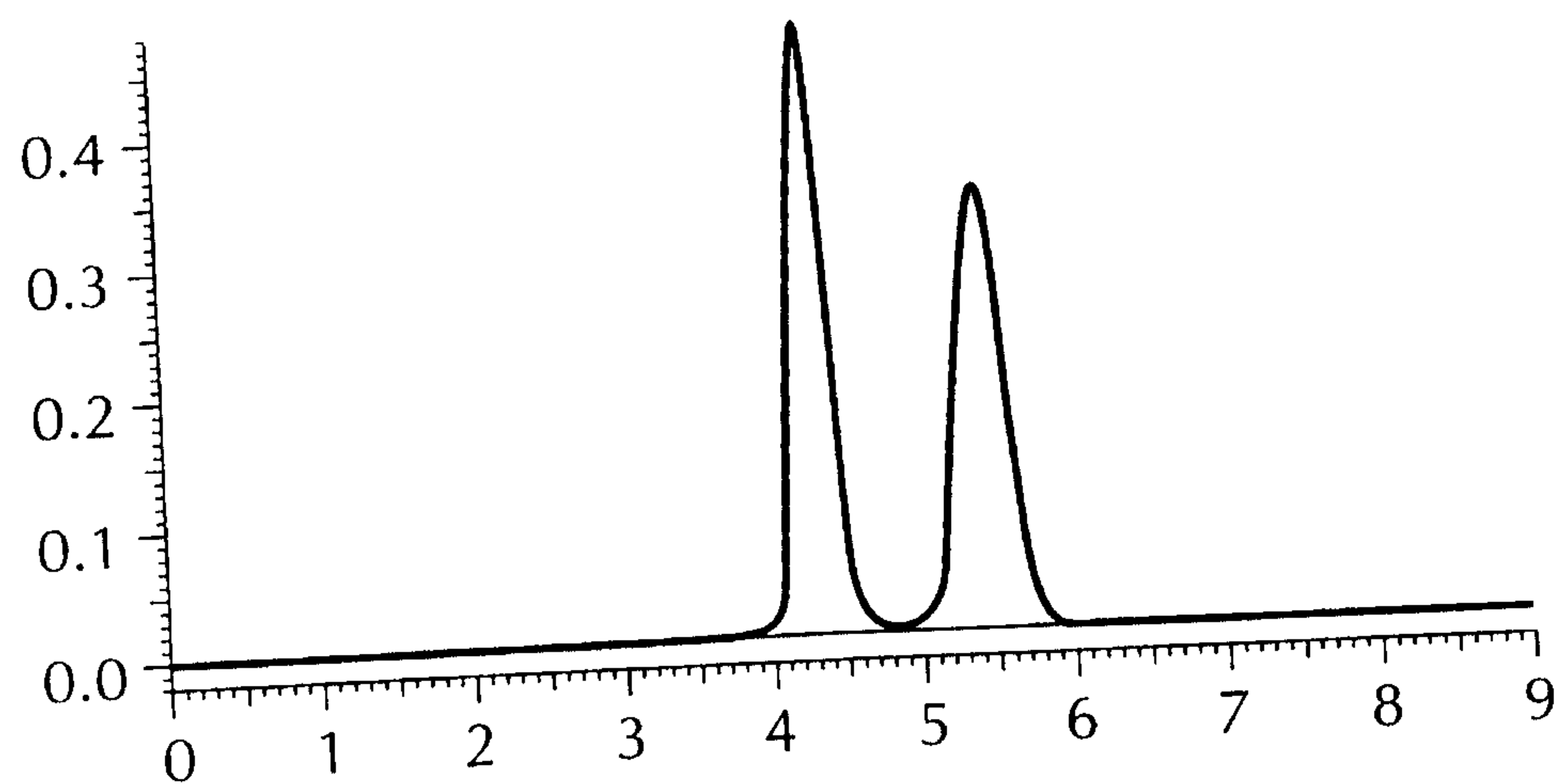


FIG. 2

