Supporting Information

Synthesis of Esomeprazole and Related Proton Pump Inhibitors through Iron-Catalyzed Enantioselective Sulfoxidation

Shigenobu Nishiguchi,^{*,a} Takuhiro Izumi,^a Takayoshi Kouno,^b Junpei Sukegawa,^a Laurean Ilies,^{*,c,d} Eiichi Nakamura^{*,c}

^a API Process Research Department, API Business Division, Towa Pharmaceutical Co., Ltd., Amagasaki Research Incubation Center 3F, 7-1-3, Doi-cho, Amagasaki, Hyogo 660-0083, Japan

^b Production Department, Himeji Plant, Daichikasei Co., Ltd., 336-2, Jihoji, Himeji, Hyogo 671-2244, Japan

^cDepartment of Chemistry, School of Science, The University of Tokyo, 7-3-1 Hongo, Bunkyo-ku, Tokyo 113-0033, Japan

^dRIKEN Center for Sustainable Resource Science, 2-1 Hirosawa, Wako, Saitama 351-0198, Japan

*E-mail: s-nishiguchi@towayakuhin.co.jp; laurean.ilies@riken.jp; nakamura@chem.s.u-tokyo.ac.jp

Table of Contents

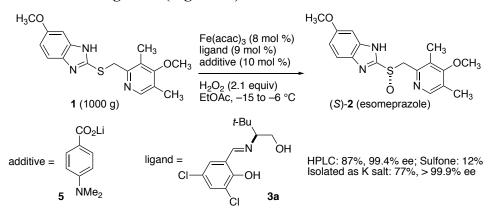
1. Materials and Methods	S2
2. Iron-Catalyzed Synthesis of Esomeprazole	S3
3. Iron-Catalyzed Synthesis of (S)-Lansoprazole, (S)-Rabeprazole, and	
(S)-Pantoprazole	
4. Heat generation profile of the FeCl ₃ -Catalyzed Reaction	S15
5. Iron-Catalyzed Oxidation of Benzyl Sulfide 13	S20

1. Materials and methods

The reaction on 1 kg scale was performed in a 30 L or 100 L glass-lined reactor fitted with a mechanical stirrer, under a nitrogen atmosphere. The reactions on small scale were performed in Schenk tubes or side-arm test tubes fitter with a stirring bar; similar results were obtained when the reaction was performed under inert gas and under air. Analytical thin-layer chromatography was performed on glass plates coated with 0.25 mm 230–400 mesh silica gel containing a fluorescent indicator (Merck). Flash silica gel column chromatography was performed on silica gel 60N (Kanto, spherical and neutral, 140-325 mesh) or wakogel C-200 (Fujifilm Wako Pure Chemical Co., 75-150 mesh), as described by Still.¹ HPLC analysis was performed on a Shimadzu Prominence, equipped with Daicel CHIRALPAK IC 4.6 x 250 mm (5 µm) column or Daicel CHIRALPAK IA 4.6 x 250 mm (5 µm) column and Agilent ZORBAX SB-C8 4.6 x 150 mm (5 µm) column. Optical rotation was measured on HORIBA SEPA-500. NMR spectra were measured on JEOL ECX-400 or Bruker AVANCE III HD400 and reported in parts per million from tetramethylsilane. ¹H NMR spectra in CDCl₃ or DMSO- d_6 were referenced internally to tetramethylsilane as a standard, and ¹³C NMR spectra to the solvent resonance. Mass spectra were measured on Waters SQ Detector. Melting point was measured on Buchi M-565. Reaction calorimetry was performed with a RC1 calorimeter. PXRD was measured on Rigaku MiniFlex300.

Unless otherwise noted, materials were purchased from Tokyo Chemical Industry Co., Aldrich Inc., and other commercial suppliers and used as received. Reagent grade ethyl acetate was used without further purification. Sulfide **1** was purchased and the sulfide substrates in Figure 1b were purchased or prepared according to a modified literature method.² *N*-methylated sulfide **11** was prepared according to the literature,³ as an inseparable 1:1 mixture of *N*-methylated isomers. Fe(acac)₃ from various commercial suppliers gave similar results. Aqueous hydrogen peroxide (30.0–35.5%) was purchased from KANTO CHEMICAL CO., INC. or Fujifilm Wako Pure Chemical Co., and stored at 5 °C. Lithium 4-dimethylaminobenzoate was prepared according to the literature.⁴ The chiral Schiff bases were prepared according to the literature⁵ and purified by recrystallization.

2. Iron-Catalyzed Synthesis of Esomeprazole



Reaction on 1 kg Scale (Figure 1a)

In a 30 L glass-lined reactor fitted with a mechanical stirrer, under a nitrogen atmosphere chiral Schiff base **3a** (79.3 g, 273 mmol) and iron(III) acetylacetonate (85.8 g, 243 mmol) were dissolved in ethyl acetate (1.80 kg) at 25 °C, and the mixture was stirred for 30 min. Lithium 4-dimethylaminobenzoate (**5**, 51.9 g, 304 mmol) and ethyl acetate (0.90 kg) were added and the resulting suspension was stirred for 30 min at 25 °C; next, sulfide **1** (1.00 kg, 3.04 mol) and ethyl acetate (6.30 kg) were added, stirred for 30 min at 25 °C, then the suspension was cooled to -15 °C. Aqueous hydrogen peroxide (35%, 613 g, 6.38 mol) was added over 6 h, and the reaction mixture was stirred for an additional 5 h at -13 to -14 °C. The reaction progress was monitored by HPLC; at the end of the reaction, the sulfoxide was formed in 87% yield and 99.4% ee, with 12% of the sulfone, and 0.2% of the sulfide **1**. After aqueous workup, KOH (178 g, 3.04 mol) in methanol (2.45 kg) was added to the organic phase, stirred overnight, and esomeprazole potassium salt dimethanol solvate was obtained upon cooling to -10 °C as an off-white solid (1.04 kg, 2.32 mol, 77% yield, >99.9% ee). The product data was in good agreement with the literature.^{67,8}

Mp 119-122 °C; $[\alpha]_D^{20} = +28.7$ (c = 1%, H₂O); ¹H NMR (400 MHz, DMSO-*d*₆): δ 8.22 (s, 1H), 7.31 (d, *J* = 8.4 Hz, 1H), 6.96 (d, *J* = 2.4 Hz, 1H), 6.54 (dd, *J* = 8.8, 2.4 Hz, 1H), 4.77 (d, *J* = 12.8 Hz, 1H), 4.36 (d, *J* = 12.8 Hz, 1H), 4.23 (br s, 2H), 3.72 (s, 3H), 3.69 (s, 3H), 3.17 (s, 6H), 2.23 (s, 3H), 2.20 (s, 3H); ¹³C NMR (100 MHz, DMSO-*d*₆): δ 163.3, 162.2, 153.4, 152.2, 148.9, 147.0, 141.7, 126.4, 124.7, 117.4, 108.7, 99.4, 59.6, 59.1, 55.2, 48.6, 12.9, 11.3; ESI-MS *m/z*: 384.27 (M+K⁺).

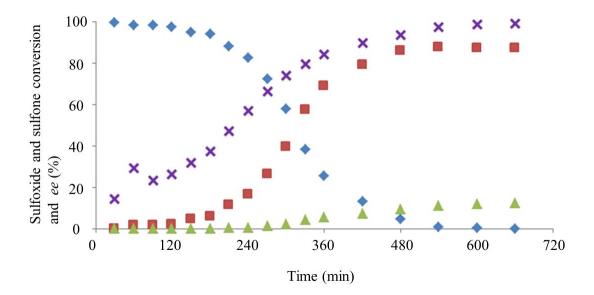


Figure S1. Time course of the enantioselective oxidation of 1 (1 kg scale). The HPLC conversion of 1 (\diamondsuit) to sulfoxide (\blacksquare) and sulfone (\blacktriangle) and *ee* (\times) are represented.

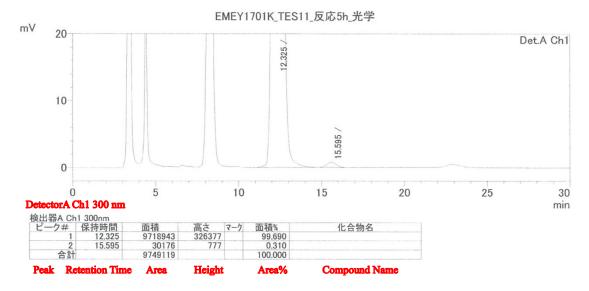


Figure S2. Chiral HPLC chart of the reaction mixture after 5 h reaction. English translation is provided in red.

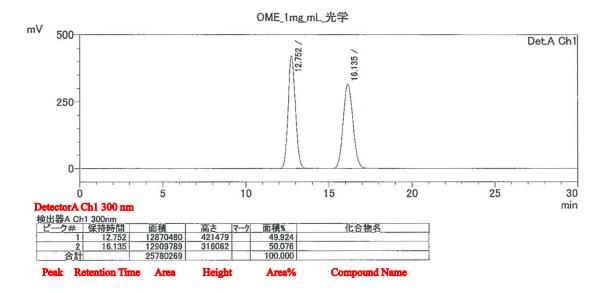


Figure S3. Chiral HPLC chart of omeprazole (racemic mixture of sulfoxide 2). English translation is provided in red.

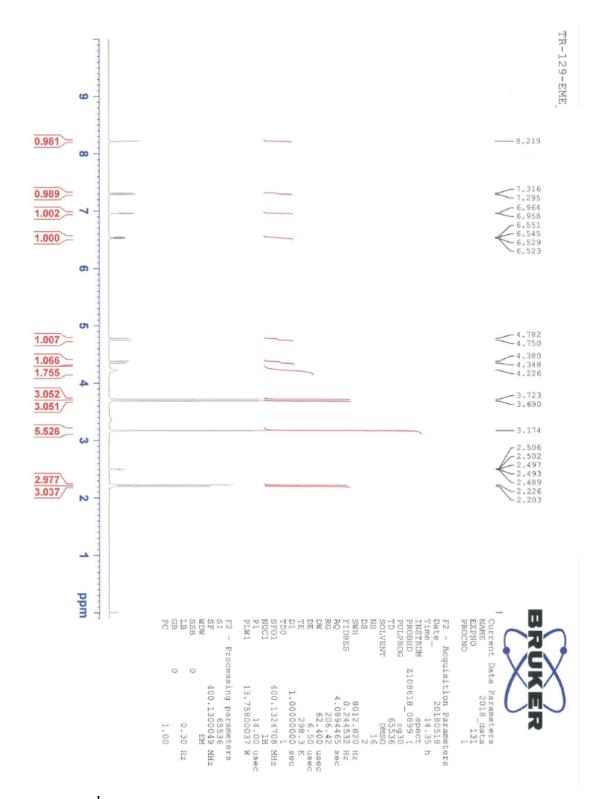


Figure S4. ¹H NMR chart of esomeprazole potassium salt dimethanol solvate.

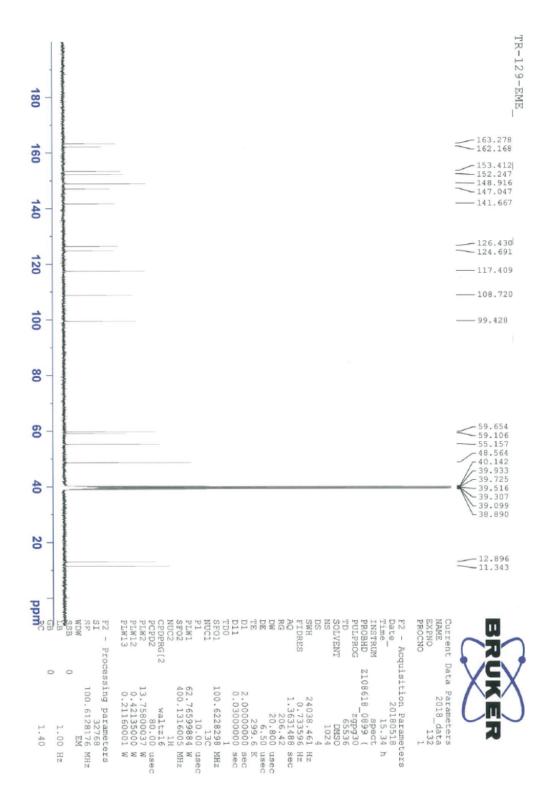


Figure S5. ¹³C NMR chart of esomeprazole potassium salt dimethanol solvate.

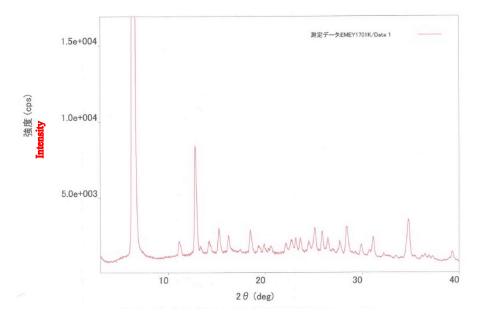
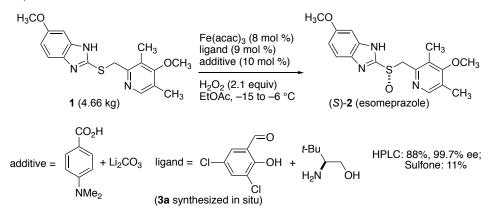


Figure S6. PXRD chart of esomeprazole potassium salt dimethanol solvate. English translation is provided in red.

Reaction on 4.66 kg Scale with *In Situ*-Generated Ligand and Additive (Figure 1a)



In a 100 L glass-lined reactor fitted with a mechanical stirrer, under a nitrogen atmosphere (*S*)-*tert*-leucinol (159.1 g, 1.36 mol), 3,5-dichlorosalicylaldehyde (272.9 g, 1.43 mol), lithium carbonate (104.5 g, 1.42 mol), 4-dimethylaminobenzoic acid (233.7 g, 1.42 mol), and iron(III) acetylacetonate (399.7 g, 1.13 mol) were added to ethyl acetate (37.7 kg) at 25 °C, and the resulting suspension was stirred for 60 min. Sulfide 1 (4.66 kg, 14.1 mol) and ethyl acetate (4.19 kg) were added at 25 °C, then the suspension was cooled to -15 °C. Aqueous hydrogen peroxide (35%, 2.85 kg, 29.7 mol) was added over 10 h, and the reaction mixture was stirred for an additional 14 h

at -13 to -9 °C. The reaction progress was monitored by HPLC; at the end of the reaction, the sulfoxide was formed in 88% yield and 99.7% ee, with 11% of the sulfone, and 0.2% of the sulfide **1**. After aqueous workup, KOH (830 g, 14.1 mol) in methanol (11.4 kg) was added to the organic phase, stirred overnight, and esomeprazole potassium salt dimethanol solvate was obtained upon cooling to -10 °C as an off white-solid (5.00 kg, 11.2 mol, 79% yield, >99.9% ee). The product data was in good agreement with the literature.^{6,7,8}

Mp 118-123 °C; $[\alpha]_D^{20} = +27.2$ (c = 1%, H₂O); ¹H NMR (400 MHz, DMSO-*d*₆): δ 8.22 (s, 1H), 7.31 (d, *J* = 8.8 Hz, 1H,), 6.97 (d, *J* = 2.4 Hz, 1H), 6.54 (dd, *J* = 8.8, 2.8 Hz, 1H), 4.76 (d, *J* = 12.8 Hz, 1H), 4.37 (d, *J* = 13.2 Hz, 1H), 4.30 (br s, 2H), 3.72 (s, 3H), 3.69 (s, 3H), 3.18 (s, 6H), 2.22 (s, 3H), 2.20 (s, 3H); ¹³C NMR (100 MHz, DMSO-*d*₆): δ 163.3, 162.1, 153.5, 152.2, 149.0, 147.0, 141.6, 126.5, 124.8, 117.4, 108.8, 99.4, 59.7, 59.2, 55.2, 48.6, 12.9, 11.4; ESI-MS *m/z*: 384.28 (M+K⁺).

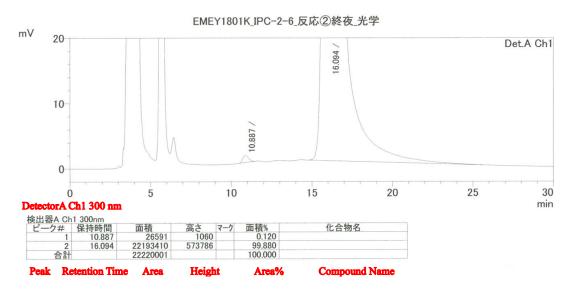


Figure S7. Chiral HPLC chart of the reaction mixture after 14 h reaction. English translation is provided in red.

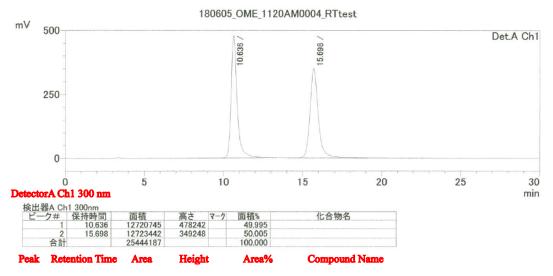


Figure S8. Chiral HPLC chart of omeprazole (racemic mixture of sulfoxide 2). English translation is provided in red.

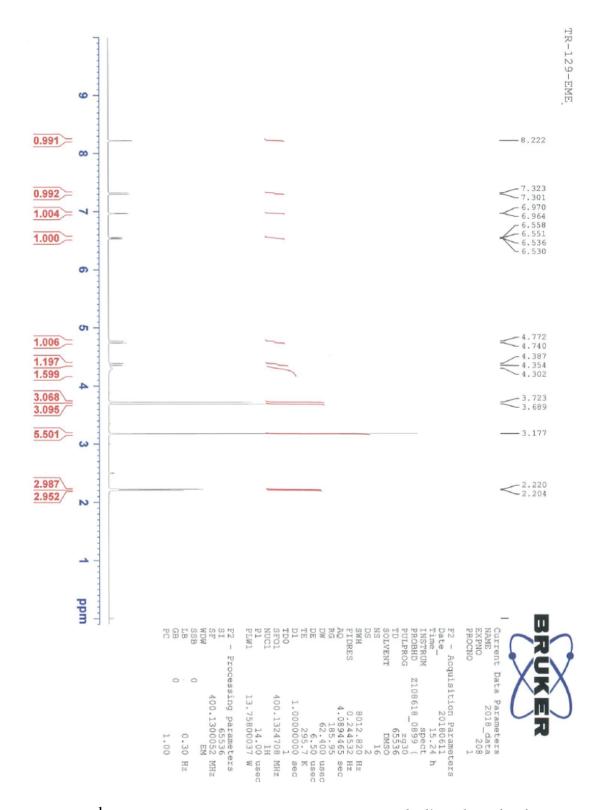


Figure S9. ¹H NMR chart of esomeprazole potassium salt dimethanol solvate.

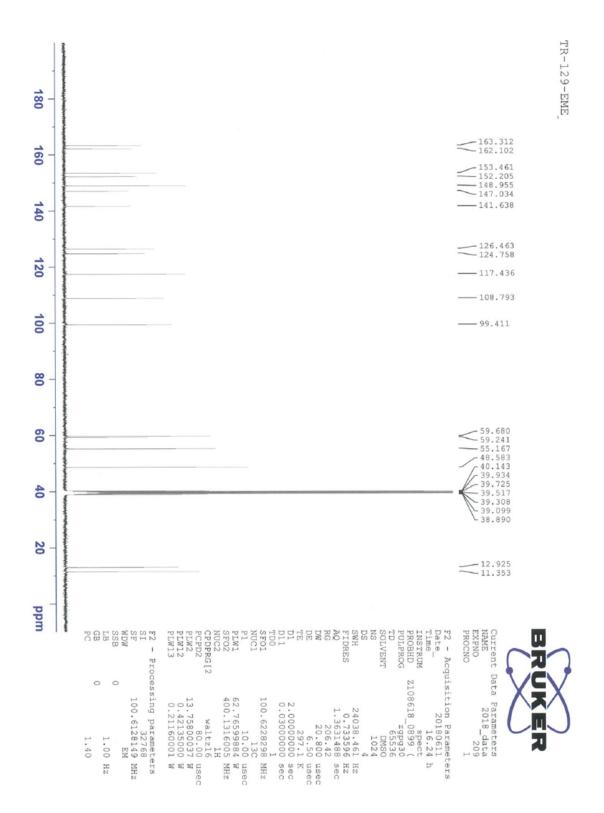


Figure S10. ¹³C NMR chart of esomeprazole potassium salt dimethanol solvate.

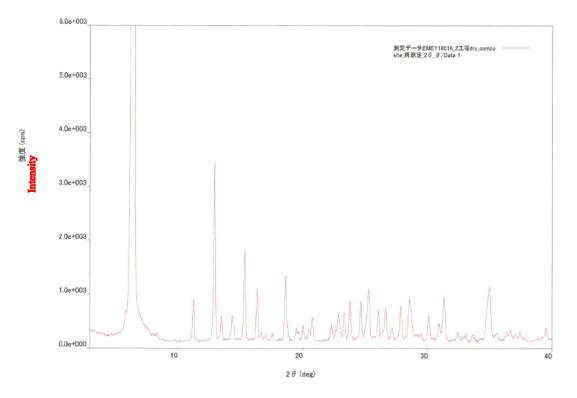


Figure S11. PXRD chart of esomeprazole potassium salt dimethanol solvate. English translation is provided in red.

Representative Procedure for Optimization Studies (Table 4, entry 8)

In a Schenck tube, chiral Schiff base **3a** (79 mg, 273 μ mol) and iron(III) acetylacetonate (32 mg, 91 μ mol) were dissolved in ethyl acetate (0.6 mL) at 25 °C, and the mixture was stirred for 30 min. Lithium 4-dimethylaminobenzoate (**5**, 7.7 mg, 45.0 μ mol) and ethyl acetate (0.3 mL) were added and the resulting suspension was stirred for 2 h at 25 °C; next, sulfide **1** (0.30 g, 911 μ mol) and ethyl acetate (0.9 mL) were added, stirred for 30 min at 25 °C, then the suspension was cooled to -5 °C. Aqueous hydrogen peroxide (30%, 186 μ L, 1.82 mmol) was slowly added over 2 min, and the reaction mixture was stirred for an additional 4.5 h at -5 °C. The reaction mixture was analyzed by HPLC, to reveal that the sulfoxide **2** was formed in 83% yield and 96% ee, with 12% of the sulfone, and 5% of the sulfide **1**.

3. Iron-Catalyzed Synthesis of (S)-Lansoprazole, (S)-Rabeprazole, and (S)-Pantoprazole (Figure 1b)

Representative Procedure: Synthesis of (S)-Lansoprazole

In a test tube fitted with a side arm, chiral Schiff base **3a** (234 mg, 806 µmol), iron(III) acetylacetonate (95 mg, 269 µmol), Lithium 4-dimethylaminobenzoate (**5**, 23 mg, 134 µmol), and ethyl acetate (7.5 mL) were added, then the resulting suspension was stirred for 30 min at 25 °C; next, lansoprazole sulfide hydrate (1.00 g, 2.69 mmol) and ethyl acetate (7.5 mL) were added, then the suspension was cooled to -5 °C. Aqueous hydrogen peroxide (35%, 550 µL, 6.29 mmol) was slowly added over 2 min, and the reaction mixture was stirred for an additional 20.5 h at -5 °C. The reaction mixture was analyzed by HPLC, to reveal that (*S*)-lansoprazole was formed in 87% yield and 98% ee, with 12% of the sulfone, and 2% of the sulfide. After aqueous workup, the organic phase was concentrated under reduced pressure, and the residue was purified by flash column chromatography (hexanes/ethyl acetate = 1:2 to ethyl acetate/methanol = 3:2) to afford an analytically pure sample of the title compound. Caution: upon standing, this compound gradually decomposed.

Compound Data

(S)-lansoprazole

The compound data was in good agreement with the literature.⁹

¹H NMR (400 MHz, DMSO-*d*₆): δ 13.58 (br s, 1H), 8.29 (d, *J* = 5.7 Hz, 1H), 7.65 (br s, 2H), 7.31 (dd, *J* = 6.1, 3.2 Hz, 2H), 7.10 (d, *J* = 5.7 Hz, 1H), 4.89 (q, *J* = 8.8 Hz, 2H), 4.83 (d, *J* = 13.8 Hz, 1H), 4.75 (d, *J* = 13.8 Hz, 1H), 2.18 (s, 3H) ; ESI-MS *m/z*: 392.40 (M+Na⁺).

(S)-rabeprazole

The compound data was in good agreement with the literature.⁹

¹H NMR (400 MHz, DMSO-*d*₆): δ 13.58 (br s, 1H), 8.22 (d, *J* = 5.6 Hz, 1H), 7.65 (br s, 2H), 7.32-7.29 (m, 2H), 6.96 (d, *J* = 5.7 Hz, 1H), 4.80 (d, *J* = 13.6 Hz, 1H), 4.71 (d, *J* = 13.6 Hz, 1H), 4.10 (t, *J* = 6.2 Hz, 2H), 3.48 (t, *J* = 6.2 Hz, 2H), 3.25 (s, 3H), 2.14 (s, 3H), 2.01–1.94 (m, 2H); ESI-MS *m/z*: 382.44 (M+Na⁺).

(S)-pantoprazole

The compound data was in good agreement with the literature.⁹

 $[\alpha]_D^{25} = -79.4$ (c = 0.3%, MeOH); ¹H NMR (400 MHz, DMSO-*d*₆): δ 13.77 (br s, 1H), 8.15 (d, *J* = 5.5 Hz, 1H), 7.70 (d, *J* = 8.4 Hz, 1H), 7.44 (s, 1H), 7.26 (s, 1H), 7.16 (dd, *J* = 8.8, 2.2 Hz, 1H), 7.11 (d, *J* = 5.6 Hz, 1H), 4.72 (d, *J* = 13.1 Hz, 1H), 4.66 (d, *J* = 13.1 Hz, 1H), 3.90 (s, 3H), 3.77 (s, 3H); ESI-MS *m/z*: 406.36 (M+Na⁺).

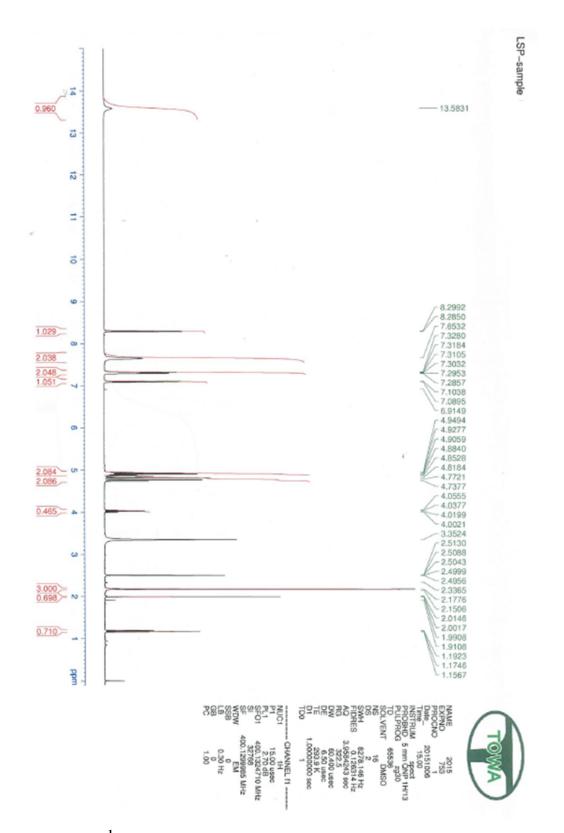


Figure S12. ¹H NMR chart of (*S*)-lansoprazole.

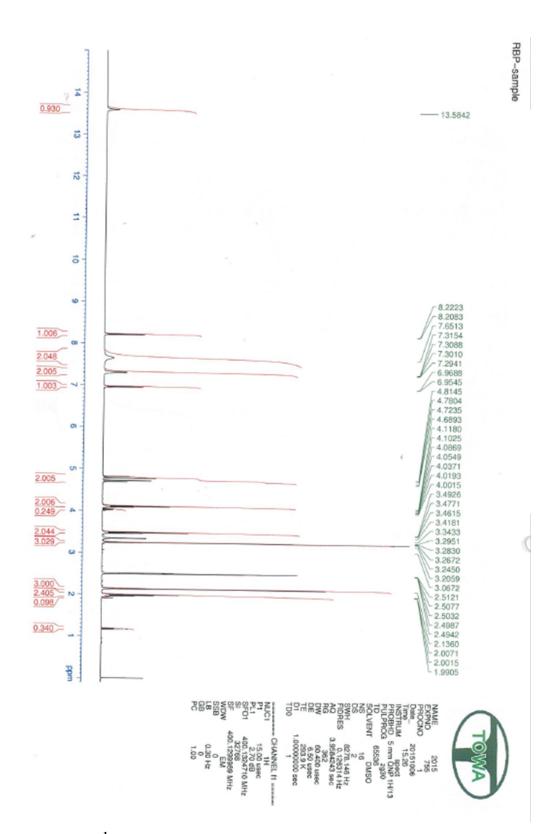


Figure S13. ¹H NMR chart of (*S*)-rabeprazole.

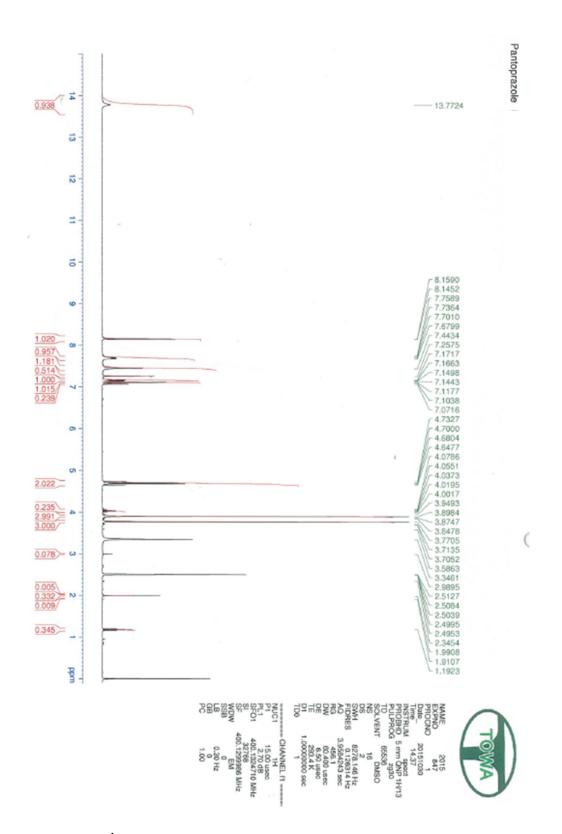


Figure S14. ¹H NMR chart of (*S*)-pantoprazole.

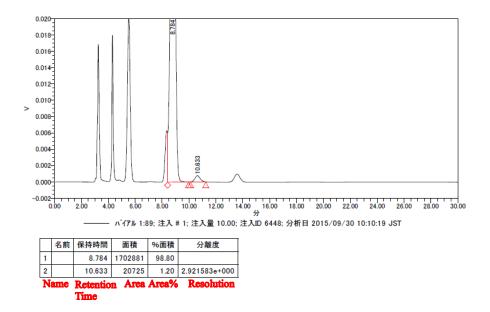


Figure S15. Chiral HPLC chart of the lansoprazole reaction mixture after 20.5 h reaction. English translation is provided in red.

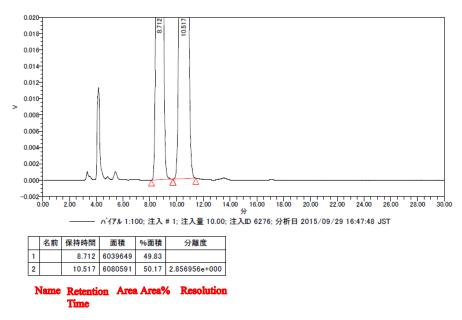


Figure S16. Chiral HPLC chart of lansoprazole (racemic mixture of sulfoxide). English translation is provided in red.

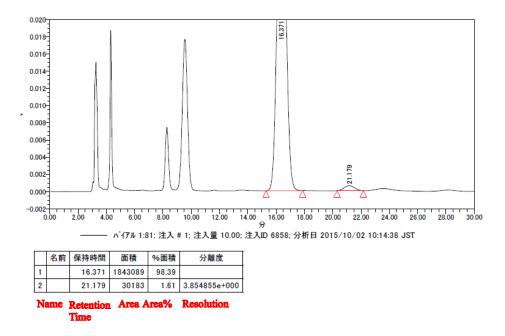


Figure S17. Chiral HPLC chart of the rabeprazole reaction mixture after 20.5 h reaction. English translation is provided in red.

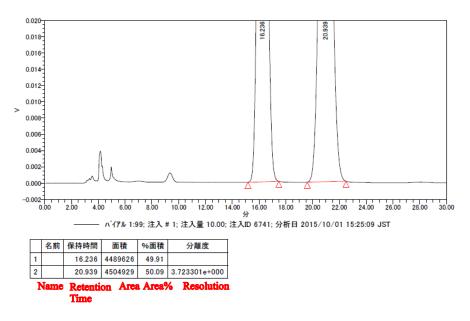


Figure S18. Chiral HPLC chart of rabeprazole (racemic mixture of sulfoxide). English translation is provided in red.

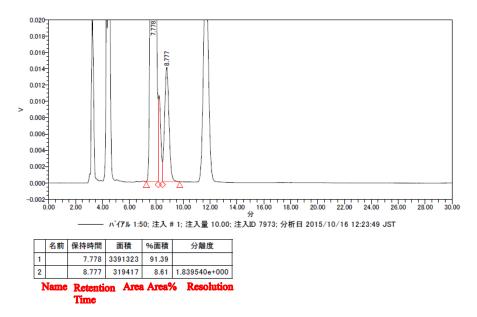


Figure S19. Chiral HPLC chart of the pantoprazole reaction mixture after 44 h reaction. English translation is provided in red.

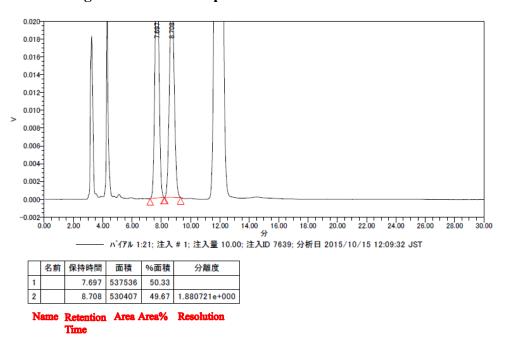


Figure S20. Chiral HPLC chart of pantoprazole (racemic mixture of sulfoxide). English translation is provided in red.

4. Heat generation profile of the FeCl₃-Catalyzed Reaction (*Figure S20*)

In a RC1 calorimeter, chiral Schiff base **3a** (1.59 g, 5.48 mmol) and iron(III) chloride hydrate (1.32 g, 4.88 mmol) were dissolved in ethyl acetate (40 mL) at 25 °C, and the mixture was stirred for 30 min. Lithium 4-dimethylaminobenzoate (**5**, 1.04 g, 6.08 mmol) and ethyl acetate (20 mL) were added and the resulting suspension was stirred for 30 min at 25 °C; next, sulfide **1** (20.0 g, 60.7 mmol) and ethyl acetate (140 mL) were added, then the suspension was cooled to -10 °C. Aqueous hydrogen peroxide (35%, 12.3 g, 128 mmol) was slowly added over 2 h (green line), and then reaction mixture (viscous suspension) was additionally stirred at -10 °C. The conversion was monitored by HPLC (red plot): no induction period was observed, and after 19 h reaction the conversion was 50% (72% ee), and after 111.5 h it was 72% (73% ee). The exothermic peak at ca. 100 min observed when Fe(acac)₃-catalyzed reaction, the heat release peaked toward the end of the addition of hydrogen peroxide.

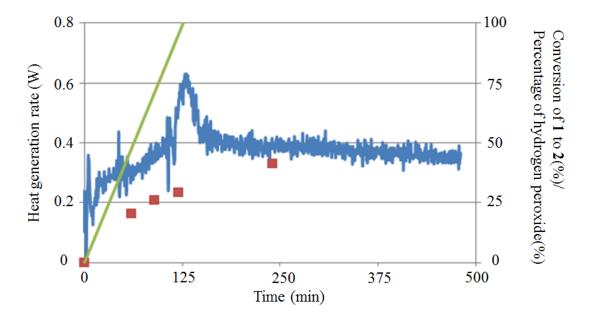


Figure S21. Heat generation profile of the FeCl₃-catalyzed reaction. Blue line: heat generation rate (left axis); Red plot: conversion of 1 to 2, determined by HPLC (right axis); Green line: the percentage of the total amount (2.1 equiv) of hydrogen peroxide added (right axis).

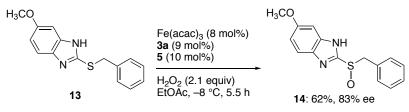
5. Iron-Catalyzed Oxidation of Benzyl Sulfide 13

Synthesis of 6-Methoxy-2-[(phenylmethyl)thio]-1H-benzimidazole (13)

In a four-necked flask, 1,3-dihydro-5-methoxy-2*H*-benzimidazole-2-thione (5.00 g, 27.4 mmol) was dissolved in DMF (50 mL) at 25 °C, the solution was cooled, and then benzyl bromide (4.75 g, 27.7 mmol) and potassium carbonate (5.75 g, 41.6 mmol) were added such as the temperature of the reaction mixture remained below 10 °C. The resulting suspension was stirred for 14 h at 25 °C. Water (200 mL) was added to the reaction mixture, the resulted solid was filtrated, washed with water (75 mL), and dried at 50 °C under vacuo and to afford the title compound.

Mp 125–126 °C; ¹H NMR (400 MHz, CDCl₃): δ 10.22 (br s, 1H), 7.55 (br s, 0.5H), 7.30-7.17 (m, 6H), 6.83 (m, 1.5H), 4.45 (s, 2H), 3.77 (s, 3H); ¹³C NMR (100 MHz, CDCl₃): δ 156.8, 149.8, 148.2, 144.9, 138.7, 137.1, 135.5, 129.0, 128.8, 127.7, 119.0, 112.6, 111.4, 110.7, 101.5, 94.7, 56.0, 38.0 (mixture of tautomers); ESI-MS *m/z*: 293.20 (M+Na⁺).

Synthesis of (–)-6-methoxy-2-[(phenylmethyl)sulfinyl]-1*H*-benzimidazole (14) (Figure 3c)



In a test tube fitted with a side arm, chiral Schiff base **3a** (97 mg, 333 μ mol) and iron(III) acetylacetonate (105 mg, 296 μ mol) were dissolved in ethyl acetate (2.0 mL) at 25 °C, and mixture was stirred for 30 min. Lithium 4-dimethylaminobenzoate (**5**, 63 mg, 370 μ mol) and ethyl acetate (1.0 mL) were added and the resulting suspension was stirred for 30 min at 25 °C; next, benzyl sulfide **13** (1.00 g, 3.70 mmol) and ethyl acetate (7.0 mL) were added, then the suspension was cooled to -9 °C. Aqueous hydrogen peroxide (35%, 660 μ L, 7.77 mmol) was slowly added over 2 min, and the reaction mixture was stirred for an additional 18.5 h at -9 °C. The reaction mixture was analyzed by HPLC, to reveal that sulfoxide was formed in 71% yield and 85% ee, with 11% of the sulfone, and 18% of the sulfide. After aqueous workup, the organic

phase was concentrated under reduced pressure, and the residue was purified by flash column chromatography (hexanes/ethyl acetate = 2:1 to 1:2) to afford an analytically pure sample of the title compound.

Mp 128-130 °C; $[\alpha]_D^{20} = -153.8$ (c = 1%, MeOH); ¹H NMR (400 MHz, CDCl₃): δ 11.33 (br s, 1H), 7.67 (d, J = 9.2 Hz, 0.5H), 7.28-7.24 (m, 2H), 7.20-7.16 (m, 2H), 7.08 (d, J = 8.0 Hz, 2H), 6.98-6.95 (m, 1H), 6.84 (d, J = 2.0 Hz, 0.5H), 4.51 (d, 13.2 Hz, 1H), 4.28 (d, 13.2 Hz, 1H), 3.89 (s, 1H), 3.81 (s, 2H); ¹³C NMR (100 MHz, CDCl₃): δ 158.0, 157.0, 152.1, 150.5, 145.2, 138.9, 135.1, 130.6, 128.9, 128.8, 121.0, 115.2, 113.8, 112.6, 102.1, 94.9, 61.7, 56.0 (mixture of tautomes); ESI-MS *m/z*: 309.22 (M+Na⁺).

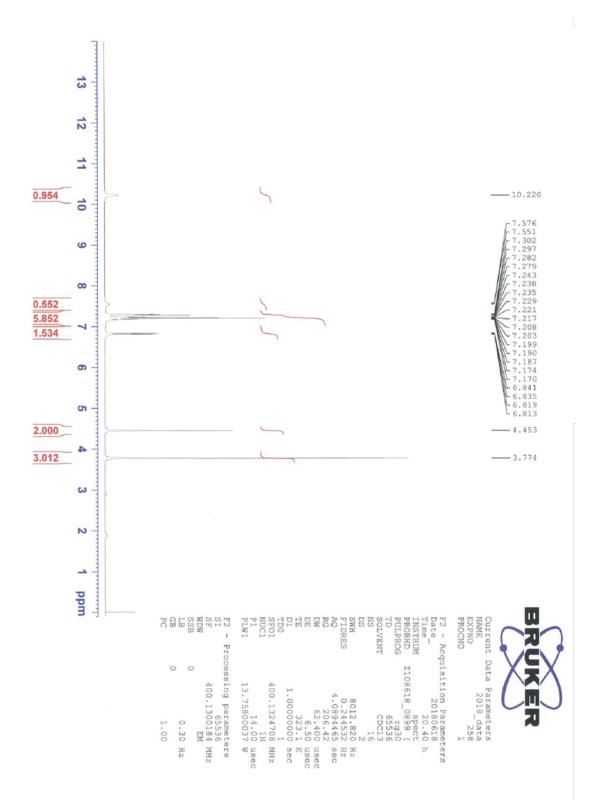


Figure S22. ¹H NMR chart of benzyl sulfide 13.

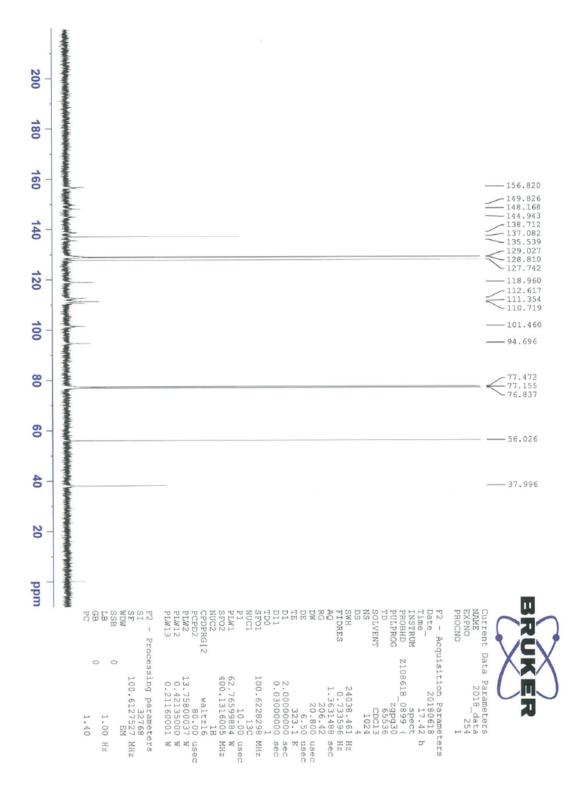


Figure S23. ¹³C NMR chart of benzyl sulfide 13.

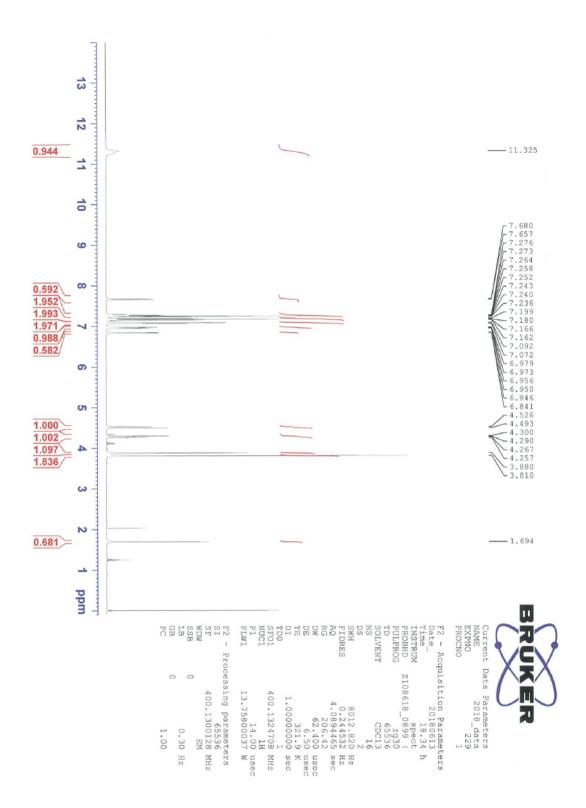


Figure S24. ¹H NMR chart of benzyl sulfoxide 14.

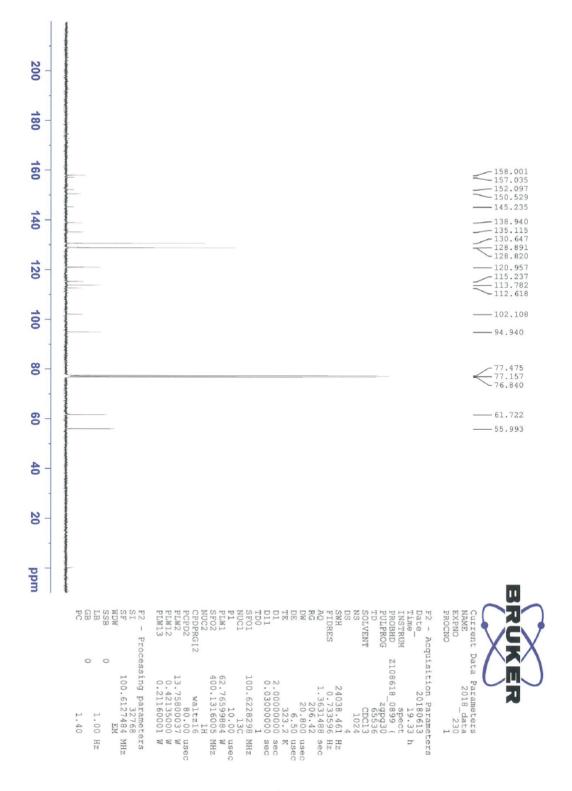


Figure S25. ¹³C NMR chart of benzyl sulfoxide 14.

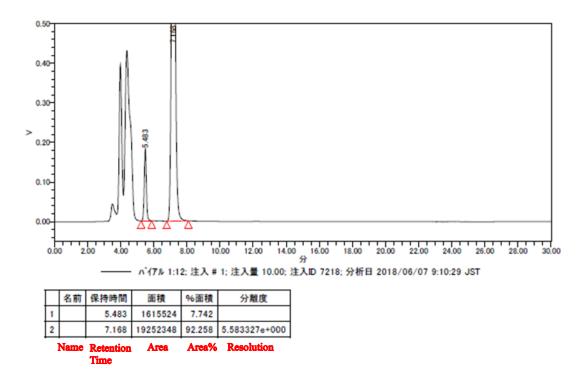


Figure S26. Chiral HPLC chart of the reaction mixture after 18.5 h reaction. English translation is provided in red.

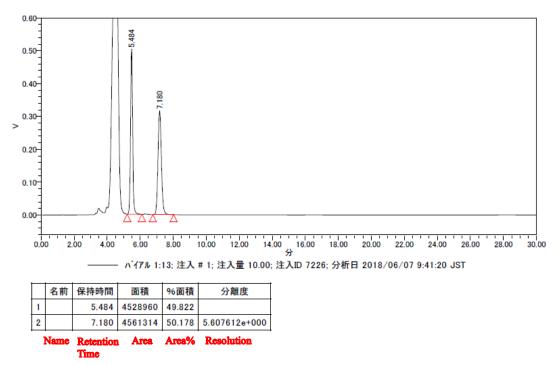


Figure S27. Chiral HPLC chart of benzyl sulfoxide 14 (racemic mixture). English translation is provided in red.

Representative Procedure for Optimization Studies (Table S1)

In a Schenck tube, chiral Schiff base **3a** (79 mg, 273 μ mol) and iron(III) acetylacetonate (32 mg, 91 μ mol) were dissolved in ethyl acetate (0.6 mL) at 25 °C, and the mixture was stirred for 30 min. 4-dimethylaminobenzoic acid (7.5 mg, 45.0 μ mol) and ethyl acetate (0.3 mL) were added and the resulting suspension was stirred for 30 min at 25 °C; next, sulfide **1** (0.30 g, 911 μ mol) and ethyl acetate (0.9 mL) were added, stirred for 30 min at 25 °C. Aqueous hydrogen peroxide (30%, 186 μ L, 1.82 mmol) was slowly added over 2 min, and the reaction mixture was stirred for an additional 0.5 h at 25 °C. The reaction mixture was analyzed by HPLC, to reveal that the sulfoxide **2** was formed in 67% yield and 69% ee, with 7% of the sulfone, and 26% of the sulfide **1**.

Table S1. Effects of addition of a benzoic acid derivative.

entry	additive	time (h)	2 (%)	ee (%)	sulfone (%)
1	Me ₂ N-CO ₂ H	0.5	67	69	7
2	CO ₂ H	0.5	57	44	5
3	F-CO ₂ H	0.5	58	42	5
4	Ph-CO ₂ H	0.5	57	44	6

References

- ¹ Still, W. C.; Kahn, M.; Mitra, A. A New, Mild Method for the Synthesis of Azo Compounds. J. Org. Chem. **1978**, 43, 2923–2925.
- ² (a) Gangula, S.; Elati, C. R.; Neredla, A.; Baddam, S. R.; Neelam, U. K.; Bandichhor, R.; Dongamanti, A. An Improved Process for the Lansoprazole: Investigation of Key Parameters That Influence the Water Content in Final API. *Org. Process Res. Dev.* **2010**, *14*, 229-233. (b) Reddy, P. R.; Himabindu, V.; Jaydeepkumar, L.; Reddy, G. M.; Kumar, J. V.; Reddy, G. M. An Improved Process for the Production of Rabeprazole Sodium Substantially Free from the Impurities. *Org. Process Res. Dev.* **2009**, *13*, 896-899.
- ³ Duncan, K. W.; Chesworth, R.; Boriack-Sjodin, P. A.; Munchhof, M. J.; Jin, L. PRMT5 Inhibitors Containing a Dihydro- or Tetrahydroisoquinoline and Uses Thereof. WO2014/100730 A1.
- ⁴ Argentar, H. Tertiary Aromatic Amine Accelerators in Acrylic Resin. US4243763.
- ⁵ (a) O'Mahony, G. E.; Ford, A.; Maguire, A. R. Copper-Catalyzed Asymmetric Oxidation of Sulfides. *J. Org. Chem.* 2012, 77, 3288-3296. (b) Legros, J.; Bolm C. Investigations on the Iron-Catalyzed Asymmetric Sulfide Oxidation. *Chem. Eur. J.* 2005, *11*, 1086-1092. (c) Hartung, J.; Dress, S.; Greb, M.; Schmidt, P.; Svoboda, I.; Fuess, H.; Murso, A.; Stalke, D. (Schiff-base)vanadium(V) Complex-Catalyzed Oxidations of Substituted Bis(homoallylic) Alcohols – Stereoselective Synthesis of Functionalized Tetrahydrofurans. *Eur. J. Org. Chem.* 2003, *13*, 2388-2408.
- ⁶ Kronstrom, A.; Leander, E.; Mattson, A.; Jansson, K.; Bohlin, M. Process. US2003/0004190 A1.
- ⁷ Vijayabhaskar, B.; Reddy, M. S.; Siva, P. R. S.; Sasikala, V. A. C. Esomeprazole Salt and Processes for Preparation Thereof. EP2000468 A1.
- ⁸ Ha, T. H.; Kim, W. J.; Oh, H. S.; Park, C. H.; Lee, J. C.; Kim, H. K. Method of Preparing Esomeprazole and Salts Thereof. WO2007/013743 A1.
- ⁹ Che, G.; Xiang, J.; Tian, T.; Huang, Q.; Cun, L.; Liao, J.; Wang, Q.; Zhu, J.; Deng, J. Catalytic Asymmetric Oxidation of 1*H*-Benzimidazolyl Pyridinylmethyl Sulfides with Cumene Hydroperoxide Catalyzed by a Titanium Complex with (*S*,*S*)-*N*,*N*'-Dibenzyl Tartramide Ligand. *Tetrahedron: Asymmetry* **2012**, *23*, 457-460.