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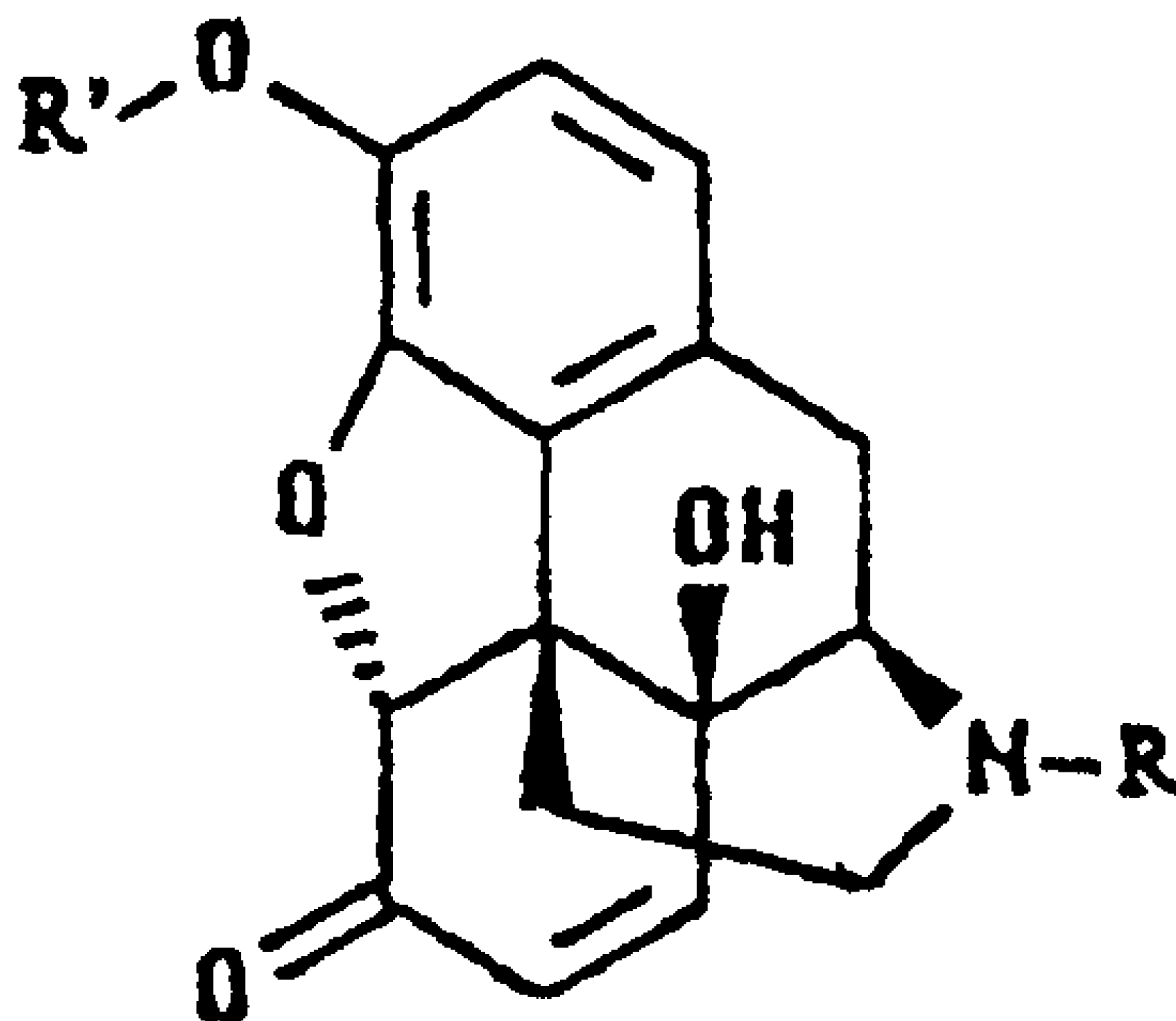
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(54) Titre : PREPARATION D'OXYMORPHONE, D'OXYCODONE ET DE DERIVES ASSOCIES

(54) Title: PREPARATION OF OXYMORPHONE, OXYCODONE AND DERIVATIVES



(57) Abrégé/Abstract:

The invention provides processes for the conversion of normorphinone and its derivatives, which can be synthesized from morphine, to the corresponding 14-hydroxynormorphinone and its derivatives including oxycodone, oxymorphone, noroxymorphone and naltrexone. Noroxymorphone is a key intermediate for the production of important narcotic analgesics and antagonists. The invention also provides certain novel intermediates.

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(21) International Application Number: PCT/US98/13592 (22) International Filing Date: 10 July 1998 (10.07.98) (30) Priority Data: 08/893,464 11 July 1997 (11.07.97) US (71) Applicant (for all designated States except US): PENICK CORPORATION [US/US]; c/o Dr. Bao-Shan Huang, 158 Mt. Olivet Avenue, Newark, NJ 07114-2114 (US). (72) Inventors; and (75) Inventors/Applicants (for US only): HUANG, Bao-Shan [US/US]; 158 Mt. Olivet Avenue, Newark, NJ 07114-2114 (US). CHRISTODOULOU, Aris [US/US]; 137 East 66th Street, New York, NY 10021 (US). LU, Yansong [CN/US]; 11 Skytop Road, Edison, NJ 08820 (US). JI, Ben-Yi [CN/US]; 108 East Calvert Avenue, Edison, NJ 08820 (US). (74) Agent: WAYNE, Milton, J.; Burgess, Ryan & Wayne, Suite 2105, 370 Lexington Avenue, New York, NY 10017 (US).		(81) Designated States: AL, AM, AT, AU, AZ, BB, BG, BR, BY, CA, CH, CN, CZ, DE, DK, EE, ES, FI, GB, GE, HU, IL, IS, JP, KE, KG, KP, KR, KZ, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, TJ, TM, TR, TT, UA, UG, US, UZ, VN, ARIPO patent (GH, GM, KE, LS, MW, SD, SZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG). Published <i>With international search report.</i>
(54) Title: PREPARATION OF OXYMORPHONE, OXYCODONE AND DERIVATIVES (57) Abstract The invention provides processes for the conversion of normorphinone and its derivatives, which can be synthesized from morphine, to the corresponding 14-hydroxynormorphinone and its derivatives including oxycodone, oxymorphone, noroxymorphone and naltrexone. Noroxymorphone is a key intermediate for the production of important narcotic analgesics and antagonists. The invention also provides certain novel intermediates.		

PREPARATION OF OXYMORPHONE, OXYCODONE AND DERIVATIVES

BACKGROUND OF THE INVENTION**1) Field of the Invention**

This invention relates in general to process for the conversion of normorphinone and its derivatives, which can be synthesized from morphine, to the corresponding 14-hydroxynormorphinone and its derivatives including oxycodone, oxymorphone, noroxymorphone, and naltrexone. Noroxymorphone is a key intermediate for the production of important narcotic analgesics and antagonists. In another aspect, the invention is directed to certain novel intermediates.

2) Background Art

14-Hydroxy-substituted morphine derivatives are important narcotic analgesics and/or antagonists. These drugs include oxycodone, oxymorphone, nalbuphine, naloxone, naltrexone, and nalmefene. They are readily synthesized from thebaine, which is a minor component of gum opium. As the supply of thebaine is limited and the demand is increasing, therefore, the price of thebaine is high. As a result, many alternative approaches have been made for the preparation of 14-hydroxymorphine derivatives.

The reported efforts for preparing these narcotics bearing a 14-hydroxy group from readily abundant starting materials morphine or codeine (a minor component of gum opium, which may also be synthesized by methylation of morphine) are summarized as the following: (1) the conversion of codeine to thebaine through

dihydrocodeinone (5.4% yield, H. Rapoport, et al., J. Am. Chem. Soc., vol. 89, 1967, p. 1942 and H. Rapoport, et al., J. Org. Chem., vol. 15, 1950, p. 1103), codeinone (20% yield, I. Seki, Chem. Pharm. Bull., vol. 18, 1970, p. 671 and H. Rapoport, et al., J. Am. Chem. Soc., vol. 77, 1955, p. 490) or 6-methyl ether of codeine (using manganese dioxide, 67% yield, R.B. Barber, et al., J. Med. Chem., vol. 18, 1975, p. 1074); (2) the oxidation of codeinone pyrrolidiny di-enamine to 14-hydroxycodeinone (30 - 40% yield, I. Seki, Chem. Pharm. Bull., vol. 18, 1970, p. 671); (3) the direct allylic oxidation of codeine to the corresponding 14-hydroxy derivatives with chromic acid (H.L. Hulmes, et al., J. Am. Chem. Soc., vol. 69, 1947, p. 1966), manganese dioxide (I. Brown, et al., J. Chem. Soc., 1960, p. 4139), and selenium dioxide plus t-butyl hydrogen peroxide (M.A. Schwartz, et al., J. Med. Chem., vol. 24, 1981, p. 1525); and (4) the six-step transformation of codeine to noroxycodone (52% yield) and noroxymorphone (43% yield) using photochemically generated singlet oxygen (M.A. Schwartz, et al., J. Med. Chem. vol. 24, 1981, p. 1525); and (5) the preparation of noroxymorphone from morphine through an intermediate with carbamate protection on the nitrogen atom (17-position) or a carbonate protection at the 3 position and the carbamate protection at the 17 position of normorphinone dienol acetate with MCPBA in the substantial absence of water (37% yield, Wallace, U.S. Patent 5,112,975). These processes suffer from either low yields, long steps, not amenable to scale-up, or involve the use of environmentally unfriendly heavy metals.

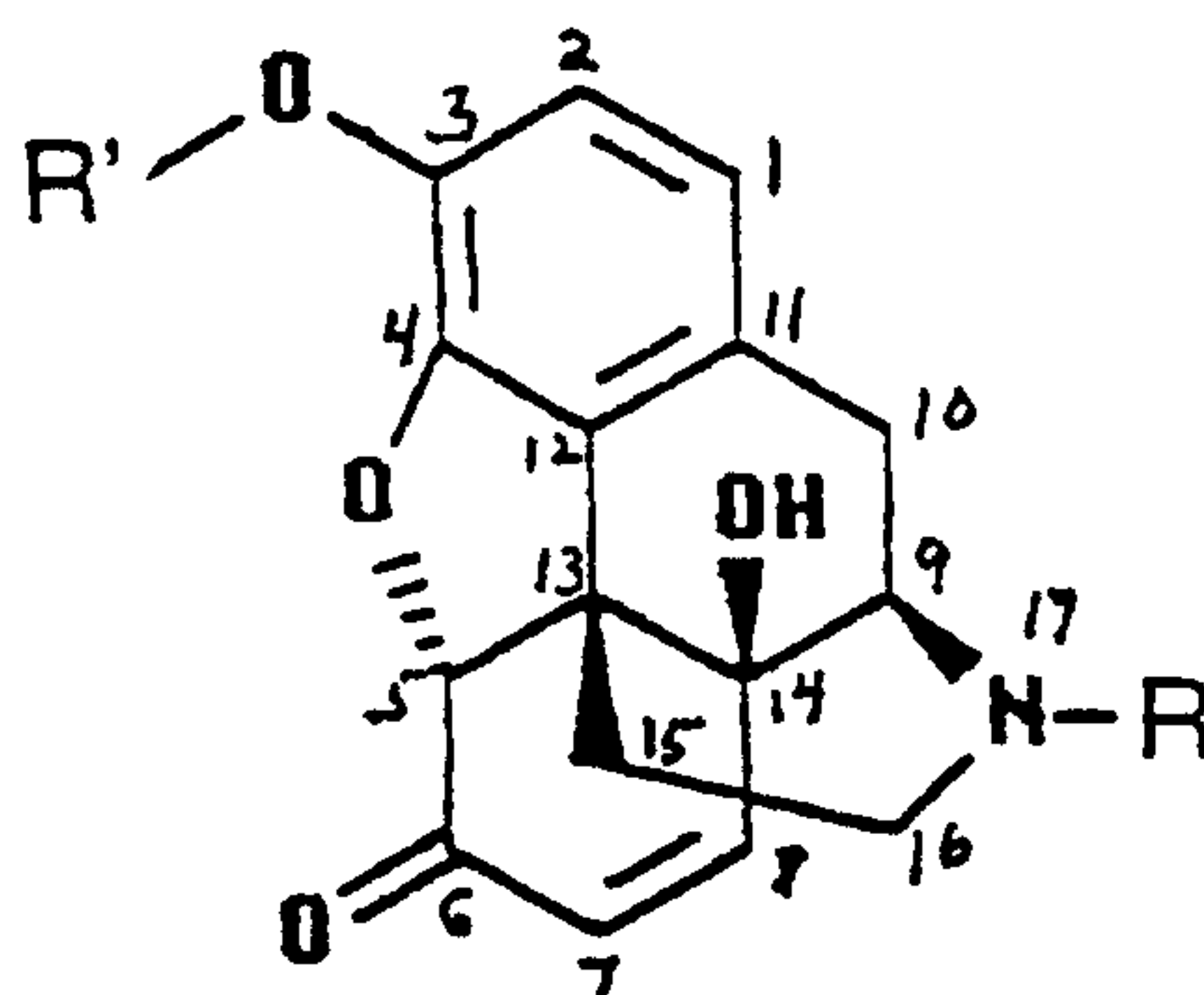
It is therefore an object of the present invention to provide methods for the conversion of normorphinone and its derivatives to the corresponding 14-hydroxy-normorphinone and its derivatives. A further object of the invention is to provide processes which provide relatively high yields of the desired products. Another object is to provide methods which are environmentally safe and avoid the use of heavy metals.

Another object of the present invention is to provide processes which can use morphine or codeine as starting material instead of the scarce thebaine. Codeine is a component of gum opium and can also be produced by methylation of morphine using known prior art techniques. A still further object of the present invention is to provide the use of an aqueous system in the oxidation step to form 14-hydroxynormorphinone

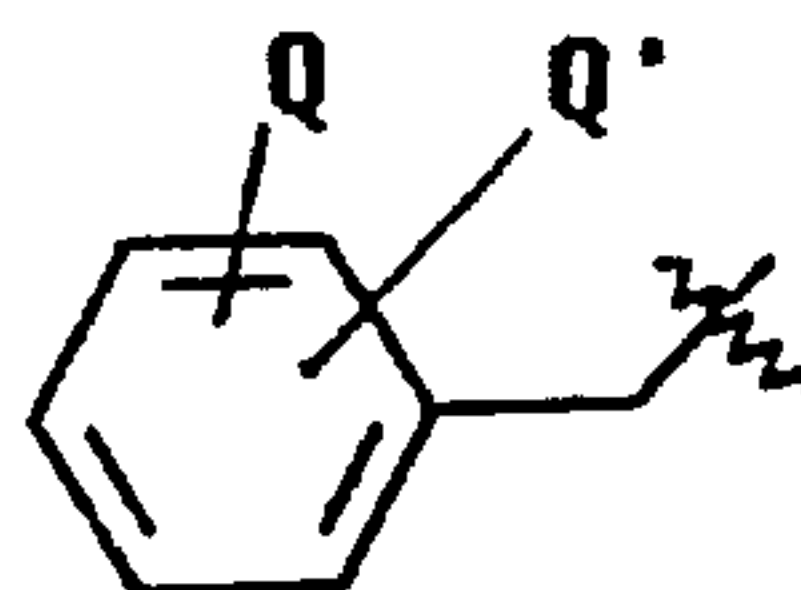
which is not only environmentally friendly, but also desirable in which to conduct the subsequent hydrogenation reaction without the need for isolating the 14-hydroxynormorphinone intermediate. A still further object is to provide certain intermediates which are novel compositions. It is a further object of this invention to provide intermediates for specific products, such as oxycodone, oxymorphone, naltrexone and noroxymorphone. These and other objects will readily become apparent to those skilled in the art in light of the teachings herein disclosed.

SUMMARY OF THE INVENTION

In its broad aspect, the present invention pertains to processes for the preparation of 14-hydroxy-normorphinones of the formula:



and certain derivatives thereof as hereinafter indicated. In the formula above R is selected from the group consisting of lower alkyl of 1-7 carbon atoms, cycloalkyl-alkyl with 3-6 ring carbon-atoms benzyl and substituted-benzyl having the formula:



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wherein Q and Q' are individually selected from hydrogen, lower alkyl, trifluoromethyl, nitro, dialkylamino, cyano;

preferably, R is methyl (when the desired products are oxycodone and oxymorphone), cyclopropylmethyl (when the desired products are naltrexone and nalmeferone), cyclobutylmethyl (when the desired product is nalbuphine), and benzyl (when the desired products are naloxone, naltrexone, nalbuphine, or nalmeferone);

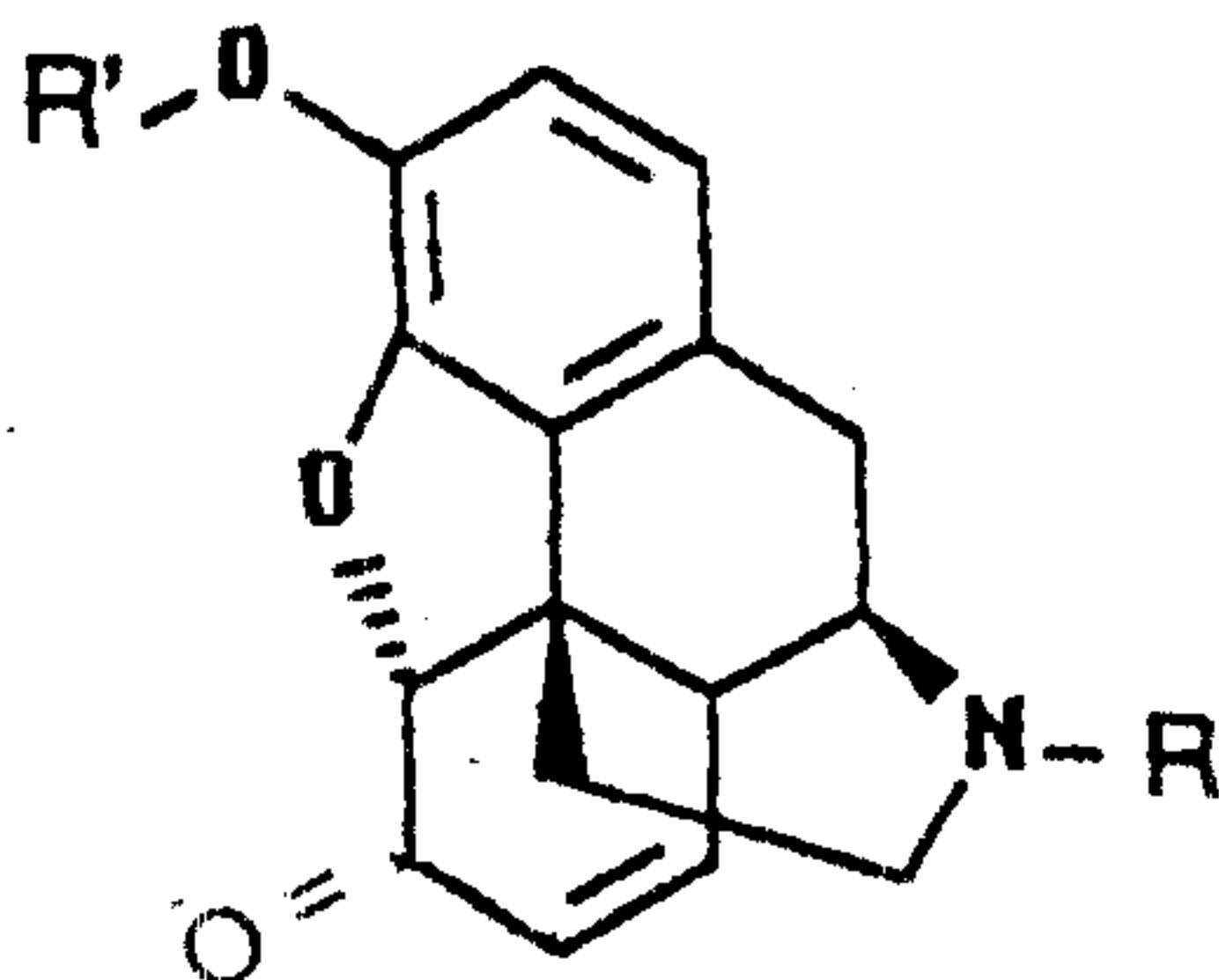
R' is methyl, ethyl, 2-(4-morpholinyl)ethyl, benzyl, substituted-benzyl (as defined above), benzyloxycarbonyl or the group having the formula :



wherein: R'' is lower alkyl of 1-4 carbon atoms;

preferably, R' is methyl (when the desired product is oxycodone), benzyl (when the desired products are oxymorphone and 14-hydroxyl-normorphinones), or acyl (when the desired product is oxymorphone) and R'' is methyl;

from the corresponding normorphinones having the formula:



wherein R and R' are as defined above;

by reacting the normorphinones (as defined above) either (1) or (2) of the following processes:

(1) directly with an oxidizing agent, hydrogen peroxide, at a temperature of about 15°C to about 70°, preferably 40°C to 50°C, in the presence of an acid such as formic

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acid, tartaric acid, acetic acid, or other mineral acids, preferably formic acid; in a suitable non-reactive solvent such as water, acetic acid, THF, DMSO or a mixture of solvents such as ETOAc/H₂O suitable for solubilizing or suspending the reactants, preferably water, for a period of 1 to 24 hours, which depends on the scale of the reaction; or

(2) in a two-step manner by first with an acyl halide having the formula:



wherein: R'' is defined above, preferably methyl;

X is Cl or Br, preferably Cl;

or an acid anhydride having the formula:



wherein R'' is as defined above;

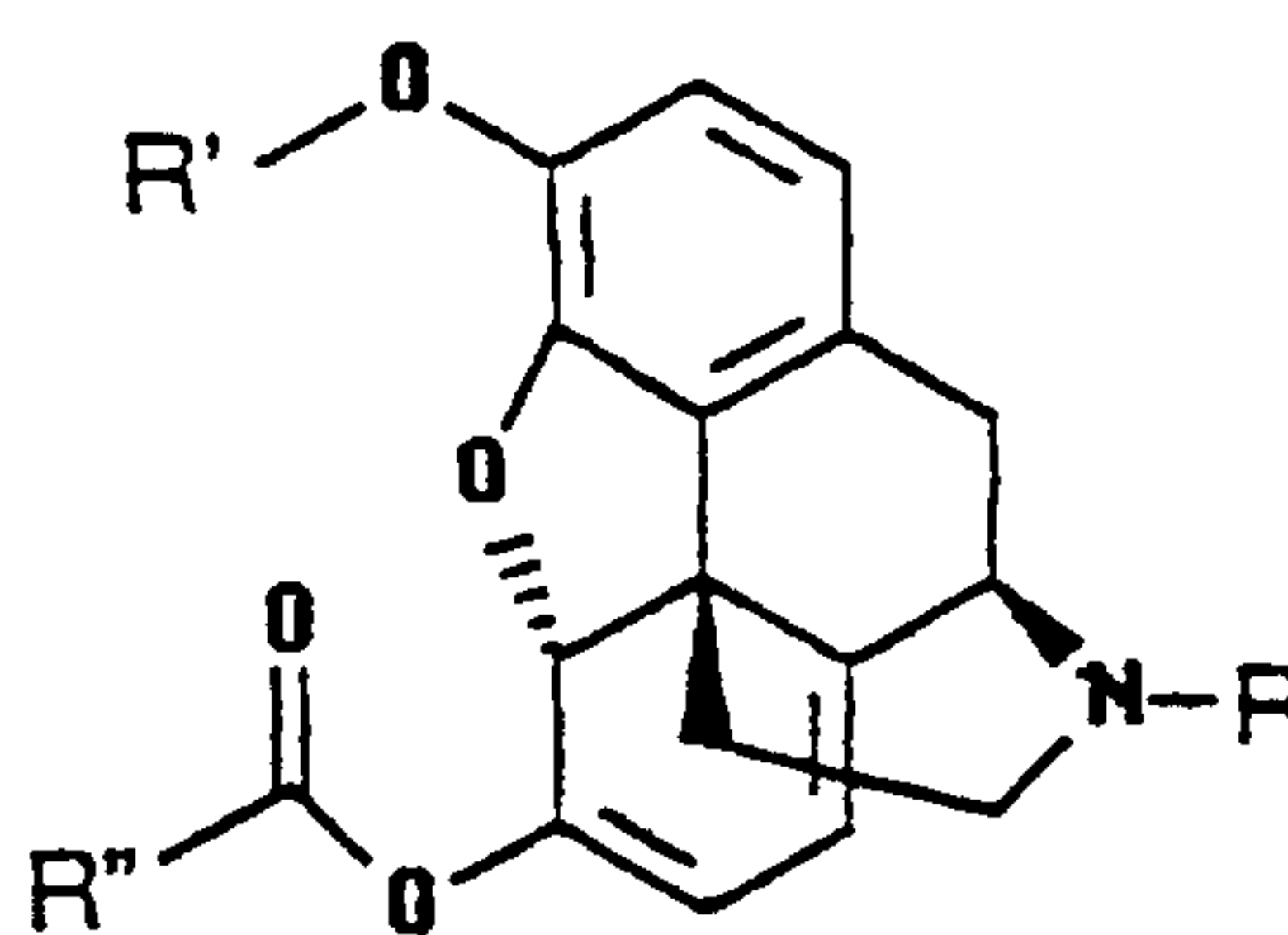
and the corresponding acid salt having the formula:



wherein: R'' is as defined above,

M is sodium or potassium atom, preferably sodium atom;

with or without a cosolvent such as toluene, DMF, or DMAC, preferably toluene; heating at a temperature of about 60°C to about 150°C, preferably 110°C for 1 to 24 hours, depending on the scale of the batch, to produce the dienol acylate having the formula:



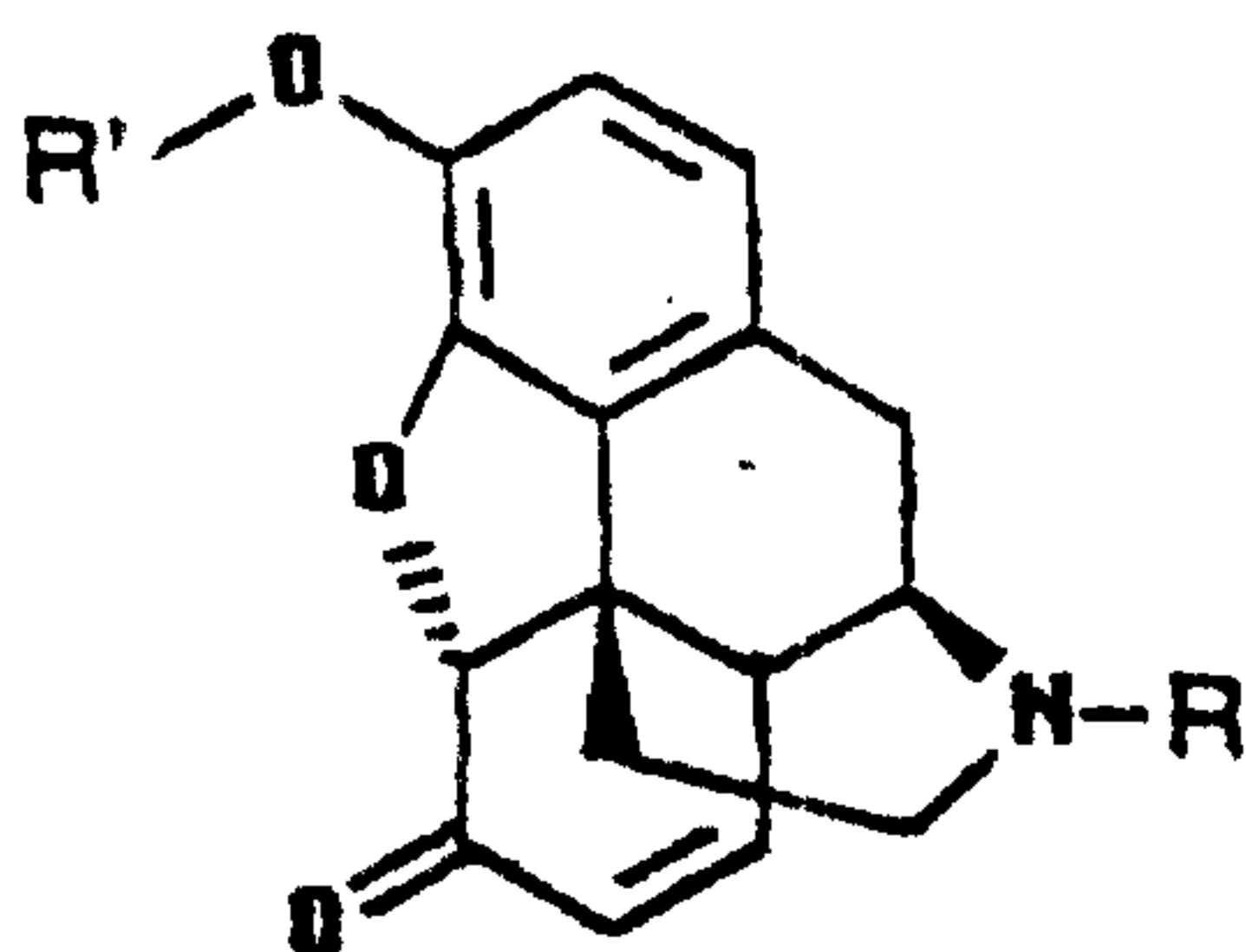
wherein: R, R', and R'' are defined as above;

then followed by reacting the dienol acylate with either an oxidizing agent under the conditions described in (1) or reacting with a peroxyacid such as 3-chloroperoxybenzoic acid (MCPBA) in a weak acid such as acetic acid or formic acid, with or without water and with or without a cosolvent, to help dissolve the peroxyacid and the reactant.

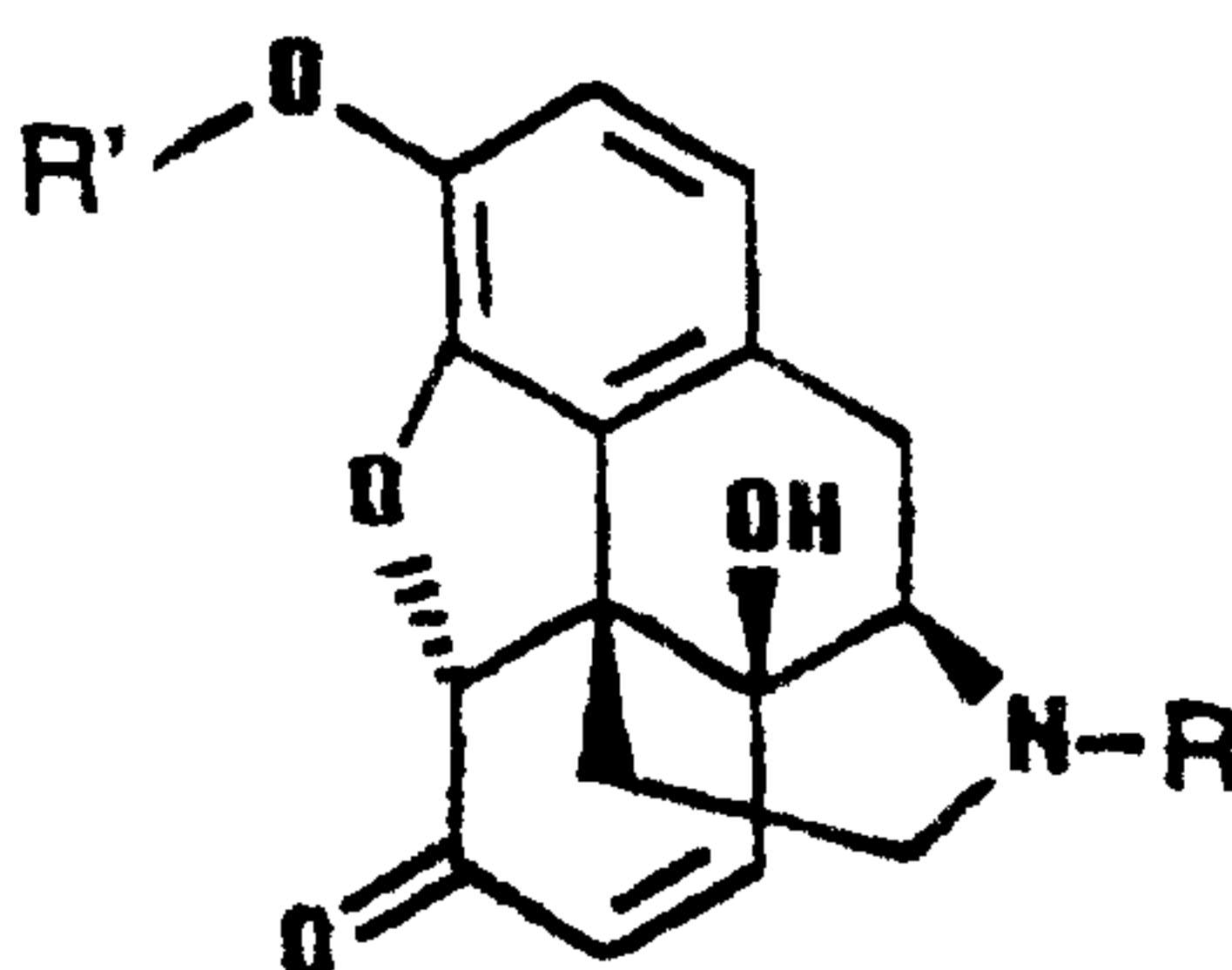
DESCRIPTION OF THE PREFERRED EMBODIMENTS

The embodiments of the present invention will be discussed with reference to various examples of reactions via which the 3(O)-substituted- and/or 17(N)-substituted-14-hydroxynormorphinone can be prepared. The R, R' and R'' are as previously defined above.

Key features of the novel reactions of the invention are made possible by the combination of several essential novel concepts and techniques, and reside in (a) the conversion of the 17(N),3(O)-substituted normorphinone having the formula:

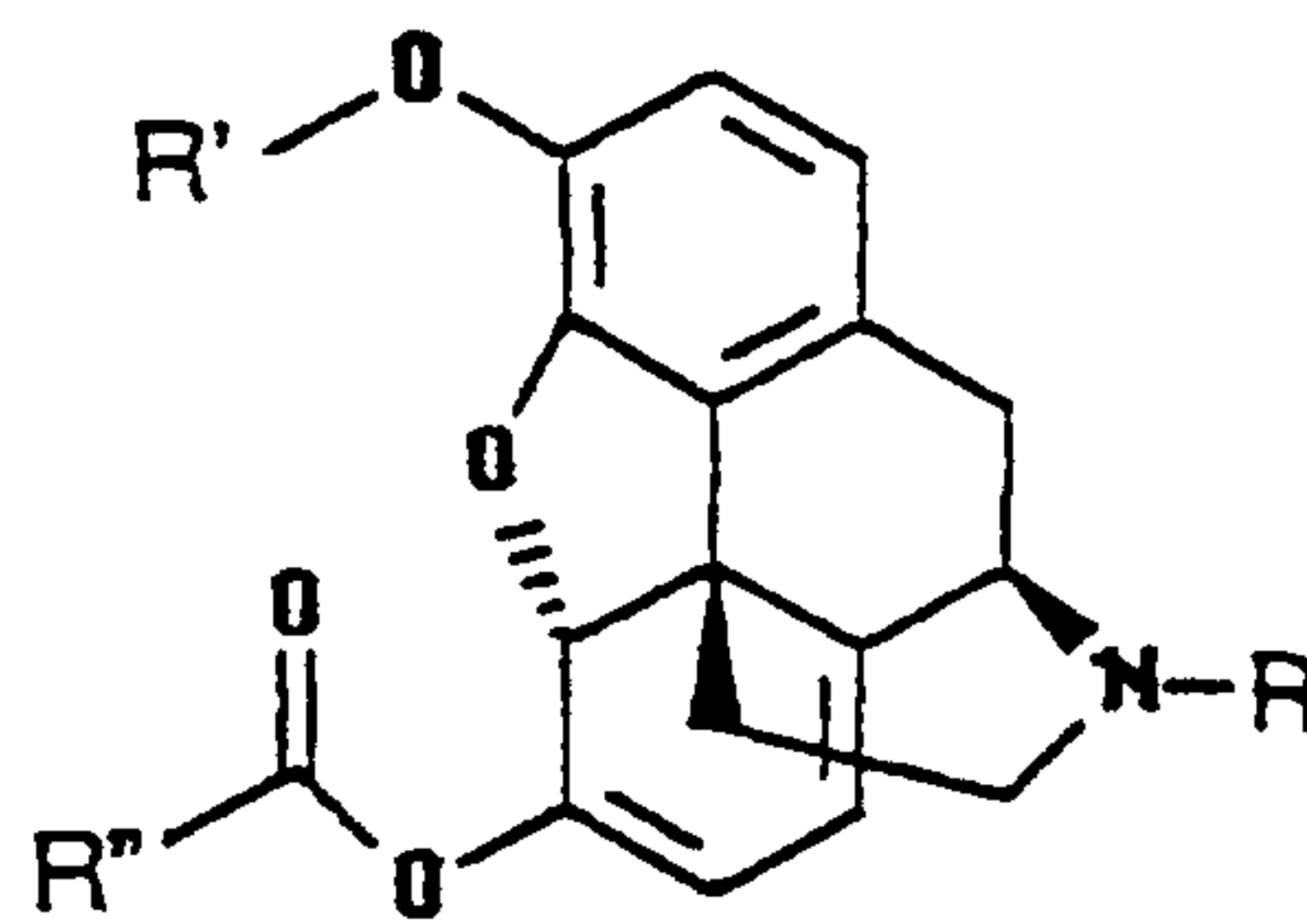


to the corresponding 14-hydroxy-17(N),3(O)-substituted-normorphinone having the formula:

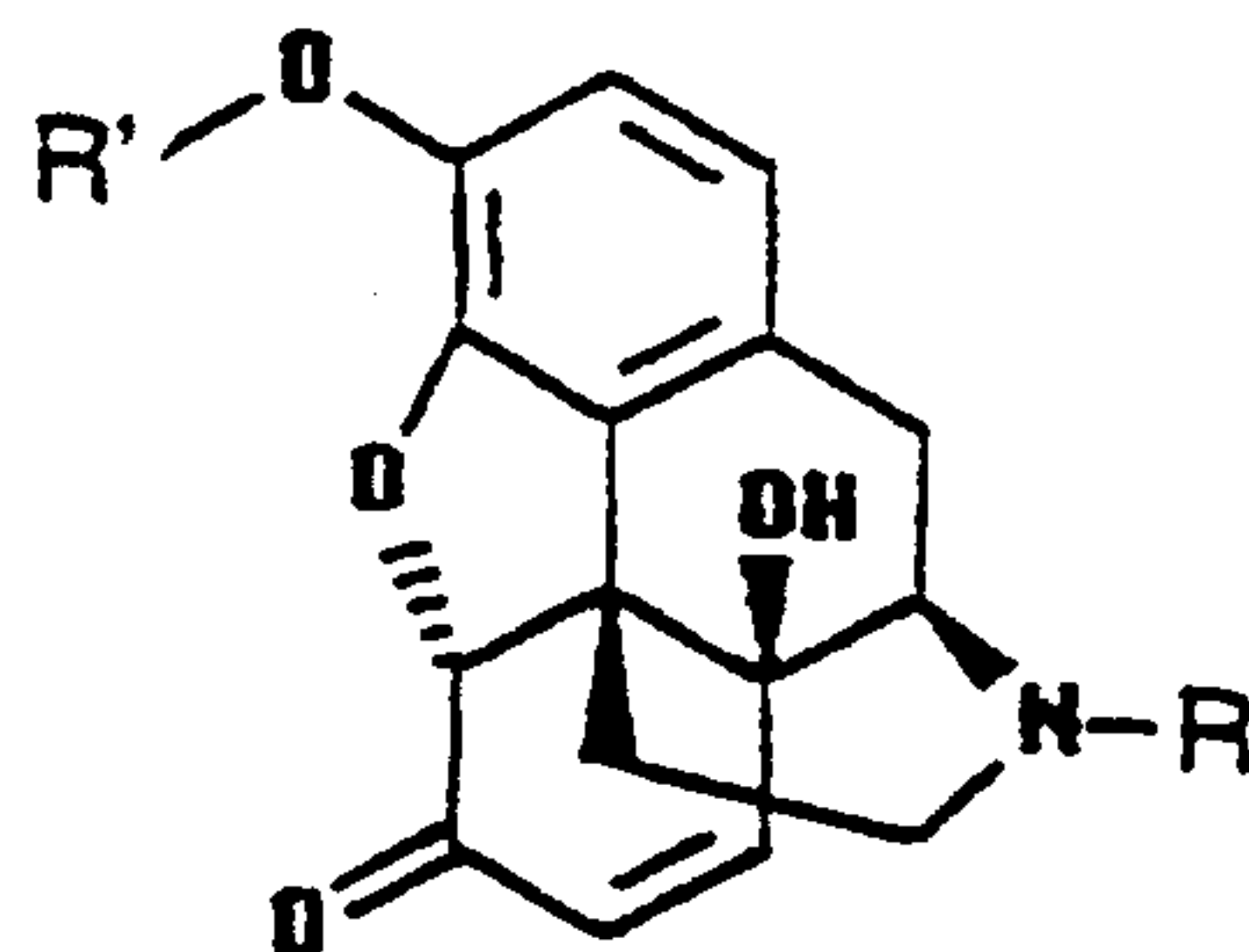


with hydrogen peroxide in an aqueous system in the presence of an acid, for example concentrated formic acid;

(b) the conversion of the 17(N),3(O)-substituted-normorphinone dienol acylate having the formula:

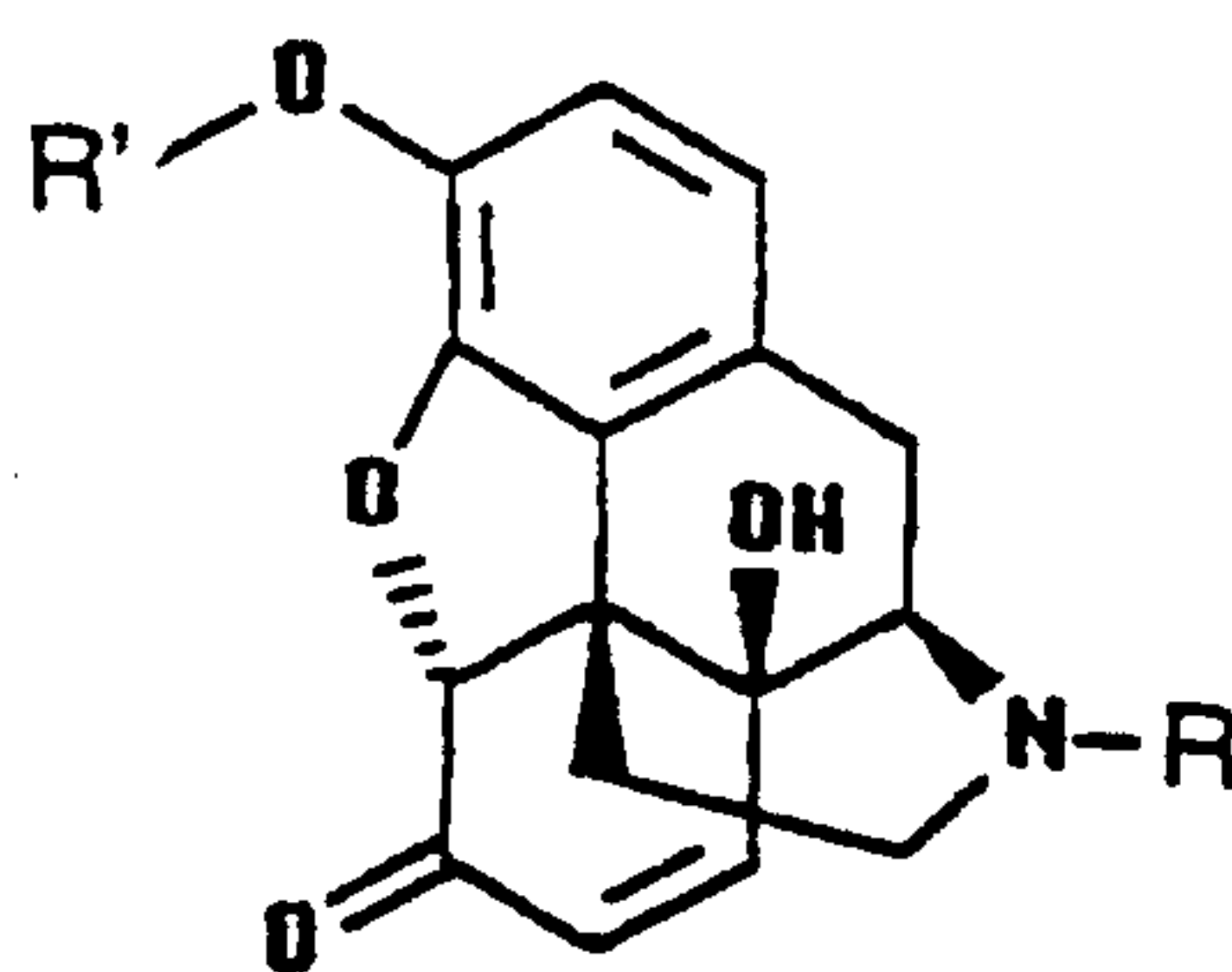


to the corresponding 14-hydroxy-17(N),3(O)-substituted-normorphinone having the formula:



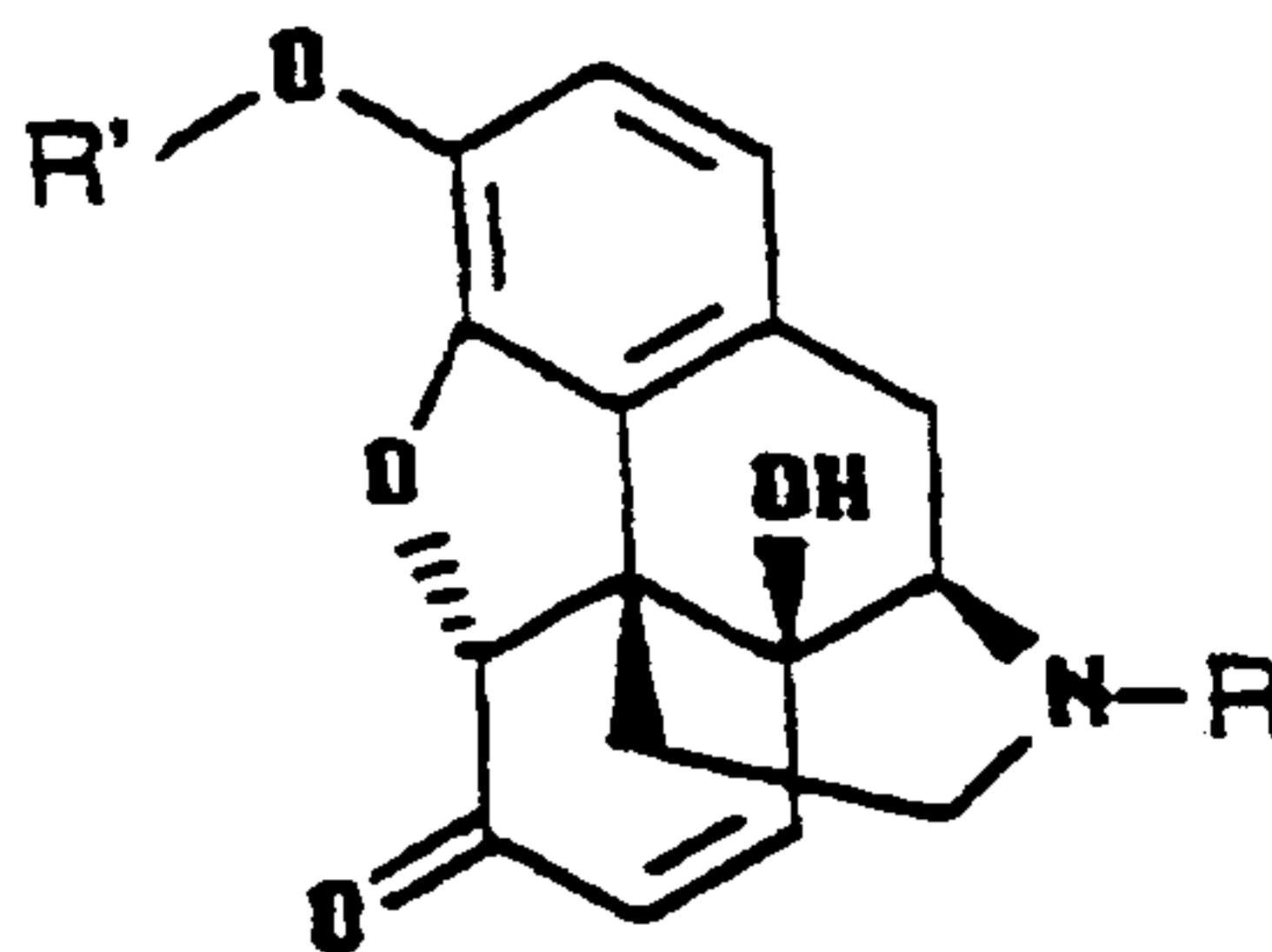
with an oxidizing agent chosen from aqueous hydrogen peroxide or a peroxycarboxylic acid in an aqueous system in the presence of a weak organic acid;

(c) the oxidation reaction to form 14-hydroxy-17(N),3(O)-substituted-normorphinone having the formula:



in an acetic aqueous system, which is very desirable for the following catalytic hydrogenation step;

(d) the 14-hydroxy 3(O)-substituted and/or 17(N)-substituted-normorphinone having the formula:



may further react in specific ways to form oxycodone, oxymorphone, naltrexone, and noroxymorphone. The later is a common intermediate for naloxone, naltrexone, nalmeffene, and nalbuphine;

(e) the choice of a preferred substitution group depends on the kind of desired product in such a way to facility the ease of operation, solvent and reagent consumption.

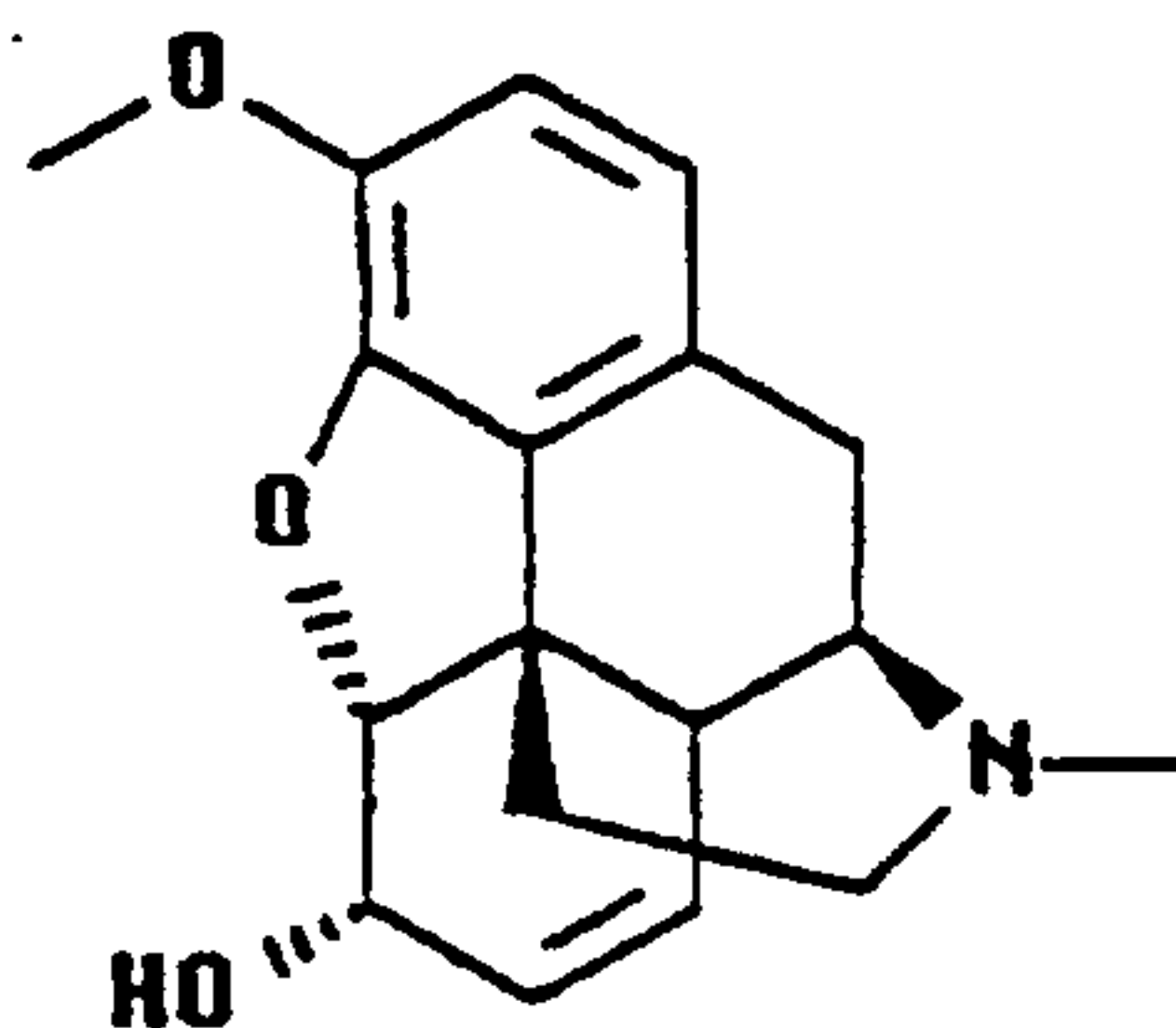
The advantages of the method of the invention for the preparation of oxycodone include, among others:

(a) the use of a currently abundant starting material, codeine, which is a minor component of gum opium and can also be produced by methylation of morphine using prior art techniques. This method does not need to demethylate the N-methyl group on the 17 position of codeine, protect the 17-nitrogen of norcodeine and norcodeinone with a carbamate and then deprotect the 14-hydroxy-N-ethoxycarbonylnorcodeinone, finally, remethylate the same nitrogen as disclosed in US Patents 4,472,253, 4,639,520 and 4,795,813;

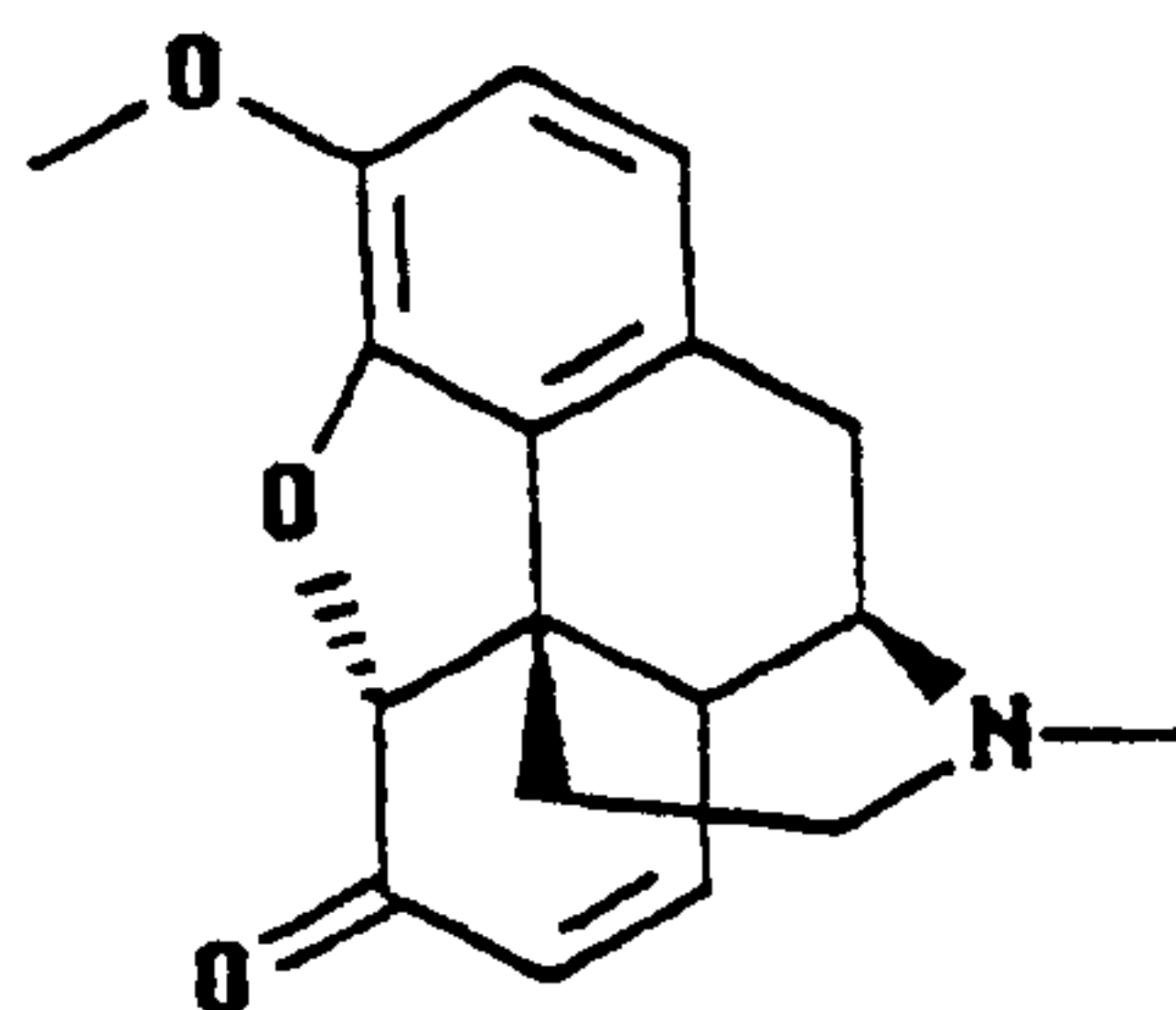
(b) the use of an aqueous system in the oxidation of normorphinones or normorphinone dienol acyletes is not only environmentally friendly but also desirable for the following hydrogenation reaction, since there is no need to isolate the intermediate 14-hydroxycodeinone. The basic nitrogen on the 17-position is protonated in the acidic aqueous system. This greatly contributes to the high solubility of the reactant and the product.

This novel synthesis route affords high yields, good reliability, and straightforward operation and control at each and every step of the synthesis and a major reduction in the cost of the synthesis of oxycodone, oxymorphone, noroxymorphone, naltrexone and nalbuphine.

Thus, for the synthesis of oxycodone from codeine in this invention, the starting material, which has the formula:



is converted to codeinone having the formula:

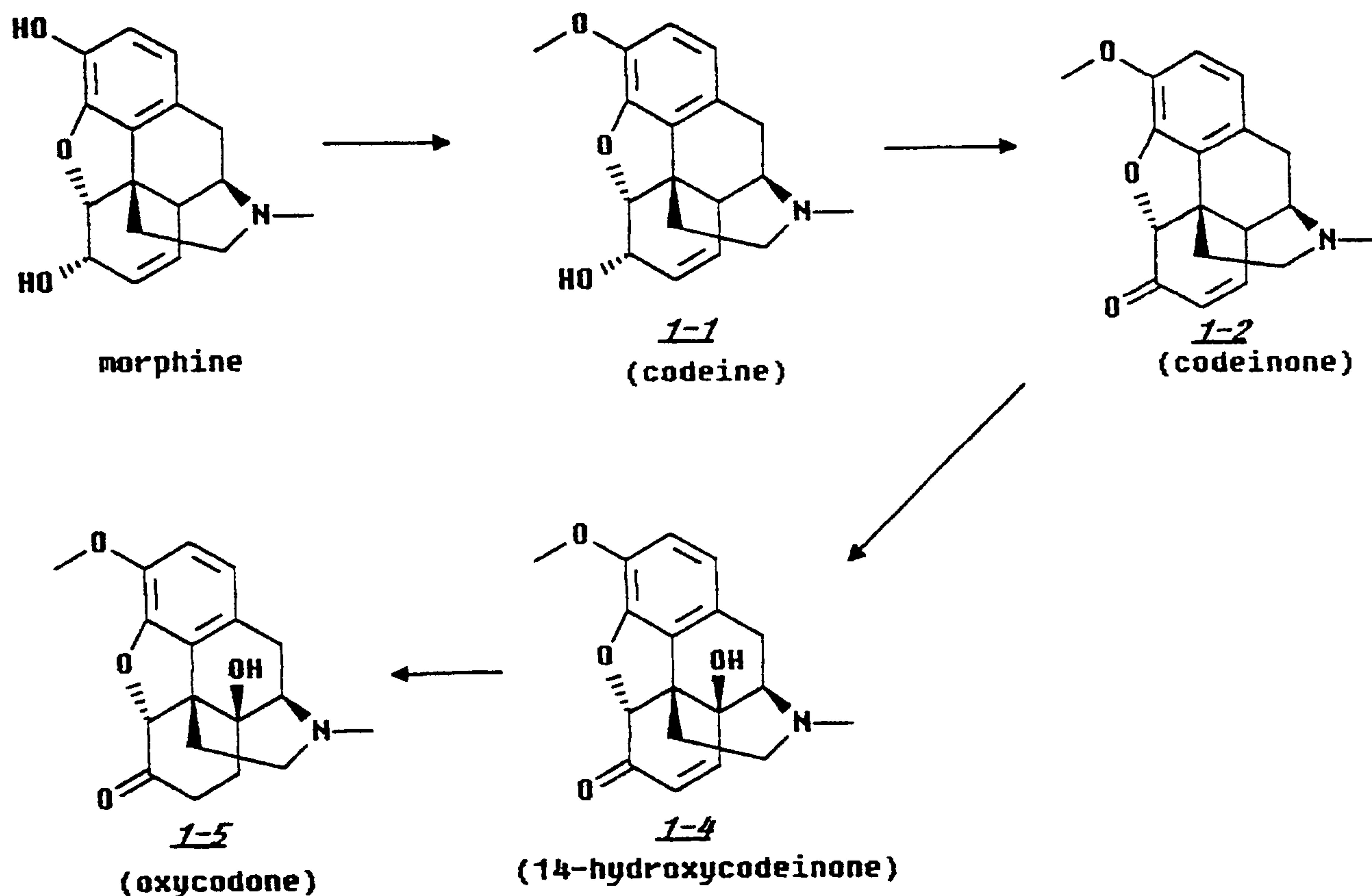


by the prior art method such as Swern oxidation (DMSO/acid halide or acid anhydride).

In the first method of this invention, codeinone is reacted with hydrogen peroxide in water in the presence of an acid at about 15° to about 70°C for a period of time depending on the scale of the reaction to afford 14-hydroxycodeinone in good yield. 14-Hydroxycodeinone so produced is hydrogenated in the same reaction media with a

catalyst to afford oxycodone in good yield. Preferably the temperature is between about 40° to about 50°C and the acid is formic acid.

The sequence of steps in the first method for the synthesis of oxycodone from morphine or codeine can be illustrated as follows:



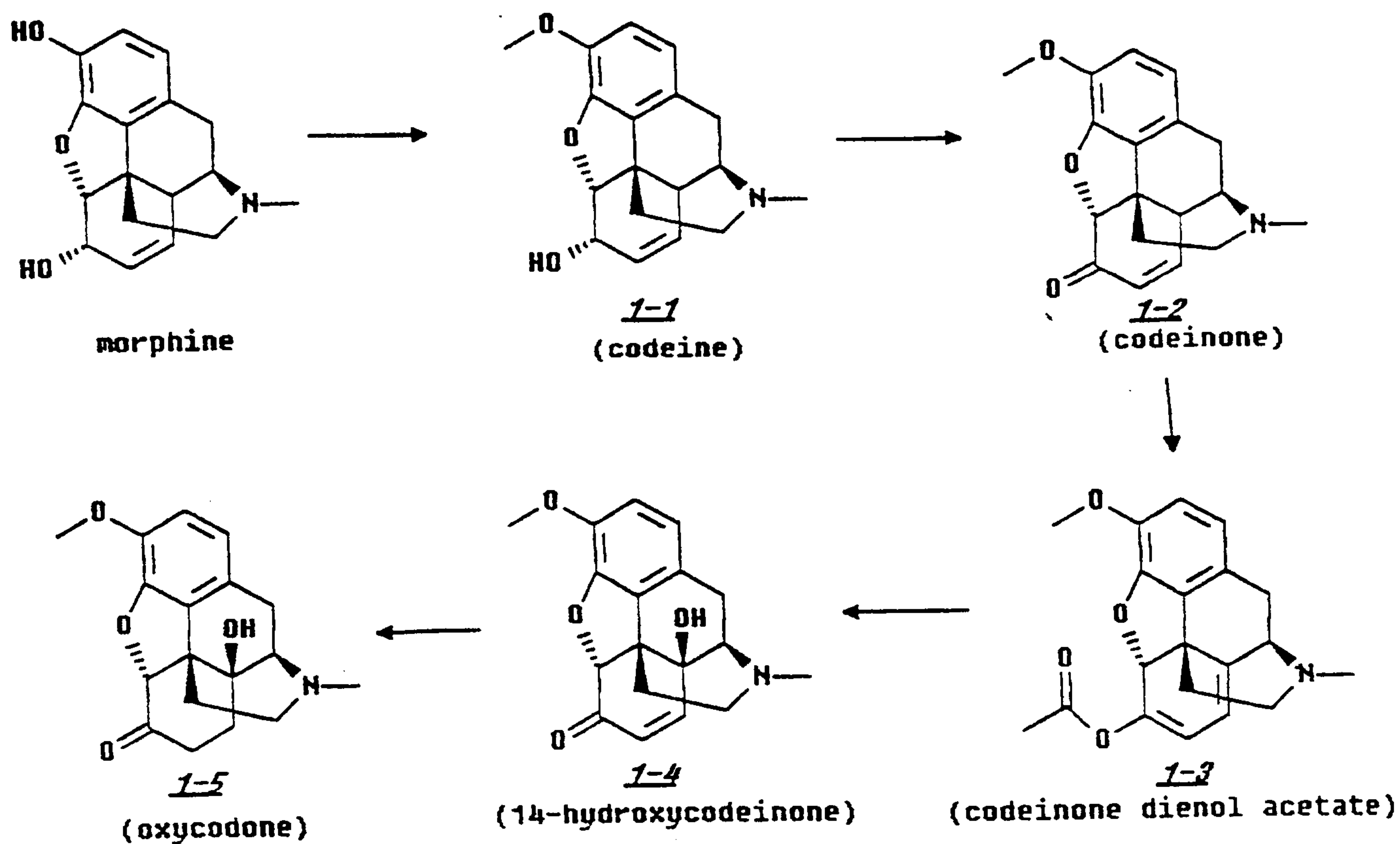
In this and the reaction sequences which are hereinafter shown, the hyphenated two digit descriptor appearing beneath each formula corresponds to the same descriptor appearing after the title to the Examples. Accordingly, the solvents, reactants, temperatures, times and yield are set forth in the examples for each step of the overall reaction.

In the present invention it was observed that the yields of the intermediate products were markedly increased by first acylating the normorphinones to the corresponding dienol acylates and then oxidizing the acrylates to the corresponding 14-hydroxynormorphinones as opposed to the direct oxidation of normorphinones to the

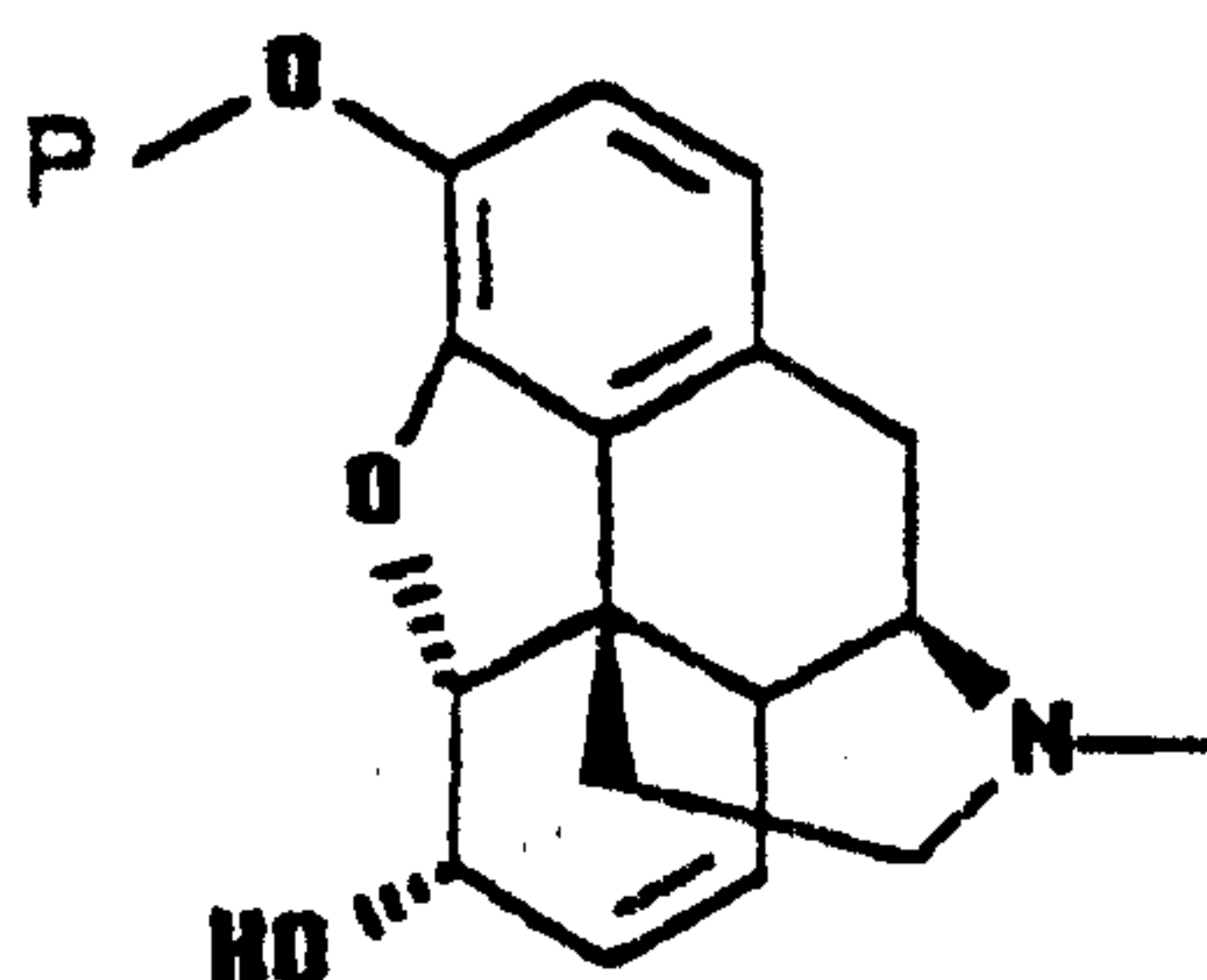
corresponding 14-hydroxynormorphinones. Although this involves an extra step, the overall yield is higher. For example, the oxidation of codeinone dienol acetate to 14-hydroxycodeinone provided a yield of 70 to 80 % after chromatography whereas direct oxidation of codeinone to the 14-hydroxycodeinone gives about 40% yield.

Accordingly, in a second method of this invention, codeinone is first converted to codeinone dienol acetate by prior art methods (DE 902257, 1957 and M-S Brown, JCS, 1960, p. 4139) and then the codeinone dienol acetate is reacted with hydrogen peroxide under the conditions set forth in the first process to 14-hydroxycodeinone which is hydrogenated to oxycodone in excellent yields. Alternatively, codeinone dienol acetate is reacted with a peroxyacid oxidizing agent in an aqueous or non-aqueous system with a weak acid at room temperature to form 14-hydroxycodeinone in excellent yield. Again the product, 14-hydroxycodeinone, in its reaction mixture is suitable for the next reaction, the catalytic hydrogenation, without isolation of the 14-hydroxycodeinone by adding the catalyst and hydrogenating the mixture and then isolating oxycodone. Preferably the peroxyacid oxidizing agent is 3-chloroperbenzoic acid; perbenzoic acid, peroxyacetic acid; more preferably 3-chloroperbenzoic acid. A non-reactive cosolvent such as ethyl acetate, tetrahydrofuran, dioxane, is used to dissolve the oxidizing agent. The preferred weak acid is acetic acid or formic acid, which also serves as the solvent. Conducting the reaction with or without water or oxalic acid does not change the yield.

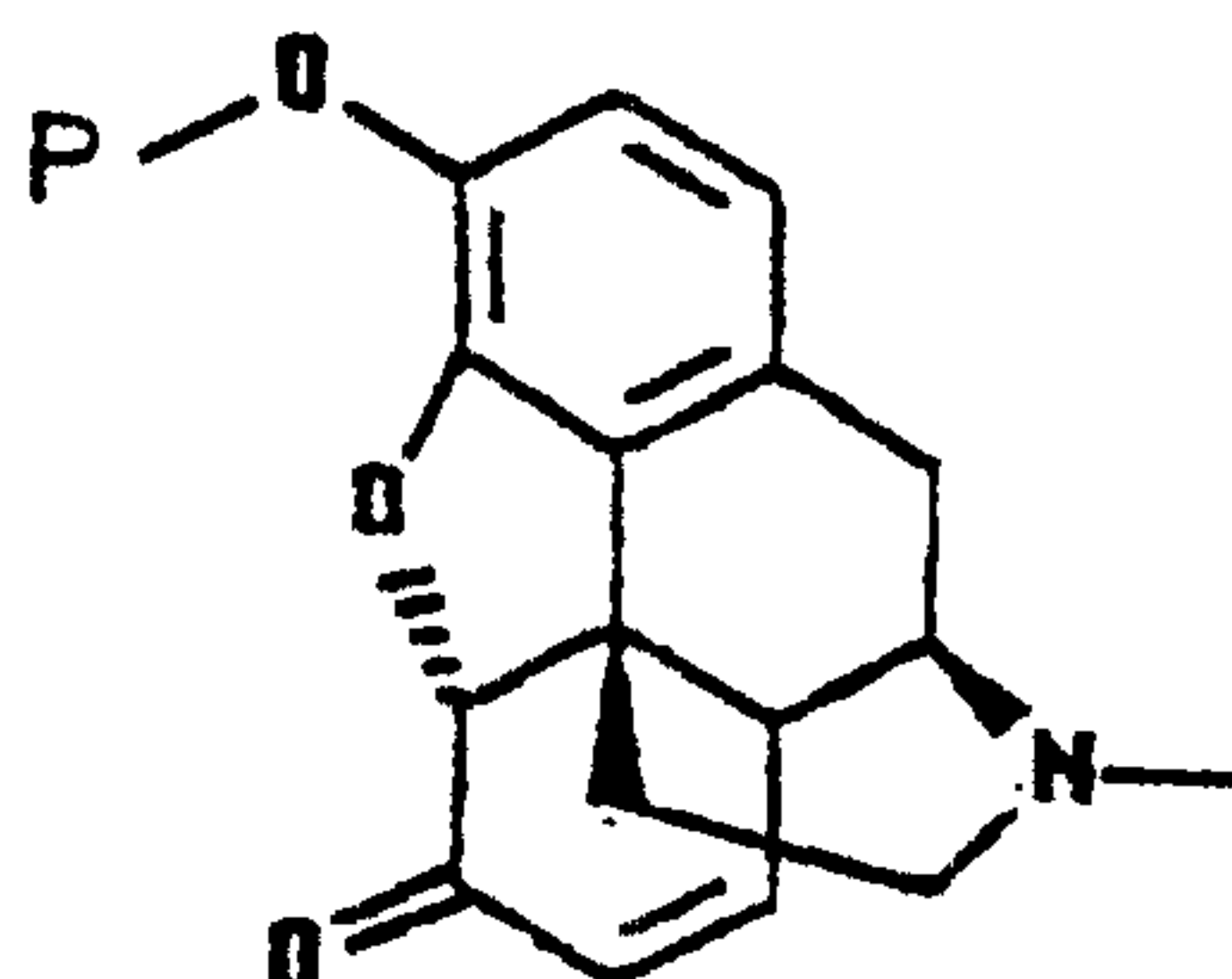
The sequence of steps for the second method wherein codeinone is converted to codeinone dienol acetate in the synthesis of oxycodone from morphine can be illustrated as follows:



For the synthesis of oxymorphone from morphine in the present invention,
 (a) the first step is to protect the phenolic hydroxy on the 3-position of morphine to form the 3(O)-protected-morphine having the formula:



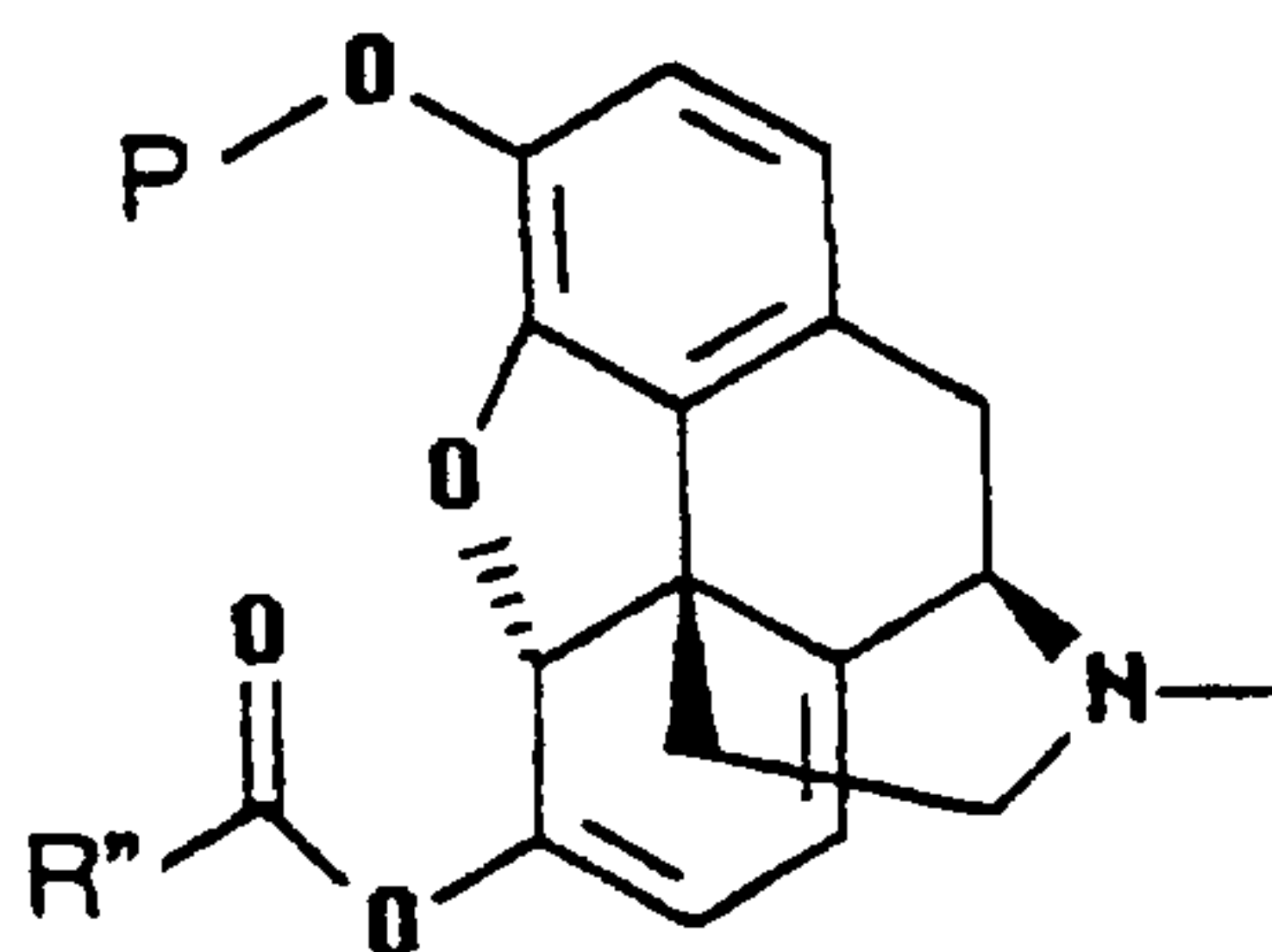
wherein $P = P_1$ or P_2 . P is a suitable protecting group which is stable under the reaction conditions and easily removable by mild hydrolysis with an acid or base (for P_1) or under catalytic hydrogenation (for P_2). P_1 includes acyl, benzoyl and alkoxycarbonyl. P_2 includes benzyl, substituted benzyl and benzyloxycarbonyl.
 (b) the second step is to oxidize the 3(O)-protected morphine to 3(O)-protected-morphinone having the formula:



by any of the prior art methods such as Swern oxidation (DMSO/acid halide or acid anhydride).

(c) the third step is to convert the 3(O)-protected-morphinone to the 14-hydroxy-3-(O)-protected-morphinone using the techniques disclosed in this invention as set forth in the conversion of codeinone to 14-hydroxycodeinone in the synthesis of oxycodone.

The intermediate, 3(O)-protected-codeinone dienol acylate, is a novel compound having the formula:



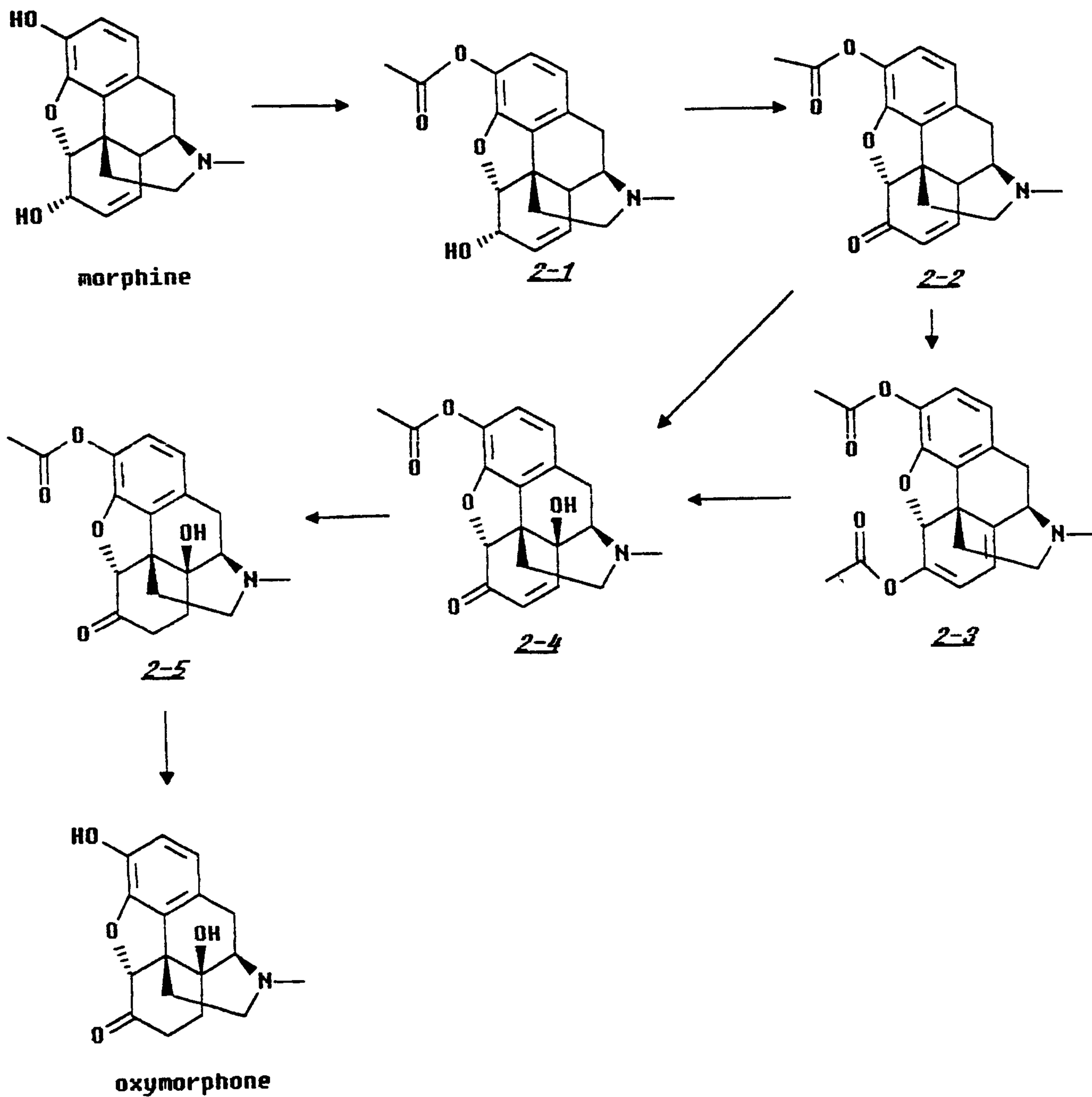
wherein P and R'' are as defined above; preferably P₁ is acetyl and P₂ is benzyl.

(d) depending on the particular protection group, P₁ or P₂, the fourth step is either (i) to first produce the 7,8-double bond of 3-(O)-P₁-protected morphinone and then to remove the protection group by acid or base hydrolysis to produce oxymorphone or (ii) to hydrogenate the 7,8-double bond and deprotect simultaneously the 3-(O)-P₂-protected morphinone to oxymorphone.

This synthesis of oxymorphone from morphine wherein P₁ is acetyl can be illustrated below:

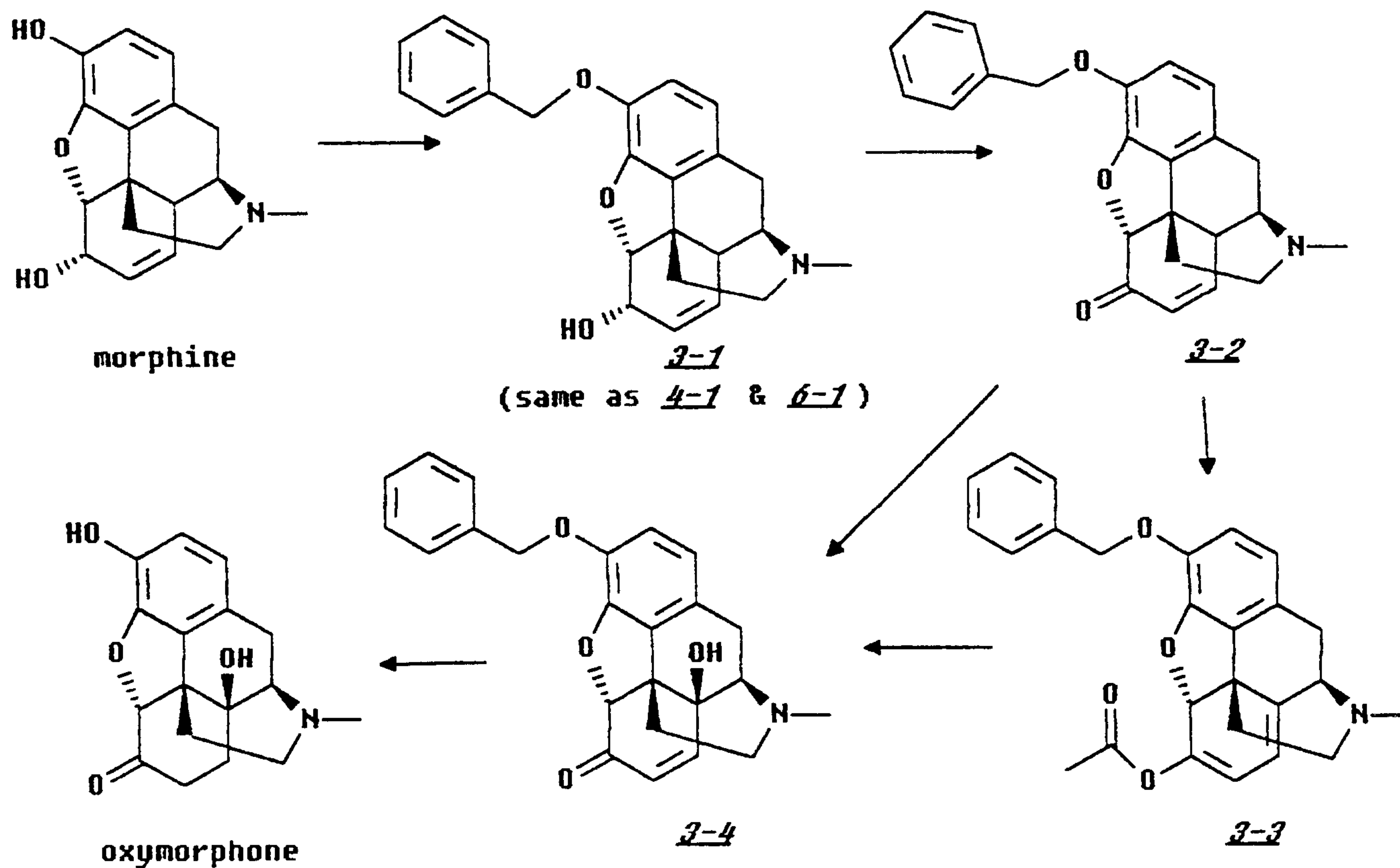
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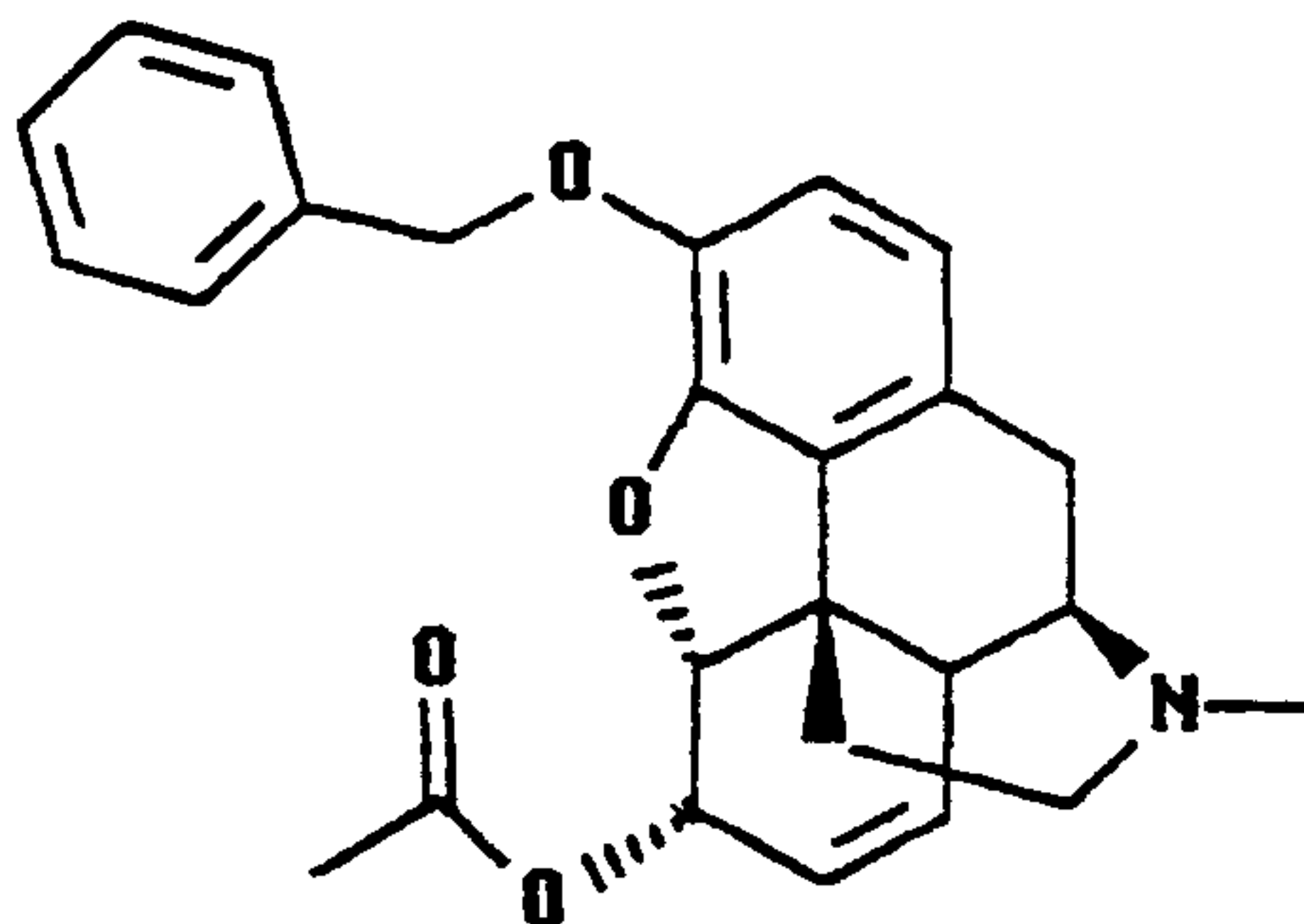


wherein the hyphenated two digits below each formula identifies this corresponding examples as previously indicated.

The synthesis of oxymorphone from morphine wherein P₂ is benzyl can be shown as follows:

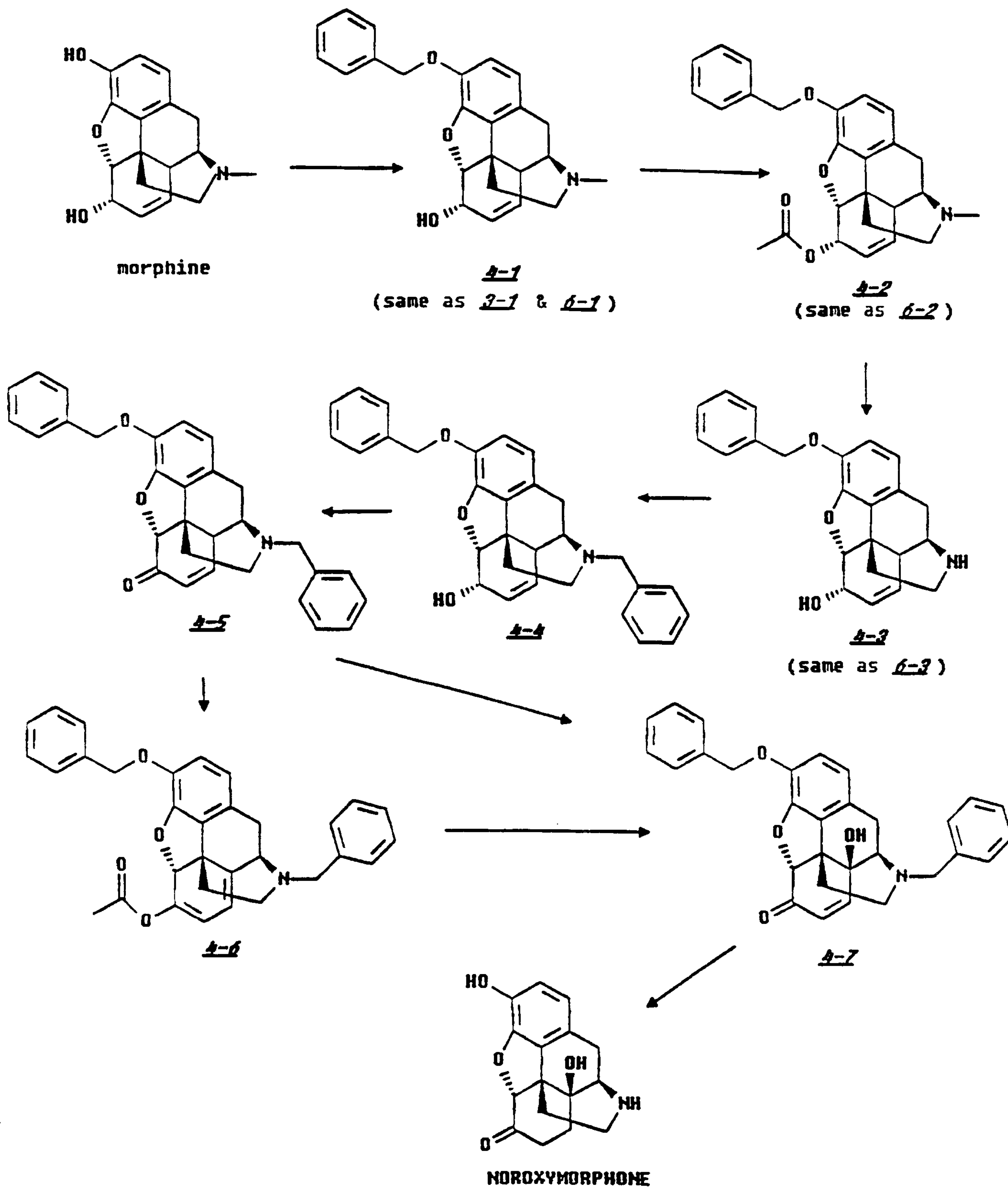


For the synthesis of noroxymorphone from morphine in another embodiment of this invention, morphine is converted to 3-benzylmorphine, which is acetylated to 6-acetyl-3-benzylmorphine having the formula:

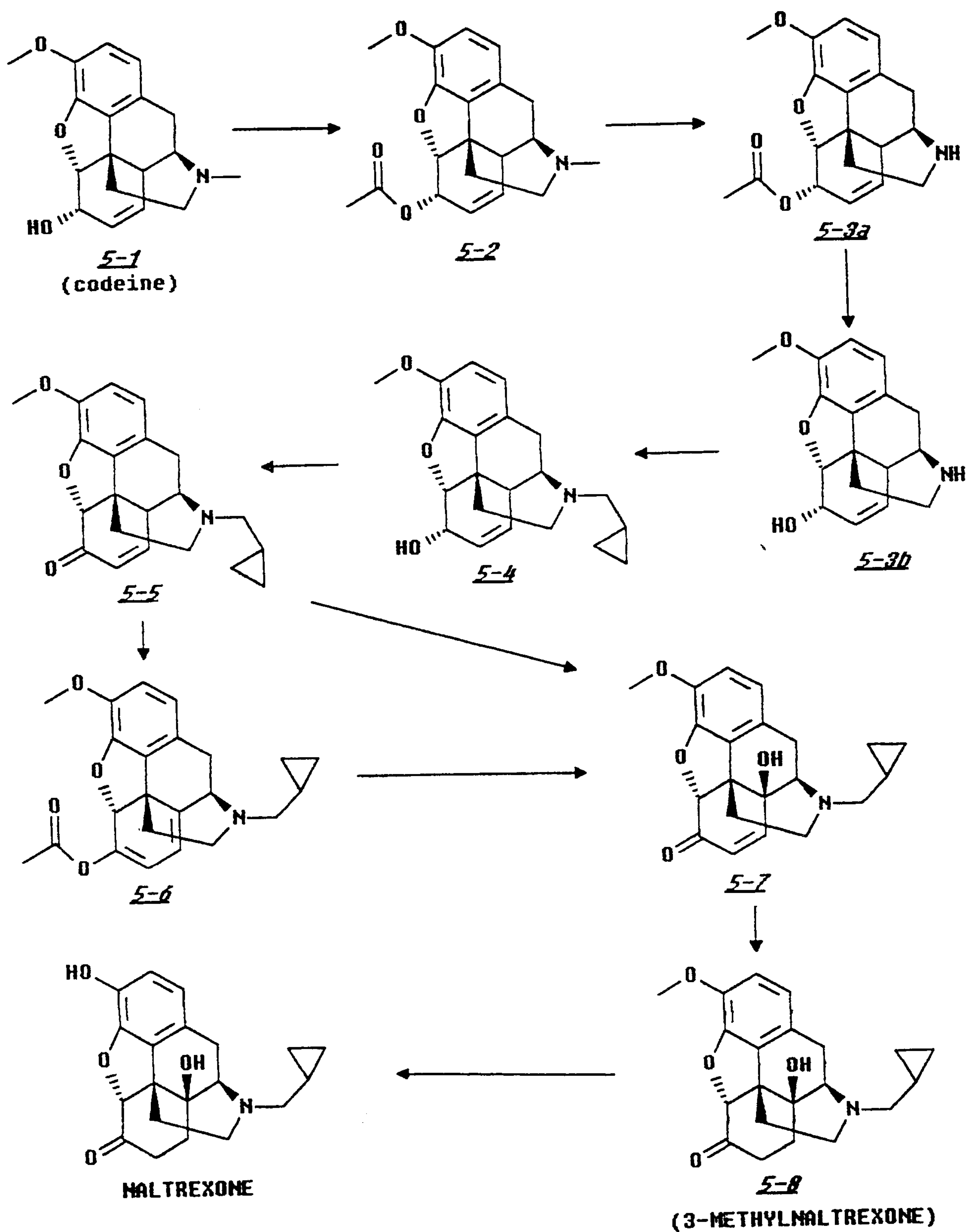


6-acetyl-3-benzylmorphine is N-de-methylated with 1-chloroethyl chloroformate or cyanogen bromide and followed by acid hydrolysis to 3-benzylnormorphine. 3-Benzylnormorphine is reacted with benzyl halide in the presence of a base such as sodium or potassium bicarbonate to produce 3,17-dibenzylnormorphine, a novel compound, which is oxidized to 3,17-dibenzylnormorphinone, a novel compound, by Swern oxidation. Using the conditions set forth in this invention, 3,17-dibenzylnormorphinone is oxidized to 3,17-dibenzyl-14-hydroxynormorphinone either by directly reacting with hydrogen peroxide in formic acid or by first converting to 3,17-dibenzylnormorphinone dienol acylate, a novel compound, and then reacting the latter with hydrogen peroxide in formic acid or a peroxyacid as set forth in the synthesis of oxycodone. Without isolation of 3,17-dibenzyl-14-hydroxynormorphinone from its reaction mixture it is hydrogenated to remove the two benzyl groups and reduce the 7,8-double bond simultaneously to produce noroxymorphone in good yields.

The synthesis of noroxymorphone from morphine can be illustrated as follows:



For the synthesis of 3-methylnaltrexone from codeine in this invention, codeine is converted to 6-acetylcodeine, which is N-demethylated to 6-acetylnorcodeine hydrochloride, followed by alkylating the nitrogen to form 17-cyclopropylmethylnorcodeine. The latter is oxidized to 17-cyclopropylmethylnorcodeinone. As set forth in the synthesis of oxycodone in this invention, 17-cyclopropylmethylnorcodeinone is converted to 14-hydroxy-17-cyclopropylmethylnorcodeinone either by oxidizing with hydrogen peroxide in formic acid; or by first converting to 17-cyclopropylmethylnorcodeinone dienol acetate, a novel compound, then oxidizing with either hydrogen peroxide or MCPBA. 14-Hydroxy-17-cyclopropylmethylnorcodeinone is hydrogenated to 3-methylnaltrexone. 3-Methylnaltrexone can be demethylated to naltrexone with BBr_3 , a prior art method. The reaction can be illustrated as follows:

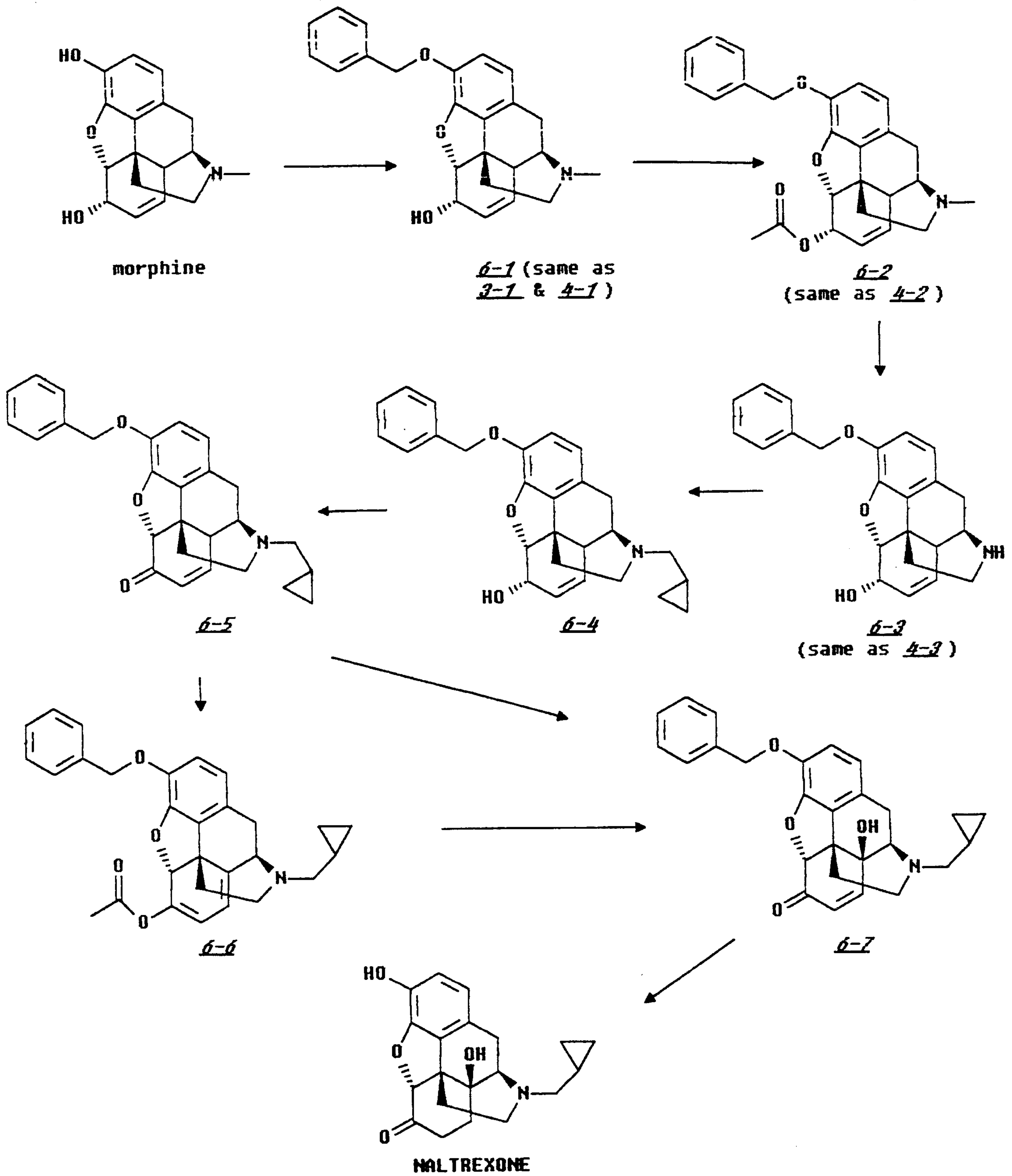


For the synthesis of naltrexone from morphine in this invention, morphine is converted to 3-benzylmorphine as described above in the synthesis of noroxymorphine. 3-Benzylmorphine is reacted with cyclopropylmethyl halide to produce 3-benzyl-17-cyclopropylmethylnormorphine, a novel compound, which is oxidized to 3-benzyl-17-cyclopropylmethyl-normorphinone, a novel compound, by Swern oxidation. Using the conditions set forth in this invention, 3-benzyl-17-cyclopropylmethylnormorphinone is oxidized to 3-benzyl-17-cyclopropylmethyl-14-hydroxynormorphinone either by directly reacting with hydrogen peroxide in formic acid or by first converting to 3-benzyl-17-cyclopropylmethylnormorphinone dienol acylate, a novel compound, and then reacting the latter with hydrogen peroxide in formic acid or a peroxyacid as set forth in the synthesis of oxycodone. Without isolation of 3-benzyl-17-cyclopropylmethyl-14-hydroxynormorphinone from its reaction mixture, it is hydrogenated to remove the benzyl group and reduce the 7, 8-double bond simultaneously to provide naltrexone in good yield.

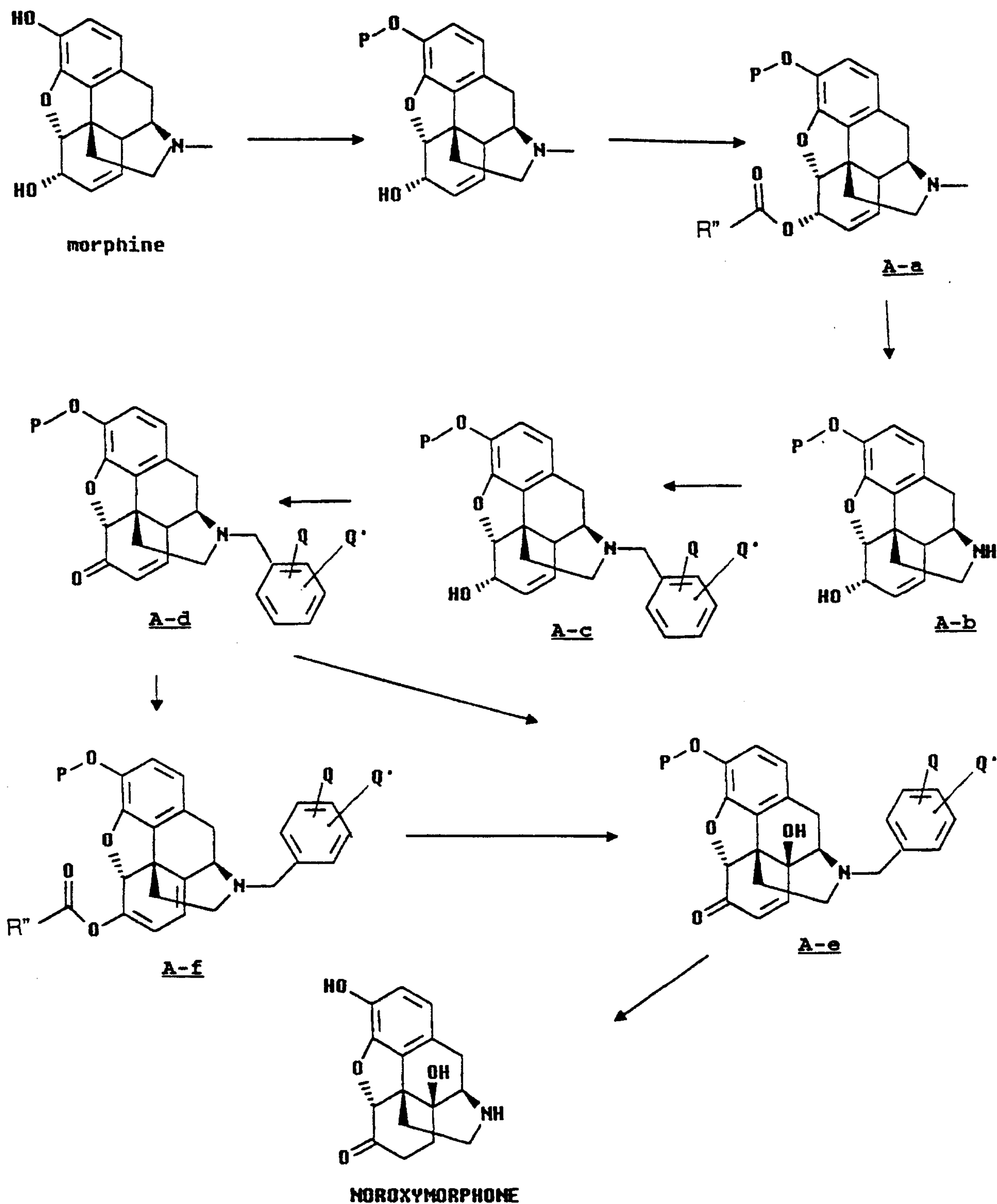
This synthesis of Naltrexone from morphine is shown below:

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A general scheme for the synthesis of noroxymorphone from morphine can be depicted below wherein P, Q, Q' and R'' are as previously indicated.



As hereinbefore indicated, certain intermediate compounds found during the synthesis of the desired end products, are themselves novel compositions of matter. These compounds are set forth in the claims.

The following examples are illustrative of the invention.

A. Synthesis of Oxycodone From Codeine Through Codeinone Dienol Acetate

EXAMPLE 1

Preparation of codeinone (1-2)

To a solution of dimethylsulfoxide (16.53g, 0.21 mole) in CH_2Cl_2 (80 ml) at -78°C was added dropwise a solution of oxalyl chloride (13.01g, 0.10 mole) in CH_2Cl_2 (50 ml) over a period of 40 min. After stirring for 10 min., a solution of codeine (20.33g, 0.068 mole) in CH_2Cl_2 (100 ml) was added over 50 min. while keeping the reaction mixture at -78°C . After stirring at -78°C for 2 hr., Et_3N (50 ml) was added, followed by CH_2Cl_2 (100 ml). The reaction mixture was allowed to warm-up to room temperature, washed with water (6 x 150 ml), dried over anhydrous Na_2SO_4 and evaporated to dryness *in vacuo* to give codeinone (25.57g). IR (KBr)(ν , cm^{-1}): 1668 (s, sharp, $-\text{C}=\text{C}-\overset{\text{O}}{\text{C}}=$); NMR (δ_{H})(CDCl_3): 6.67 (1, d, J, 8.2, 2-H), 6.62 (1, d, J, 10.2, 8-H), 6.59 (1, d, J, 8.2, 1-H), 6.07 (1, dd, J, 10.2 & 2.9, 7-H), 4.68 (1, s, 5-H), 3.85 (3, s, OCH_3), 3.45-3.35 (1, m, 9-H), 3.25-3.17 (1, m, 14-H), 3.10 (1, d, J, 18.5, 10- H_β), 2.61 (1, dm, J, 11.9, 16- H_e), 2.45 (3, s, NCH_3), 2.30 (1, dd, J, 18.5 & 5.5, 10- H_α), 2.30 (1, td, J, 11.9 & 3.7, 16- H_a), 2.06 (1, td, J, 12.0 & 4.8, 15- H_a), 1.85 (1, dm, J, 12.5, 15- H_e).

EXAMPLE 2**Preparation of codeinone dienol acetate (1-3)**

A mixture of codeinone (5.98g, 0.02 mole), sodium acetate (1.77g, 0.02 mole) and acetic anhydride (35.76g, 0.35 mole) in toluene (6 ml) was heated at 90 ~ 105°C for 5 hr, cooled, diluted with CH₂Cl₂ (300 ml), and basified with NaHCO₃ (66g in 300 ml of ice-cold water). The organic portion was separated, washed with water (4 x 150 ml), dried over anhydrous Na₂SO₄, and evaporated to dryness *in vacuo* to give an oil (9.4g), which was chromatographed on silica gel with 5% CH₃OH in CH₂Cl₂ to give codeinone dienol acetate as brown needles (5.62g, 83% yield), IR (KBr)(v, cm⁻¹): 1745 (s, sharp, C=C-OAc); NMR (δ_H)(CDCl₃): 6.67 (1, d, J, 8.1, 2-H), 6.59 (1, d, J, 8.2, 1-H), 5.79 (1, dd, J, 6.3 & 1.0, 7-H), 5.57 (1, d, J, 6.3, 8-H), 5.48 (1, s, 5-H), 3.85 (3, s, OCH₃), 3.66 (1, d, J, 7.0, 9-H), 3.35 (1, d, J, 18.2, 10-H_β), 2.90 (1, td, J, 12.8 & 3.7, 16-H_a), 2.74 (1, dd, J, 18.4 & 7.4, 10-H_α), 2.65 (1, dm, J, 13.2, 16-H_e), 2.48 (3, s, NCH₃), 2.31 (1, td, J, 12.7 & 5.2, 15-H_a), 2.20 (3, s, OAc), and 1.75 (1, dm, J, 12.7, 15-H_e).

EXAMPLE 3**Preparation of 14-hydroxycodeinone (1-4) from codeinone dienol acetate (1-3) by H₂O₂**

A solution of codeinone dienol acetate (1.12g, 3.3 mmol), formic acid (90% aqueous solution, 0.80g, 15.6 mmol), hydrogen peroxide (31% aqueous solution, 0.90g, 8.2 mmol), and water (1.60g) was allowed to stir at 40-42°C for 4.5 hr, cooled to room temperature, basified with concentrated NH₄OH, and extracted with CH₂Cl₂ (50 ml). The extract was washed with water (20 ml), dried over anhydrous Na₂SO₄, and evaporated to dryness *in vacuo* to give 14-hydroxycodeinone (0.80g, 78% yield). The R_f value in TLC, the IR spectrum and the NMR spectrum of the product were comparable to those obtained from an authentic sample.

EXAMPLE 4**Preparation of 14-hydroxycodeinone (1-4) from codeinone dienol acetate (1-3) by MCPBA**

A solution of codeinone dienol acetate (1.16g, 3.4 mmol), oxalic acid (0.70g, 7.4 mmol) and 3-chloroperoxybenzoic acid (57 ~ 86%, 0.83g) in glacial acetic acid (10.02g) was allowed to stir at room temperature for 6 hr, basified with concentrated NH₄OH,

and extracted with CH_2Cl_2 (50 ml). The extract was washed with water (10 ml), dried over anhydrous Na_2SO_4 , and evaporated to dryness *in vacuo* to give a crude product (1.29g), which was chromatographed on silica gel to give pure 14-hydroxycodeinone (0.76g, 72% yield). IR (KBr)(ν , cm^{-1}): 3300 (m, b, -OH), 1670 (s, sharp, $\text{C}=\text{C}-\text{C}=\text{O}$), NMR (δ_{H})(CDCl_3): 6.69 (1, d, J, 8.2, 2-H), 6.60 (1, d, J, 8.2, 1-H), 6.60 (1, d, J, 10.1, 8-H), 6.17 (1, dd, J, 10.1 & 0.3, 7-H), 4.69 (1, s, 5-H), 3.85 (3, s, OCH_3), 3.23 (1, d, J, 18.6, 10- H_β), 3.03 (1, d, J, 6.0, 9-H), 2.63-2.16 (1, m, 15- H_a), 2.63-2.16 (2, m, 16- H_a & 16- H_e), 2.6-2.4 (1, b, -OH), 2.50 (1, dd, J, 18.5 & 4.9, 10- H_α), 2.45 (3, s, NCH_3), 1.68 (1, dm, J, 12.7, 15- H_e). The R_f value in TLC, the IR spectrum and the NMR spectrum of the product were consistent with those obtained from an authentic sample.

EXAMPLE 5

Preparation of 14-hydroxycodeinone (1-4) from codeinone (1-2) by H_2O_2

A solution of codeinone (0.503g, 1.7 mmol), formic acid (0.7 ml) and H_2O_2 (1.0 ml) in Water (1.4 ml) was allowed to stir at 50 - 55°C for 7 hr. The mixture was cooled, basified with NH_4OH , and extracted with CHCl_3 (3 x 15 ml). The extract was washed with water, dried over anhydrous Na_2SO_4 and evaporated to dryness *in vacuo* to give a solid residue (0.17g), which is comparable to 14-hydroxycodeinone in its IR spectrum, NMR spectrum, and the R_f value in TLC with those of an authentic sample.

EXAMPLE 6

Preparation of oxycodone (1-5) from codeinone dienol acetate (1-3)

A solution of codeinone dienol acetate (0.50 g, 1.48 mmol), formic acid (0.7 ml), hydrogen peroxide (0.43 g, 30%, 3.79 mmol), and water (1.4 ml) was heated at 43 - 44°C for 6 hr and cooled to rt. over night. To the solution was added 5% Pd/C (80 mg) and hydrogenated at rt. under 28 psi of hydrogen gas for 18 hr. The reaction mixture was filtered. The filtrate was basified with NH_4OH and extracted with methylene chloride. The extract was washed with water, dried over anhydrous sodium sulfate, and evaporated *in vacuo* to dryness to give oxycodone (0.40 g, 85% yield). The R_f value in TLC and the IR spectrum of the product were comparable to those obtained from an authentic sample.

B. Synthesis of Oxymorphone From Morphine Through 3-Acetylmorphinone**EXAMPLE 7**Preparation of 3-acetylmorphine(2-1)

A mixture of morphine (23.63 g, 83 mmol), NaHCO₃ (28.2 g, 336 mmol), Ac₂O (8.69 g, 85 mmol) in toluene (500 ml) and CH₃CN (900 ml) was heated at reflux for 21 hrs. The reaction mixture was evaporated to dryness *in vacuo*. To the residue was added water (80 ml) and extracted with chloroform (500 ml). The extracts were dried, combined and evaporated to dryness *in vacuo* to obtain a residue, which was chromatographed on silica gel (column: d = 6 cm, l = 8 cm, packed with 141 g of silica gel; solvent system: 5 - 10% MeOH in CH₂Cl₂) to yield 3-acetylmorphine (27 g, 100% yield). IR (KBr)(ν , cm⁻¹): 3500 (m, sharp, -OH), 1750 (s, sharp, AcO); NMR (δ_H)(CDCl₃): 6.73 (1, d, J, 8.1, 2-H), 6.57 (1, d, J, 8.1, 1-H), 5.74 (1, dm, J, 10.1, 7-H), 5.25 (1, dm, J, 9.9, 8-H), 4.91 (1, d, J, 6.9, 5-H), 4.25-4.10 (1, m, 6-H), 3.50-3.35 (1, m, 9-H), 3.05 (1, d, J, 19.1, 10-H _{β}), 2.8-2.7 (1, m, 14-H), 2.85-2.60 (1, m, 16-H_e), 2.50-2.25 (1, m, 16-H_a), 2.45 (3, s, NCH₃), 2.5-2.2 (1, m, 10-H _{α}), 2.28 (3, s, AcO), 2.06 (1, td, J, 12.1 & 5.0, 15-H_a), 2.0-1.85 (1, m, 15-H_e).

EXAMPLE 8Preparation of 3-acetylmorphinone (2-2)

To a solution of DMSO (14.42 g, 158 mmol) in CH₂Cl₂ at -78°C was added oxalyl chloride (11.68 g, 92 mmol) in CH₂Cl₂ (50 ml) in 18 min. The solution was allowed to stir for 15 min. A solution of 3-acetylmorphine (20.02 g, 61 mmol) in CH₂Cl₂ (100 ml) was added dropwise in one hr. The resulting mixture was allowed to stir at -78°C for 2 hrs. Et₃N (50 ml) was added. The reaction mixture was allowed to warm-up to rt., washed with water (4 X 100 ml), dried over anhydrous Na₂SO₄, and evaporated to dryness *in vacuo* to obtain a dark residue (25.8 g), which was chromatographed on silica gel (column: d = 5 cm, l = 10 cm; solvent system: 5% MeOH in CHCl₃) to give 3-acetylmorphinone (14.5 g, 73% yield). IR (KBr)(ν , cm⁻¹): 1760 (s, sharp, AcO), 1670 (s, sharp, C=C-C=O); NMR (δ_H)(CDCl₃): 6.81 (1, d, J, 8.1, 2-H), 6.65 (1, d, J, 8.2, 1-H), 6.62 (d, J, 10.2, 8-H), 6.08 (1, dd, J, 10.3 & 2.8, 7-H), 4.73 (1, s, 5-H), 3.53-3.40 (1, m, 9-H), 3.25-3.20 (1, m, 14-H), 3.14 (1, d, J, 18.9, 10-H _{β}), 2.63 (1, dm, J, 12.1, 16-H_e),

2.46 (3, s, NCH₃), 2.5-2.2 (1, m, 10-H_α), 2.5-2.2 (1, m, 16-H_a), 2.27 (3, s, AcO), 2.09 (1, td, J, 12.9 & 4.8, 15-H_a), 1.95-1.80 (1, m, 15-H_e).

EXAMPLE 9

Preparation of 3-acetylmorphinone dienol acetate (2-3)

A solution of 3-acetylmorphinone (3.25 g, 10 mmol) and acetic anhydride (29.1 g) was stirred at 99°C for 15 hr. The resulting mixture was basified with aqueous sodium bicarbonate, and extracted with CH₂Cl₂. The extract was washed with water, dried over anhydrous sodium sulfate, and evaporated *in vacuo* to dryness. The residue (3.95 g) was chromatographed on silica gel to give 3-acetylmorphinone dienol acetate (1.5 g, 41% yield). IR (KBr)(v, cm⁻¹): 2900 (m, sharp), 1750 (s, sharp, AcO); NMR (δ_H)(CDCl₃): 6.78 (1, d, J, 8.1, 2-H), 6.62 (1, d, J, 8.1, 1-H), 5.78 (1, dd, J, 6.3 & 0.9, 7-H), 5.55 (1, d, J, 6.3, 8-H), 5.50 (1, s, 5-H), 3.63 (1, d, J, 6.9, 9-H), 3.34 (1, d, J, 18.3, 10-H_β), 2.85 (1, td, J, 12.8 & 3.6, 16-H_a), 2.72 (1, dd, J, 18.5 & 6.5, 10-H_α), 2.63 (1, dm, J, 12.3, 16-H_e), 2.46 (3, s, NCH₃), 2.28 (3, s, 3-AcO), 2.19 (3, s, 6-AcO), 2.25-2.10 (1, m, 15-H_a), 1.76 (1, dm, J, 12.7, 15-H_e); MS (EI), m/e (%): 367 (M⁺, 52), 325 (89, [M-CH₂CO]⁺), 283 (68, [M-2CH₂CO]⁺), 43 (100, [CH₃CO]⁺).

EXAMPLE 10

Preparation of 3-acetylmorphinone dienol acetate (2-3)

A mixture of 3-acetylmorphinone (6.05 g, 18.6 mmol), NaHCO₃ (2.12 g, 26 mmol), and Ac₂O (40.3 g, 395 mmol) in toluene (110 ml) was heated at 75°C for 29 hrs. The cooled reaction mixture was chromatographed on silica gel (column: d = 5 cm, packed with 100 g of dry silica gel; solvent systems: 700 ml of CH₂Cl₂ and then 5% MeOH in CH₂Cl₂) to obtain 3-acetylmorphinone dienol acetate (6.71 g, 99% yield). The R_f value in TLC, the IR spectrum, and the NMR spectrum of the product were comparable to those obtained from an authentic sample.

EXAMPLE 11

Preparation of 3-acetyl-14-hydroxymorphinone (2-4) from 3-acetylmorphinone dienol acetate (3-3) by MCPBA

A solution of 3-acetylmorphinone dienol acetate (1.42 g, 3.88 mmol), oxalic acid (0.71 g, 7.89 mmol), meta-chloroperbenzoic acid (0.63 g, 57-86% pure) in AcOH was

allowed to stir at rt. overnight, basified with conc. NH_4OH , extracted with CH_2Cl_2 (3 x 40 ml). The extracts were dried, combined, and evaporated to dryness *in vacuo* to give a solid residue, which was chromatographed on silica gel (column: d = 2 cm, packed with 28 g of silica gel, eluting solvent: 5% MeOH in CH_2Cl_2 to give 3-acetyl-14-hydroxymorphinone (1.12g, 85% yield). The R_f value in TLC and the IR spectrum of the product were comparable to those obtained from an authentic sample.

EXAMPLE 12

Preparation of 3-acetyl-14-hydroxymorphinone (2-4) from 3-acetylmorphine dienol acetate (3-3) by H_2O_2

A solution of 3-acetylmorphinone dienol acetate (1.5 g, 4.1 mmol), formic acid (10 ml), water (0.5 ml), and hydrogen peroxide (0.55 ml, 30%, 4.8 mmol) was stirred at 40 - 47°C for 5.5 hr. The reaction solution was basified with sodium carbonate (12 g, 115 mmol) and extracted with CH_2Cl_2 (3 x 40 ml). The combined extract was dried over anhydrous sodium sulfate and evaporated *in vacuo* to dryness. The residue (1.06 g) was chromatographed on silica gel to give 3-acetyl-14-hydroxymorphinone (0.75 g, 57% yield). IR (KBr)(v, cm^{-1}): 3300 (m, b, -OH), 2900 (m, sharp), 1757 (s, sharp, 3-AcO), 1670 (s, sharp, C=C-C=O); NMR (δ_{H})(CDCl_3): 6.82 (1, d, J, 8.2, 2-H), 6.67 (1, dd, J, 8.2 & 0.9, 1-H), 6.61 (1, dd, J, 10.0 & 0.7, 8-H), 6.18 (1, dd, J, 10.0 & 0.3, 7-H), 5.22-3.82 (1, b, -OH), 4.73 (1, s, 5-H), 3.26 (1, d, J, 18.9, 10- H_β), 3.05 (1, d, J, 6.0, 9-H), 2.66-2.20 (2, m, 16- H_a & 16- H_b), 2.66-2.20 (1, m, 15- H_a), 2.56 (1, dd, J, 19.7 & 6.0, 10- H_α), 2.45 (3, s, NCH_3), 2.26 (3, s, -AcO), 1.72 (1, dm, J, 13.1, 15- H_b); MS (EI), m/e (%): 341 (M^+ , 54), 299 (67, $[\text{M}-\text{CH}_2\text{CO}]^+$), 70 (100, $[\text{CH}_2=\text{CH}-\text{CH}=\text{CH}-\text{OH}]^+$).

EXAMPLE 13

Preparation of 3-acetyloxymorphone (2-5)

A mixture of 3-acetyl-14-hydroxymorphinone (0.34 g, 1 mmol) and Pd-C (5%, 0.8 g) in ethanol (50 ml) was hydrogenated in a Parr hydrogenator with hydrogen gas (28) at rt. for 3 hr. The reaction mixture was filtered through celite*. The filtrate was evaporated *in vacuo* to give 3-acetyloxymorphone (0.28 g, 82% yield). IR (KBr)(v, cm^{-1}): 3400 (s, b, -OH), 2900 (m, sharp), 1760 (s, sharp, AcO), 1720 (s, sharp, C=O); NMR (δ_{H})(CDCl_3): 6.86 (1, d, J, 8.2, 2-H), 6.68 (1, d, J, 8.2, 1-H), 5.29 (1, s, b, -OH), 4.67 (1,

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s, 5-H), 3.19 (1, d, J, 18.9, 10-H_β), 3.01 (1, dd, J, 14.6 & 5.3, 7-H_a), 2.92 (1, d, J, 5.5, 9-H), 2.59 (1, dd, J, 18.9 & 6.0, 10-H_α), 2.42 (3, s, NCH₃), 2.60-2.15 (1, m, 7-H_e), 2.60-2.15 (1, m, 15-H_a), 2.60-2.15 (2, m, 16-H_a & 16-H_e), 2.30 (3, s, AcO), 1.88 (1, ddd, J, 13.3, 5.2 & 3.0, 8-H_e), 1.62 (1, td, J, 13.8 & 3.6, 8-H_a), 1.57 (1, dm J, 13.4, 15-H_e); MS (EI), m/e (%): 343 (M⁺, 1.6), 301 (100, [M-CH₂CO]⁺), 70 (57, [CH₂=CH-CH=CH-OH]⁺).

EXAMPLE 14Preparation of oxymorphone from 3-acetyloxymorphone (2-6)

A solution of 3-acetyloxymorphone (0.18 g, 0.52 mmol) and sodium carbonate (0.13 g, 1.2 mmol) in methanol (5 ml) and water (0.7 ml) was stirred at rt. for 4 hr. The reaction mixture was evaporated *in vacuo* to remove methanol, added water (20 ml) and extracted with chloroform (4 x 20 ml). The combined extract was dried over anhydrous sodium sulfate, and evaporated *in vacuo* to dryness to give oxymorphone (0.127 g, 85% yield). IR (KBr)(ν, cm⁻¹): 3340 (m, b, -OH), 2900 (m, sharp), 1715 (s, sharp, C=O); NMR (δ_H)(CDCl₃): 6.71 (1, d, J, 8.2, 2-H), 6.59 (1, d, J, 8.2, 1-H), 5.55-4.10 (2, b, -OH), 4.67 (1, s, 5-H), 3.14 (1, d, J, 18.8, 10-H_β), 3.04 (1, td, J, 14.4 & 5.3, 7-H_a), 2.86 (1, d, J, 5.8, 9-H), 2.60-2.15 (1, m, 7-H_e), 2.60-2.15 (2, m, 16-H_a & 16-H_e), 2.52 (1, dd, J, 18.2 & 5.8, 10-H_α), 2.50-2.15 (1, m, 15-H_a), 2.40 (3, s, NCH₃), 1.87 (1, ddd, J, 13.4, 5.1 & 2.8, 8-H_e), 1.62 (1, td, J, 13.9 & 3.5, 8-H_a), 1.58 (1, dm, J, 13.4, 15-H_e).

C. Synthesis of Oxymorphone From Morphine Through 3-Benzylmorphinone**EXAMPLE 15**Preparation of 3-benzylmorphine (3-1)

A solution of morphine (14.27 g, 50.0 mmol), NaOH (2.04 g, 51.0 mmol), and benzylbromide (8.47 g, 49.5 mmol) in MeOH (150 ml) and water (50 ml) was stirred at rt. for 3.5 hr., evaporated *in vacuo* to remove MeOH. The residue was extracted with CH₂Cl₂ (120 ml). The extract was dried over anhydrous Na₂SO₄ and evaporated *in vacuo* to dryness to give a crude residue, which was chromatographed on silica gel (column: d = 6.5 cm, l = 10.5 cm; eluting solvent: 15% MeOH in CH₂Cl₂) to obtain 3-benzylmorphine (13.1 g, 70% yield). The R_f value in TLC and the IR spectrum of the product were comparable to those obtained from an authentic sample.

EXAMPLE 16Preparation of 3-benzylmorphinone (3-2) by Swern oxidation

To a solution of dimethyl sulfoxide (3.75 g, 48 mmol) in CH_2Cl_2 (15 ml) at -78°C , was added a solution of oxalyl chloride (3.8 g, 30 mmol) in CH_2Cl_2 (5 ml) in 20 min. It was allowed to stir for another 20 min. To this solution at -78°C , was added a solution of 3-benzylmorphine (6.0 g, 16 mmol) in CH_2Cl_2 (15 ml) in 45 min. Then, the reaction mixture was stirred at -78°C for 3 hr., added triethylamine (17 ml), warmed up to rt., washed with water (8 x 100 ml), dried over anhydrous sodium sulfate, and evaporated *in vacuo* to dryness to give 3-benzylmorphinone (about 65% yield). The R_f value in TLC and the IR spectrum of the product were comparable to those obtained from an authentic sample.

EXAMPLE 17Preparation of 3-benzylmorphinone dienol acetate (3-3)

A mixture of 3-benzylmorphinone (6.0 g, 16.1 mmol), acetic anhydride (47.5 g, 466 mmol), sodium acetate (2.65 g), sodium carbonate (5.2 g), and DMAP (about 0.3 g) was heated at 95°C for 17 hr., basified with aqueous sodium bicarbonate solution to pH 9.0, and extracted with CH_2Cl_2 . The extract was washed with water, dried over anhydrous sodium sulfate, evaporated off the solvent *in vacuo* to give a crude product (9 g), which was chromatographed on silica gel to obtain 3-benzylmorphinone dienol acetate (2.6 g, 39% yield). IR (KBr)(ν , cm^{-1}): 2900 (m, sharp), 1750 (s, sharp, $\text{C}=\text{C}-\text{C}=\text{C}-\text{OAc}$); NMR (δ_{H})(CDCl_3): 7.53-7.15 (5, m, $-\text{C}_6\text{H}_5$), 6.69 (1, d, J, 8.2, 2-H), 6.53 (1, d, J, 8.2, 1-H), 5.79 (1, dd, J, 6.2 & 0.9, 7-H), 5.58 (1, d, J, 6.4, 8-H), 5.49 (1, s, 5-H), 5.14 (2, s, OCH_2Ph), 3.70 (1, d, J, 7.0, 9-H), 3.33 (1, d, J, 18.1, 10- H_β), 2.93 (1, td, J, 12.9 & 3.7, 16- H_α), 2.76 (1, dd, J, 18.5 & 6.7, 10- H_α), 2.68 (1, dm, J, 13.5, 16- H_β), 2.49 (3, s, NCH_3), 2.32 (1, td, J, 12.8 & 5.1, 15- H_α), 2.18 (3, s, AcO), 1.74 (1, dm, J, 12.8, 15- H_β); MS (EI), m/e (%): 415 (M^+ , 15), 324 (40, $[\text{M}-\text{CH}_2\text{Ph}]^+$), 282 (48, $[\text{M}-\text{CH}_2\text{Ph}-\text{CH}_2\text{CO}]^+$), 91 (100, $[\text{CH}_2\text{Ph}]^+$).

EXAMPLE 18**Preparation of 3-benzyl-14 hydroxymorphinone (3-4) from 3-benzylmorphinone dienol acetate (3-3) by MCPBA in HOAc**

A solution of 3-benzylmorphinone dienol acetate (2.6 g, 6.26 mmol), oxalic acid (1.15 g, 12.8 mmol), and 3-chloroperbenzoic acid (1.85 g, 57-86%) in glacial acetic acid (20 ml) was stirred at rt. for 15.5 hr., basified with aqueous sodium bicarbonate solution to pH 9, extracted with CH₂Cl₂. The extract was washed with water, dried over anhydrous sodium sulfate, and evaporated *in vacuo* to dryness to obtain a crude product (2.3 g), which was chromatographed on silica gel to give 3-benzyl-14-hydroxymorphinone (1.43 g, 59% yield). IR (KBr)(v, cm⁻¹): 3280 (m, b, OH), 2900 (m sharp), 1670 (s, sharp, C=C-C=O); NMR (δ_H)(CDCl₃): 7.44-7.20 (5, m, -C₆H₅), 6.71 (1, d, J, 8.1, 2-H), 6.59 (1, d, J, 10.1, 8-H), 6.55 (1, d, J, 8.2, 1-H), 6.16 (1, dd, J, 10.1 & 0.5, 7-H), 5.16 (2, s, OCH₂Ph), 4.71 (1, s, 5-H), 3.20 (1, d, J, 18.6, 10-H_β), 3.02 (1, d, J, 6.0, 9-H), 2.70-2.40 (1, b, -OH), 2.60-2.35 (2, m, 16-H_a & 16-H_e), 2.53 (1, dd, J, 19.4 & 6.0, 10-H_α), 2.5-2.2 (1, m, 15-H_a), 2.43 (3, s, NCH₃); 1.67 (1, dm, J, 12.7, 15-H_e).

EXAMPLE 19**Preparation of 3-benzyl-14 hydroxymorphinone (3-4) from 3-benzylmorphinone dienol acetate (3-3) by H₂O₂ in formic acid and water**

A solution of 3-benzylmorphinone dienol acetate (1.4 g, 3.37 mmol), formic acid (10 ml, 90%), and hydrogen peroxide (0.48 ml, 30%, 4.2 mmol) was stirred at 38 ~ 47°C for 4 hr., basified with sodium carbonate to pH 8, extracted with CH₂Cl₂. The extract was washed with aqueous sodium bicarbonate solution, dried over anhydrous sodium sulfate, and evaporated *in vacuo* to dryness. The residue (1.0 g) was chromatographed on silica gel to give 3-benzyl-14 hydroxymorphinone (0.7 g, 54% yield). The R_f value in TLC and the IR spectrum of the product were comparable to those obtained from an authentic sample.

EXAMPLE 20**Preparation of oxymorphone (3-5) from 3-benzyl-14 hydroxymorphinone (3-4)**

A mixture of 3-benzyl-14-hydroxymorphinone (0.9 g, 2.31 mmol) and 5% Pd-C (0.65 g) in ethanol (50 ml) was hydrogenated in a Parr hydrogenator with hydrogen gas

(30 psi) at rt. for 4 hr., and filtered through celite*. The filtrate was evaporated *in vacuo* to give oxymorphone (0.65 g, 94% yield). IR (KBr)(ν , cm^{-1}): 3200 (s, b, -OH), 2920 (m, sharp), 1720 (s, sharp, C=O); NMR (δ_{H})(CDCl_3): 6.72 (1, d, J, 8.1, 2-H), 6.58 (1, d, J, 8.2, 1-H), 5.38 (2, b, -OH), 4.70 (1, s, 5-H), 3.15 (1, d, J, 18.6, 10- H_β), 3.04 (1, td, J, 14.5 & 5.3, 7- H_a), 2.88 (1, d, J, 5.8, 9-H), 2.54 (1, dd, J, 19.6 & 5.7, 10- H_α), 2.55-2.15 (2, m, 16- H_a & 16- H_b), 2.45-2.15 (2, m, 15- H_a & 7- H_b), 2.41 (3, s, NCH_3), 1.88 (1, ddd, J, 13.3, 5.2 & 3.0, 8- H_b), 1.67 (1, td, J, 14.4 & 3.5, 8- H_a), 1.73-1.50 (1, m, 15- H_b).

Synthesis of Noroxymorphone From Morphine Through 3,17-Dibenzylmorphine

EXAMPLE 21

Preparation of 3-benzylmorphine (4-1) (see also 3-1))

To a suspension of morphine (10.0 g, 35.1 mmol) in THF (200 ml), was added benzyl bromide (5.5 ml, 98%, 45.3 mmol) and sodium hydroxide (1.48 g, 37.0 mmol) at 0°C. The reaction mixture was stirred overnight. The reaction temperature rose gradually to rt. during the process. THF in the reaction mixture was removed on a rotary evaporator. The residue was dissolved in CH_2Cl_2 (150 ml) and water (50 ml). The organic layer was separated. The aqueous layer was extracted with CH_2Cl_2 (3 x 50 ml). The combined organic layer was dried over anhydrous sodium sulfate, evaporated *in vacuo* to obtain a crude product (13 g), which was dissolved in CH_2Cl_2 and loaded onto a silica gel column (3 x 30 cm). The column was first eluted with 3% methanol in CH_2Cl_2 , followed by 5% methanol in CH_2Cl_2 . Pure fractions were combined to obtain 3-benzylmorphine (7.9 g, 60% yield). IR (KBr)(ν , cm^{-1}): 3540 (m, sharp, -OH), 3020 (m, sharp), 2900 (s, sharp), 1600 (m, sharp); NMR (δ_{H})(CDCl_3): 7.50-7.20 (5, m, $-\text{C}_6\text{H}_5$), 6.70 (1, d, J, 8.1, 2-H), 6.51 (1, dd, J, 8.1 & 0.9, 1-H), 5.65 (1, dm, J, 9.9, 7-H), 5.26 (1, dt, J, 9.9 & 2.5, 8-H), 5.12 (2, AB, OCH_2Ph), 4.85 (1, dd, J, 6.6 & 1.2, 5-H), 4.22-4.05 (1, m, 6-H), 3.32 (1, dd, J, 6.2 & 3.3, 9-H), 3.02 (1, d, J, 18.6, 10- H_β), 2.75-2.65 (1, m, 14-H), 2.75-2.65 (1, b, -OH), 2.58 (1, dm, J, 12.0, 16- H_b), 2.5-2.3 (1, m, 16- H_a), 2.42 (3, s, N-CH_3), 2.27 (1, dd, J, 18.6 & 6.6, 10- H_α), 2.05 (1, td, J, 12.1 & 5.3, 15- H_a), 1.85 (1, dm, J, 12.5, 15- H_b).

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EXAMPLE 22**Preparation of 6-acetyl-3-benzylmorphine (4-2)**

To a solution of 3-benzylmorphine (12.7 g, 33.9 mmol) in CH_2Cl_2 (300 ml), was added triethylamine (10 ml, 99%, 71.2 mmol), acetic anhydride (7.5 ml, 99%, 78.6 mmol), and 4-dimethylaminopyridine (0.3 g). The reaction mixture was heated under reflux for 2 hr, cooled with an ice - H_2O bath, then transferred to a separatory funnel, and washed with cold 10% aqueous NaHCO_3 solution (3 x 100 ml). The organic layer was separated and dried over anhydrous Na_2SO_4 . Removal of solvent gave 6-acetyl-3-benzylmorphine (13.87 g, 96% yield). IR (KBr)(ν , cm^{-1}): 2900 (m, sharp), 1727 (s, sharp, AcO); NMR (δ_{H})(CDCl_3): 7.47-7.20 (5, m, $-\text{C}_6\text{H}_5$), 6.68 (1, d, J, 8.1, 2-H), 6.48 (1, d, J, 8.2, 1-H), 5.63 (1, dm, J, 10.1, 7-H), 5.43 (1, dt, J, 10.1 & 2.3, 8-H), 5.25-5.15 (1, m, 6-H), 5.14 (2, s, $-\text{OCH}_2\text{Ph}$), 5.10 (1, dd, J, 6.7 & 1.1, 5-H), 3.34 (1, dd, J, 6.0 & 3.3, 9-H), 3.01 (1, d, J, 18.6, 10- H_β), 2.79-2.70 (1, m, 14-H), 2.59 (1, dd, J, 12.1 & 3.4, 16- H_e), 2.43 (3, s, N- CH_3), 2.37 (1, td, J, 11.8 & 3.6, 16- H_a), 2.27 (1, dd, J, 18.8 & 6.6, 10- H_α), 2.10 (3, s, AcO), 2.04 (1, td, J, 11.9 & 5.1, 15- H_a), 1.86 (1, dm, J, 12.5, 15- H_e).

EXAMPLE 23**Preparation of 3,17-dibenzylnormorphine (4-4) from 6-acetyl-3-benzylmorphine**

To a solution of 6-acetyl-3-benzylmorphine (13.7 g, 32.1 mmol) and proton sponge (1.2 g) in 1,2-dichloroethane (50 ml) was added 1-chloroethyl chloroformate (ACE-Cl, 4.5 ml, 41.7 mmol) at 0°C . The reaction mixture was heated under reflux for 30 min. The reaction mixture was cooled to rt., added methanol (30 ml) and conc. HCl (a few drops), and heated under reflux for another 30 min. Precipitate came out. Then, methanol (50 ml), Na_2CO_3 (10.2 g, 96.2 mmol) and benzyl bromide (4.7 ml, 98%, 38.7 mmol) were added at rt. The reaction mixture was stirred at rt. over the weekend. The solvents were removed on a rotary evaporator. Ethyl acetate (100 ml) and water (100 ml) was added. The organic layer was separated and washed with 10% aqueous NaHCO_3 solution (2 x 50 ml), then dried over anhydrous Na_2SO_4 . Removal of solvent gave a crude product (7.5 g), which was dissolved in CH_2Cl_2 and loaded onto a column (5 x 16 cm, packed with silica gel in CH_2Cl_2). The column was eluted first with CH_2Cl_2 and then with $\text{CH}_2\text{Cl}_2/\text{EtOAc}$ (50/50) to give 3,17-dibenzylnormorphine (13.3 g, 92%

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yield from 6-acetyl-3-benzylmorphine). IR (KBr)(ν , cm^{-1}): 3440 (m, b, -OH), 3020 (m, sharp), 2900 (m, sharp), 1600 (m, sharp); NMR (δ_{H})(CDCl_3): 7.50-7.20 (10, m, $-\text{C}_6\text{H}_5$), 6.70 (1, d, J, 8.2, 2-H), 6.52 (1, d, J, 8.1, 1-H), 5.58 (1, dm, J, 9.9, 7-H), 5.21 (1, dm, J, 9.9, 8-H), 5.12 (2, AB, $-\text{OCH}_2\text{Ph}$), 4.85 (1, dd, J, 6.4 & 1.2, 5-H), 4.25-4.05 (1, m, 6-H), 3.69 (2, AB, $\text{N-CH}_2\text{Ph}$), 3.37 (1, dd, J, 6.2 & 3.3, 9-H), 3.06 (1, d, J, 18.6, 10-H_β), 2.80-2.55 (1, b, -OH), 2.75-2.65 (1, m, 14-H), 2.61 (1, dd, J, 12.1 & 4.0, 16-H_θ), 2.46 (1, td, J, 11.9 & 3.7, 16-H_α), 2.29 (1, dd, J, 18.6 & 6.4, 10-H_α), 2.04 (1, td, J, 11.7 & 5.3, 15-H_α), 1.86 (1, dm, J, 12.5, 15-H_θ).

EXAMPLE 24Preparation of 3,17-dibenzylmorphinone (4-5)

To a solution of DMSO (5.87 g, 75.1 mmol) in CH_2Cl_2 (40 ml) at -78°C , was added a solution of oxalyl chloride (4.7 g, 37.6 mmol) in CH_2Cl_2 (15 ml) in 20 min. The mixture was stirred for 10 min. and then was added a solution of 3,17-dibenzylmorphine (11.3 g, 25.1 mmol) in CH_2Cl_2 (20 ml) in 40 min. The mixture was stirred at -78°C for 2 hr, and then Et_3N (13 ml) was added. It was allowed to warm up to rt., transferred to a separatory funnel, washed with water (10 x 100 ml), dried over anhydrous sodium sulfate, and evaporated *in vacuo* to dryness to give 3,17-dibenzylmorphinone (11.0 g, 98% yield). IR (KBr)(ν , cm^{-1}): 3020 (m, sharp), 2900 (m, sharp), 1670 (s, sharp, $-\text{C}=\text{C}-\text{C}=\text{O}$); NMR (δ_{H})(CDCl_3): 7.51-7.16 (10, m, $-\text{C}_6\text{H}_5$), 6.71 (1, d, J, 8.2, 2-H), 6.56 (1, d, J, 8.2, 1-H), 6.56 (1, d, J, 10.5, 8-H), 6.05 (1, dd, J, 10.2 & 2.9, 7-H), 5.17 (2, s, OCH_2Ph), 4.70 (1, s, 5-H), 3.71 (2, AB, NCH_2Ph), 3.43 (1, dd, J, 5.2 & 3.1, 9-H), 3.23 (1, dd, J, 5.1 & 2.6, 14-H), 3.12 (1, d, J, 18.5, 10-H_β), 2.64 (1, dm, J, 11.8, 16-H_θ), 2.50-2.25 (1, m, 10-H_α), 2.35 (1, td, J, 11.9 & 3.7, 16-H_α), 2.05 (1, td, J, 12.0 & 4.9, 15-H_α), 1.81 (1, dm, J, 12.1, 15-H_θ); MS (EI), m/e (%): 449 (M^+ , 5.5), 358 (21, $[\text{M}-\text{CH}_2\text{Ph}]^+$), 91 (100, $[\text{CH}_2\text{Ph}]^+$).

EXAMPLE 25Preparation of 3,17-dibenzylmorphinone dienol acetate (4-6)

To a mixture of 3,17-dibenzylmorphinone (3.7 g, 8.2 mmol), $\text{CH}_3\text{CO}_2\text{Na}$ (2.7 g, 32.9 mmol) and Na_2CO_3 (10.4 g, 124 mmol), was added Ac_2O (26.3 g, 25.8 mmol). The mixture was stirred at 100°C for 14 hr., cooled, basified to pH 8 with cold aqueous

NaHCO₃, and extracted with CH₂Cl₂ (50 ml). The extract was washed with water (2 x 100 ml), dried over anhydrous sodium sulfate, evaporated *in vacuo* to give a crude product (4.6 g), which was dissolved in CH₂Cl₂ and loaded onto a column (2.4 x 37 cm, 77 g silica gel, packed in CH₂Cl₂). The column was eluted with CH₂Cl₂, and then with a gradient solution of ethyl acetate in hexane to obtain pure 3,17-dibenzylnormorphinone dienol acetate (1.7 g, 42% yield). IR (KBr)(ν , cm⁻¹): 3020 (m, sharp), 2900 (m, sharp), 1750 (s, sharp, -C=C-C=C-OAc); NMR (δ _H)(CDCl₃): 7.50-7.20 (10, m, -C₆H₅), 6.68 (1, d, J, 8.2, 2-H), 6.53 (1, d, J, 8.2, 1-H), 5.77 (1, dd, J, 6.2 & 0.8, 7-H), 5.47 (1, d, J, 7.3, 8-H), 5.49 (1, s, 5-H), 5.14 (2, s, OCH₂Ph), 3.75 (2, s, NCH₂Ph), 3.64 (1, d, J, 7.0, 9-H), 3.32 (1, d, J, 18.0, 10-H _{β}), 2.95 (1, td, J, 13.0 & 3.5, 16-H_a), 2.75-2.60 (1, m, 16-H_e), 2.74 (1, dd, J, 18.7 & 7.1, 10-H _{α}), 2.34 (1, td, J, 12.6 & 4.9, 15-H_a), 2.17 (3, s, AcO), 1.70 (1, dm, J, 12.8, 15-H_e); MS (EI), m/e (%): 491 (M⁺, 2.9), 400 (8, [M-CH₂Ph]⁺), 458 (10, [M-CH₂Ph-CH₂CO]⁺), 91 (100, [CH₂Ph]⁺).

EXAMPLE 26

Preparation of 3,17-dibenzyl-14-hydroxynormorphinone (4-7) from 3,17-dibenzylnormorphinone dienol acetate (4-6) by MCPBA in HOAc

To a solution of 3,17-dibenzylnormorphinone dienol acetate (1.4 g, 2.85 mmol) in glacial acetic acid (10 ml) was added oxalic acid (0.5 g, 5.6 mmol) and 3-chloroperbenzoic acid (MCPBA, 0.98g, 57 ~ 86%). The reaction mixture was stirred at rt. for 5 hr., basified to pH 8 ~ 9 with NH₄OH, extracted with CH₂Cl₂ (3 x 50 ml). The combined organic extract was dried over anhydrous sodium sulfate, evaporated *in vacuo* to dryness to obtain 3,17-dibenzyl-14-hydroxynormorphinone (0.9 g, 68% yield). The R_f value in TLC and the IR spectrum of the product were comparable to those obtained from an authentic sample.

EXAMPLE 27

Preparation of 3,17-dibenzyl-14-hydroxynormorphinone (4-7) from 3,17-dibenzylnormorphinone dienol acetate (4-6) by MCPBA in 90% formic acid

To a solution of 3,17-dibenzylnormorphinone dienol acetate (1.54 g, 3.13 mmol) in formic acid (20 ml, 90%), was added 3-chloroperbenzoic acid (MCPBA, 1.02 g, 57-86%). The reaction mixture was stirred at rt. for 17 hr., basified to pH 8 with cold

aqueous Na_2CO_3 , and extracted with CH_2Cl_2 . The extract was dried over anhydrous Na_2SO_4 , and evaporated *in vacuo* to dryness. The residue was chromatographed on silica gel to give 3,17-dibenzyl-14-hydroxynormorphinone (0.86 g, 60% yield). The R_f value in TLC and the IR spectrum of the product were comparable to those obtained from an authentic sample.

EXAMPLE 28

Preparation of 3,17-dibenzyl-14-hydroxynormorphinone (4-7) from 3,17-dibenzylnormorphinone dienol acetate (4-6) by H_2O_2 in formic acid and water

A solution of 3,17-dibenzylnormorphinone dienol acetate (1.7 g, 3.46 mmol) and H_2O_2 (30%, 0.5 ml) in formic acid (90%, 20 ml) was stirred at 37 ~ 47°C for 4 hr., basified to pH 8.0 with NaHCO_3 and 5% NaHCO_3 solution, extracted with CH_2Cl_2 . The extract was washed with 5% NaHCO_3 , dried over anhydrous Na_2SO_4 , and evaporated *in vacuo* to obtain a crude product, which was chromatographed on silica gel to give pure 3,17-dibenzyl-14-hydroxynormorphinone (0.74 g, 60% yield). IR (KBr)(ν , cm^{-1}): 3340 (s, b, -OH), 2900 (m, sharp), 1675 (s, sharp, -C=C-C=O); NMR (δ_{H})(CDCl_3): 7.48-7.15 (10, m, - C_6H_5), 6.73 (1, d, J, 8.2, 2-H), 6.58 (1, d, J, 8.8, 1-H), 6.53 (1, d, J, 10.1, 8-H), 6.14 (1, d, J, 10.1, 7-H), 5.3-4.8 (1, b, -OH), 5.16 (2, s, OCH_2Ph), 4.71 (1, s, 5-H), 3.70 (2, s, NCH_2Ph), 3.27 (1, d, J, 18.6, 10- H_β), 3.11 (1, d, J, 5.8, 9-H), 2.70-2.55 (1, m, 16- H_e), 2.57 (1, dd, J, 18.5 & 5.7, 10- H_α), 2.45 -2.25 (2, m, 15- H_a & 16- H_a), 1.68 (1, dm, J, 11.6, 15- H_e); MS (EI), m/e (%): 465 (M^+ , 10), 374 (20, $[\text{M}-\text{CH}_2\text{Ph}]^+$), 91 (100, $[\text{CH}_2\text{Ph}]^+$).

EXAMPLE 29

Preparation of 3,17-dibenzyl-14-hydroxynormorphinone (4-7) from 3,17-dibenzylnormorphinone (4-5)

A solution of 3,17-dibenzylnormorphinone (0.875 g, 2.22 mmol), H_2O_2 (30%, 0.76 ml), and formic acid (90%, 0.7 ml) in water (0.8 ml) and EtOAc (0.7 ml) was stirred at 41°C for 7 hr., basified to pH 10 with Na_2CO_3 and extracted with CH_2Cl_2 (3 x 20 ml). The combined extract was washed with water, dried over anhydrous Na_2SO_4 , and evaporated *in vacuo* to obtain 3,17-dibenzyl-14-hydroxynormorphinone (0.48 g, 53%).

yield). The R_f value in TLC and the IR spectrum of the product were comparable to those obtained from an authentic sample.

EXAMPLE 30

Preparation of noroxymorphone hydrochloride (4-8) from 3,17-dibenzyl-14-hydroxynormorphinone (4-7)

A mixture of 3,17-dibenzyl-14-hydroxynormorphinone (1.48 g, 35.9 mmol), 5% Pd-C (1.0 g), and conc. HCl (0.5 ml) in ethanol (100 ml) was hydrogenated with a Parr* hydrogenator with hydrogen gas (30 PSIG) at rt. for 47 hr., and filtered through celite.* The filtrate was evaporated *in vacuo* to give noroxymorphone hydrochloride (1.05 g, 100% yield). IR (KBr)(ν , cm^{-1}): 3300 (s, b, -OH, -NH), 2900 (m, sharp), 2430 (m, sharp, NH $\cdot$ HCl), 1710 (s, sharp, C=O); NMR (δ_H)(CDCl_3): 10.4-8.0 (2, b, $^+\text{NH}_2\text{Cl}^-$), 9.40 (1, s, -OH), 6.69 (1, d, J, 8.1, 2-H), 6.61 (1, d, J, 8.1, 1-H), 6.50 (1, s, -OH), 4.93 (1, s, 5-H), 3.70 (1, d, J, 5.5, 9-H), 3.33 (1, d, J, 19.1, 10- H_β), 3.15-2.85 (1, m, 7- H_a), 3.15-2.85 (2, m, 16- H_a & 16- H_e), 2.75-2.24 (1, m, 10- H_α), 2.75-2.24 (1, m, 15- H_a), 2.10 (1, dm, J, 14.6, 7- H_e), 1.96 (1, dm, J, 11.8, 15- H_e), 1.64-1.20 (2, m, 8- H_a & 8- H_e).

Synthesis of naltrexone from codeine through 17-cyclopropylmethylnorcodeinone and 3-methylnaltrexone

EXAMPLE 31

Preparation of 6-acetylcodeine (5-2)

A solution of codeine (30 g, 100.2 mmol), acetic anhydride (18.4 g, 180.2 mmol), triethylamine (18.25 g, 180.2 mmol) and 4-dimethylaminopyridine (0.5 g) in dry ethyl acetate (620 ml) was stirred at rt. under nitrogen for 12 hr, added saturated aqueous sodium bicarbonate solution until no acetic anhydride detected. The organic portion was separated, washed with water (3x 120 ml), dried over anhydrous sodium sulfate, and evaporated *in vacuo* to dryness to give 6-acetylcodeine as white solids (34.0 g, 99% yield). IR (KBr)(ν , cm^{-1}): 1725 (st, sharp, 3-AcO); NMR (δ_H)(CDCl_3): 6.66 (1, d, J, 8.2, 2-H), 6.53 (1, d, J, 8.2, 1-H), 5.63 (1, ddd, J, 10.0, 2.4 & 1.0, 7-H), 5.42 (1, dt, J, 9.9 & 2.3, 8-H), 5.22 - 5.51 (1, m, 6-H), 5.06 (dd, J, 6.7 & 1.0, 5-H), 3.85 (3, s, 3-OCH₃), 3.39 (1, dd, J, 6.0 & 3.3, 9-H), 3.03 (1, d, J_{gem} , 18.6, 10- H_β), 2.78 (1, dd, J, 5.2 & 2.6, 14-H), 2.63 (1, dd, J, 11.9 & 4.6, 16- H_a), 2.45 (3, s, N-CH₃), 2.40 (1, td, J, 12.0

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& 3.8, 16-H_e), 2.33 (1, dd, J, 18.5 & 6.0, 10-H_α), 2.15 (3, s, 6-OAc), 2.06 (1, td, J, 12.0 & 5.0, 15-H_a) and 1.85 (1, dm, J, 12.0, 15-H_e).

EXAMPLE 32Preparation of 6-acetylnorcodeine hydrochloride (5-3a)

A solution of 6-acetylcodeine (10.0 g, 29.3 mmol), 1-chloroethyl chloroformate (5.51 g, 37.8 mmol), and proton sponge (1.0 g) in methylene chloride (80 ml) was heated at reflux for 80 min. The reaction mixture was evaporated *in vacuo* to dryness. The residue was chromatographed on silica gel with ethyl acetate to give 6-acetyl-17-(1-chloroethoxycarbonyl)norcodeine as an oil (12.13 g), which was dissolved in methanol with a few drops of conc. HCl. The solution was heated at reflux for 1 hr and evaporated *in vacuo* to almost dryness. The residue was added hexane and filtered to give 6-acetylnorcodeine hydrochloride (10.7 g, 100% yield). IR (KBr)(ν , cm⁻¹): 3540 (NH), 1730 (st, sharp, 6-AcO), 2800-2600 (broad) and 2470 (sharp)(NH•HCl); NMR (δ_H)(DMSO-d₆): 9.69 (2, s (broad), 17-N⁺H₂ Cl⁻), 6.76 (1, d, J, 8.2, 2-H), 6.63 (1, d, J, 8.2, 1-H), 5.65 (1, dd, J, 10.1 & 1.8, 7-H), 5.51 (1, dt, J, 10.1 & 2.0, 8-H), 5.16 (1, dt, J, 6.7 & 2.0, 6-H), 5.09 (1, dd, J, 6.7 & 0.8, 5-H), 4.20 (1, dd, J, 5.8 & 3.2, 9-H), 3.77 (3, s, 3-OCH₃), 3.28-3.14 (1, m, 16-H_e), 3.23 (1, d, J, 18.3, 10-H_β), 3.07 (1, m), 14-H), 2.88 (1, dd, J, 19.2 & 6.3, 10-H_α), 2.73 (1, dd, J, 13.3 & 4.0, 16-H_a), 2.24 (1, td, J, 13.4 & 4.6, 15-H_a), 2.07 (3, s, 6-AcO) and 1.88 (1, dm, J, 13.4, 15-H_e).

EXAMPLE 33Preparation of norcodeine hydrochloride (5-3b)

A solution of 6-acetylcodeine (10.0 g, 29.3 mmol), 1-chloroethyl chloroformate (5.56 g, 38.1 mmol), and proton sponge (1.0 g) in methylene chloride (50 ml) was heated at reflux for 50 min. The reaction mixture was evaporated *in vacuo* to about 30 ml. Methanol (25 ml) and concentrated HCl (2 ml) were added. The solution was heated at reflux for 40 min. and evaporated *in vacuo* to almost dryness. The residue was added hexane and filtered to give norcodeine hydrochloride (8.8 g, 93% yield). IR (KBr), (ν , cm⁻¹): 3540 (NH), 3380 (6-OH), 2800-2600 (broad) and 2480 (sharp) (NH•HCl); NMR (δ_H)(DMSO-d₆): 9.66 (2, s (broad), 17-N⁺H₂ Cl⁻), 6.72 (1, d, J, 8.2, 2-H), 6.57 (1, d, J, 8.2, 1-H), 5.66 (1, dt, J, 9.9 & 3.0, 7-H), 5.28 (1, dt, J, 9.8 & 3.0, 8-H), 5.10 (1, s

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(broad), 6-OH), 4.82 (1, dd, J, 6.1 & 1.2, 5-H), 4.15 (2, m, 6-H & 9-H), 3.77 (3, s, 3-OCH₃), 3.22 (1, d, J, 19.1, 10-H_β), 3.21 (1, td, J, 13.2 & 4.1, 16-H_e), 3.06 (1, m, 14-H), 2.91 (1, dd, J, 18.5 & 6.3, 10-H_α), 2.79 (1, dd, J, 13.0 & 3.9, 16-H_a), 2.22 (1, td, J, 13.4 & 4.9, 15-H_a) and 1.89 (1, dd, J, 13.6 & 2.7, 15-H_e).

EXAMPLE 34Preparation of 17-cyclopropylmethylnorcodeine (5-4)

A mixture of norcodeine hydrochloride (11.48 g, 27.8 mmol), (chloromethyl)-cyclopropane (5.14 g, 55.6 mmol), sodium carbonate (14.73 g, 139.0 mmol), and potassium iodide (4.61 g, 27.8 mmol) in ethanol (250 ml) was heated at reflux for 20 hr, cooled, and evaporated *in vacuo* to dryness. The residue was basified with NH₄OH, and extracted with methylene chloride. The extract was washed with water and evaporated *in vacuo* to dryness. The residue (11.7 g) was chromatographed on silica gel with a eluting solvent system of methanol/ethyl acetate (10/90) to give 17-cyclopropylmethylnorcodeine (10.68 g, 91% yield). IR (KBr)(v, cm⁻¹): 3300 (sharp, 6-OH); NMR (δ_H)(CDCl₃): 6.65 (1, d, J, 8.2, 2-H), 6.523 (1, d, J, 8.2, 1-H), 5.70 (1, dtd, J, 9.9, 1.8 & 1.2, 7-H), 5.29 (1, dt, J, 9.9 & 2.6, 8-H), 4.88 (1, dd, J, 6.6 & 1.2, 5-H), 4.20-4.13 (1, m, 6-H), 3.84 (3, s, 3-OCH₃), 3.66 (1, dd, J, 6.3 & 3.3, 9-H), 2.94 (1, d, J, 18.6, 10-H_β), 2.82 (1, dd, J, 12.1 & 3.9, 16-H_a), 2.70 (1, quintet, J, 2.8, 14-H), 2.44 (2, d, J, 6.3, -N-CH₂-cyclopropyl), 2.44 (1, overlap, 6-OH), 2.37 (1, td, J, 12.1 & 3.9, 16-H_e), 2.30 (1, dd, J, 18.5 & 6.4, 10-H_α), 2.09 (1, td, J, 12.4 & 4.9, 15-H_a), 1.87 (1, dd, J, 12.5 & 1.8, 15-H_e), 0.94-0.80 (1, m, -N-CH₂-CH in cyclopropyl ring), 0.54 (2, AB, CH-CH in cyclopropyl ring) and 0.15 (2, AB, CH-CH in cyclopropyl ring).

EXAMPLE 35Preparation of 17-cyclopropylmethylnorcodeinone (5-5)

To a solution of DMSO (14.50 g, 185.6 mmol) in methylene chloride (80 ml) at -78°C, was added a solution of oxalyl chloride (11.78 g, 92.8 mmol) in methylene chloride (20 ml) in 20 min. After stirring at -78°C for 20 min., a solution of 17-cyclopropylmethylnorcodeine (9.0 g, 26.5 mmol) in methylene chloride (40 ml) was added dropwise in 50 min. The reaction mixture was stirred at -74 to -76°C for 3 hr, added triethylamine (9.39 g, 92.8 mmol), allowed to warm up to rt., added methylene

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chloride (200 ml), washed with water (10 x 50 ml), and evaporated *in vacuo* to dryness. The residue was mixed with hexane and filtered to give 17-cyclopropylmethylnorcodeinone (8.85 g, 99% yield). IR (KBr)(ν , cm^{-1}): 1670 (st, sharp, $-\text{C}=\text{C}-\text{C}=\text{O}$); NMR (δ_{H})(CDCl_3): 6.67 (1, d, J, 8.1, 2-H), 6.65 (1, dt, J, 10.2 & 1.07, 8-H), 6.57 (1, d, J, 8.1, 1-H), 6.07 (1, dt, J, 10.2 & 2.9, 7-H), 4.68 (1, s, 5-H), 3.85 (3, s, 3-OCH₃), 3.69 (1, dd, J, 5.2 & 3.0, 9-H), 3.22 (1, dd, J, 5.2 & 2.6, 14-H), 3.00 (1, d, J, 18.3, 10-H _{β}), 2.85 (1, dm, J, 11.8, 16-H_e), 2.32 (1, dd, J, 18.3 & 5.0, 10-H _{α}), 2.25 (1, td, J, 11.9, 16-H_a), 2.07 (1, td, J, 11.9 & 4.6, 15-H_a), 1.84 (1, dt, J, 12.0 & 2.0, 15-H_e), 2.45 (2, AB, N-CH₂-cyclopropyl), 0.93-0.85 (1, m, N-CH₂-CH in cyclopropyl ring), 0.55 (2, AB, CH-CH in cyclopropyl ring) and 0.15 (2, AB, CH-CH in cyclopropyl ring); MS (EI), m/e (%): 337 (89.9, [M⁺]), 296 (17.4, [M - C₃H₅]⁺) and 55 (100, [CH₂C₃H₅]⁺).

EXAMPLE 36

Preparation of 17-cyclopropylmethylnorcodeinone dienol acetate (5-6)

A mixture of 17-cyclopropylmethylnorcodeinone (3.55 g, 10.5 mmol), acetic anhydride (20 ml, 210.4 mmol), sodium acetate (1.3 g, 15.8 mmol), and toluene (6 ml) was heated at 71 - 73°C for 14 hr. The reaction mixture was cooled, added methylene chloride (250 ml), water (50 ml), and sodium bicarbonate (73.5 g), stirred for 4 hr, and filtered. The organic portion of the filtrate was separated, washed with water (30 ml), dried over anhydrous sodium sulfate, and evaporated *in vacuo* to dryness. The residue (3.94 g) was chromatographed on silica gel with 100% ethyl acetate to give 17-cyclopropylmethylnorcodeinone dienol acetate (2.87 g, 72% yield). IR (KBr)(ν , cm^{-1}): 1750 (st, sharp, $-\text{C}=\text{C}-\text{C}=\text{C}-\text{OAc}$); NMR (δ_{H})(CDCl_3): 6.67 (1, d, J, 8.1, 2-H), 6.58 (1, d, J, 8.1, 1-H), 5.79 (1, dd, J, 6.3 & 0.9, 7-H), 5.55 (1, d, J, 6.3, 8-H), 5.47 (1, s, 5-H), 3.92 (1, d, J, 7.0, 9-H), 3.85 (3, s, 3-OCH₃), 3.26 (1, d, J, 17.9, 10-H _{β}), 2.89-2.82 (2, m, 16-H_e & 16-H_a), 2.75 (1, dd, J, 18.6 & 7.0, 10-H _{α}), 2.49 (2, d, J, 6.4, N-CH₂-cyclopropyl), 2.32 (1, td, 12.0 & 4.5, 15-H_a), 2.20 (3, s, 6-AcO), 1.71 (1, d, J, 12.2, 15-H_e), 0.93-0.86 (1, m, N-CH₂-CH in cyclopropyl ring), 0.55 (2, AB, CH-CH in cyclopropyl ring) and 0.15 (2, AB, CH-CH in cyclopropyl ring); MS (EI), m/e (%): 380 (11.2, [M⁺]), 379 (46.6, [M-H]⁺), 337 (14.4, [M-CH₃CO]⁺), 282 (15.5, [M - CH₃CO -

$\text{CH}_2\text{C}_3\text{H}_5]^+$), 241 (33.2, $[(\text{M}+\text{H}) - \text{CH}_3\text{CO} - \text{CH}_2\text{C}_3\text{H}_5 - \text{NCH}_2\text{CH}_2]^+$), 55 (100, $[\text{CH}_2\text{C}_3\text{H}_5]^+$) and 43 (29.5, $[\text{CH}_3\text{CO}]^+$).

EXAMPLE 37

Preparation of 17-cyclopropylmethyl-14-hydroxynorcodeinone (5-7) from 17-cyclopropylmethylnorcodeinone (5-5) by H_2O_2 in HCOOH

A solution of 17-cyclopropylmethylnorcodeinone (0.20 g, 0.59 mmol), formic acid (90 %, 0.304 g), water (0.504 g), EtOAc (0.27 g), and hydrogen peroxide (30%, 0.17 g) was heated at 42-43° C for 15 hr, added water (20 ml), basified with Na_2CO_3 (1.02 g), and extracted with EtOAc (80 ml & 2 x 20 ml). The combined extract was washed with water, dried over anhydrous sodium sulfate, and evaporated *in vacuo* to dryness to give 17-cyclopropylmethyl-14-hydroxynorcodeinone (0.10 g, 56% yield). The R_f value in TLC and the IR spectrum of the product were comparable to those obtained from an authentic sample.

EXAMPLE 38

Preparation of 17-cyclopropylmethyl-14-hydroxynorcodeinone (5-7) from 17-cyclopropylmethylnorcodeinone dienol acetate (5-6) by H_2O_2 in HCOOH

A solution of 17-cyclopropylmethylnorcodeinone dienol acetate (1.00 g, 2.63 mmol), formic acid (8 ml, 90%), and hydrogen peroxide (0.37 g, 30%, 3.26 mmol) was heated at 44 - 45°C for 6 hr, added water (20 ml) and ethyl acetate (80 ml), basified with sodium bicarbonate. The organic portion was separated, washed with water (15 ml), dried over anhydrous sodium sulfate and evaporated *in vacuo* to dryness. The residue (0.9 g) was chromatographed on silica gel with methanol/methylene chloride (2.5/97.5) to give 17-cyclopropylmethyl-14-hydroxynorcodeinone (0.72 g, 78% yield). IR (KBr)(ν , cm^{-1}): 1680 (st, sharp, $\text{C}=\text{C}-\text{C}=\text{O}$), 3480-3100 (broad, 3335 (sharp), 14-OH); NMR (δ_{H})(CDCl_3): 6.70 (1, d, J, 8.2, 2-H), 6.62 (1, dd, J, 10.1 & 0.5, 8-H), 6.59 (1, dd, J, 8.2 & 0.9, 1-H), 6.18 (1, dd, J, 10.1 & 0.5, 7-H), 4.70 (2, m, 5-H & 14-OH), 3.84 (3, s, 3-OCH₃), 3.35 (1, d, J, 6.1, 9-H), 3.14 (1, d, J, 18.6, 10-H _{β}), 2.75 (1, ddd, J, 13.7, 4.3 & 1.4, 16-H_e), 2.55 (1, dd, J, 19.4 & 6.0, 10-H _{α}), 2.45 (2, d, J, 6.6, -N-CH₂-cyclopropyl), 2.38 (1, td, J, 13.8 & 4.3, 16-H_a), 2.26 (1, td, J, 12.1 & 3.7, 15-H_a), 1.70

(1, dd, J, 13.9 & 2.7, 15-H_a), 0.97-0.80 (1, m, N-CH₂-CH in cyclopropyl ring), 0.58 (2, AB, CH-CH in cyclopropyl ring) and 0.17 (2, AB, CH-CH in cyclopropyl ring).

EXAMPLE 39

Preparation of 17-cyclopropylmethyl-14-hydroxynorcodeinone (5-7) from 17-cyclopropylmethylnorcodeinone dienol acetate (5-6) by MCPBA

A solution of 17-cyclopropylmethylnorcodeinone dienol acetate (0.5 g, 1.31 mmol), 3-chloroperbenzoic acid (0.36 g, 2.10 mmol) and oxalic acid (0.27 g, 2.90 mmol) in acetic acid (7 ml) was stirred at rt. overnight, added cold water (35 ml), basified with sodium carbonate, and extracted with methylene chloride (100 ml). The extract was washed with water (2 x 30 ml), dried over anhydrous sodium sulfate, and evaporated *in vacuo* to dryness. The residue (0.41 g) was chromatographed on silica gel to give 17-cyclopropylmethyl-14-hydroxynorcodeinone (0.34 g, 74% yield). The R_f value in TLC and the IR spectrum of the product were comparable to those obtained from an authentic sample.

EXAMPLE 40

Preparation of 3-methylnaltrexone (5-8)

A mixture of 17-cyclopropylmethyl-14-hydroxynorcodeinone (0.30 g, 0.85 mmol) and Pd/C (5%, 0.45g) in ethanol (35 ml) was hydrogenated in a Parr hydrogenator at rt. under 28 psi of hydrogen gas. The mixture was filtered. The filtrate was evaporated *in vacuo* to dryness to give 3-methylnaltrexone (0.30 g, 99% yield). IR (KBr)(ν , cm⁻¹): 1720 (st, sharp, C=O), 3380-3340 (broad, 14-OH); NMR (δ _H)(CDCl₃): 6.70 (1, d, J, 8.2, 2-H), 6.60 (1, d, J, 8.1, 1-H), 4.65 (1, s, 5-H), 3.91 (3, s, 3-OCH₃), 3.17 (1, d, J, 6.0, 9-H), 3.06 (1, d, J, 18.2, 10-H _{β}), 3.03 (1, td, J, 14.4 & 5.2, 7-H_a), 2.70 (1, dd, J, 11.7 & 4.5, 16-H_a), 2.58 (1, dd, J, 18.4 & 6.0, 10-H _{α}), 2.41 (2, d, J, 6.6, -N-CH₂-cyclopropyl), 2.41 (2, overlap, 14-OH & 16-H_a), 2.29 (1, dt, J, 14.5 & 3.1, 7-H_a), 2.12 (1, td, J, 11.9 & 3.5, 15-H_a), 1.88 (1, ddd, J, 13.3, 5.2 & 3.1, 8-H_a), 1.67 (1, dd, J, 14.5 & 3.4, 8-H_a), 1.58 (1, dt, J, 12.8 & 5.1, 15-H_a), 0.91-0.81 (1, m, -N-CH₂-CH in cyclopropyl ring), 0.56 (2, AB, CH-CH in cyclopropyl ring) and 0.15 (2, AB, CH-CH in cyclopropyl ring).

EXAMPLE 41Preparation of naltrexone from 3-methylnaltrexone (5-9)

A solution of 3-methylnaltrexone (0.48 g, 1.35 mmol) in methylene chloride (30 ml) was cooled with an ice-water bath, and then added a solution of boron tribromide (5.4 ml, 1 M solution in methylene chloride, 5.4 mmol). The reaction mixture was stirred at rt. for 15 hr, basified with NH_4OH , and extracted with methylene chloride (60 ml). The extract was washed with water (2 x 15 ml), dried over anhydrous sodium sulfate, and evaporated *in vacuo* to dryness to give naltrexone (0.45 g, 98% yield). IR (KBr)(ν , cm^{-1}): 1725 (st, sharp, C=O), 3620-3040 (broad, 3-OH & 14-OH); NMR (δ_{H})(CDCl_3): 6.72 (1, d, J, 8.2, 2-H), 6.57 (1, d, J, 8.2, 1-H), 5.18 (2, s (broad), 3-OH & 14-OH), 4.69 (1, s, 5-H), 3.18 (1, d, J, 5.8, 9-H), 3.05 (1, d, J, 18.5, 10- H_β), 3.05 (1, td, J, 14.3 & 5.3, 7- H_a), 2.71 (1, dd, J, 11.4 & 4.3, 16- H_e), 2.56 (1, dd, J, 18.8 & 5.9, 10- H_α), 2.41 (2, d, J, 6.6, -N- CH_2 -cyclopropyl), 2.41 (1, overlap, 16- H_a), 2.30 (1, dt, J, 14.7 & 3.1, 7- H_e), 2.18 (1, td, J, 12.1 & 3.7, 15- H_a), 1.90 (1, dd, J, 13.3 & 4.0, 8- H_e), 1.63 (1, dd, J, 14.4 & 3.2, 8- H_a), 1.57 (1, dm, J, 9.9, 15- H_e), 0.91-0.81 (1, m, N- CH_2 -CH in cyclopropyl ring), 0.55 (2, AB, AB, CH-CH in cyclopropyl ring) and 0.15 (2, AB, CH-CH in cyclopropyl ring).

F. Synthesis of Naltrexone From Morphine Through 3-Benzyl-17-**Cyclopropylmethylnormorphinone**

6-1 (see 3-1 & 4-1)

6-2 (see 4-2)

EXAMPLE 42Preparation of 3-benzyl-17-cyclopropylmethylnormorphine (6-4) from 6-acetyl-3-benzylmorphine (6-2)

A solution of 6-acetyl-3-benzylmorphine (13.17 g, 31.5 mmol), 1,8-bis-(dimethylamino)naphthalene (proton sponge, 1.34 g, 6.25 mmol), and 1-chloroethyl chloroformate (ACE-Cl, 7.03 g, 98% pure, 48.2 mmol) in $\text{ClCH}_2\text{CH}_2\text{Cl}$ was heated at reflux for 1.5 hrs. To this reaction mixture, was added MeOH (100 ml) and conc. HCl (8 drops). The reflux was continued for another 3 hr. The mixture was cooled and evaporated to dryness *in vacuo* to give 3-benzylnormorphine hydrochloride as white

flakes (15.05 g). IR (KBr)(ν , cm^{-1}): 3550 (m, sharp), 3400 (m, b), 2475 (s, sharp); NMR (δ_{H})(DMSO- d_6): 10.35-9.62 (2 b, $^+\text{NH}_2\text{Cl}^-$), 7.49-7.21 (5, m, $-\text{C}_6\text{H}_5$), 6.74 (1, d, J, 8.2, 2-H), 6.54 (1, d, J, 8.2, 1-H), 5.77 (1, dm, J, 9.8, 7-H), 5.23 (1, dm, J, 10.2, 8-H), 5.13 (2, AB, OCH_2Ph), 4.89 (1, dd, J, 6.4 & 1.1, 5-H), 4.41 (d, J, 6.6, 9-H), 4.28-4.09 (2, m, 6-H & OH), 3.4-2.8 (2, m, 10- H_β & 10- H_α), 3.4-2.8 (1, m, 14-H), 3.4-2.8 (2, m, 16- H_a & 16- H_e), 2.39 (1, td, J, 13.3 & 5.1, 15- H_a), 2.02 (1, dm, J, 10.6, 15- H_e).

A suspension of 3-benzylmorphine (31.5 mmol, crude), chloromethylcyclopropane (5.81 g, 64.2 mmol), and Na_2CO_3 (20.54 g, 194 mmol) in 2-propanol (150 ml) was heated at reflux for a day. The solvent was evaporated off *in vacuo*. The residue was added water and extracted with CH_2Cl_2 (250 ml). The extract was dried over anhydrous Na_2SO_4 and evaporated *in vacuo* to dryness to give a crude product (16.08 g), which was chromatographed on silica gel (column: d = 6 cm, l = 13.5 cm; eluting solvent: 4% MeOH in CH_2Cl_2) to give 3-benzyl-17-cyclopropylmethylnormorphine (13 g, 100%). IR (KBr)(ν , cm^{-1}): 3440 (m, b, -OH); NMR (δ_{H})(CDCl_3): 7.56-7.10 (5, m, $-\text{C}_6\text{H}_5$), 6.69 (1, d, J, 8.1, 2-H), 6.48 (1, d, J, 8.2, 1-H), 5.64 (1, dm, J, 9.9, 7-H), 5.28 (1, dm, J, 9.8, 8-H), 5.11 (2, AB, OCH_2Ph), 4.85 (1, dd, J, 6.5 & 1.3, 5-H), 4.23-4.02 (1, m, 6-H), 3.64 (1, dd, J, 6.4 & 3.2, 9-H), 2.91 (1, d, J, 18.4, 10- H_β), 2.73 (1, dm, J, 11.8, 16- H_e), 2.72-2.55 (1, m, 14-H), 2.72-2.55 (1, m, -OH), 2.48-2.20 (1, m, 16- H_a), 2.42 (2, d, J, 6.4, N- CH_2 -cyclopropyl), 2.27 (1, dd, J, 18.6 & 6.2, 10- H_α), 2.07 (1, td, J, 12.2 & 5.1, 15- H_a), 1.84 (1, dm, J, 13.0, 15- H_e), 1.0-0.7 (1, m, m, N- CH_2 -CH in cyclopropyl ring), 0.53 (2, AB, CH-CH in cyclopropyl ring), 0.14 (2, AB, CH-CH in cyclopropyl ring).

EXAMPLE 43

Preparation of 3-benzyl-17-cyclopropylmethylnormorphinone (6-5)

To a solution of DMSO (5.88 g, 75.3 mmol) in CH_2Cl_2 (80 ml) at -78°C was added a solution of oxalyl chloride (4.51 g, 35.5 mmol) in CH_2Cl_2 (10 ml) in 10 min. This solution was allowed to stir at -78°C for 20 min. then was added a solution of 3-benzyl-17-cyclopropylmethylnormorphine (7.06g, 17.0 mmol) in CH_2Cl_2 (30 ml) in 30 min. The resulting solution was allowed to stir at -78°C for 3 hr. Et_3N (20 ml, 148 mmol) was added. The mixture was allowed to warm up to rt., washed with water (5 x 80 ml), dried

over anhydrous Na_2SO_4 , and evaporated *in vacuo* to dryness to give a reddish oil (7.98 g), which was chromatographed on silica gel (column: d = 5 cm, l = 19 cm; eluting solvent: 5% MeOH in EtOAc) to give 3-benzyl-17-cyclopropylmethylnormorphinone (5.56 g, 79% yield). IR (KBr)(ν , cm^{-1}): 1670 (s, sharp, $\text{C}=\text{C}-\text{C}=\text{O}$); NMR (δ_{H})(CDCl_3): 7.52-7.18 (5, m, $-\text{C}_6\text{H}_5$), 6.69 (1, d, J, 8.2, 2-H), 6.64 (1, dd, J, 10.5 & 2.2, 8-H), 6.52 (1, d, J, 8.2, 1-H), 6.07 (1, dd, J, 10.2 & 3.1, 7-H), 5.17 (2, s, OCH_2Ph), 4.70 (1, s, 5-H), 3.68 (1, dd, J, 5.4 & 2.9, 9-H), 3.29-3.16 (1, m, 14-H), 2.98 (1, d, J, 18.3, 10- H_β), 2.83 (1, dm, J, 10.7, 16- H_e), 2.6-2.3 (1, m, 10- H_α), 2.41 (2, AB, N- CH_2 -cyclopropyl), 2.24 (1, td, J, 11.7 & 3.2, 16- H_a), 2.07 (1, td, J, 11.6 & 4.8, 15- H_a), 1.84 (1, dm, J, 13.0, 15- H_e), 1.0-0.78 (1, m, N- CH_2 - CH in cyclopropyl ring), 0.55 (2, AB, $\text{CH}-\text{CH}$ in cyclopropyl ring), 0.15 (2, AB, $\text{CH}-\text{CH}$ in cyclopropyl ring); MS (EI), m/e (%): 413 (M^+ , 8), 322 (28, $[\text{M}-\text{CH}_2\text{Ph}]^+$), 91 (68, $[\text{CH}_2\text{Ph}]^+$), 55 (100, $[\text{CH}_2\text{C}_3\text{H}_5]^+$).

EXAMPLE 44

Preparation of 3-benzyl-17-cyclopropylmethylnormorphinone dienol acetate (6-6)

A mixture of 3-benzyl-17-cyclopropylmethylnormorphinone (4.34 g, 10.5 mmol), NaOAc (1.92 g, 23.4 mmol), Ac_2O (44.14 g, 432.4 mmol) in toluene (10 ml) was heated at 100°C for 20 hr., cooled, basified with aqueous NaHCO_3 , and extracted with CH_2Cl_2 (300 ml). The extract was washed with water (3X150 ml), dried over anhydrous Na_2SO_4 , and evaporated *in vacuo* to dryness to give an oil (5.57 g), which was chromatographed on silica gel (column: d = 5 cm, l = 19.5 cm; eluting solvent: EtOAc) to obtain 3-benzyl-17-cyclopropylmethylnormorphinone dienol acetate (3.0 g, 63% yield). IR (KBr)(ν , cm^{-1}): 1760 (s, sharp, $\text{C}=\text{C}-\text{C}=\text{C}-\text{OAc}$); NMR (δ_{H})(CDCl_3): 7.51-7.20 (5, m, C_6H_5), 6.68 (1, d, J, 8.1, 2-H), 6.52 (1, d, J, 8.3, 1-H), 5.77 (1, dd, J, 6.3 & 0.9, 7-H), 5.55 (1, d, J, 6.3, 8-H), 5.48 (1, s, 5-H), 5.14 (2, s, OCH_2Ph), 3.92 (1, d, J, 7.0, 9-H), 3.25 (1, d, J, 17.9, 10- H_β), 2.95-2.80 (2, m, 16- H_a & 16- H_e), 2.74 (1, dd, J, 18.5 & 7.3, 10- H_α), 2.49 (2, s, N- CH_2 -cyclopropyl), 2.29 (1, td, J, 12.4 & 6.5, 15- H_a), 2.19 (3, s, m, $\text{C}=\text{C}-\text{C}=\text{C}-\text{OAc}$), 1.72 (1, dm, J, 12.4, 15- H_e), 1.0-0.8 (1, m, CH_2 - CH in cyclopropyl ring), 0.55 (2, AB, $\text{CH}-\text{CH}$ in cyclopropyl ring), 0.15 (2, AB, $\text{CH}-\text{CH}$ in cyclopropyl ring); MS (EI), m/e (%): 455 (M^+ , 16), 364 (27, $[\text{M}-\text{CH}_2\text{Ph}]^+$), 322 (28, $[\text{M}-\text{CH}_2\text{Ph}-\text{CH}_2=\text{C}=\text{O}]^+$), 91 (68, $[\text{CH}_2\text{Ph}]^+$), 55 (100, $[\text{CH}_2\text{C}_3\text{H}_5]^+$).

EXAMPLE 45

Preparation of 3-benzyl-17-cyclopropylmethyl-14-hydroxynormorphinone (6-7) from 3-benzyl-17-cyclopropylmethyl-14-hydroxynormorphinone dienol acetate (6-6) by MCPBA

A solution of 3-benzyl-17-cyclopropylmethylnormorphinone dienol acetate (0.61 g, 1.34 mmol), oxalic acid (0.25 g, 2.8 mmol), and 3-chloroperbenzoic acid (0.36 g, 57-86%, 1.2-1.8 mmol) in AcOH (5.44 g, 88.9 mmol) was stirred at rt. for 5 hr, basified with cold aqueous NaHCO₃, extracted with CH₂Cl₂ (120 ml). The extract was dried over anhydrous Na₂SO₄ and evaporated *in vacuo* to dryness to give an oily residue (0.93 g), which was chromatographed on silica gel (column: d = 2.54 cm, l = 23 cm; eluting solvent: 1% MeOH in CH₂Cl₂) to obtain 3-benzyl-17-cyclopropylmethyl-14-hydroxynormorphinone (0.46 g, 80% yield). The R_f value in TLC and the IR spectrum of the product were comparable to those obtained from an authentic sample.

EXAMPLE 46

Preparation of 3-benzyl-17-cyclopropylmethyl-14-hydroxynormorphinone (6-7) from 3-benzyl-17-cyclopropylmethyl-14-hydroxymorphinone dienol acetate (6-6) by H₂O₂ in HCOOH

A solution of 3-benzyl-17-cyclopropylmethylnormorphinone dienol acetate (0.91 g, 2.0 mmol), formic acid (6.02 g, 90%, 117.7 mmol), and H₂O₂ (0.28 g, 30%, 2.47 mmol) was heated at 35-46° C. for 3 hr., basified with cold aqueous NaHCO₃, extracted with CH₂Cl₂ (200 ml). The extract was washed with water (50 ml), dried over anhydrous Na₂SO₄ and evaporated *in vacuo* to dryness to give an oily residue (1.15 g), which was chromatographed on silica gel (column: d = 2.54 cm, l = 19 cm; eluting solvent: 3% MeOH in CH₂Cl₂) to obtain 3-benzyl-17-cyclopropylmethyl-14-hydroxynormorphinone (0.75 g, 87% yield). IR (KBr)(v, cm⁻¹): 3300 (m, OH), 1680 (s, sharp, C=C-C=O); NMR (δ_H)(CDCl₃): 7.43-7.19 (5, m, C₆H₅), 6.71 (1, d, J, 8.1, 2-H), 6.62 (1, d, J, 9.8, 8-H), 6.53 (1, d, J, 8.2, 1-H), 6.18 (1, d, J, 10.1, 7-H), 5.16 (2, s, OCH₂Ph), 4.73 (1, s, 5-H), 3.34 (1, d, J, 6.1, 9-H), 3.12 (1, d, J, 18.6, 10-H_β), 2.74 (1, dm, J, 11.1, 16-H_e), 2.53 (1, dd, J, 19.2 & 6.0, 10-H_α), 2.55-2.35 (1, b, -OH), 2.55-2.35 (1, m, 15-H_a), 2.44 (2, d, J, 6.4, N-CH₂-cyclopropyl), 2.25 (1, td, J, 11.8 & 3.4, 16-H_a), 1.69 (1, dm, J, 13.0, 15-H_e), 0.98-0.78 (1, m, CH₂-CH in cyclopropyl ring), 0.58 (2, AB, CH-CH in cyclopropyl ring), 0.16

(2, AB, CH-CH in cyclopropyl ring); MS (EI), m/e (%): 429 (M^+ , 32), 338 (75, $[M-CH_2Ph]^+$), 91 (100, $[CH_2Ph]^+$), 55 (97, $[CH_2C_3H_5]^+$).

EXAMPLE 47

Preparation of naltrexone (6-8) from 3-benzyl-17-cyclopropylmethyl-14-hydroxynormorphinone (6-7)

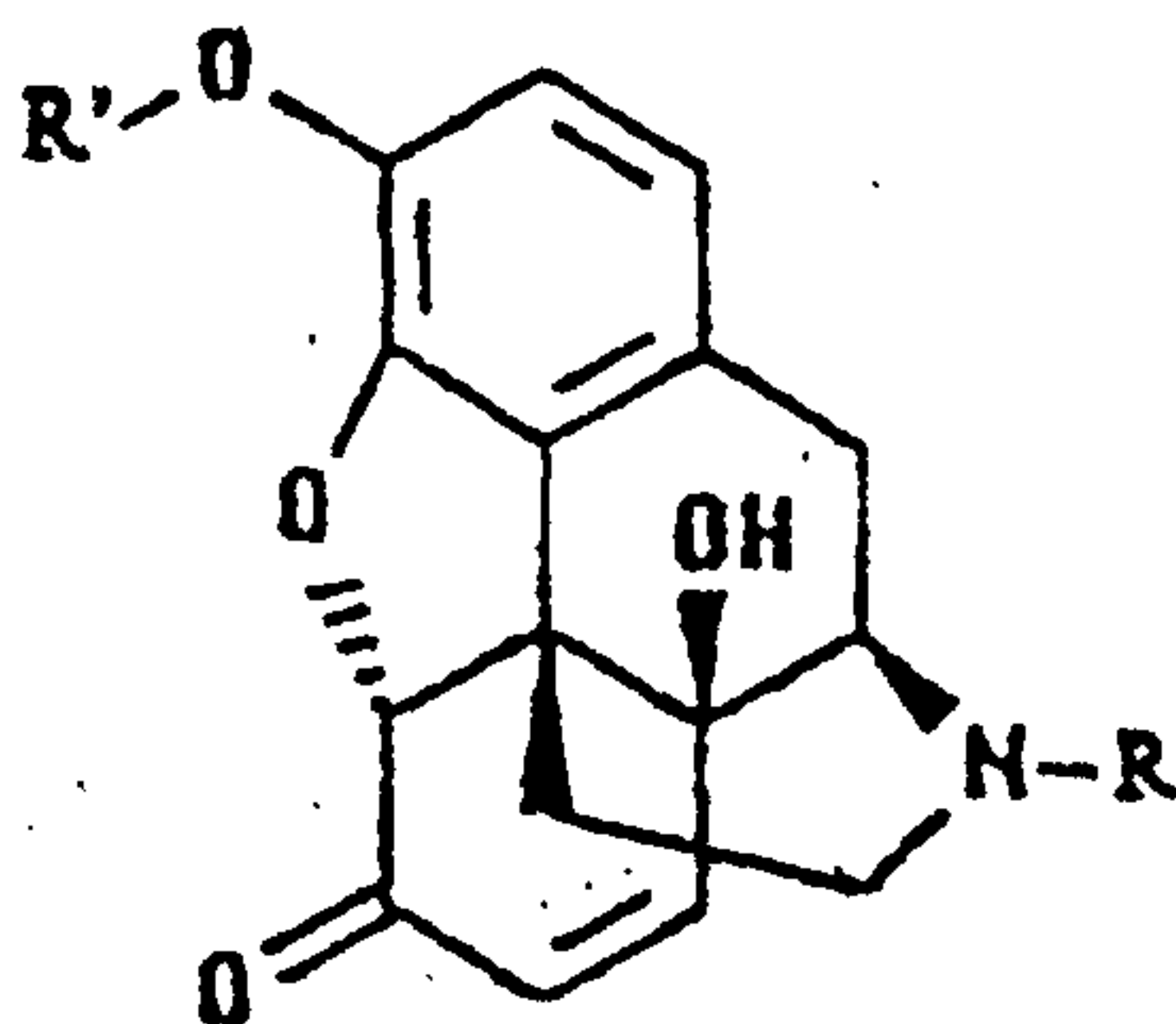
A mixture of 3-benzyl-17-cyclopropylmethyl-14-hydroxynormorphinone (0.40 g, 0.93 mmol) and 5% Pd/C (0.25 g) in 2-propanol (60 ml) was hydrogenated under 30 psi at rt. overnight, filtered through celite^{*}, and evaporated to dryness to give naltrexone (0.32 g, 100% yield). The R_f value in TLC and the IR spectrum of the product were comparable to those obtained from an authentic sample.

Although the invention has been illustrated by the preceding examples, they are not to be construed as being limited to the materials employed therein, but rather the invention is directed to the generic as hereinbefore disclosed. Various modifications and embodiments can be made without departing from the spirit or scope thereof.

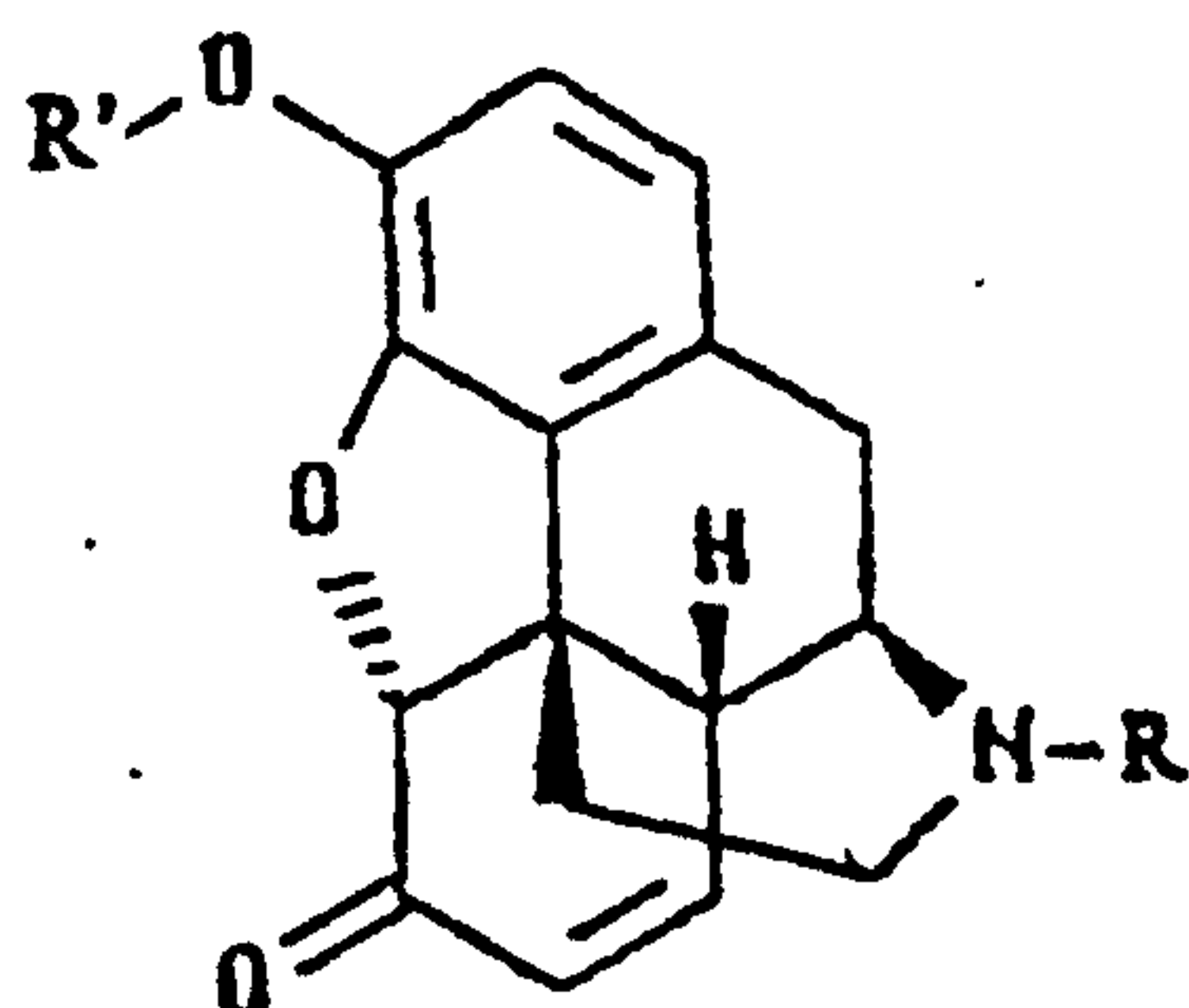
* Trademark

What is claimed is:

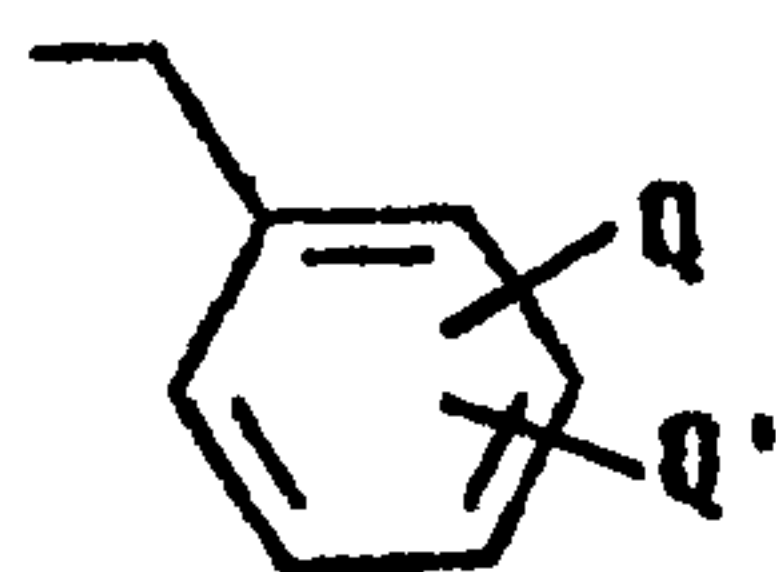
1. A process of preparing 14-hydroxynormorphinones having the formula:



which comprises forming reactants by reacting normorphinone having the formula:



wherein R is selected from the group consisting of lower alkyl of 1 to 7 carbon atoms, cycloalkyl-lower alkyl with 3-6 ring carbon atoms, benzyl and a substituted-benzyl having the formula:



wherein Q and Q' are individually selected from the group consisting of hydrogen, lower alkyl, trifluoromethyl, nitro, dialkylamino and cyano;

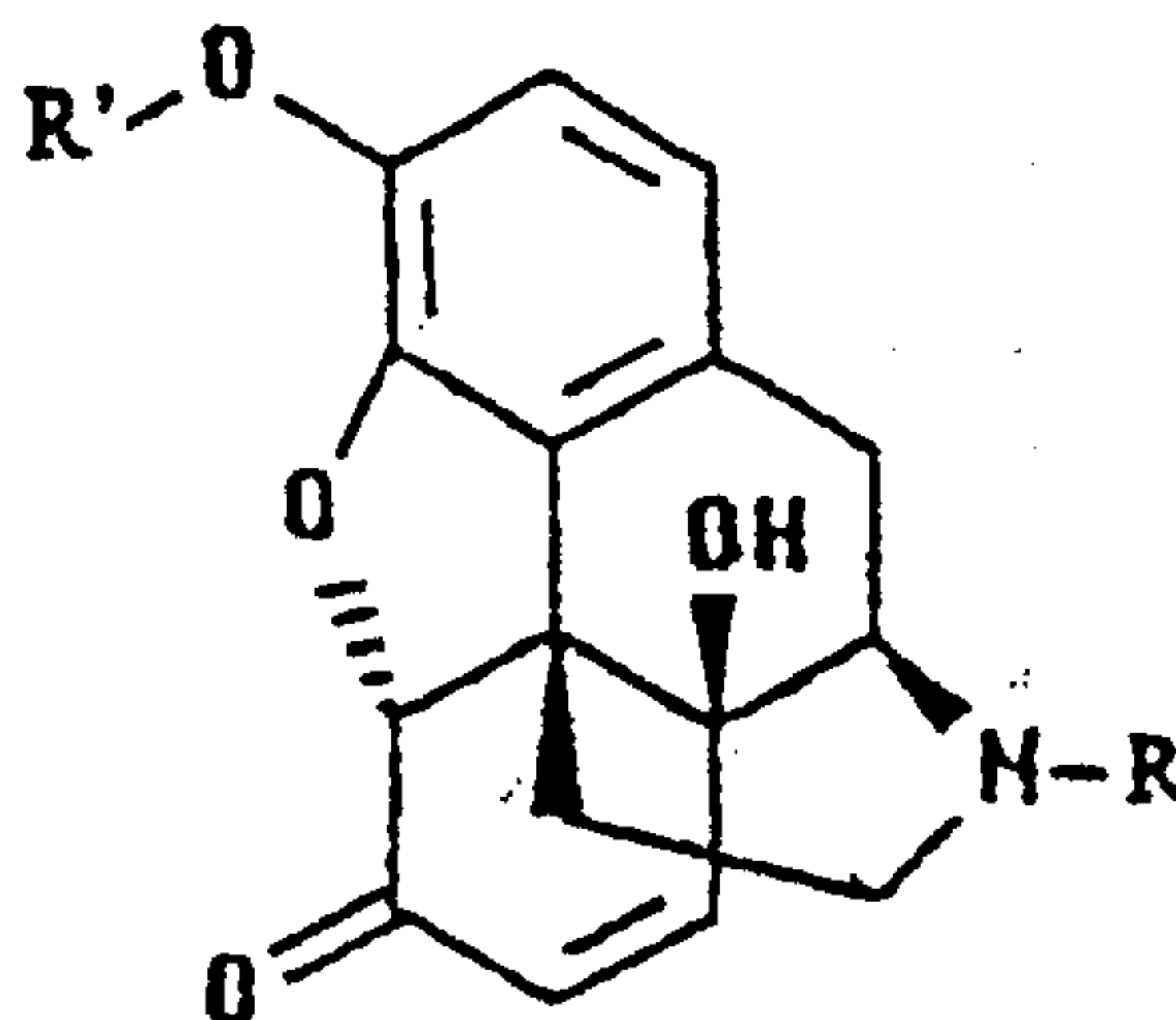
R' is selected from the group consisting of R, 2-(4-morpholinyl)ethyl, benzyloxy carbonyl and R''C(O)- wherein R'' is lower alkyl of 1-4 carbon atoms;

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with hydrogen peroxide as an oxidizing agent at a temperature of from about 15°C to about 70°C in the presence of an acid and an aqueous solvent system to solubilize the reactants for a period of 1 to 24 hours so as to form the 14-hydroxynormorphinones.

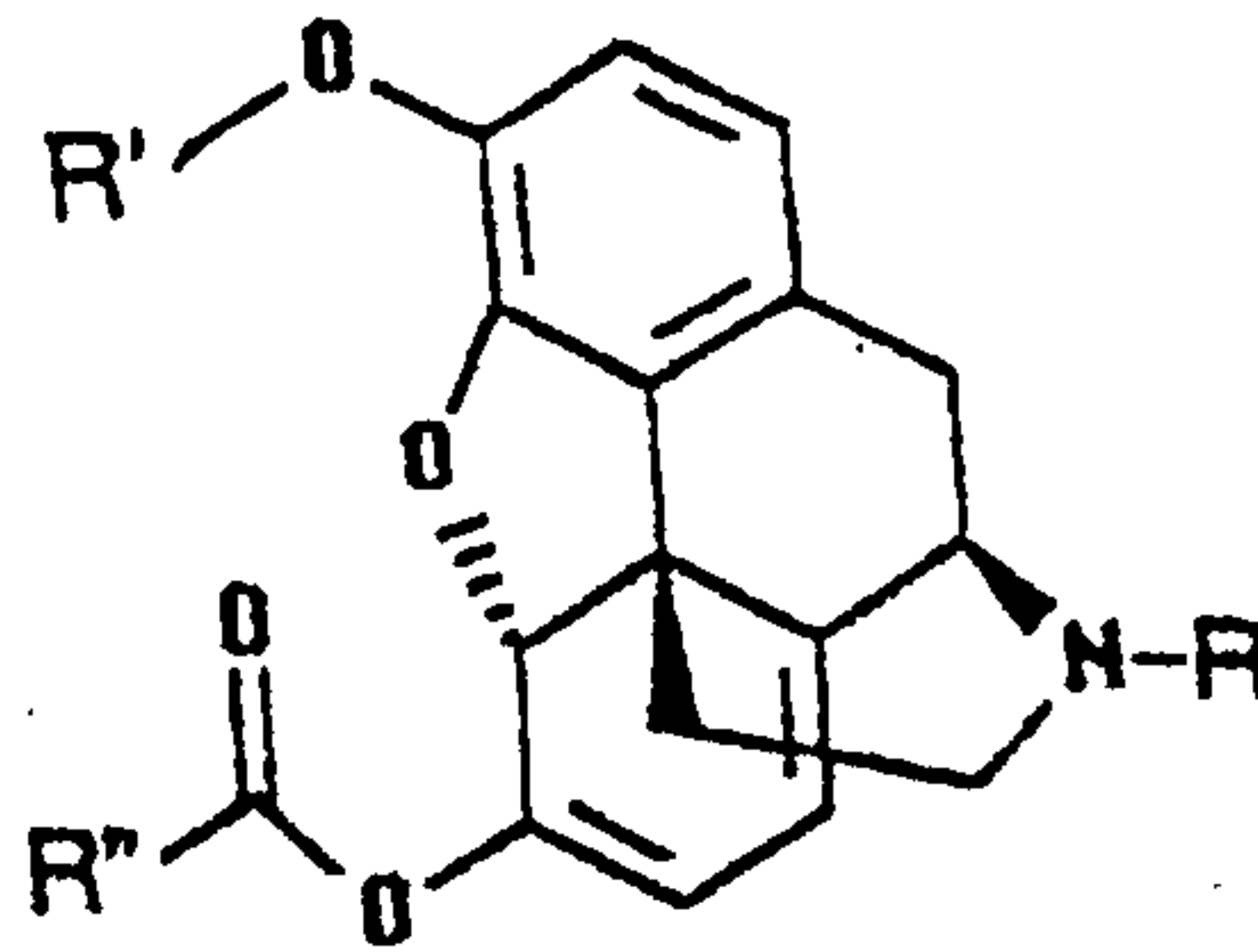
2. The process of Claim 1 wherein the acid is formic acid.
3. The process of Claim 1 wherein the solvent system is water.
4. The process of Claim 1 wherein the solvent system is water and ethyl acetate.
5. The process of Claim 1 wherein the temperature is from about 40°C to about 50°C, the acid is concentrated formic acid and the solvent is water.
6. The process of Claim 1 wherein R and R' are individually methyl.
7. The Process of Claim 1 wherein R is methyl and R' is benzyl.
8. The process of Claim 1 wherein R and R' are individually benzyl.
9. The process of Claim 1 wherein R is cyclopropylmethyl and R' is benzyl.
10. A process for preparing 14-hydroxynormorphinones having the formula:



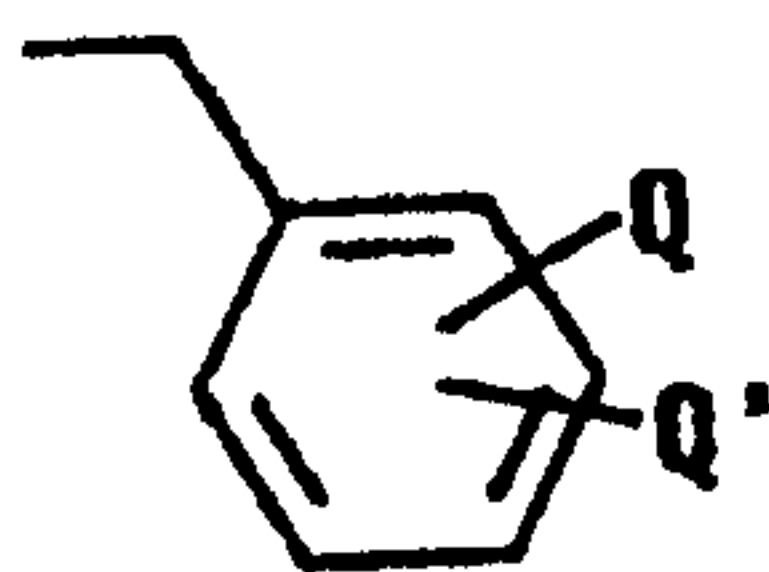
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which comprises forming reactants by reacting normorphinone dienol acylates having the formula:



wherein R is selected from the group consisting of lower alkyl of 1-7 carbon atoms, cycloalkylmethyl with 3-6 ring carbon atoms, and substituted and unsubstituted benzyl having the formula:



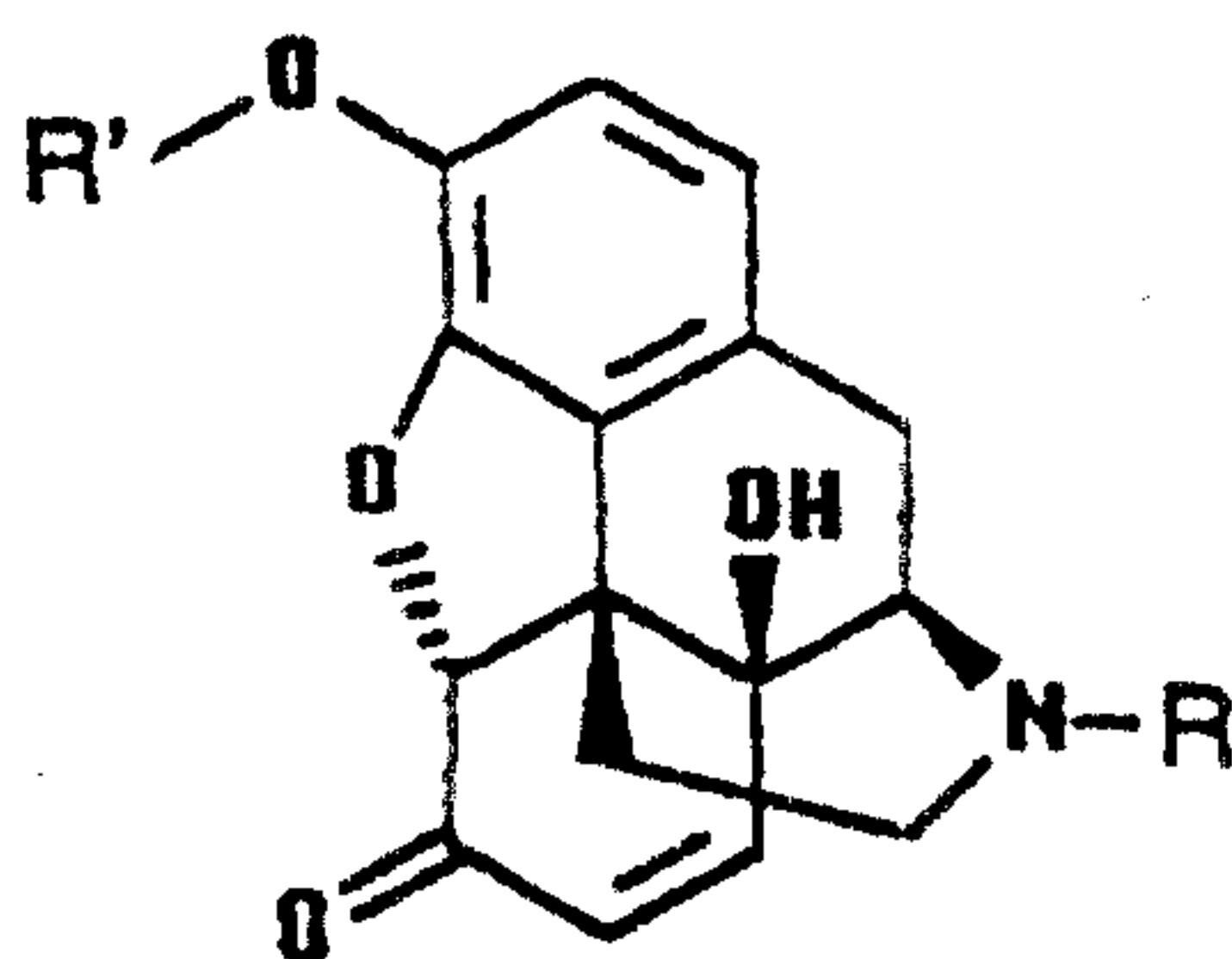
wherein Q and Q' are individually selected from the group consisting of hydrogen, lower alkyl, trifluoromethyl, nitro, dialkylamino and cyano;

R' is selected from the group consisting of R, 2-(4-morpholinyl)ethyl, R''C(O)-, and benzyloxycarbonyl, wherein R'' is lower alkyl of 1-4 carbon atoms; with an oxidizing agent at a temperature of from about 15°C to about 70°C in the presence of a weak acid and an aqueous solvent to solubilize the reactants for a period of 1 to 24 hours so as to form the 14-hydroxynormorphinones.

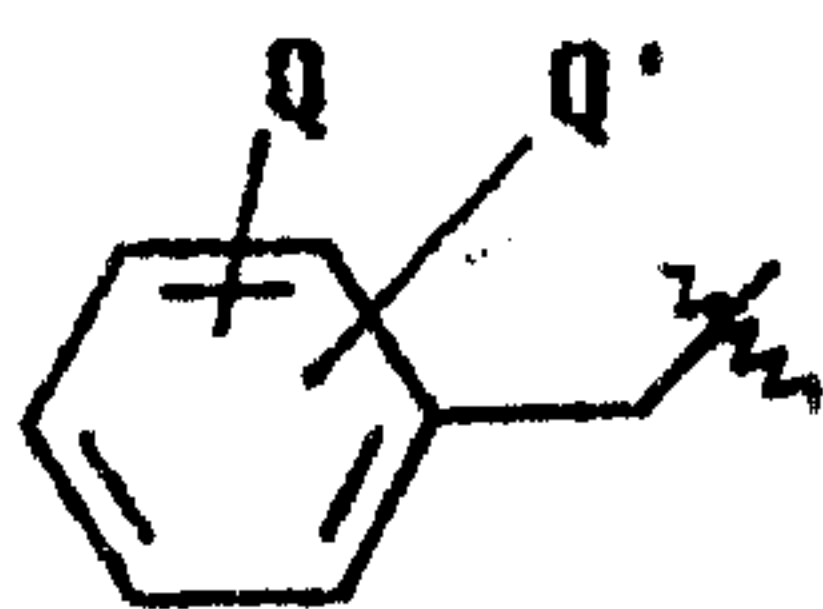
11. The process of Claim 10 wherein the oxidizing agent is hydrogen peroxide, the temperature is from about 40°C to about 50°C, the acid is concentrated formic acid and the solvent is water.

12. The process of Claim 10 wherein the oxidizing agent is meta-chloroperoxybenzoic acid, the temperature is from about 15°C to about 30°C, the acid is formic acid and the aqueous solvent system is one that solubilizes the reactants.

13. The process of Claim 10 wherein the oxidizing agent is meta-chloroperbenzoic acid, the temperature is from about 15°C to about 30°C, the acid is acetic acid and the aqueous solvent system is one that solubilizes the reactants.
14. A compound having the formula:



wherein R is selected from the group consisting of lower alkyl of 1-7 carbon atoms, cycloalkyl-lower alkyl with 3-6 ring carbon atoms and substituted and unsubstituted benzyl having the formula:



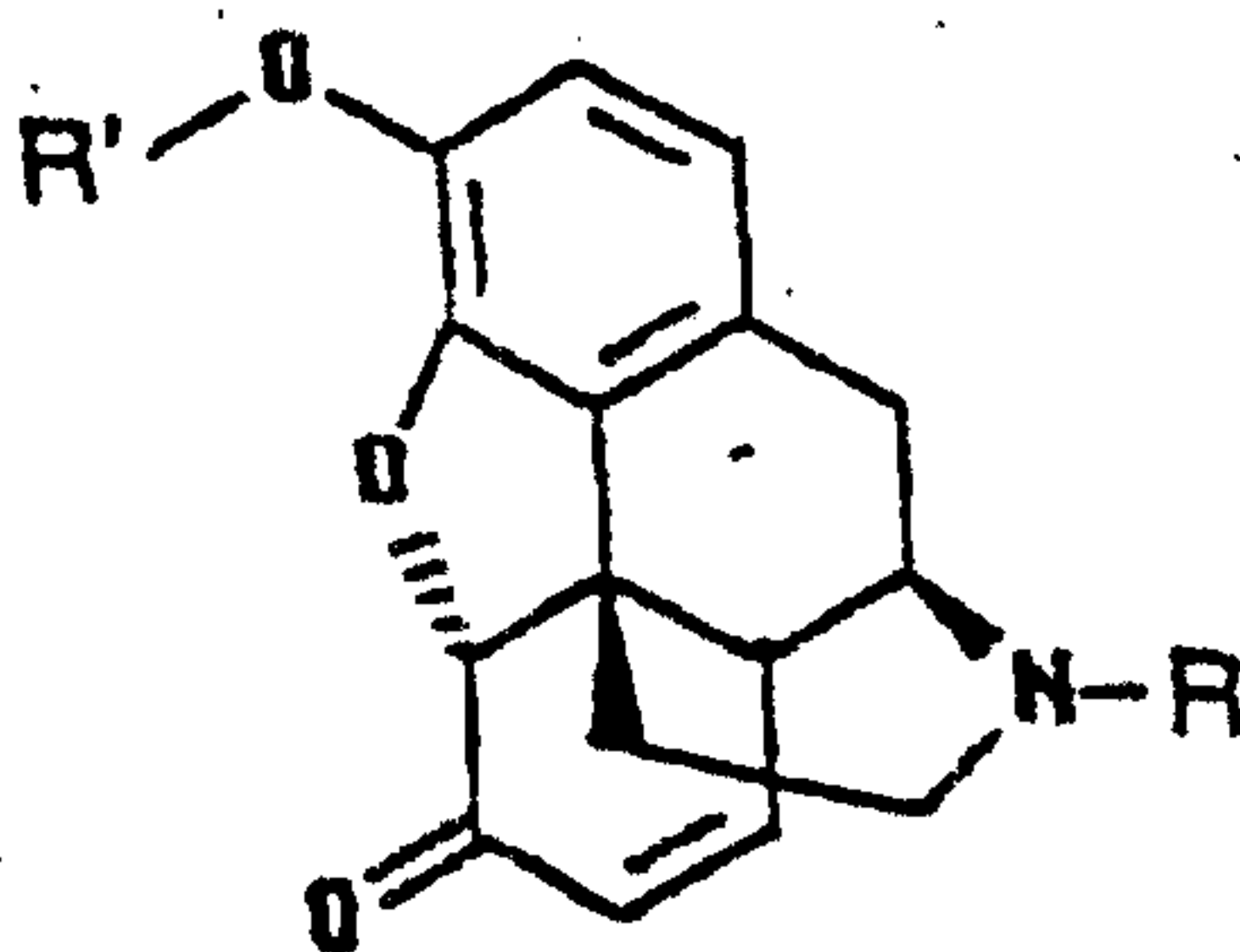
wherein Q and Q' are individually selected from the group consisting of hydrogen, lower alkyl, trifluoromethyl, nitro, dialkylamino and cyano;

R' is selected from the group consisting of R, 2-(4-morpholinyl)ethyl, benzyloxycarbonyl and the group having the formula:



wherein R'' is lower alkyl of 1-4 carbon atoms.

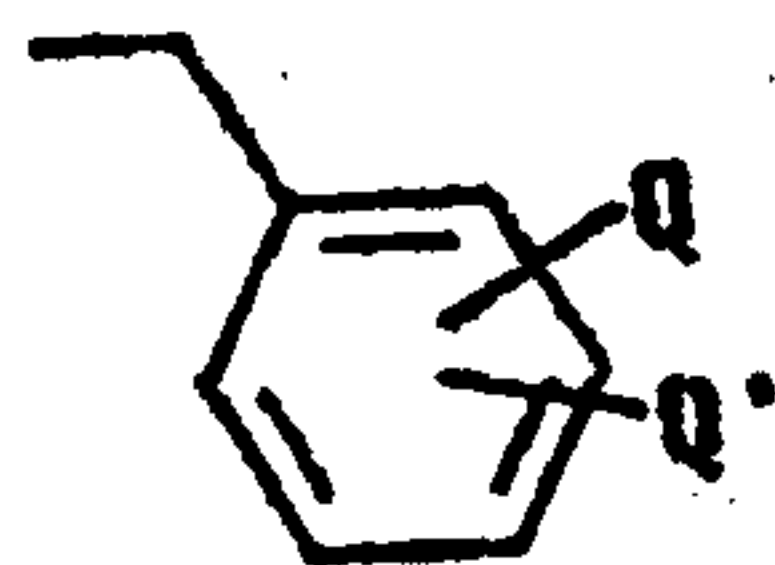
15. A compound having the formula:



wherein R' is selected from the group consisting of substituted and unsubstituted benzyl having the formula:

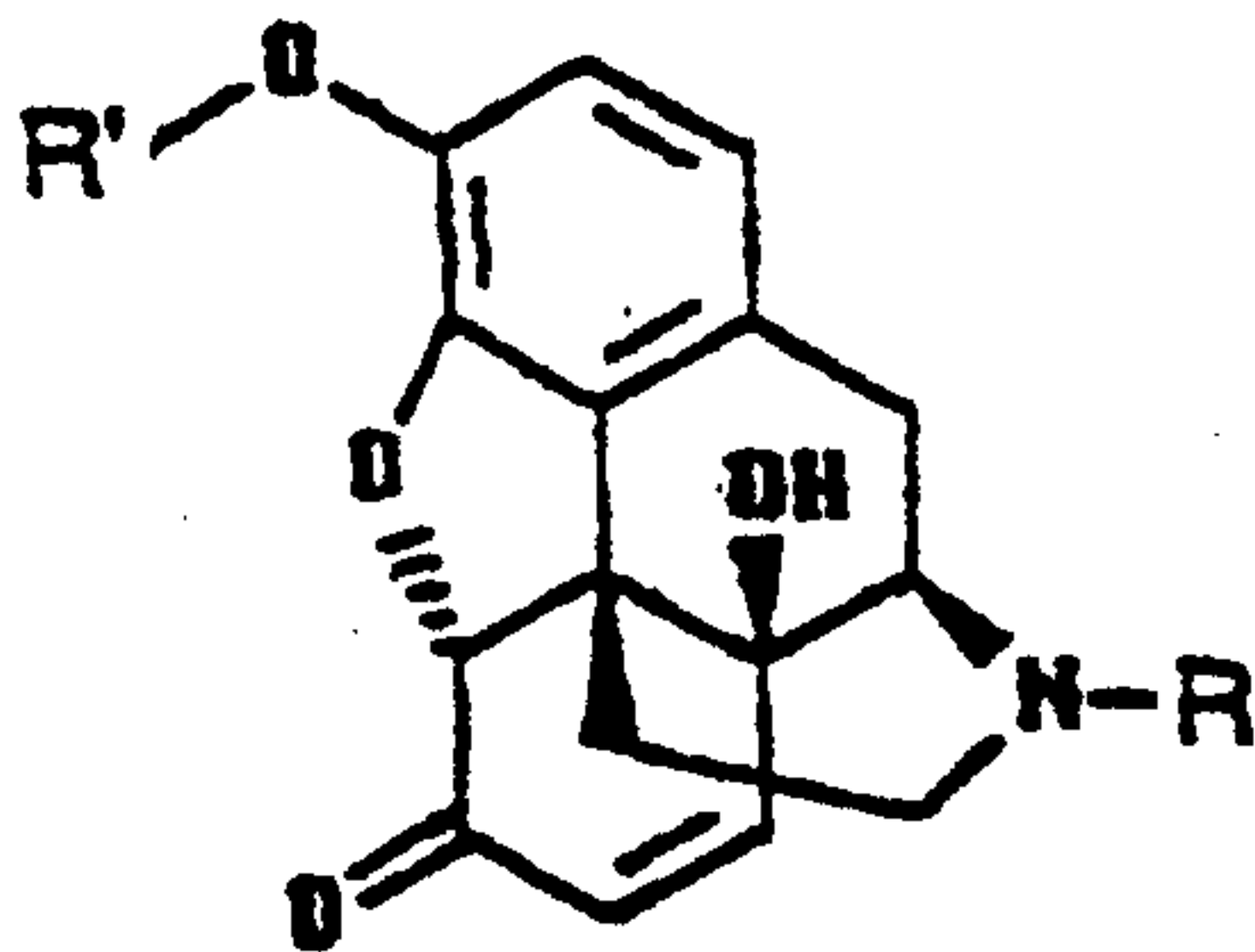
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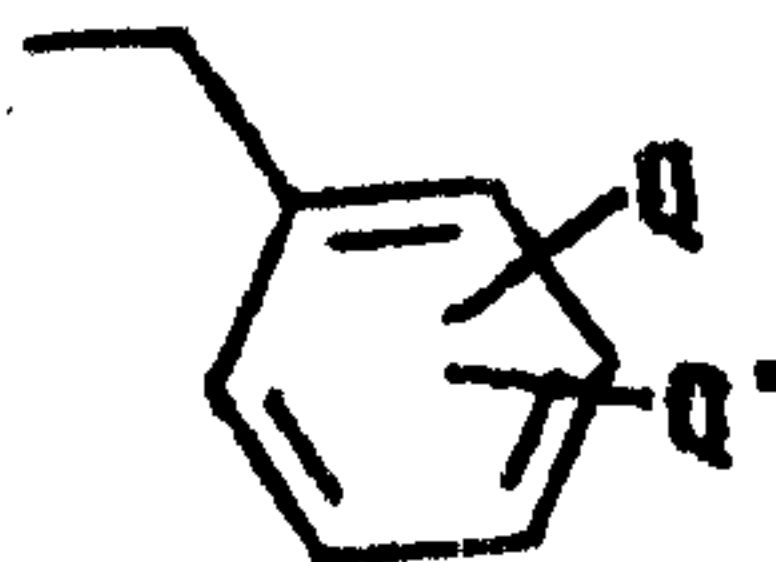


wherein Q and Q' are individually selected from the group consisting of hydrogen, lower alkyl, trifluoromethyl, nitro, dialkylamino, and cyano and R is selected from the group consisting of R' and cycloalkyl-lower alkyl with 3-6 ring carbon atoms.

16. A compound having the formula:

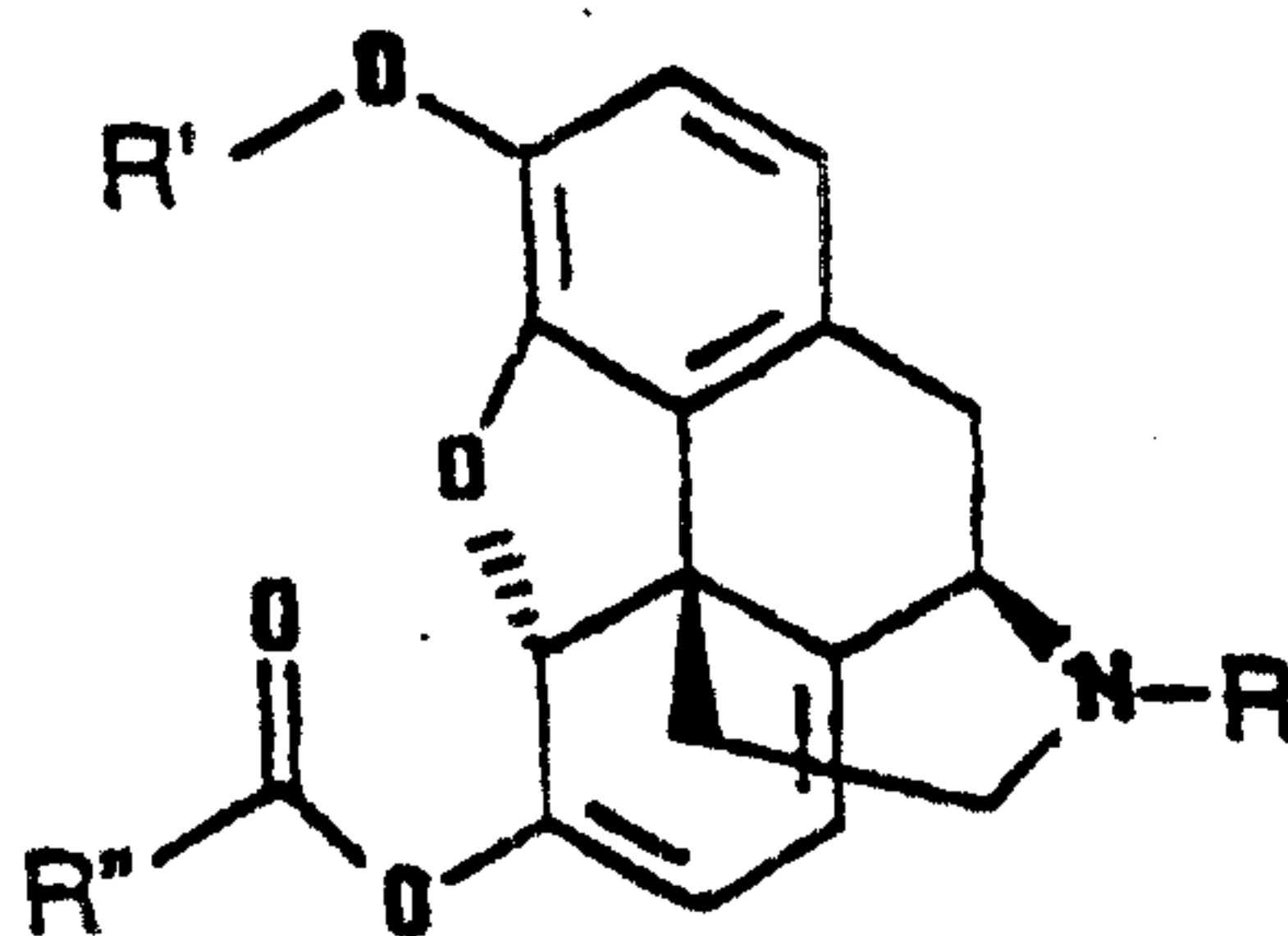


wherein R' is selected from the group consisting of substituted and unsubstituted benzyl having the formula:

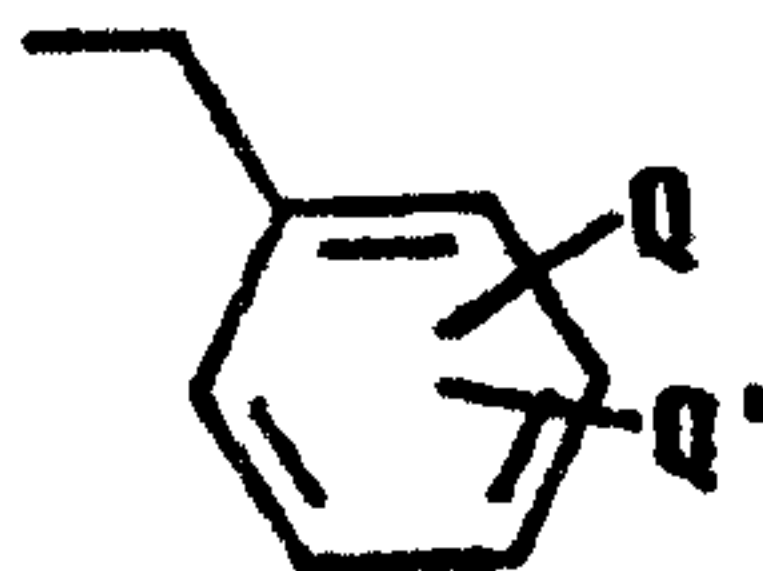


wherein Q and Q' are individually selected from the group consisting of hydrogen, lower alkyl, trifluoromethyl, nitro, dialkylamino and cyano and R is selected from the group consisting of R' and cycloalkyl-lower alkyl with 3-6 ring carbon atoms.

17. A compound having the formula:



wherein R is selected from the group consisting of lower alkyl of 1-7 carbon atoms, cycloalkyl-lower alkyl with 3-6 ring carbon atoms and substituted and unsubstituted benzyl having the formula:



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wherein Q and Q' are individually selected from the group consisting of hydrogen, lower alkyl, trifluoromethyl, nitro, dialkylamino, and cyano; and

R' is selected from the group consisting of R, 2-(4-morpholinyl)ethyl, benzyloxycarbonyl and the group having the formula:



wherein R'' is lower alkyl of 1-4 carbon atoms.

18. A compound selected from the group consisting of 3-acetylmorphinone dienol acetate, 3-benzylmorphinone dienol acetate, 3,17-dibenzylnormorphinone, 3,17-dibenzylnormorphinone dienol acetate, 3,17-dibenzyl-14-hydroxynormorphinone, 17-cyclopropylmethylnorcodeinone dienol acetate, 3-benzyl-17-cyclopropylmethylnormorphinone, 3-benzyl-17-cyclopropylmethylnormorphinone dienol acetate and 3-benzyl-17-cyclopropylmethyl-14-hydroxynormorphinone.

