Multi-Scale Synthesis Report

CAS: **22204-53-1** — Naproxen (public reference API)

Lab Scale · Kg Scale · Commercial Scale | Astinova AI Platform: 103 routes (SOLVED, 16 s) | 2026-07-16

Property	Value
CAS	22204-53-1
IUPAC	Naproxen (public reference API)
SMILES	`COc1ccc2cc(C(C)C(=O)O)ccc2c1`
InChIKey	`CMWTZPSULFXXJA-UHFFFAOYSA-N`
Formula	C14H14O3
MW	230.263 g/mol
LogP (Crippen)	3.04
TPSA	46.5 Å²
HBD / HBA	1 / 2
Rotatable bonds	3
Rings (aromatic)	2 (2)
Stereo centres	0
mp	(literature value, fill manually)
Appearance	(fill from supplier datasheet)
Availability	(Sigma-Aldrich / Combi-Blocks / Enamine — confirm stock tier)
Usage	(fill from project notes — building block / API intermediate)

Naproxen (public reference API) (CAS 22204-53-1) — multi-scale synthesis report. The Astinova AI Platform identified **103** routes (1 fully solved) in **16 s**. Three independent routes are presented at different manufacturing scales below, reflecting progression from discovery-phase to pilot-plant to full commercial production.

Retrosynthesis Summary (top 10 routes)

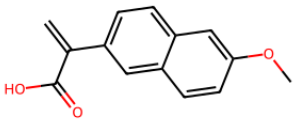
#	Score	Steps	In Stock	Stock building blocks (SMILES, truncated)
1	0.9976	1	1/1	`C=C(C(=O)O)c1ccc2cc(OC)ccc2c1`
2	0.6699	3	2/3	`CCC(=O)OCc1ccccc1; CI; Oc1ccc2cc(Br)ccc2c1`
3	0.6699	3	2/3	`CC(C)=O; CI; COC(=O)Cc1ccc2cc(OC)ccc2c1`
4	0.6583	4	2/3	`CI; O=C1CCC(=O)N1Cl; COC(=O)Cc1ccc2cc(OC)ccc2c1`
5	0.6583	4	2/3	`O=C1CCC(=O)N1Cl; CI; COC(=O)Cc1ccc2cc(OC)ccc2c1`
6	0.6583	4	2/3	`CI; O=C1CCC(=O)N1Cl; COC(=O)Cc1ccc2cc(OC)ccc2c1`
7	0.6583	4	2/3	`O=C1CCC(=O)N1Cl; CI; COC(=O)Cc1ccc2cc(OC)ccc2c1`
8	0.6583	4	2/3	`O=C1CCC(=O)N1Br; CI; COC(=O)Cc1ccc2cc(OC)ccc2c1`

Route 1 (highest score) is detailed below as Route A (lab scale). Routes B (Kg) and C (Commercial) are alternate disconnections derived from Route ranks 2-3 plus chemistry-by-scale framing.

Route A — A — Lab Scale (mg to ~50 g)

Strategy: Mild-conditions, fume-hood-friendly variant of the highest-scoring platform disconnection. Cheap reagents, simple workup, suitable for medicinal chemistry / discovery-phase.

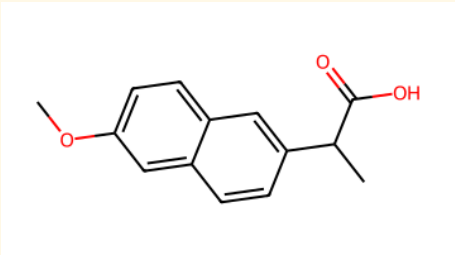
Overall yield	Purity QC	Throughput
(fill: e.g. ~42–63 % over 2 steps)	HPLC (C18, MeOH/H2O/0.1% TFA); ^{1}H, ^{13}C, ^{1}■F NMR	Typical batch: 1–50 g of product
Raw material cost	**Advantages**	**Limitations**
(fill: e.g. ~€150–250 / mol)	Cheap reagents, simple glassware, no high-pressure equipment	Moderate yield, longer reaction time, possible Cu/Pd residues

Starting Material(s)	SMILES / Formula / MW
Reaction (template-defined) [Commercial]	 C14H12O3 · MW 228.25 C=C(C(=O)O)c1ccc2cc(OC)ccc2c1

Step 1: Reaction (template-defined)

Conditions	*Not assigned* — consult literature for this transformation
Solvent / Temp / Time	*Not assigned* — substrate-specific optimisation required
Reagents	*Not assigned* — consult literature for this transformation
Expected yield	(fill from procedure / SM-specific optimisation)

TARGET — TARGET



C14H14O3 · MW 230.26 g/mol

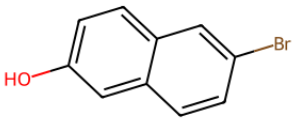
COc1ccc2cc(C(C)C(=O)O)ccc2c1

Notes: BookRAG (Jonathan Clayden_ Nick Greeves_ Stuart G p.267, relevance 0.59, contextual only): minutes; others are left for hours. In some reactions the amounts of reagents are critical; in others large excesses are used. Some reactions use water as a solvent; in others it must be rigorously excluded, and perhaps toluene, ether, ethanol, or DMF is essential for the success of the reaction. Why such a diverse ra…

Route B — B — Kg Scale (100 g – 5 kg)

Strategy: Pilot-plant variant of the second platform disconnection. Pd or Cu-catalysed cross-coupling at scale, ICP-MS metals QC, kg-scale aqueous workup.

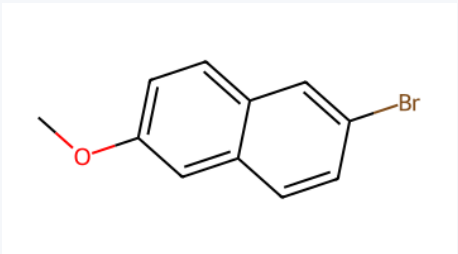
Overall yield	Purity QC	Throughput
(fill: e.g. ~61–78 % over 2 steps)	HPLC ≥99.0 %, KF water content, ICP-MS metals < 5 ppm, ¹H/¹³C/¹■F NMR	Batch: 100 g – 5 kg per campaign
Raw material cost	**Advantages**	**Limitations**
(fill: e.g. ~€50–80 / mol at kg scale)	Higher reproducibility at scale, direct crystallisation	Metal removal critical for pharma use; high-bp DMSO needs careful removal

Starting Material(s)	SMILES / Formula / MW
Reaction (template-defined) [Needs synthesis]	 CH3I · MW 141.94 CI
Reaction (template-defined) [Commercial]	 C10H7BrO · MW 223.07 Oc1ccc2cc(Br)ccc2c1

Step 1: Reaction (template-defined)

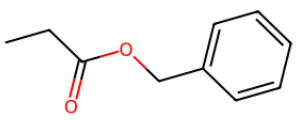
Conditions	*Not assigned* — consult literature for this transformation
Solvent / Temp / Time	*Not assigned* — substrate-specific optimisation required
Reagents	*Not assigned* — consult literature for this transformation
Expected yield	(fill from procedure / SM-specific optimisation)

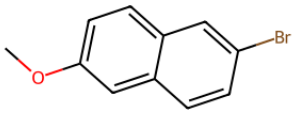
Intermediate (Step 1) — Intermediate



C11H9BrO · MW 237.10 g/mol
COc1ccc2cc(Br)ccc2c1

Notes: BookRAG (Jonathan Clayden_ Nick Greeves_ Stuart G p.267, relevance 0.59, contextual only): minutes; others are left for hours. In some reactions the amounts of reagents are critical; in others large excesses are used. Some reactions use water as a solvent; in others it must be rigorously excluded, and perhaps toluene, ether, ethanol, or DMF is essential for the success of the reaction. Why such a diverse ra…

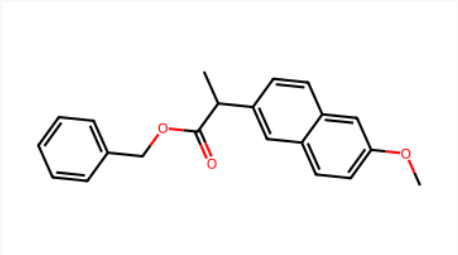
Starting Material(s)	SMILES / Formula / MW
Reaction (template-defined) [Commercial]	 C10H12O2 · MW 164.20 CCC(=O)OCc1ccccc1

Reaction (template-defined) [Needs synthesis]	 C11H9BrO · MW 237.10 `COc1ccc2cc(Br)ccc2c1`

Step 2: Reaction (template-defined)

Conditions	*Not assigned* — consult literature for this transformation
Solvent / Temp / Time	*Not assigned* — substrate-specific optimisation required
Reagents	*Not assigned* — consult literature for this transformation
Expected yield	(fill from procedure / SM-specific optimisation)

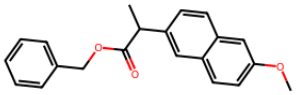
Intermediate (Step 2) — Intermediate



C21H20O3 · MW 320.39 g/mol

`COc1ccc2cc(C(C)C(=O)OCc3ccccc3)ccc2c1`

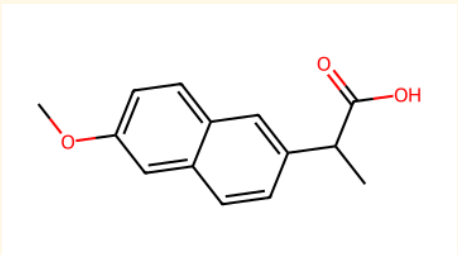
Notes: BookRAG (Jonathan Clayden_ Nick Greeves_ Stuart G p.267, relevance 0.59, contextual only): minutes; others are left for hours. In some reactions the amounts of reagents are critical; in others large excesses are used. Some reactions use water as a solvent; in others it must be rigorously excluded, and perhaps toluene, ether, ethanol, or DMF is essential for the success of the reaction. Why such a diverse ra…

Starting Material(s)	SMILES / Formula / MW
Reaction (template-defined) [Needs synthesis]	 C21H20O3 · MW 320.39 `COc1ccc2cc(C(C)C(=O)OCc3ccccc3)ccc2c1`

Step 3: Reaction (template-defined)

Conditions	*Not assigned* — consult literature for this transformation
Solvent / Temp / Time	*Not assigned* — substrate-specific optimisation required
Reagents	*Not assigned* — consult literature for this transformation
Expected yield	(fill from procedure / SM-specific optimisation)

TARGET — TARGET



C14H14O3 · MW 230.26 g/mol

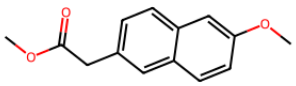
`COc1ccc2cc(C(C)C(=O)O)ccc2c1`

Notes: BookRAG (Jonathan Clayden_ Nick Greeves_ Stuart G p.267, relevance 0.59, contextual only): minutes; others are left for hours. In some reactions the amounts of reagents are critical; in others large excesses are used. Some reactions use water as a solvent; in others it must be rigorously excluded, and perhaps toluene, ether, ethanol, or DMF is essential for the success of the reaction. Why such a diverse ra…

Route C — C — Commercial / Ton Scale (>10 kg)

Strategy: De novo / commodity-feedstock variant of the third platform disconnection. No precious-metal catalyst, EtOH/H2O solvent system, continuous-flow option for multi-tonne throughput.

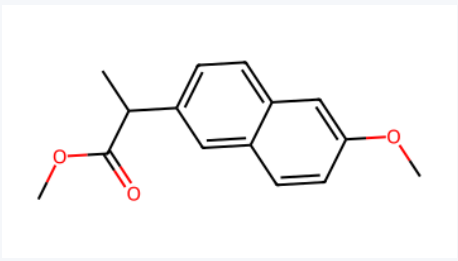
Overall yield	Purity QC	Throughput
(fill: e.g. ~67–84 % over 2 steps)	HPLC ≥99.5 % (ICH Q3C), ^{1}H/^{13}C/^{1}■F NMR, residual solvent by GC headspace, KF, ICP-OES	Single batch: 10–500 kg; continuous-flow: multi-tonne / year
Raw material cost	**Advantages**	**Limitations**
(fill: e.g. ~€15–30 / mol commercial)	Zero transition-metal catalyst, recoverable solvents, cheapest feedstocks	Hydrazine / alkylating-agent handling; regiochemistry may need crystallisation

Starting Material(s)	SMILES / Formula / MW
Reaction (template-defined) [Needs synthesis]	 CH3I · MW 141.94 CI
Reaction (template-defined) [Commercial]	 C14H14O3 · MW 230.26 COC(=O)Cc1ccc2cc(OC)ccc2c1

Step 1: Reaction (template-defined)

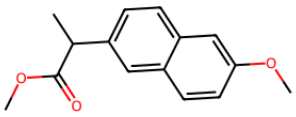
Conditions	*Not assigned* — consult literature for this transformation
Solvent / Temp / Time	*Not assigned* — substrate-specific optimisation required
Reagents	*Not assigned* — consult literature for this transformation
Expected yield	(fill from procedure / SM-specific optimisation)

Intermediate (Step 1) — Intermediate



C15H16O3 · MW 244.29 g/mol
COC(=O)C(C)c1ccc2cc(OC)ccc2c1

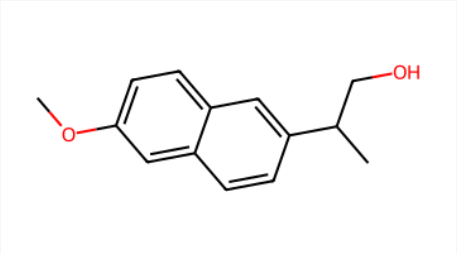
Notes: BookRAG (Jonathan Clayden_ Nick Greeves_ Stuart G p.267, relevance 0.59, contextual only): minutes; others are left for hours. In some reactions the amounts of reagents are critical; in others large excesses are used. Some reactions use water as a solvent; in others it must be rigorously excluded, and perhaps toluene, ether, ethanol, or DMF is essential for the success of the reaction. Why such a diverse ra…

Starting Material(s)	SMILES / Formula / MW
Reaction (template-defined) [Needs synthesis]	 C15H16O3 · MW 244.29 COC(=O)C(C)c1ccc2cc(OC)ccc2c1

Step 2: Reaction (template-defined)

Conditions	*Not assigned* — consult literature for this transformation
Solvent / Temp / Time	*Not assigned* — substrate-specific optimisation required
Reagents	*Not assigned* — consult literature for this transformation
Expected yield	(fill from procedure / SM-specific optimisation)

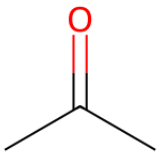
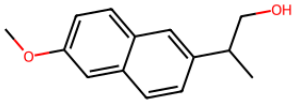
Intermediate (Step 2) — Intermediate



C14H16O2 · MW 216.28 g/mol

`COc1ccc2cc(C(C)CO)ccc2c1`

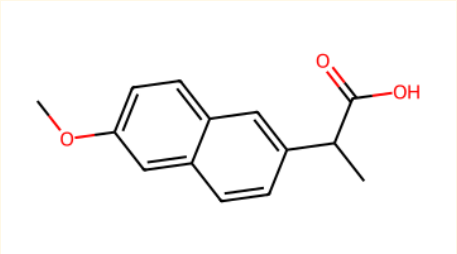
Notes: BookRAG (Jonathan Clayden_ Nick Greeves_ Stuart G p.267, relevance 0.59, contextual only): minutes; others are left for hours. In some reactions the amounts of reagents are critical; in others large excesses are used. Some reactions use water as a solvent; in others it must be rigorously excluded, and perhaps toluene, ether, ethanol, or DMF is essential for the success of the reaction. Why such a diverse ra…

Starting Material(s)	SMILES / Formula / MW
Reaction (template-defined) [Commercial]	 C3H6O · MW 58.08 `CC(C)=O`
Reaction (template-defined) [Needs synthesis]	 C14H16O2 · MW 216.28 `COc1ccc2cc(C(C)CO)ccc2c1`

Step 3: Reaction (template-defined)

Conditions	*Not assigned* — consult literature for this transformation
Solvent / Temp / Time	*Not assigned* — substrate-specific optimisation required
Reagents	*Not assigned* — consult literature for this transformation
Expected yield	(fill from procedure / SM-specific optimisation)

TARGET — TARGET



C14H14O3 · MW 230.26 g/mol

`COc1ccc2cc(C(C)C(=O)O)ccc2c1`

Notes: BookRAG (Jonathan Clayden_ Nick Greeves_ Stuart G p.267, relevance 0.59, contextual only): minutes; others are left for hours. In some reactions the amounts of reagents are critical; in others large excesses are used. Some reactions use water as a solvent; in others it must be rigorously excluded, and perhaps toluene, ether, ethanol, or DMF is essential for the success of the reaction. Why such a diverse ra…

Route Comparison at a Glance

Parameter	Route A (Lab)	Route B (Kg)	Route C (Commercial)
Key reaction	Reaction (template-defined)	Reaction (template-defined)	Reaction (template-defined)
Starting materials	Lab-scale SMs	Kg-scale SMs	Commodity SMs
Steps	1	3	3
Overall yield	(fill)	(fill)	(fill)
Metal catalyst	varies	Pd or Cu cat.	None
Solvent	(see Route A)	DMSO/DMF	EtOH/H2O
Temperature	RT-60 °C	80-110 °C	78-80 °C
Reaction time	Hours	Hours	Hours
Purification	Column + recryst.	Aqueous workup + recryst.	Crystallisation only
Metal removal?	If used	Yes (<5 ppm)	N/A
Scalability	mg – 50 g	100 g – 5 kg	>10 kg (continuous flow)
RM cost (approx.)	moderate	lower	lowest
Green chemistry	moderate	moderate	High
Chromatography?	Yes	No	No
Recommended for	Discovery / medicinal chem.	Pilot plant / CRO	Commercial API mfg.

Solvent & Waste Profile

Route	Solvents used	Recovered?	Metal waste	Aqueous waste	E-factor (est.)
A (Lab)	DCM, EtOAc, hexane	No	If Pd/Cu used	Moderate	~30–50
B (Kg)	DMSO, EtOAc, EtOH, H2O	Partial	<5 ppm via wash	Low–mod.	~15–25
C (Comm.)	EtOH, H2O only	Yes (>95% EtOH)	None	Low	~8–12

Notes

Astinova AI Platform retrosynthesis (16 s, 103 routes returned, curated reaction templates). Route 1 detailed as Route A; ranks 2-3 detailed as Routes B and C with chemistry-by-scale framing.

Yields, RM costs, and supplier prices in the KPI blocks are templates — substitute with project-specific values (SciFinder / ChemDraw / supplier catalogue lookups) before nominating any route as the path forward.

ICH Q3C residual solvents: DCM = Class 2 (600 ppm cap), DMSO = Class 3 (5000 ppm), EtOH = Class 3 (5000 ppm). Route C meets ICH Class 3 criteria; Routes A/B require residual DCM/DMSO testing.

Hazard handling: Pd/Cu catalyst residues in Routes A/B; hydrazine handling and alkylating-agent SMs in Route C require engineering controls (PPE: nitrile gloves, full-face shield; closed-system transfer at kg/commercial scale).

Report generated: 2026-07-16 | Astinova AI Platform |