Scheme 1. (a) TEA (1.1 eq), chloroacetyl chloride (1.1 eq), THF, 0°C to 25°C, 6 hr, ; (b) PCl_3 (1.2 eq), EDIPA (1.0 eq), then aniline (1.1 eq), dioxane, 25°C to 70°C, 6 hr; (c) piperazine (3.0 eq), THF, 25°C, 14 hr; (d) EDIPA (1.2 eq), 4-DMAP (0.5 eq), acyl chloride (1.2 eq), CH_2Cl_2 0°C to 25°C, 3 hr -or- EDIPA (1.2 eq), carboxylic acid (1.1 eq), HBTU (1.2 eq), 30 min, then amine DMF, 12 hr; e) alkyl halide (1.5 eq), K_2CO_3 (1.2 eq), 60°C, DMF 24 hr; (f) EDIPA (1.2 eq), chloroacetyl chloride (1.2 eq), CH_2Cl_2 0°C to 25°C, 3 hr g) 4-chloroaniline (3.0 eq), DMF, 70°C, 12 hr.