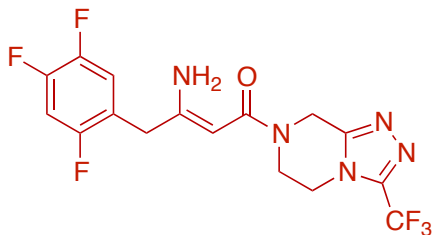
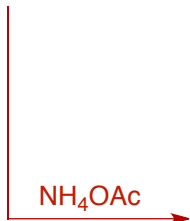


sitagliptin phosphate salt



1. Rh[Josiphos]/H₂ (250 psi)
2. remove Rh (carbon treatment)
3. recrystallization
4. phosphate salt formation

Chemocatalytic Shortcomings:

- requires removal of trace Rh
- insufficient ee requires recrystallization
- practical concerns with high-pressure reaction
- high catalyst cost