

CRYSTALLINE SOLVATES AND COMPLEXES OF
(1S)-1,5-ANHYDRO-1-C-(3-((PHENYL)METHYL)PHENYL)-D-GLUCITOL DERIVATIVES WITH
AMINO ACIDS AS SGLT2 INHIBITORS FOR THE TREATMENT OF DIABETES

FIELD OF THE INVENTION

- 5 **[0001]** The present invention relates to free acid polymorphic crystal structures of SGLT2 Inhibitors, pharmaceutical compositions thereof, process for preparing such crystal structures, and methods of treating disorders, such as diabetes, therewith.

BACKGROUND OF THE INVENTION

- 10 **[0002]** Approximately 100 million people worldwide suffer from type II diabetes (NIDDM), which is characterized by hyperglycemia due to excessive hepatic glucose production and peripheral insulin resistance, the root causes for which are as yet unknown. Consistent control of plasma glucose levels in diabetes patients may offset the development of diabetic complications and beta cell failure seen in advanced
15 disease.

- [0003]** Plasma glucose is normally filtered in the kidney in the glomerulus and actively reabsorbed in the proximal tubule. Ninety percent of glucose reuptake in the kidney occurs in the epithelial cells of the early S1 segment of the renal cortical proximal tubule. SGLT2, a 672 amino acid protein containing 14 membrane-
20 spanning segments that is predominantly expressed in the early S1 segment of the renal proximal tubules, is likely to be the major transporter responsible for this reuptake. The substrate specificity, sodium dependence, and localization of SGLT2 are consistent with the properties of the high capacity, low affinity, sodium-dependent glucose transporter previously characterized in human cortical kidney proximal
25 tubules. In addition, hybrid depletion studies implicate SGLT2 as the predominant Na^+ /glucose cotransporter in the S1 segment of the proximal tubule, since virtually all Na-dependent glucose transport activity encoded in mRNA from rat kidney cortex is inhibited by an antisense oligonucleotide specific to rat SGLT2. In humans, mutations in SGLT2 have been associated with familial forms of renal glucosuria,
30 providing further evidence of the primary role of SGLT2 in renal glucose reabsorption. In such patients, renal morphology and renal function is otherwise

normal. Inhibition of SGLT2 would be predicted to reduce plasma glucose levels via enhanced glucose excretion in diabetic patients.

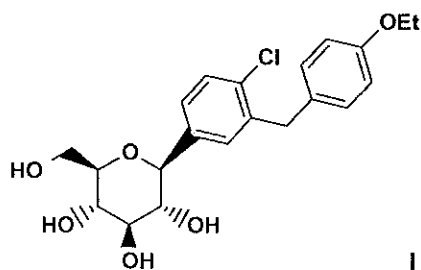
[0004] Selective inhibition of SGLT2 in diabetic patients could normalize plasma glucose by enhancing the excretion of glucose in the urine, thereby improving insulin sensitivity, and delaying the development of diabetic complications, in the absence of

5 significant gastrointestinal side effects.

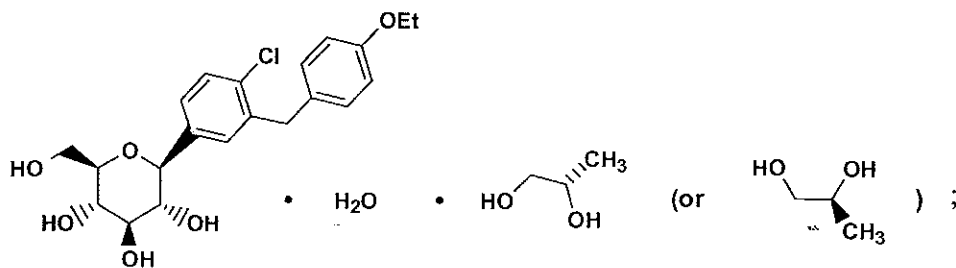
SUMMARY OF THE INVENTION

[0005] One aspect of the invention relates to crystal structures of a compound of

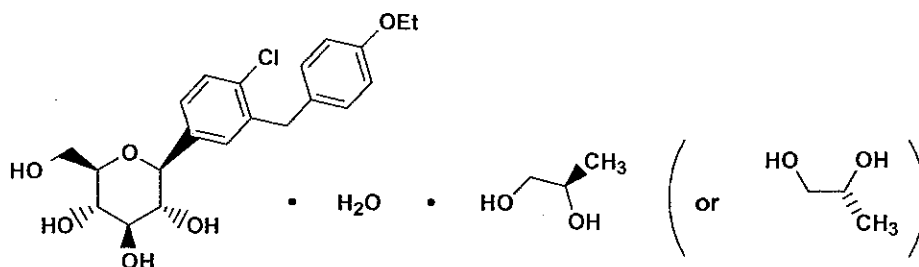
10 the formula I



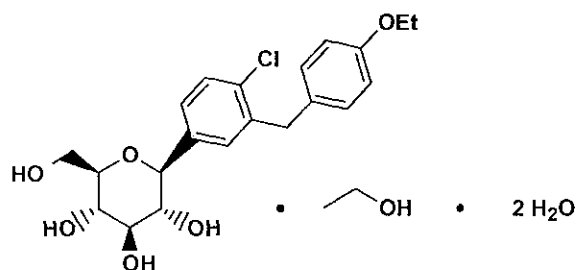
pharmaceutical compositions containing crystal structures of compound I, including the (S)-propylene glycol ((S)-PG) structure Ia which is form SC-3



15 the (R)-propylene glycol ((R)-PG) structure Ib which is form SD-3



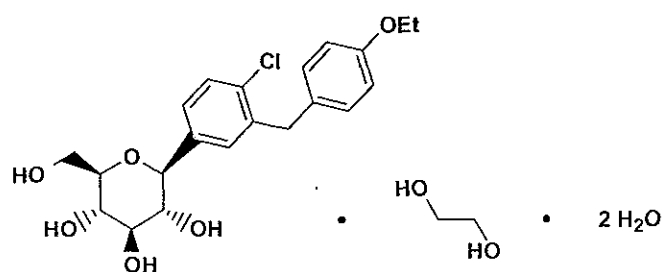
the ethanol or mono-ethanol dihydrate structure Ic which is form SA-1



Compound Ic

;

the ethylene glycol structure Id which is form SB-1

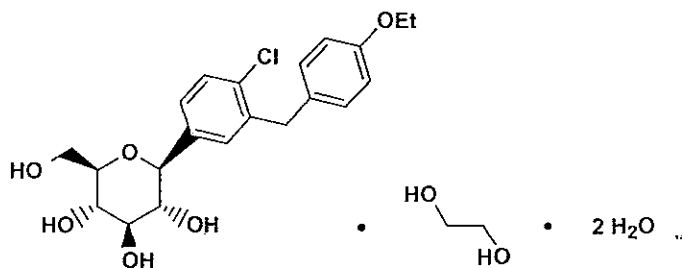


Ethylene Glycol
Form SB-1

Compound Id

; and

5 the ethylene glycol structure Ie which is form SB-2



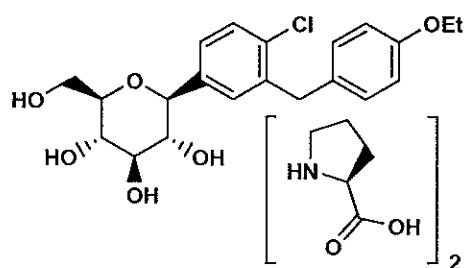
Ethylene Glycol
Form SB-2

Compound Ie

;

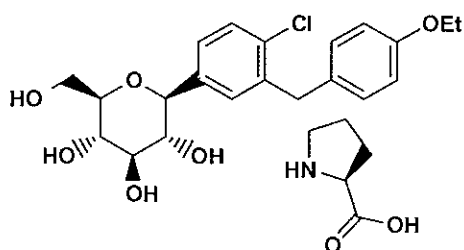
processes for preparing such crystal structures;

the 1:2 crystalline complex with L-proline structure Ih which is form 3



Compound Ih ;

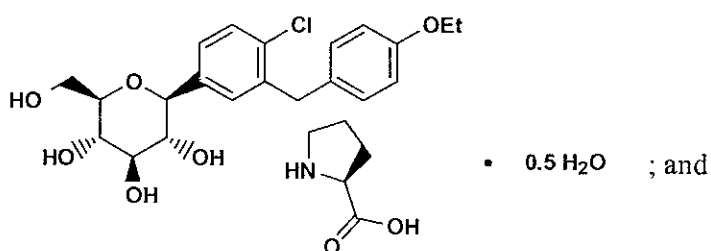
the 1:1 crystalline complex with L-proline structure Ii which is form 6



Compound Ii ;

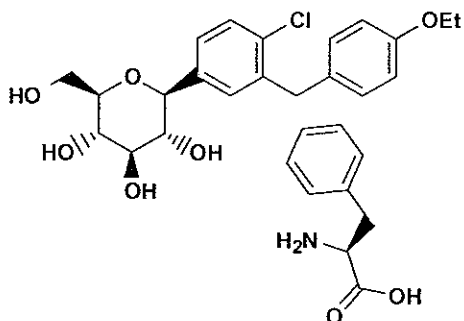
the hemihydrate of the 1:1 crystalline complex with L-proline structure Ij

5 which is form H.5-2



Compound Ij

the 1:1 crystalline complex with L-phenylalanine structure Ik which is form 2

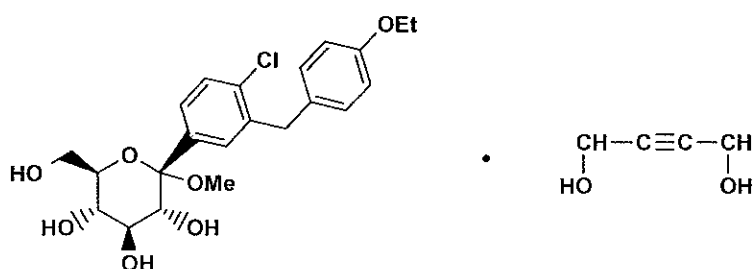


Compound Ik ; and

methods of treating diabetes and related diseases using the crystal structures of the compound I, compound Ia, compound Ib, compound Ih, compound Ii, compound Ij and compound Ik, and compound II as defined herein.

- 5 [0006] The compound of formula I in the form of a non-crystalline solid is disclosed in U.S. Patent No. 6,515,117, the disclosure of which in its entirety is incorporated herein by reference.

[0007] In addition, in another aspect of the invention, a crystalline of compound If which has the structure



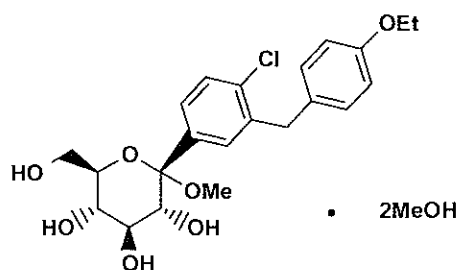
10

If ;

(also referred to as the “1,4-butyne-diol solvate” or “butyne-diol solvate”); and

a process for preparing such crystal structure and using such crystal structure to prepare crystalline compound Ia (S)-PG are also provided.

- 15 [0008] In still another aspect of the present invention, a crystalline compound Ig which has the structure



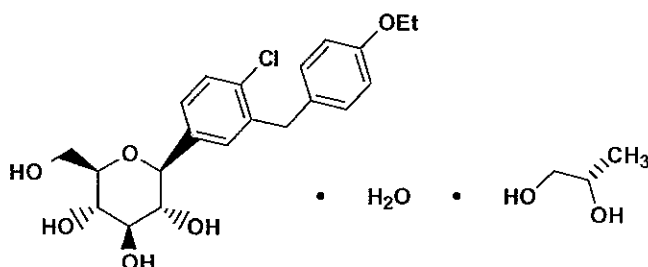
Ig

also referred to as the “dimethanol solvate”, and a process for preparing the dimethanol solvate Ig and using Ig to prepare crystalline compound Ia (S)-PG are also provided.

20

[0009] The dimethanol solvate Ig and the 1,4-butyne-diol solvate If may be used as intermediates in the preparation of crystalline compound of formula I of the invention.

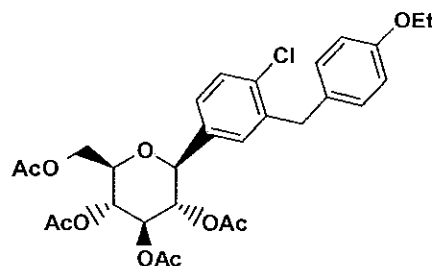
- 5 [0010] In yet another aspect of the present invention, a process for the preparation of the crystalline compound (S)-PG of the structure Ia (SC-3 form) is provided



Compound Ia

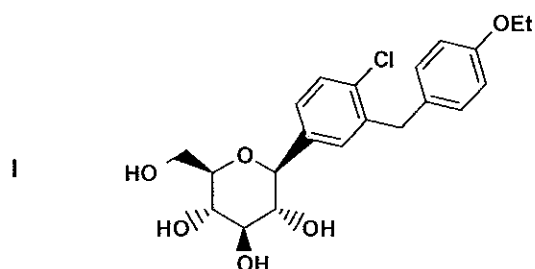
which includes the steps of providing a compound A (prepared as described in U.S. application Serial No. 10/745,075 filed December 23, 2003, Examples 17 to 20), of

- 10 the structure



Compound A

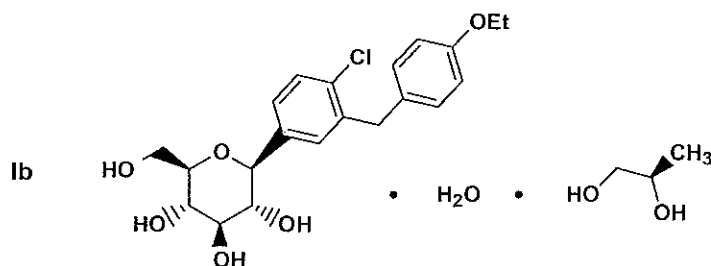
- treating compound A with an alcohol solvent such as methanol or ethanol, and aqueous base such as sodium hydroxide, and water, if necessary, under an inert atmosphere, and elevated temperature, if necessary, adding an acid such as
- 15 hydrochloric acid to neutralize the reaction mixture, to form compound I of the structure



Compound I

and treating the reaction mixture containing compound I with an organic solvent such as methyl t-butyl ether, an alkyl acetate such as ethyl acetate, methyl acetate, isopropyl acetate, or butyl acetate, and (S)-propylene glycol, optionally adding seeds of (S)-PG compound Ia (SC-3) to the mixture, to form (S)-PG compound Ia (SC-3 form).

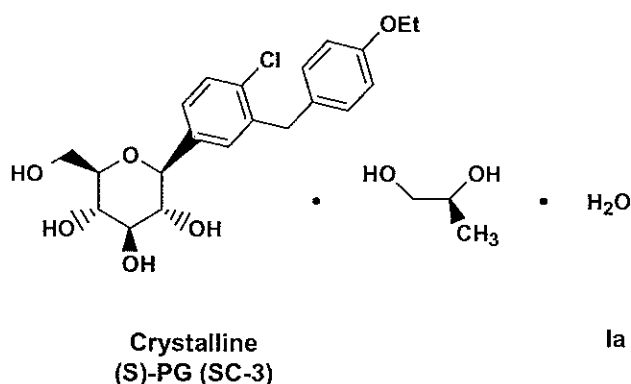
[0011] In still another aspect of the present invention, a process for preparing the crystalline compound (R)-PG of the structure Ib (SD-3 form)



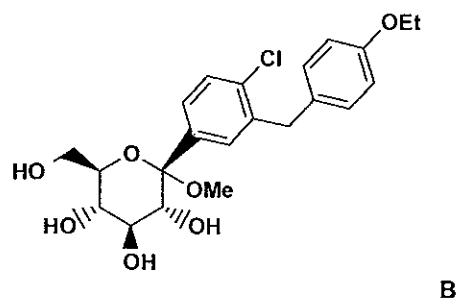
(R)-propylene glycol

is provided which is similar to the process for preparing (S)-PG (SC-3 form) Ia described above except that (R)-propylene glycol is employed in place of (S)-propylene glycol.

[0012] In still another aspect of the invention, a novel process is provided for preparing compound Ia

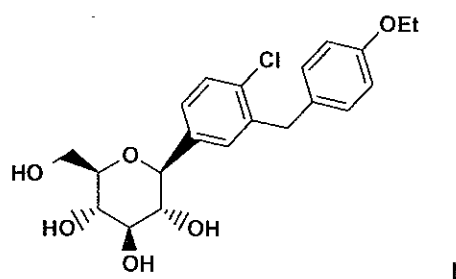


which includes the step of reducing a compound B of the structure



to remove the methoxy group by treating compound B (prepared as described in U.S.

- 5 Application Serial No. 10/745,075 filed December 23, 2003, Example 17), or a crystalline solvate such as the dimethanol solvate Ig or the 1,4-butyne-diol solvate (If), with a reducing agent, such as triethylsilyl hydride and an activating group which is a Lewis acid such as $\text{BF}_3 \cdot \text{Et}_2\text{O}$ or $\text{BF}_3 \cdot 2\text{CH}_3\text{COOH}$, preferably $\text{BF}_3 \cdot 2\text{CH}_3\text{COOH}$, and an organic solvent such as CH_3CN , and added water, separating out the
- 10 compound of the structure I



and treating compound I with (S)-propylene glycol in the presence of a solvent such as t-butylmethyl ether, optionally with seeds of compound Ia ((S)-PG), to form a crystal slurry of compound Ia ((S)-PG) and separating out compound Ia ((S)-PG).

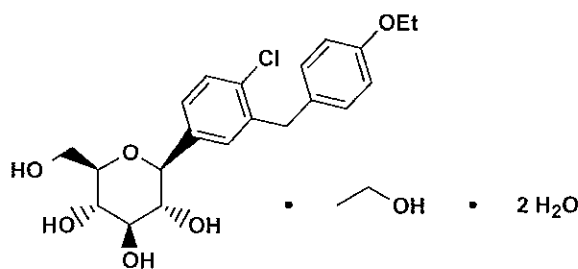
[0013] The above process of the invention is a one-pot operation which minimizes the production of intermediates, resulting in improved yield and priority of the final crystalline compound Ia.

[0014] The crystalline compound Ia which is also referred to as the (S)-propylene glycol solvate of compound I is a novel crystalline structure and is part of the present invention.

[0015] The compound of formula B (amorphous form) is disclosed in U.S. application Serial No. 10/745,075 filed December 23, 2003, the disclosure of which in its entirety is incorporated herein by reference.

10

[0016] In another aspect of the present invention, a process is provided for preparing the mono-EtOH-dihydrate (ethanol or EtOH structure) form SA-1 having the structure Ic

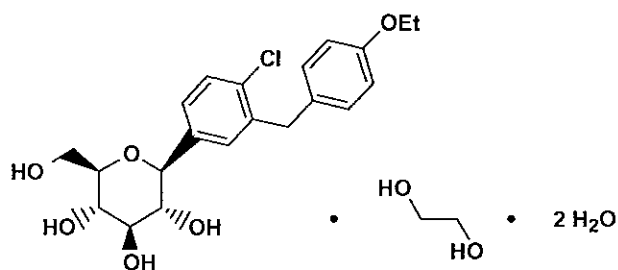


Ic

15 which includes the steps of dissolving compound I in ethanol and cooling the solution to -20°C to form crystals of formula Ic form SA-1.

[0017] Compound I may be prepared by dissolving compound A in ethanol by preferably heating to a boil to form an oily product which is compound I.

20 [0018] In yet another embodiment of the invention, a process is provided for forming the ethylene glycol dihydrate structure of formula Id



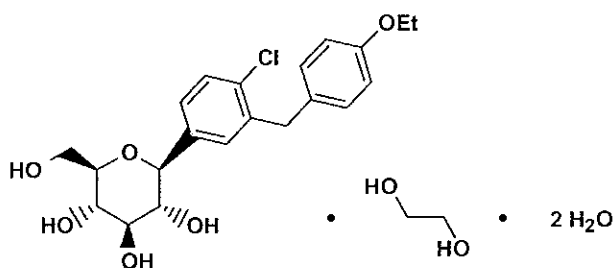
Ethylene Glycol
Form SB-1

Id

which includes the steps of dissolving compound I in aqueous ethylene glycol preferably with heating,

- optionally, upon cooling, adding seeds of the (S)-propylene glycol crystal form SC-3 (Ia) to the above solution, and recovering crystals of ethylene glycol dihydrate form SB-1 (Id).

[0019] In an additional embodiment of the invention, a process is provided for forming the ethylene glycol dihydrate structure form SB-2



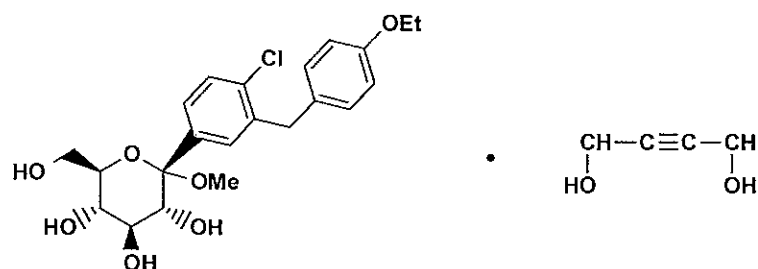
Ethylene Glycol
Form SB-2

Ie.

which includes the steps of:

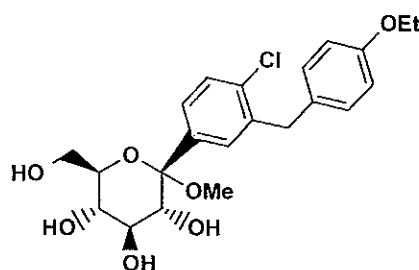
- dissolving compound I in aqueous ethylene glycol, preferably with heating;
optionally, upon cooling, adding seeds of the mono-EtOH-dihydrate crystal form SA-1 (Ic) to the above solution; and
recovering crystals of ethylene glycol dihydrate form SB-2 (Ie).

[0020] In yet another embodiment of the present invention, a process is provided for preparing the crystalline 1,4-butyne-diol solvate If



If

which includes the steps of dissolving the base compound B

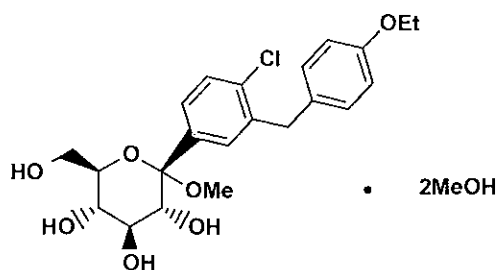


B

in an alkyl acetate such as ethyl acetate, propyl acetate or butyl acetate or an alcohol
 5 such as isopropanol or butanol, or water, adding 2-butyne-1,4-diol to the solution of
 compound B, heating the resulting mixture until the diol dissolves, cooling the
 mixture, and recovering crystals of 1,4-butyne-diol solvate If. Toluene or heptane
 may be employed as an antisolvent when the solvate If is crystallized in an alkyl
 acetate.

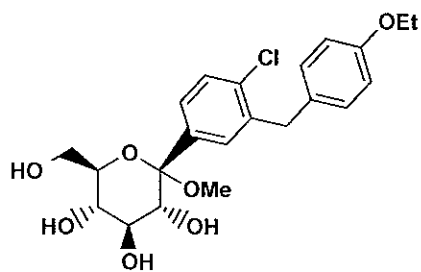
10 [0021] The 1,4-butyne-diol solvate If can be isolated and used to prepare
 compound I or compound Ia in a continuous process or batch process as described
 hereinafter.

[0022] In addition, in another aspect of the present invention, a process for
 15 preparing the crystalline dimethanol solvate Ig is provided



Ig

wherein the base compound B

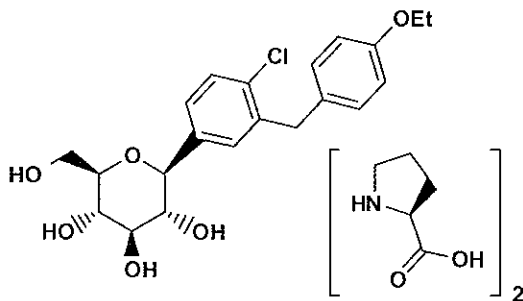
**B**

is treated with methanol to form the crystalline dimethanol solvate Ig.

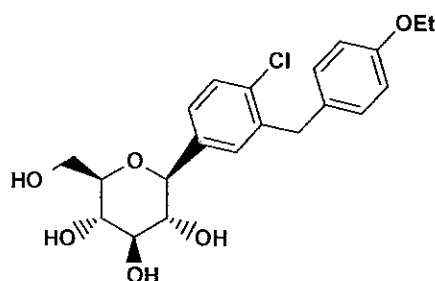
[0023] Still further in accordance with the invention, a process is provided for
 5 preparing the crystalline dimethanol solvate Ig wherein the base compound B is
 dissolved in a mixture of methanol/toluene or in a mixture of
 methanol/toluene/heptane, or in a mixture of methanol/toluene/ethyl acetate or other
 alkyl acetate, with seeding with seeds of dimethanol solvate Ig.

[0024] The dimethanol solvate Ig and the 1,4-butyne-diol solvate If may be used
 10 to prepare crystalline compound Ia as described herein.

[0025] In yet another aspect of the present invention, a process for the preparation
 of the crystalline 1:2 complex with L-proline of the structure Ih (form 3) is provided

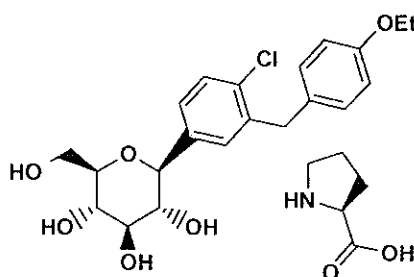
**Compound Ih**

15 which includes the steps of providing compound I of the structure

**Compound I**

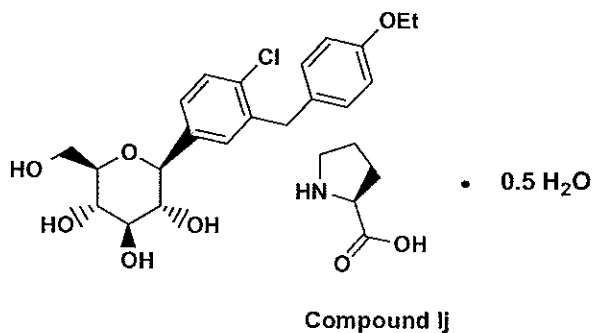
forming a solution of L-proline in water and an alcohol solvent such as methanol, ethanol or isopropanol heated to a temperature within the range from about 70 to about 95°C, treating compound I in an alcohol solvent such as methanol, ethanol, or isopropanol, with the heated solution of L-proline (containing two times the number of moles of L-proline as compound I), and cooling the resulting solution to about room temperature to form compound Ih.

[0026] In still another aspect of the present invention, a process for preparing the crystalline compound 1:1 complex with L proline of the structure Ii (form 6) is provided

**Compound Ii**

which includes the steps of providing compound I, treating a solution of compound I in an alcohol solvent such as ethanol or methanol with a boiling solution of L-proline in an alcohol/water solvent such as ethanol/water (employing about five times as much compound I as L-proline), and cooling the resulting mixture (for example to from about -10 to about -25°C) to form compound Ii.

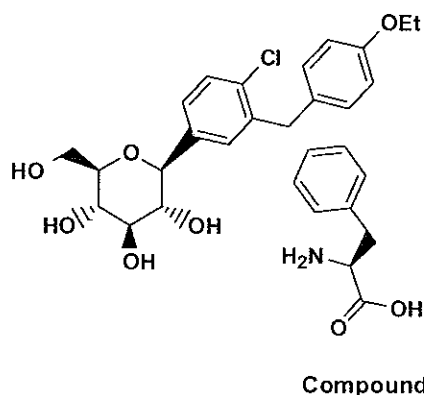
[0027] In still another aspect of the present invention, a process for the preparation of the crystalline hemihydrate of the 1:1 complex with L-proline of the structure Ij (form H.5-2) which has the structure



- 5 is provided which includes the steps of providing seed crystals of the 1:1 complex with L-proline (structure Ii, form 6), mixing the seed crystals Ii, form 6 with a cooled solution of (-10 to -25°C) of L-proline and compound I in an alcohol/water solvent, and cooling the resulting mixture at a temperature from about -10 to -25°C to form the hemihydrate structure Ij (form H.5-2).

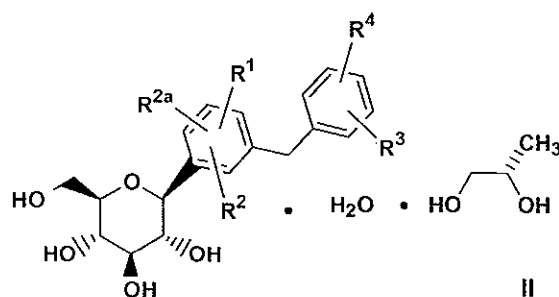
10

[0028] In yet another aspect of the present invention, a process for preparing the 1:1 crystalline complex with L-phenylalanine structure Ik form 2



- 15 is provided, which includes the steps of forming a solution of L-phenylalanine in water heated at from about 75 to about 85°C, mixing the L-phenylalanine solution with compound I, heating the resulting solution to from about 75 to about 85°C, and allowing the resulting solution to cool to room temperature to form compound Ik.

[0029] Another aspect of the invention relates to crystal structures of a compound of the formula II



which is also referred to as the (S)-propylene glycol ((S)-PG) crystalline structure II,
 5 wherein:

R^1 , R^2 and R^{2a} are independently hydrogen, OH, OR^5 , alkyl, $-OCHF_2$, $-OCF_3$, $-SR^{5a}$ or halogen;

R^3 and R^4 are independently hydrogen, OH, OR^{5b} , alkyl, alkenyl, alkynyl, cycloalkyl, CF_3 , $-OCHF_2$, $-OCF_3$, halogen, $-CONR^{6a}$, $-CO_2R^{5c}$, $-CO_2H$, $-COR^{6b}$,
 10 $-CH(OH)R^{6c}$, $-CH(OR^{5d})R^{6d}$, $-CN$, $-NHCOR^{5e}$, $-NHSO_2R^{5f}$, $-NHSO_2Aryl$, $-SR^{5g}$, $-SOR^{5h}$, $-SO_2R^{5i}$, $-SO_2Aryl$, or a five, six or seven membered heterocycle which may contain 1 or 4 heteroatoms in the ring which are N, O, S, SO, and/or SO_2 , or R^3 and R^4 together with the carbons to which they are attached form an annelated five, six or seven membered carbocycle or heterocycle which may contain 1 to 4 heteroatoms in
 15 the ring which are N, O, S, SO, and/or SO_2 ;

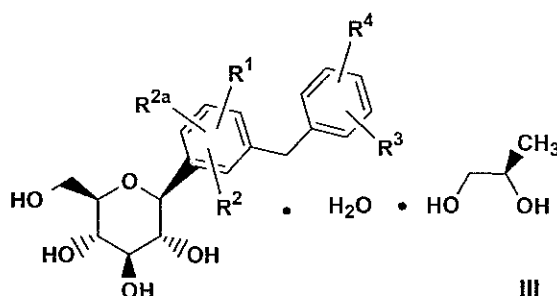
R^5 , R^{5a} , R^{5b} , R^{5c} , R^{5d} , R^{5e} , R^{5f} , R^{5g} , R^{5h} and R^{5i} are independently alkyl; and

R^6 , R^{6a} , R^{6b} , R^{6c} and R^{6d} are independently hydrogen, alkyl, aryl, alkylaryl or cycloalkyl, or R^6 and R^{6a} together with the nitrogen to which they are attached form an annelated five, six or seven membered heterocycle which may contain 1 to 4
 20 heteroatoms in the ring which are N, O, S, SO, and/or SO_2 .

[0030] In addition, in accordance with the invention, pharmaceutical compositions containing a crystal structure of compound II and processes for preparing such crystal structure II are also provided.

25

[0031] Still another aspect of the invention relates to crystal structures of a compound of the formula III



which is also referred to as the (R)-propylene glycol ((R)-PG) crystalline structure III, wherein

R^1 , R^2 and R^{2a} are independently hydrogen, OH, OR^5 , alkyl, $-OCHF_2$, $-OCF_3$, $-SR^{5a}$ or halogen;

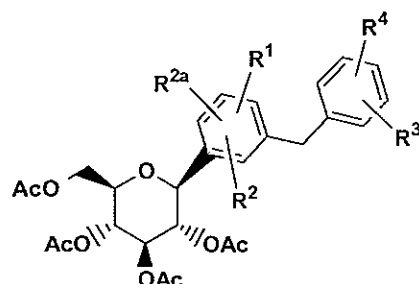
R^3 and R^4 are independently hydrogen, OH, OR^{5b} , alkyl, alkenyl, alkynyl, cycloalkyl, CF_3 , $-OCHF_2$, $-OCF_3$, halogen, $-CONR^6R^{6a}$, $-CO_2R^{5c}$, $-CO_2H$, $-COR^{6b}$, $-CH(OH)R^{6c}$, $-CH(OR^{5d})R^{6d}$, $-CN$, $-NHCOR^{5e}$, $-NHSO_2R^{5f}$, $-NHSO_2Aryl$, $-SR^{5g}$, $-SOR^{5h}$, $-SO_2R^{5i}$, $-SO_2Aryl$, or a five, six or seven membered heterocycle which may contain 1 to 4 heteroatoms in the ring which are N, O, S, SO, and/or SO_2 , or R^3 and R^4 together with the carbons to which they are attached form an annelated five, six or seven membered carbocycle or heterocycle which may contain 1 to 4 heteroatoms in the ring which are N, O, S, SO, and/or SO_2 ;

R^5 , R^{5a} , R^{5b} , R^{5c} , R^{5d} , R^{5e} , R^{5f} , R^{5g} , R^{5h} and R^{5i} are independently alkyl; and R^6 , R^{6a} , R^{6b} , R^{6c} and R^{5d} are independently hydrogen, alkyl, aryl, alkylaryl or cycloalkyl, or R^6 and R^{6a} together with the nitrogen to which they are attached form an annelated five, six or seven membered heterocycle which may contain 1 to 4 heteroatoms in the ring which are N, O, S, SO, and/or SO_2 .

[0032] In addition, in accordance with the invention, pharmaceutical compositions containing crystal structure of compound III and to processes for preparing such crystal structure III are also provided.

[0033] In yet another aspect of the present invention, a process for the preparation of the crystalline compound (S)-PG of the structure II is provided which includes the steps of providing a compound C (including where R^3 or R^4 is alkenyl or alkynyl, all

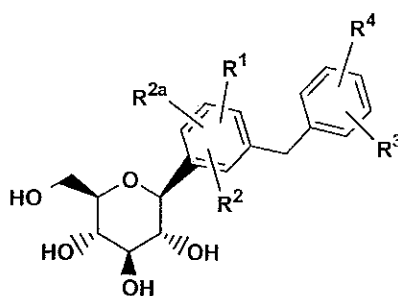
of which may be prepared using procedures as described in U.S. application Serial No. 10/745,075 filed December 23, 2003, Examples 17 to 20), of the structure



Compound C

wherein R^1 , R^2 , R^{2a} , R^3 and R^4 are as described above;

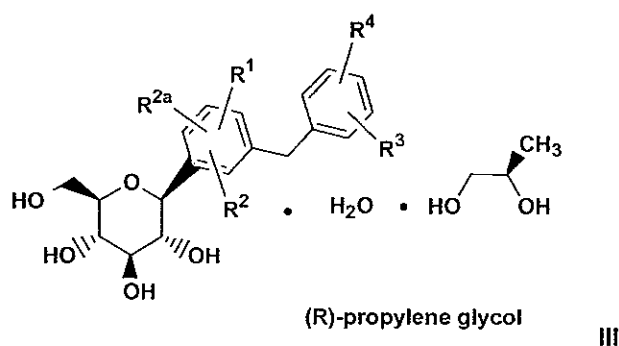
- 5 treating compound C with an alcohol solvent such as methanol, and aqueous base such as sodium hydroxide, and water, if necessary, under an inert atmosphere, and elevated temperature to form compound D of the structure



Compound D

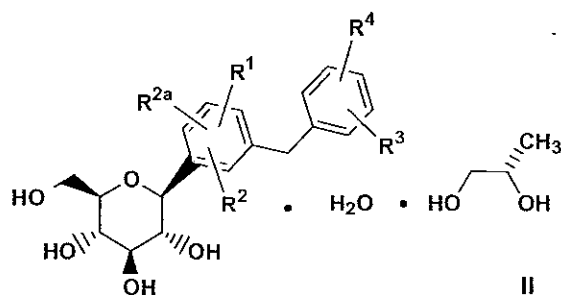
- and treating the reaction mixture containing compound D with an organic solvent
- 10 such as methyl t-butyl ether, an alkyl acetate such as ethyl acetate, methyl acetate, isopropyl acetate, or butyl acetate, and (S)-propylene glycol, optionally adding seeds of (S)-PG compound II to the mixture, to form (S)-PG compound II.

- [0034] In still another aspect of the present invention, a process for preparing the
- 15 crystalline compound (R)-PG of the structure III

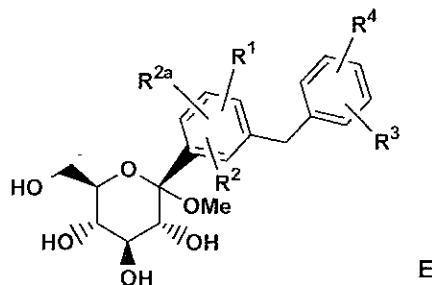


is provided which is similar to the process for preparing (S)-PG II described above except that (R)-propylene glycol is employed in place of (S)-propylene glycol.

- 5 [0035] In still another aspect of the invention, a novel process is provided for preparing compound II



which includes the step of reducing a compound E of the structure



- 10 (which is disclosed in U.S. application Serial No. 10/745,075 filed December 23, 2003) to remove the methoxy group by treating compound E with a reducing agent, such as triethylsilyl hydride and an activating group which is a Lewis acid such as $\text{BF}_3 \cdot \text{Et}_2\text{O}$, and an organic solvent such as CH_3CN , and water, separating out the compound of the structure D and treating compound D with (S)-propylene glycol in
- 15 the presence of a solvent such as t-butylmethyl ether, optionally with seeds of

compound II ((S)-PG), to form a crystal slurry of compound II ((S)-PG) and separating out compound II ((S)-PG).

[0036] The above process of the invention is a one-pot operation which minimizes the production of intermediates.

5

BRIEF DESCRIPTION OF THE FIGURES

[0037] The invention is illustrated by reference to the accompanying drawings described below.

[0038] FIGURE 1 shows calculated (simulated at 25°C) and observed
10 (experimental at room temperature) powder X-ray diffraction patterns of the (S)-PG crystalline structure Ia, SC-3 form.

[0039] FIGURE 2 shows observed (experimental at room temperature) powder X-ray diffraction pattern of the (R)-PG crystalline structure Ib.

[0040] FIGURE 3 shows ¹³C NMR CPMAS spectrum for the (S)-PG crystalline
15 structure Ia SC-3 form.

[0041] FIGURE 4 shows ¹³C NMR CPMAS spectrum for the (R)-PG crystalline structure of Ib.

[0042] FIGURE 5 shows a thermogravimetric analysis (TGA) curve of the (S)-PG crystalline structure of Ia, SC-3 form.

20 [0043] FIGURE 6 shows a thermogravimetric analysis (TGA) curve of the (R)-PG crystalline structure of Ib, SD-3 form.

[0044] FIGURE 7 shows a differential scanning calorimetry (DSC) thermogram of the (S)-PG crystalline structure of the compound of form Ia, SC-3 form.

[0045] FIGURE 8 shows a differential scanning calorimetry (DSC) thermogram
25 of the (R)-PG crystalline structure of Ib.

[0046] FIGURE 9 shows an observed (experimental at room temperature) powder X-ray diffraction pattern of the 1,4-butyne-diol solvate crystalline structure If.

[0047] FIGURE 10 shows an observed (experimental at room temperature) powder X-ray diffraction pattern of the dimethanol solvate crystalline structure Ig.

30 [0048] FIGURE 11 shows a differential scanning calorimetry (DSC) thermogram of the 1,4-butyne-diol solvate crystalline structure If.

[0049] FIGURE 12 shows a differential scanning calorimetry (DSC) thermogram of the dimethanol solvate crystalline structure of Ib.

[0050] FIGURE 13 shows calculated (simulated at -40°C), hybrid (at room temperature) and observed (experimental at room temperature) powder X-ray
5 diffraction patterns of the 1:2 L-proline complex crystalline structure Ih, form 3, N-1.

[0051] FIGURE 14 shows calculated (simulated at -40°C), hybrid (at room temperature) and observed (experimental at room temperature) powder X-ray diffraction pattern of the 1:1 L-proline complex crystalline structure Ii, form 6, N-1.

[0052] FIGURE 15 shows calculated (simulated at -40°C), hybrid (at room
10 temperature) and observed (experimental at room temperature) powder X-ray diffraction pattern of the 1:1 L-proline hemihydrate crystalline structure Ij, form H.5-2.

[0053] FIGURE 16 shows a thermogravimetric analysis (TGA) curve of the 1:2 L-proline complex crystalline structure of Ih, form 3, N-1.

15 [0054] FIGURE 17 shows a thermogravimetric analysis (TGA) curve of the 1:1 L-proline complex crystalline structure of Ii, form 6, N-1.

[0055] FIGURE 18 shows a thermogravimetric analysis (TGA) curve of the 1:1 L-proline hemihydrate crystalline structure Ij, form H.5-2.

[0056] FIGURE 19 shows a differential scanning calorimetry (DSC) thermogram
20 of the 1:2 L-proline complex crystalline structure Ih, form 3, N-1.

[0057] FIGURE 20 shows a differential scanning calorimetry (DSC) thermogram of the 1:1 L-proline crystalline complex structure of Ii, form 6, N-1.

[0058] FIGURE 21 shows a differential scanning calorimetry (DSC) thermogram of the 1:1 L-proline hemihydrate crystalline structure Ij, form H.5-2.

25 [0059] FIGURE 22 is a schematic representation of a continuous reaction set-up.

DETAILED DESCRIPTION OF THE INVENTION

[0060] The present invention provides, at least in part, crystalline structures of compound I as a novel material.

30 [0061] The term "pharmaceutically acceptable", as used herein, refers to those compounds, materials, compositions, and/or dosage forms which are, within the scope of sound medical judgment, suitable for contact with the tissues of human beings and

animals without excessive toxicity, irritation, allergic response, or other problem complications commensurate with a reasonable benefit/risk ratio. In certain preferred embodiments, the crystalline structures of compound I of the invention is in substantially pure form. The term "substantially pure", as used herein, means a compound having a purity greater than about 90% including, for example, about 91%, about 92%, about 93%, about 94%, about 95%, about 96%, about 97%, about 98%, about 99%, and about 100%.

[0062] The ability of a compound to exist in different crystal structures is known as polymorphism. As used herein "polymorph" refers to crystalline forms having the same chemical composition but different spatial arrangements of the molecules, atoms, and/or ions forming the crystal. While polymorphs have the same chemical composition, they differ in packing and geometrical arrangement, and may exhibit different physical properties such as melting point, shape, color, density, hardness, deformability, stability, dissolution, and the like. Depending on their temperature-stability relationship, two polymorphs may be either monotropic or enantiotropic. For a monotropic system, the relative stability between the two solid phases remains unchanged as the temperature is changed. In contrast, in an enantiotropic system there exists a transition temperature at which the stability of the two phases reverse. (Theory and Origin of Polymorphism in "Polymorphism in Pharmaceutical Solids" (1999) ISBN: 0-8247-0237).

[0063] Samples of the crystalline structures of the invention may be provided with substantially pure phase homogeneity, indicating the presence of a dominant amount of a single crystalline structure and optionally minor amounts of one or more other crystalline structures. The presence of more than one crystalline structure of the invention in a sample may be determined by techniques such as powder X-ray diffraction (PXRD) or solid state nuclear magnetic resonance spectroscopy (SSNMR). For example, the presence of extra peaks in the comparison of an experimentally measured PXRD pattern (observed) with a simulated PXRD pattern (calculated) may indicate more than one crystalline structure in the sample. The simulated PXRD may be calculated from single crystal X-ray data. (see Smith, D.K., "A FORTRAN Program for Calculating X-Ray Powder Diffraction Patterns," Lawrence Radiation Laboratory, Livermore, California, UCRL-7196, April 1963; see

also Yin. S., Scaringe, R.P., DiMarco, J., Galella, M. and Gougoutas, J.Z., *American Pharmaceutical Review*, 2003, 6, 2, 80). Preferably, the crystalline structure has substantially pure phase homogeneity as indicated by less than 10%, preferably less than 5 %, and more preferably less than 2 % of the total peak area in the

5 experimentally measured PXRD pattern arising from the extra peaks that are absent from the simulated PXRD pattern. Most preferred is a crystalline structure of the invention having substantially pure phase homogeneity with less than 1% of the total peak area in the experimentally measured PXRD pattern arising from the extra peaks that are absent from the simulated PXRD pattern.

10 [0064] The various crystalline structures of the invention described herein may be distinguishable from one another through the use of various analytical techniques known to one of ordinary skill in the art. Such techniques include, but are not limited to, solid state nuclear magnetic resonance (SSNMR) spectroscopy, X-ray powder diffraction (PXRD), differential scanning calorimetry (DSC), and/or
15 thermogravimetric analysis (TGA).

PREPARATION OF CRYSTAL STRUCTURES

[0065] The crystalline structures of the invention may be prepared by a variety of methods, including for example, crystallization or recrystallization from a suitable
20 solvent, sublimation, growth from a melt, solid state transformation from another phase, crystallization from a supercritical fluid, and jet spraying. Techniques for crystallization or recrystallization of crystalline structures from a solvent mixture include, for example, evaporation of the solvent, decreasing the temperature of the solvent mixture, crystal seeding a supersaturated solvent mixture of the molecule
25 and/or salt, freeze drying the solvent mixture, and addition of antisolvents (counter solvents) to the solvent mixture. High throughput crystallization techniques may be employed to prepare crystalline structures, including polymorphs.

[0066] Crystals of drugs, including polymorphs, methods of preparation, and characterization of drug crystals are discussed in *Solid-State Chemistry of Drugs*, S.R. Byrn, R.R. Pfeiffer, and J.G. Stowell, 2nd Edition, SSCI, West Lafayette, Indiana,
30 1999.

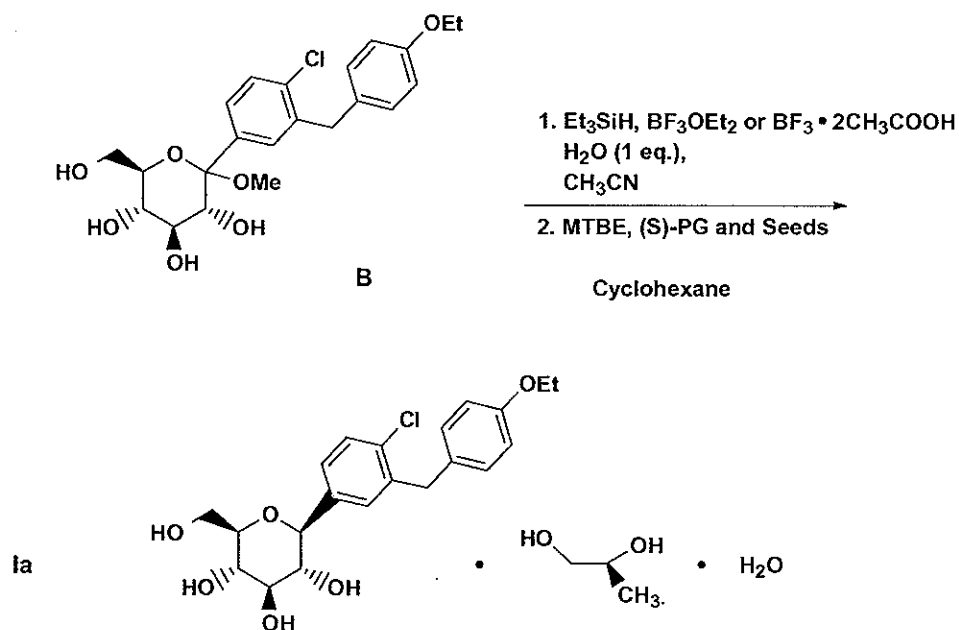
[0067] Seed crystals may be added to any crystallization mixture to promote crystallization. As will be clear to the skilled artisan, seeding is used as a means of controlling growth of a particular crystalline structure or as a means of controlling the particle size distribution of the crystalline product. Accordingly, calculation of the amount of seeds needed depends on the size of the seed available and the desired size of an average product particle as described, for example, in "Programmed cooling of batch crystallizers," J.W. Mullin and J. Nyvlt, *Chemical Engineering Science*, 1971, 26, 369-377. In general, seeds of small size are needed to effectively control the growth of crystals in the batch. Seeds of small size may be generated by sieving, milling, or micronizing of larger crystals, or by micro-crystallization of solutions. Care should be taken that milling or micronizing of crystals does not result in any change in crystallinity from the desired crystal structure (i.e. change to amorphous or to another polymorph).

[0068] As used herein, the term "room temperature" or "RT" denotes an ambient temperature from 20 to 25°C (68-77°F).

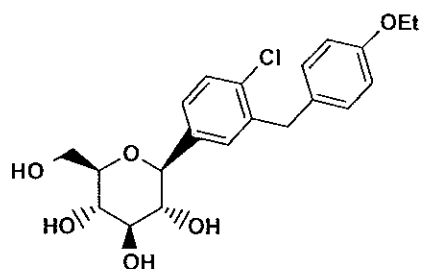
[0069] In general, in preparing crystalline compound Ia as described below, solvent(s) will be employed to enable formation of the crystalline compound Ia, preferably having a bulk density as described below.

[0070] The crystalline compound of the structure Ia (S-PG) SC-3 of the invention prepared according to the following telescoped reaction as shown in Scheme I.

SCHEME I



- [0071] As seen in Scheme I, compound B or If or Ig (collectively referred to as compound B) wherein compound B in the form of an amorphous solid or crystalline solid (If or Ig) is treated with a reducing agent such as a silyl hydride, preferably an alkylsilyl hydride, more preferably triethylsilane (or triethylsilyl hydride), in the presence of an activating group which is a Lewis acid, such as $\text{BCl}_3 \cdot \text{Me}_2\text{S}$, BBR_3 , BF_3OEt_2 , BCl_3 , or $\text{BF}_3 \cdot 2\text{CH}_3\text{COOH}$, preferably BF_3OEt_2 or $\text{BF}_3 \cdot 2\text{CH}_3\text{COOH}$ and an organic solvent such as CH_3CN , $\text{CH}_3\text{CN}/\text{toluene}$ or $\text{CH}_3\text{CN}/\text{dichloromethane}$, methylene chloride or water, at a temperature within the range from about -15 to about 25°C , preferably from about 5 to about 10°C , to reduce compound B and form the corresponding base compound I



- which is separated from the reaction mixture and treated with (S)-propylene glycol ((S)-PG) and an organic solvent such as an alkyl acetate as set out hereinbefore,

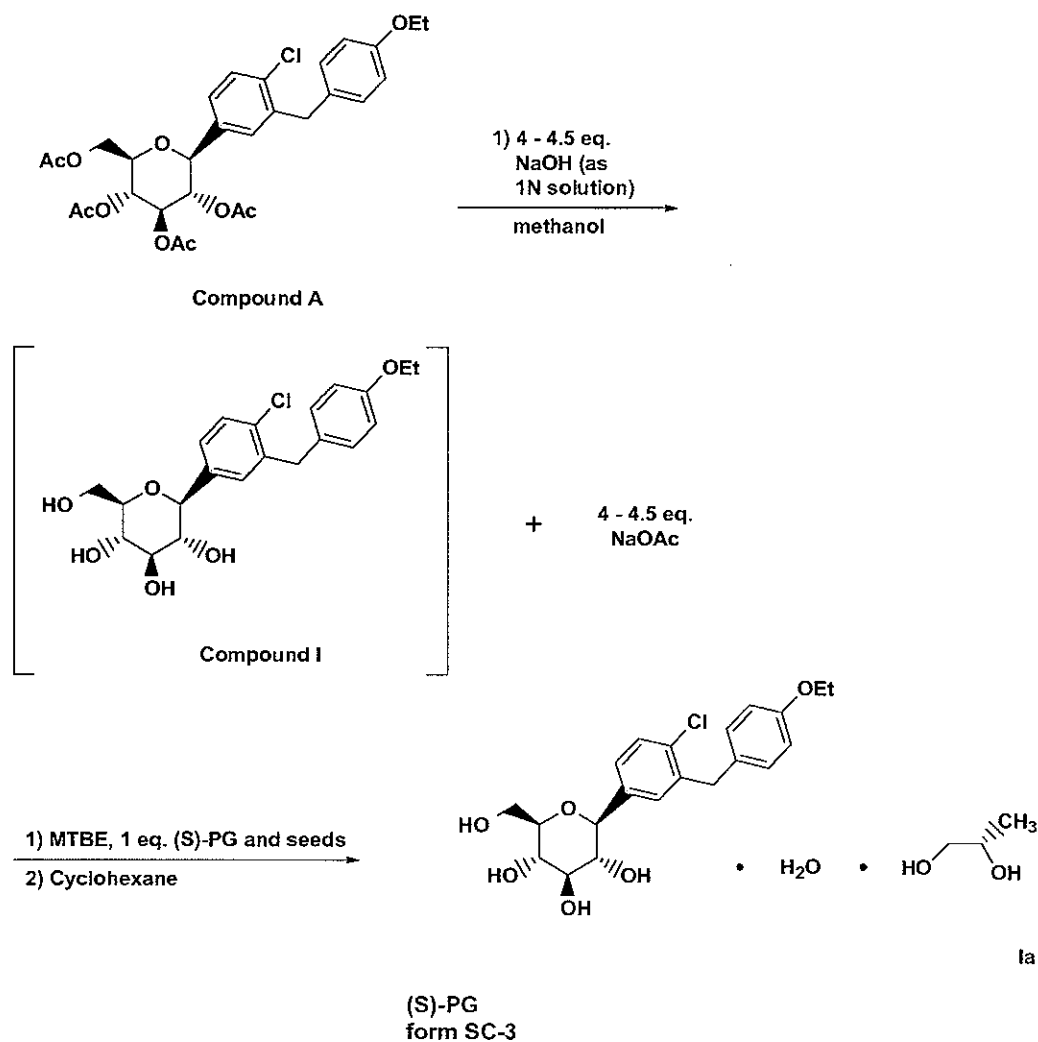
preferably isopropyl acetate, or t-butyl methyl ether (MTBE), and optionally seeds of compound ((S)-PG) Ia (molar ratio of seeds Ia:compound B within the range from about 0.1 to about 10%, preferably from about 0.5% to about 3%), to form a crystal slurry of compound ((S)-PG) Ia and separating out crystalline compound ((S)-PG) Ia
5 from the crystal slurry.

[0072] In carrying out the above telescoped reaction of Scheme I, the silyl reducing agent will be employed in a molar ratio to compound B within the range from about 1.2:1 to about 4.5:1, preferably from about 2:1 to about 4:1, while the activating group (Lewis acid) will be employed in a molar ratio to the silyl reducing
10 agent within the range from about 1.2:1 to about 4.5:1, preferably from about 2:1 to about 4:1. (S)-propylene glycol ((S)-PG) will be employed in a molar ratio to compound B within the range from about 0.9:1 to about 1.5:1, preferably from about 0.98:1 to about 1.2:1; water will be employed in a molar ratio to the (S)-PG within the range from about 0.95:1 to about 5:1, preferably from about 0.99:1 to about 2:1.

15

[0073] The crystalline compound of the structure Ia ((S)-PG) form SC-3 of the invention may also be prepared according to the reaction Scheme II set out below.

SCHEME II



wherein compound A is treated with an alcohol solvent such as methanol, ethanol or isopropyl alcohol, preferably methanol, water and aqueous base such as an alkali metal hydroxide such as NaOH, KOH or LiOH, preferably NaOH, preferably under an inert atmosphere such as nitrogen, at an elevated temperature within the range from about 50 to about 85°C, preferably from about 60 to about 80°C to form compound I.

[0074] The aqueous base will be employed in a molar ratio of compound A within the range from about 3.5:1 to about 5.5:1, preferably from about 3:1 to about 5:1.

[0075] The reaction mixture containing compound I is treated with an organic solvent such as methyl-butyl ether (MTBE) or an alkyl acetate as described above, preferably isopropyl acetate, or MTBE, to separate out compound I which is treated

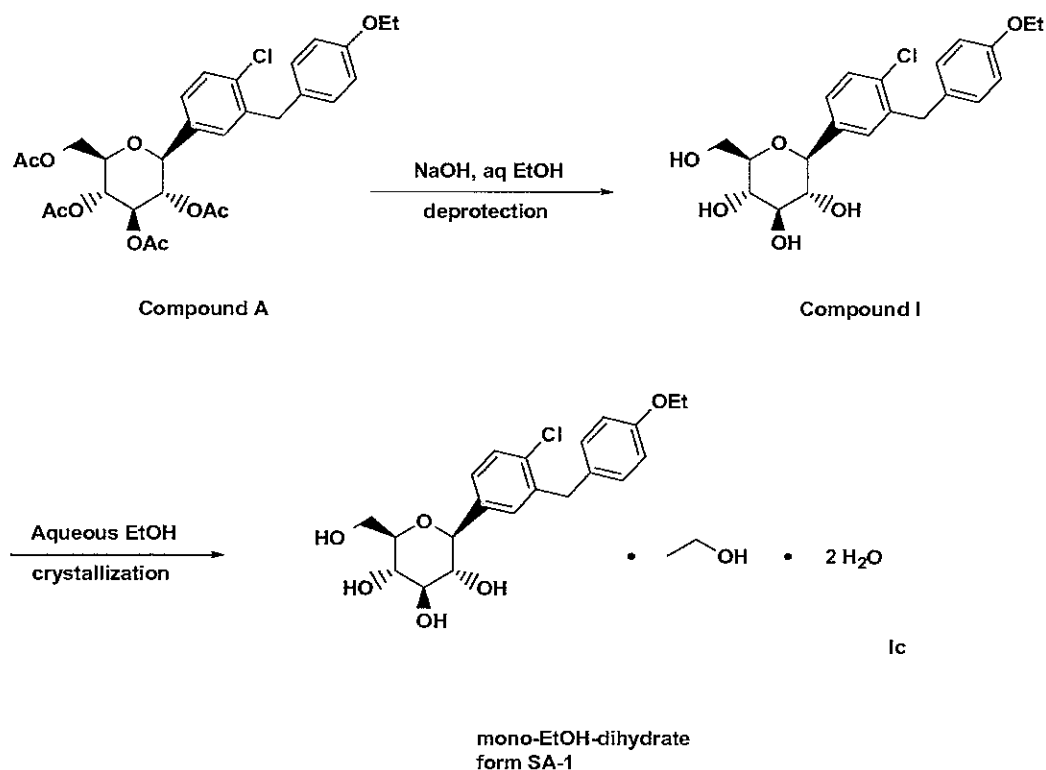
with (S)-propylene glycol to form a thick slurry containing crystalline product Ia (S)-PG, form SC-3. Optionally, seeds of compound ((S)-PG) Ia are added to the reaction mixture. The crystalline compound Ia is separated from the slurry employing conventional procedures, for example, the slurry of compound Ia is treated with an organic solvent such as cyclohexane, iso-octane or methyl cyclohexane, preferably cyclohexane, and crystalline compound Ia is recovered.

[0076] In carrying out the formation of compound Ia, the (S)-PG is employed in a molar ratio to compound I with the range from about 0.9:1 to about 1.5:1, preferably from about 0.98:1 to about 1.2:1.

10 [0077] As indicated herein before, the (R)-propylene glycol solvate Ib of compound I may be prepared in a manner similar to the corresponding (S)-propylene glycol solvate Ia except that (R)-propylene glycol is used in place of (S)-propylene glycol.

15 [0078] The process of the invention for preparing the mono-EtOH-dihydrate (ethanol or EtOH/structure) form SA-1 (compound Ic) is shown in Scheme III below.

SCHEME III



wherein compound A is dissolved in ethanol by heating to a boil then adding water in volume ratio to the ethanol within the range from about 1:1 to about 3:1, preferably from about 1.5:1 to about 2.5:1. Ethanol is added and the mixture cooled to a temperature with the range from about -10°C to about -30°C, preferably from about -15°C to about -25°C. Compound Ic is recovered as crystals of the mono-EtOH-dihydrate.

[0079] The process of the invention for preparing the ethylene glycol dihydrate structures form SB-1 and form SB-2 (compounds Id and Ie, respectively), is carried out as follows.

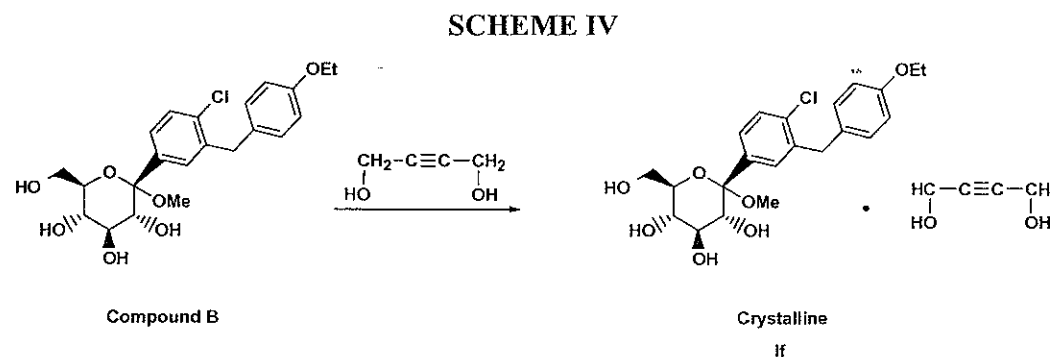
[0080] Compound Id form SB-1 is prepared by dissolving compound A in aqueous ethylene glycol (water: ethylene glycol from about 1:1 to about 0.4:1, preferably from about 0.7:1 to about 0.5:1), by heating at a temperature within the range from about 35 to about 55°C, preferably from about 40 to about 50°C, for about 1.5 to about 2 hours, preferably from about 0.30 min to about 1 hours. The mixture is cooled to a temperature within the range from about 10 to about 22°C, preferably from about 14 to about 16°C, and seeds of the mono-EtOH-dihydrate crystals Ic or

ethylene glycol dihydrate crystals form SB-1 Id are added in a molar ratio to compound A within the range from about 0.1 to about 10%, preferably from about 0.5 to about 3%, to form the ethylene glycol dihydrate crystal form SB-1 Id.

[0081] In accordance with the present invention, the ethylene glycol dihydrate crystal form SB-2 Ie is formed by dissolving compound A in aqueous ethylene glycol (water: ethylene glycol from about 1:1 to about 0.4:1, preferably from about 0.7:1 to about 0.5:1), by heating at a temperature within the range from about 35 to about 55°C, preferably from about 40 to about 50°C, for about 1.5 to about 2 hours, preferably from about 0.30 min to about 1 hour. The mixture is cooled to a temperature within the range from about 10 to about 30°C, preferably from about 20 to about 25°C, and seeds of the ethylene glycol dihydrate crystals form SB-2 Ie are added in a molar ratio to compound A within the range from about 0.1 to about 10%, preferably from about 0.5 to about 3%, to form the ethylene glycol dihydrate crystal form SB-2 Ie.

[0082] The process of the invention for preparing the crystalline form of compound B, that is If, is carried out in accordance with Scheme IV set out below.

[0083] The crystalline 1,4-butyne-diol solvate If of the invention is prepared according to the following reaction Scheme IV.



wherein non-crystalline compound B (which may be prepared as described in U.S. patent application Serial No. 10/745,075 filed December 23, 2003 or in U.S. Patent No. 6,515,117), preferably in substantially pure form (for example 50 to 100% pure), is mixed with toluene/alkyl acetate (such as ethyl acetate), and the mixture heated to a temperature within the range from about 50 to about 70°C, preferably from about 55

to about 65°C, 2-butyne-1,4-diol is added and heated as above until the diol dissolves, seeds of compound If are added, and the mixture cooled to form crystals of compound If.

5 [0084] In an alternative process for preparing crystalline compound If, compound B is dissolved in an alkyl acetate (such as butyl acetate) or an alkyl acetate/heptane (0.5:1 to 1.5:1) mixture at an elevated temperature within the range from about 50 to about 70°C, preferably from about 55 to about 65°C, 1,4-butyne-diol is added, and the mixture is cooled to room temperature to form crystals of compound If.

10 [0085] In a preferred embodiment, compound If is crystallized from a mixture of compound B and toluene/alkyl acetate (preferably ethyl acetate) containing a volume ratio of toluene to alkyl acetate within the range from about 1:1 to about 19:1, preferably from about 4:1 to about 9:1. The mixture of toluene/alkyl acetate will include sufficient toluene to provide a molar ratio with compound B within the range from about 40:1 to about 90:1, preferably from about 60:1 to about 80:1, so as to
15 enable formation of the 1,4-butyne-diol solvate If.

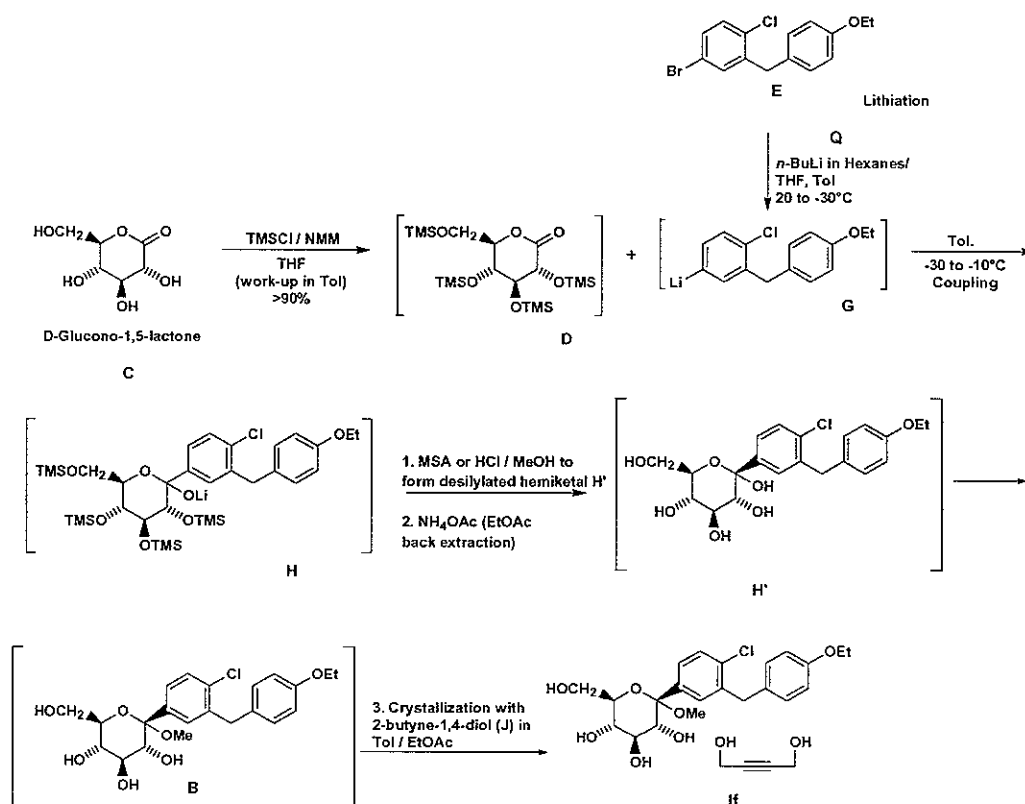
[0086] The crystallization to form 1,4-butyne-diol solvate If may be more easily effectuated employing seed crystals of compound If in an amount from about 0.1 to about 10%, preferably from about 0.5 to about 3% based on the weight of starting compound B.

20 [0087] In another preferred embodiment, compound If (which may or may not be purified) is crystallized from a mixture of compound B and alkyl acetate/heptane (preferably butyl acetate/toluene) optionally with seeding with seeds of crystalline compound If employing from about 0.1 to about 10%, preferably from about 0.5 to about 3% seeds of If based on the weight of starting compound B. The alkyl acetate
25 will be employed in a volume ratio with heptane within the range from about 0.5:1 to about 2:1, preferably from about 1:1 to about 1:1.5.

[0088] The crystalline 1,4-butyne-diol solvate If may also be prepared in a continuous process as shown in Scheme IVA.

30 [0089] The synthesis of solvate If involves two sequential steps with compound E and compound D: (1) Lithiation of compound E to generate a lithiated intermediate G, and (2) coupling of the lithiated intermediate G with compound D.

SCHEME IVA



[0090] Referring now to Figure 22, a schematic process flow diagram (similar to that disclosed in U.S. Patent No. 7,164,015 which is incorporated herein by reference), is shown. In this embodiment, the entire process for preparing compound 1 as shown in Scheme IVA is performed under non-cryogenic conditions. An aromatic reactant E having a group suitable for Li and halogen exchange is stored in a first vessel 1 at room temperature. A lithium reagent Q is fed into a second vessel 2, also at room temperature. The aromatic reactant E and the lithium reagent Q are transferred from the vessels 1 and 2 via pumps 3 and 4, respectively, to a first jacketed static mixer 5. The temperature of a reaction to produce a lithiated anion species is regulated at from about -30°C to about 20°C, in the first mixer 5 by a chiller 6.

[0091] The lithiated anion species G thus formed is fed directly from the first mixer 5 to a second static mixer 22 along a conventional transfer line 19. A carbonyl substituted reactant D is fed into a third vessel 20 at room temperature and is

transferred via pump 21 through chiller 26 where it is chilled to a temperature within the range from about -10 to about -30 °C, and then passed to the second jacketed static mixer 22. A reaction to produce a glycoside product H is regulated in the second mixer 22 by a second chiller 23.

- 5 [0092] Further processing under glycosidation conditions occurs where H is fed into a conventional reactor 25 where it is treated with acid in an alcohol solvent, preferably MSA/MeOH or HCl/MeOH, to form H' (desilylated hemiketal) which further converts to glycoside B. Further additional work-up and back extraction and crystallization with 2-butyne-1,4-diol (J) in toluene/EtOAc produces crystalline
10 product If. The reactor 25 may be maintained at room or other non-cryogenic temperature during the course of any subsequent reactions.

[0093] The lithium reagent used is desirably an organo lithium reagent. Suitable organo lithium reagents include n-BuLi, s-BuLi and t-BuLi. Others will be apparent to those having ordinary skill in the art.

- 15 [0094] After completion of the reaction, the desired product If can be isolated and purified according to techniques widely known in the field of organic chemistry (e.g. precipitation, solvent extraction, recrystallization, and chromatography). The deprotected compound If may itself be a useful intermediate or end product. The compound If may be further reacted to obtain pharmaceutically acceptable acid
20 addition or base salts thereof using methods that will be known to those having ordinary skill in the art.

- [0095] Temperature and reaction time are two important parameters in the continuous process design shown in Scheme IVA: the lithiation can be operated continuously from -30°C (or lower) up to 20°C (or higher), preferably from about
25 -17° to about -10°C, with minutes to seconds of reaction time. For the subsequent coupling reaction, the stream of lithiated derivative G is further mixed with the compound D stream (the third feed) in a mixer. The mixed flow can be then sent to a flow reactor if extra reaction time is needed for completion. The coupling reaction can be operated continuously at higher temperatures from -30°C to -10°C (or higher),
30 preferably from about -30° to about -20°C, with minutes to seconds of reaction time. The coupling stream is then sent to a batch reactor for further reactions as described herein. With continuous processing, both lithiation and coupling reactions can be

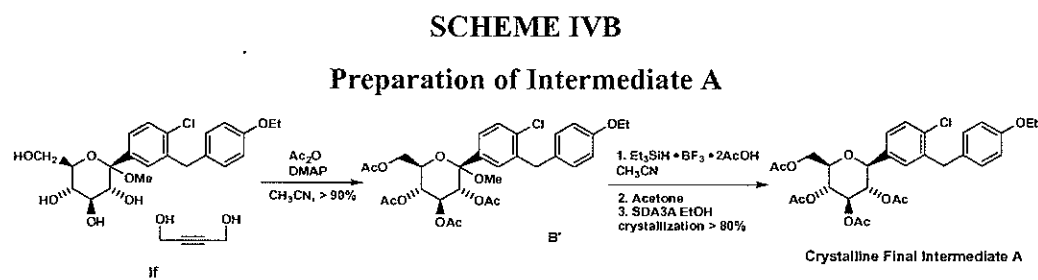
well integrated and operated at higher temperatures utilizing smaller flow reactors with efficient temperature control, compared with cryogenic batch reactors on scale.

[0096] The operating temperature of continuous lithiation in the above process can be as high as 20°C (not limited to), preferably -17 to -10°C, while generating >95

5 RAP, of the desired lithiated intermediate G.

[0097] In the coupling reaction, the coupling product from the above process at -20°C to -30°C, preferably ranged in 70-79 RAP.

[0098] Compound If may be employed to prepare crystalline intermediate A as
10 shown in Scheme IVB.



15 [0099] Referring to Scheme IVB, solid compound If, solid DMAP, liquid acetonitrile, and liquid acetic anhydride are heated to a temperature within the range from about 70 to about 85°C and held until reaction is complete.

[00100] The batch is cooled (e.g. 5°C). Triethylsilane and boron trifluoride acetic acid complex or other Lewis acid (as described with respect to Scheme I) are added to
20 the reaction mixture. After completion of the reaction, acetone or other solvent is added. The batch is warmed (for example from about 20 to about 30°C) and held until triethylsilane is consumed. Aqueous NH_4OAc is added and the batch is mixed, and allowed to settle until upper and lower phases form. Batch volume of product in the rich upper phase is reduced by distilling off acetonitrile to minimum agitation.

25 SDA3A Ethanol is added at elevated temperature (> 60°C).

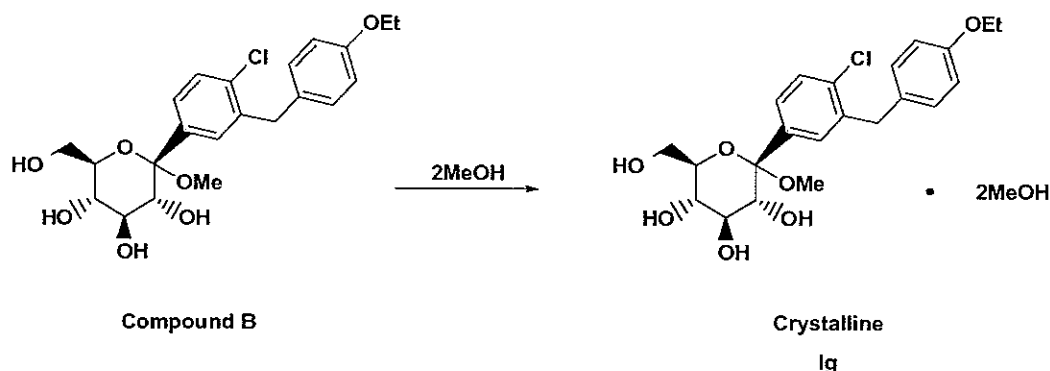
[00101] The product A crystallizes out by cooling or cooling with seeding (5 wt% based on compound If wet-milled, nitrogen jet milled, or a previous batch).

[00102] The product is recrystallized as either a wet or dry cake from SDA3A ethanol.

[00103] The crystalline dimethanol solvate Ig of the invention is prepared according to the following reaction Scheme V.

5

SCHEME V



wherein non-crystalline compound B (which may be prepared as described in U.S. patent application Serial No. 10/745,075 filed December 23, 2003 or in U.S. Patent No. 6,515,117), preferably in substantially pure form (50 to 100% pure), is dissolved in methanol, a mixture of methanol/toluene, or a mixture of methanol/toluene/heptane, a mixture of methanol/methyl t-butyl ether (MTBE)/heptane, or a mixture of methanol/toluene/ethyl acetate or other alkyl acetate with stirring, to form a white slurry containing crystalline dimethanol solvate Ig. The crystalline dimethanol solvate Ig may be recovered from the slurry using conventional procedures, such as filtration.

[00104] The above process may be carried out at room temperature, although elevated temperatures of up to about 20-25°C may be employed to enhance crystallization.

[00105] In a preferred embodiment, compound Ig is crystallized from a mixture of methanol/toluene containing a volume ratio of methanol to toluene within the range from about 6:1 to about 1:1, preferably from about 3:1 to about 5:1. The mixture of methanol/toluene will include sufficient methanol to provide a molar ratio with compound B within the range from about 80:1 to about 10:1, preferably from about 40:1 to about 20:1, so as to enable formation of the dimethanol solvate Ig.

[00106] The crystallization to form dimethanol solvate Ig may be more easily effectuated employing seed crystals of compound Ig in an amount from about 0.1 to

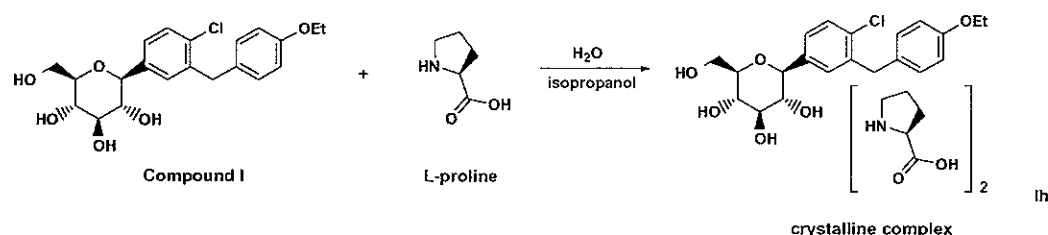
about 10%, preferably from about 0.5 to about 3% based on the weight of starting compound B.

[00107] In another preferred embodiment, compound Ig (which may or may not be purified) is crystallized from a mixture of methanol/toluene/heptane with seeding
 5 with seeds of crystalline compound Ig employing from about 0.1 to about 10%, preferably from about 0.5 to about 3% based on the weight of starting compound B. The methanol will be employed in a volume ratio with toluene within the range from about 1:0.5 to about 1:6, preferably from about 1:1.5 to about 1:2.5, and a volume ratio of heptane:toluene within the range from about 2:1 to about 0.5:1, preferably
 10 from about 1.3:1 to about 0.5:1.

[00108] The crystalline complex 1:2 L-proline Ih of the invention is prepared according to the following reaction Scheme VI.

15

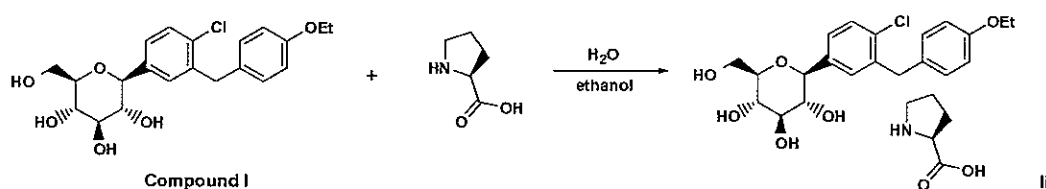
SCHEME VI



wherein a solution of L-proline in water is heated to a temperature within the range from about 70 to about 90°C and an alcohol solvent such as methanol, ethanol or isopropyl alcohol, preferably isopropyl alcohol, is added. A solution of compound I
 20 is added to the above L-proline solution (which is stirred), wherein compound I is employed in a molar ratio to L-proline of about 0.5:1. The solution is cooled slowly to room temperature during which time solids form. The solution is filtered to remove solids which are washed with alcohol solvent. The solids are dried and recovered in the form of a white solid which is the 1:2 L-proline crystalline complex
 25 Ih, form 3, N-1.

[00109] The crystalline 1:1 L-proline complex II of the invention is prepared according to the following reaction Scheme VII.

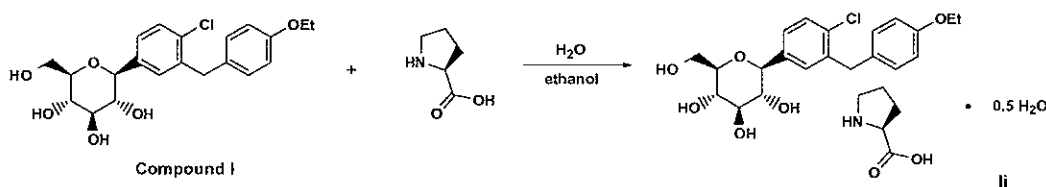
SCHEME VII



[00110] A solution of L-proline in ethanol/water is heated to boiling and a solution of compound I in ethanol or other alcohol solvent is added. The resulting solution is cooled from -10 to -25°C at which time solids form, which solids are the 1:1 crystalline complex with L-proline II which is recovered employing conventional procedures. In carrying out the above procedure for preparing the 1:1 L-proline complex II, the L-proline is employed in a molar ratio to compound I within the range from about 1:4 to about 1:6.

[00111] The crystalline L-proline hemihydrate complex Ij of the invention is prepared according to the following reaction Scheme VIII.

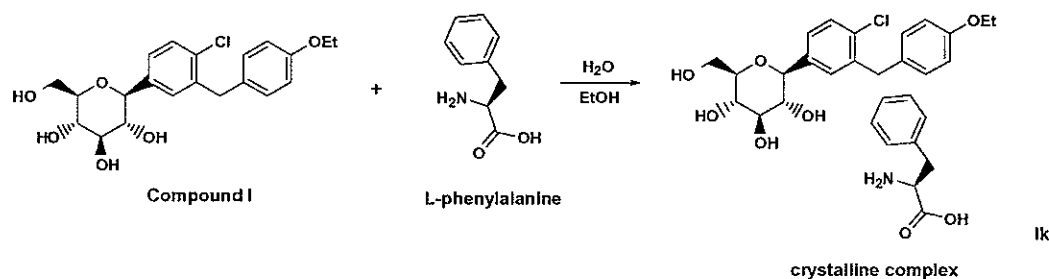
SCHEME VIII



wherein a solution of L-proline and compound I (4.34 g, 10 mmol) in ethanol/water is heated to 70°C to give a clear solution. The resulting solution is cooled from -20 to -25°C and seed crystals of 1:1 complex with L-proline II are added. After 3 days at -20°C, solids are collected via filtration, and the filter cake is washed with cold (-20°C) ethanol. The resulting solids are suspended and recovered as a white crystalline solid Ij, H_{0.5}-2 employing conventional procedures.

[00112] The crystalline L-phenylalanine complex Ik of the invention is prepared according to the following reaction Scheme IX.

SCHEME IX



[00113] L-phenylalanine is dissolved in water with heating. The resulting solution is filtered and added to an ethanol (or other alcohol) solution containing compound I.

- 5 The resulting solution is heated at from 70 to 90°C and allowed to cool slowly to room temperature (crystal formation is observed at 55°C). The solution is subjected to conventional recovery procedures. The L-phenylalanine complex Ik is recovered as a white solid identified as 1:1 complex of compound I with L-Phe.

- 10 [00114] The following examples are provided to describe the invention in further detail. These examples, which set forth the best mode presently contemplated for carrying out the invention, are intended to illustrate and not to limit the invention.

[00115] The preparation of compounds of formula I is generally described in U.S. Patent 6,414,126, and specifically described in Scheme 1 and Example 1 of U.S.

- 15 Patent 5,515,117. U.S. Patent 6,414,126, and U.S. Patent 5,515,117 incorporated by reference herein in their entirety. Stable forms of compounds of formula (I) can be crystallized as solvates (e.g., hydrates).

EXAMPLES

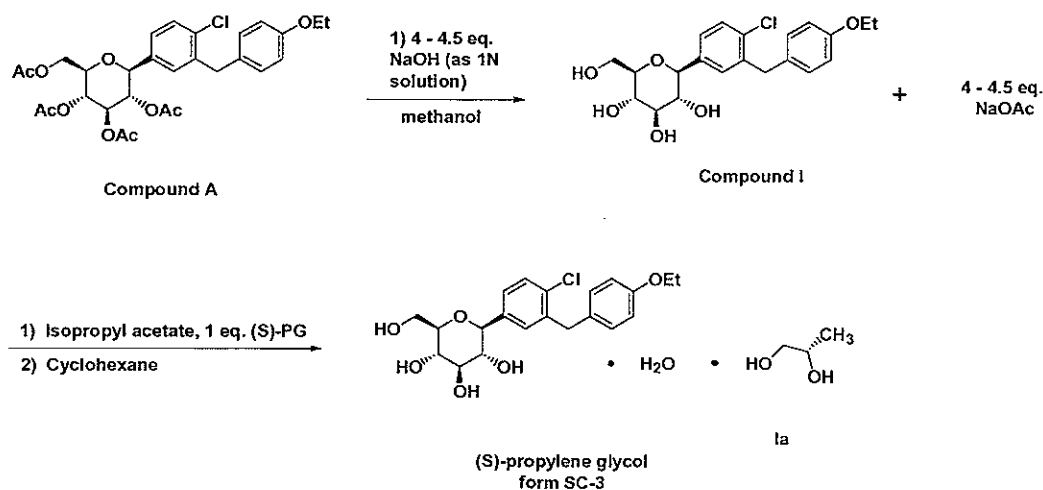
20

PREPARATION OF CRYSTAL STRUCTURES

EXAMPLE 1

Preparation of (S)-Propylene Glycol ((S)-PG) Structure –

Form SC-3 – Formula Ia



[00116] Compound A can be prepared as described in Example 1, Part E of U.S. Patent 6,515,117.

- 5 [00117] A 10-L glass reactor equipped with a thermocouple and a nitrogen inlet was charged with MeOH (1.25 L), deionized water (3.6 L) followed by 50% aqueous NaOH (205.9 ml, 3.899 mol). The residual solution of NaOH in the measuring cylinder was transferred with water (94 ml) to the reaction vessel. Compound A (503.11 g, 0.872 mol) was added and the mixture was stirred and heated to ~68°C
- 10 over 1.5 h. After 1 h, the circulation bath temperature was lowered from 80 to 70°C; internal temperature became 65°C. After a total of 3 h HPLC¹ indicated completion of reaction, Compound I AP ~99.5. After the mixture was cooled to 25°C, isopropyl acetate (2.5 L) was added. The mixture was stirred for 10 minutes and then the aqueous layer was separated (pH = 12.5) and organic layer was washed with water (1
- 15 L). During this wash the pH of the biphasic system was adjusted to 6.0 with conc. HCl (5.0 ml) and then the aqueous layer was separated.² The organic layer was collected in a separate vessel. The reactor was washed with water (2 L), MeOH (2 L) and flushed with nitrogen gas. The wet solution of compound B was recharged into the reactor and (S)-propylene glycol ((S)-PG) (67.03 g, 0.872 mole) was introduced.
- 20 Optionally, seed crystals of (S)-PG Ia may be added at this stage. Instantaneous crystallization produced a thick slurry. After stirring for 1 h, cyclohexane (2.5 L) was added rapidly over 10 minutes and the stirring was continued for 21 h. The product was filtered through a filter paper (Whatman #5, Buchner funnel 24" diameter). The

filtration was rapid and took about 15 minutes. The filter cake was washed with a mixture (1:1) of MTBE/cyclohexane (2 x 1 L) and dried under suction for 0.5 h. The solid was transferred to a pyrex tray and dried under vacuum (25 mm Hg) in an oven at 25-30°C for two days till water analysis by KF corresponded to monohydrate (3.6 wt.%). The (S)-PG product Ia was obtained (0.425 kg, yield 97%) as a snow white solid, HPLC³ AP 99.7.

[00118] Seed crystals may be prepared by dissolving compound I in a solvent such as MTBE and treating the resulting solution with (S)-propylene glycol and proceeding as described above without the use of seeding.

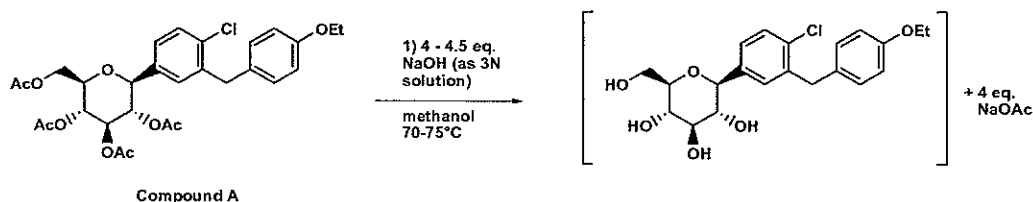
10 ¹HPLC: Column: YMC ODS-A (C-18) S3, 4.6 x 50 mm. Solvent A: 0.2% aq. H₃PO₄. Solvent B: 90% CH₃CN/10%H₂O Start %B = 0, final %B = 100 Gradient time 8 min; hold time 3 min. Integration stop time 11.0 min. Flow rate 2.5 ml/min. UV wave length 220 nm.

15 ²Neutralization before phase split was done to prevent contamination of the product with NaOH. (S)-PG structure prepared without neutralization was slightly basic [pH 8.3 of a suspension sonicated in water (~20 mg/ml)].

20 ³HPLC method: Mobile Phase A: 0.05% TFA in H₂O. Mobile Phase B: 0.05% TFA in CAN. Column: YMC Hydrosphere 4.6x150 (3μ). Gradient: 30-90%B over 45 minutes, hold 5 minutes; back to 30%B and re-equilibrate for 10 min. Wavelength: 220 nm. Injection Volume: 10μl. Temperature: Ambient

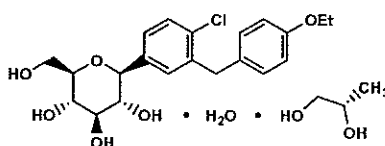
EXAMPLE 1A

(S)-Propylene Glycol ((S)-PG) Structure - Form SC-3 - Formula Ia



$C_{29}H_{33}ClO_{10}$
 Exact Mass: 576.18
 Mol. Wt.: 577.02
 C, 60.36; H, 5.76; Cl, 6.14; O, 27.73

1) Neutralize to pH 6 - 7.5 using
 1N acetic acid
 2) Isopropyl acetate
 3) (S)-(+)-1,2 propanediol (1 eq.)
 4) Cyclohexane



$C_{24}H_{35}ClO_9$
 Exact Mass: 502.20
 Mol. Wt.: 502.98
 C, 57.31; H, 7.01; Cl, 7.05; O, 28.63

5 Procedure

[00119] 20g of compound A was charged to a reactor at ambient temperature and pressure. 30mL Methanol and 49.75mL 3N NaOH were added to the reactor and the reaction mixture was heated to 80°C or reflux, and held about 2-3 hours for reaction completion < 0.5 AP. The batch was cooled to 20°C and neutralized to pH 6.0-7.5
 10 using con. HCl or 1N acetic acid (requires ~ 1mL/gm input).

Extraction

[00120] The product was extracted from the reaction mixture into 100mL isopropyl acetate, the aqueous phase was split away and the organic phase washed
 15 with water until conductivity < 10mS (~ 4mL/gm input). The aqueous phase was split away.

Crystallization

[00121] 2.8g (1.05 eq) (S)-(+)-1,2 Propanediol was added to the reaction mixture.
 20 The batch was seeded with 0.1g compound I seed. 160mL Cyclohexane was added

and the batch cooled to from room temperature to 5°C . The batch was allowed to stir at from room temparture to 5°C at least 1 hour before isolation.

Isolation and Drying

- 5 [00122] Each load of isolated cake was washed with 50/50 by volume isopropyl acetate/cyclohexane mixture. The cake was dried at 30°C in a vacuum oven under full vacuum. (Cake is dry when KF = 3.6% - 4.1%).

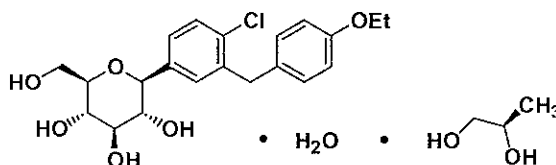
Yield = 84% (uncorrected)

- 10 Typical purity = 99.81AP

Typical PG content = 15.1 - 15.8% by GC

EXAMPLE 2

Preparation of (R)-Propylene Glycol Structure - Ib



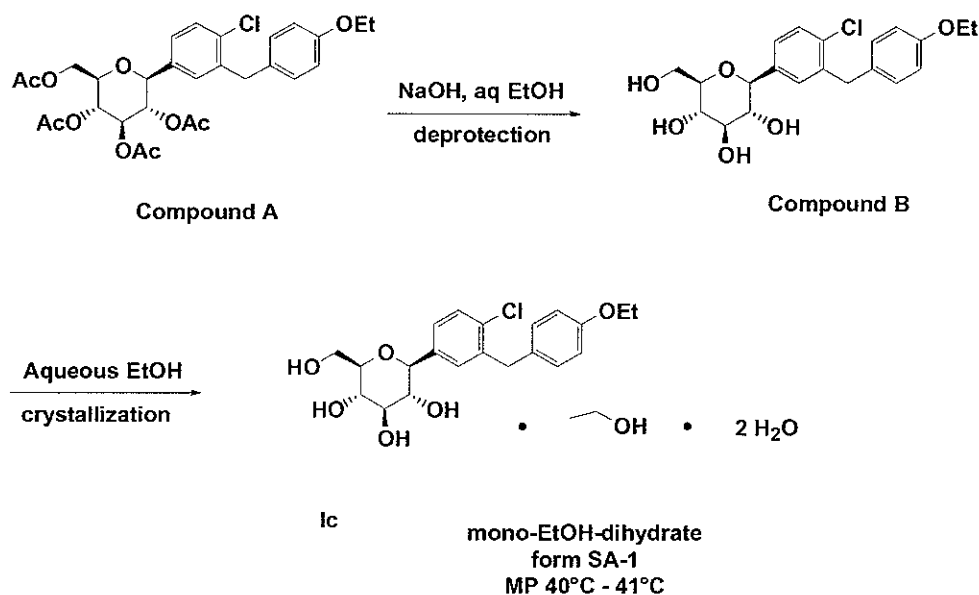
- 15 (R)-propylene glycol Ib

[00123] The (R)-propylene glycol structure was prepared using the same process as described above for the (S)-propylene glycol structure Ia (Example 1) except that (R)-propylene glycol was used in place of (S)-propylene glycol.

- 20 EXAMPLE 3

Preparation of Mono-EtOH-Dihydrate (Ethanol or EtOH Structure) –

Form SA-1 - Formula Ic



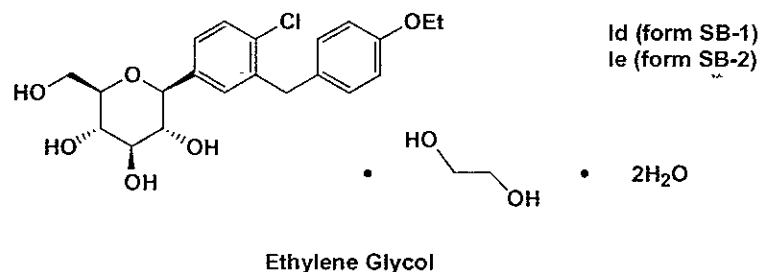
- [00124] Compound A (1.0 g) was dissolved in EtOH (3.0 ml) by heating to a boil and the solution was diluted with water (7 ml). 1 ml EtOH was added and the mixture was divided in three portions for crystallization at 20°C , 5°C and -20°C . After cooling to -10 to -20°C , crystals were formed which have M.P. $40-41^\circ\text{C}$.

EXAMPLES 4 AND 5

Preparation of Ethylene Glycol Structure Forms SB-1 and SB-2 –

10

Formulation Id and Ic, Respectively



- [00125] To obtain the polymorphic form of the ethylene glycol dihydrate crystal form SB-1 Id, compound A (0.5 gm) was dissolved in aqueous ethylene glycol (0.3 mL water: 0.5 ml ethylene glycol) by heating at 45°C for 30 min. Upon cooling to room temperature, seeds of the SB-1 (10 mg) were added. The reaction mixture was stirred for 16 hrs, to provide white crystalline solid. The crystals were filtered, washed with water and dried. To obtain the polymorphic form of the ethylene glycol

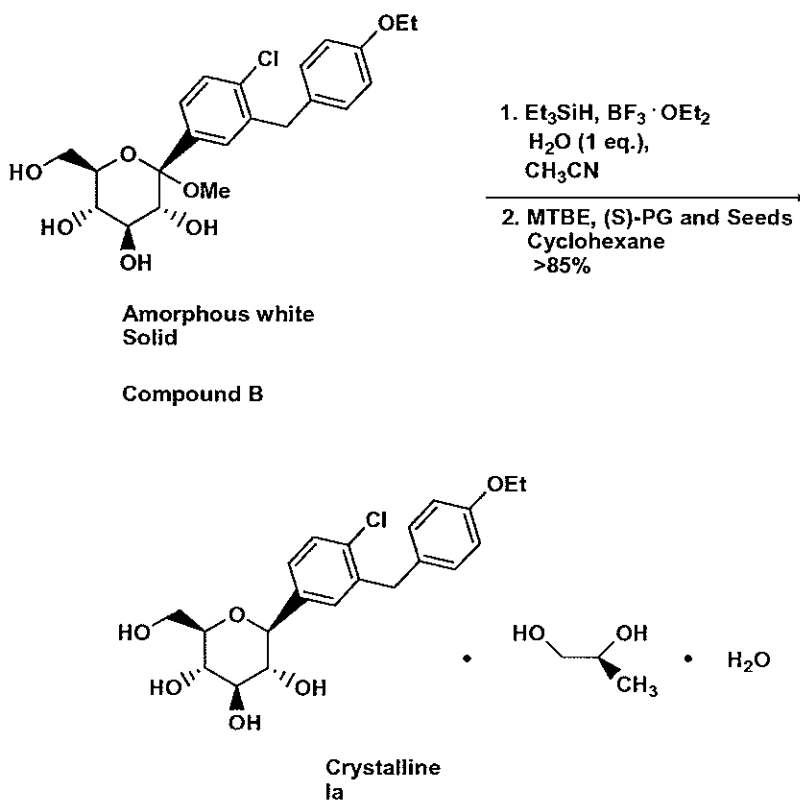
dihydrate seed crystals form SB-1 Id, compound A was dissolved in aqueous ethylene glycol (S)-propylene glycol crystal form SC-3 Ia were added to obtain the ethylene glycol dihydrate crystal form SB-1 Id (Example 4). These crystals were filtered and washed with excess water.

- 5 [00126] To obtain the polymorphic form of the ethylene glycol dihydrate crystal form SB-2 Ic (Example 5), Compound A was dissolved in aqueous ethylene glycol by heating. Upon cooling, seeds of the mono-EtOH-dihydrate crystal form SA-1, Ic were added to obtain the ethylene glycol dihydrate crystal form SB-2 Ic (Example 5). These crystals were filtered and washed with excess water.

- 10 [00127] ^1H NMR for forms SB-1 and SB-2: ^1H NMR (400 MHz, DMSO) δ 1.29 (t, 3H, $J = 6.98$ Hz, -CH₃) 3.15 (m, 4H,), 3.33 (bs, 6H, -CH₂), 3.42 (m, 3H), 3.6 (bdd, $J = 11.4$ Hz, 1H), 3.9 (bm, 5H, H-1, -2CH₂), 4.43 (t, 1H, $J = 7.4$ Hz, OH), 4.86 (d, 1H, $J = 2.4$, OH), 4.95 (q, 1H, -OH), 6.82 (d, 2H, $J = 11.47$ Hz, Ar-H), 7.8 (d, 2H, $J = 11.4$ Hz, Ar-H), 7.22 (dd, 1H, $J = 2.5$ Hz, $J = 11.4$ Hz, Ar-H), 7.35 (t, 2H, $J = 10.96$, Ar-H;
- 15 ^{13}C NMR (400 MHz, DMSO) δ 12.49, 59.16, 60.61, 60.69, 68.10, 72.51, 76.11, 78.51, 79.02, 112.09, 125.16, 126.47, 127.38, 128.61, 129.02, 129.73, 135.62, 137.48, 154.70.

EXAMPLE 6

Preparation of (S)-PG Solvate Form SC-3 Ia



[00128] To acetonitrile (12 mL), at batch temperature of 8-10°C under nitrogen atmosphere, was charged borontrifluoride diethyletherate (2.3 mL, 18.4 mmol) and water (0.82 mL, 4.6 mmol). After holding the above mixture for about 1 hour, triethylsilane (3 mL, 18.4 mmol) was added. The resulting mixture was held for about 1 hour, and then compound B (prepared as described in Example 17) in 10 mL acetonitrile was added. The batch was held at 5 to 10°C. On completion of the reaction as determined by HPLC, the reaction mixture was quenched with aqueous ammonium acetate (24 mL; 85 g) in 200 mL water. The phases were separated and product rich organic phase was dried over sodium sulfate. The product rich organic phase was concentrated under reduced pressure.

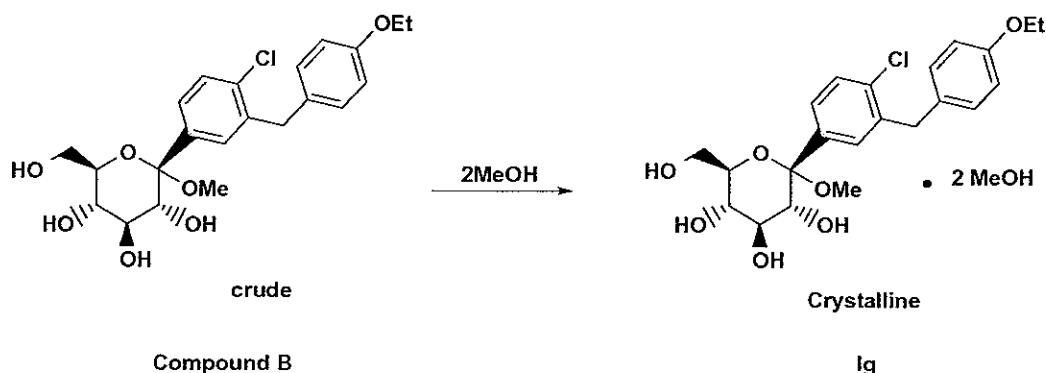
[00129] Water (13 mg, 0.7 mmol, based on 0.3g crude compound B input), (S)-propylene glycol (56 mg, 0.7 mmol), t-butylmethyl ether (5 mL, ~17 mL/g compound B input), compound Ia seeds (~20 mg) were mixed and held for 1 hr., to form a crystal slurry. Cyclohexane (10 mL, 33 mL/g compound B (input)) was added. The

crystalline product (Ia) was isolated by filtration (4-5%) and dried in vacuo at 20-25°C.

EXAMPLE 7

5

Preparation of Crystalline MeOH Solvate Ig



[00130] Crystals of methanol solvate Ig were obtained by dissolving pure compound B in methanol and stirring at room temperature. A white slurry formed after a few days, and was found to be crystalline methanol solvate Ig.

10 [00131] The so formed crystalline di-MeOH solvate Ig may be used in place of compound B in the preparation of crystalline compound Ia as described in Example 6.

EXAMPLE 8

Preparation of Crystalline Di-MeOH Solvate Ig from Unpurified Compound B in 80/20 Methanol/Toluene using Seeds

15

[00132] 6g of compound B (HPLC AP approximately 80%) was dissolved in 15 mL of 80/20 methanol/toluene.

[00133] Seeds (about 1% of starting compound B) of compound Ig crystals were added and the mixture was cooled to form a slurry containing crystals.

20 [00134] The slurry was stirred for 6 hours before isolating.

[00135] The wet cake was found to be crystalline methanol solvate Ig but loses crystallinity if left open for a few hours.

EXAMPLE 9

25 Preparation of Crystalline Di-MeOH Solvate Ig from Unpurified Compound B in Methanol/Toluene/Heptane using Seeds

[00136] 2.5 g of compound B (91.5 %) was added to a scintillation vial with a magnetic stir-bar.

[00137] 4 mL toluene was added to dissolve the compound Ia.

[00138] 2 mL methanol was added. Next, seeds of compound Ig crystals (about
5 1%) were added.

[00139] 4 mL heptane was added over 30 minutes and the mixture was stirred for 12 hours. Wet cake was isolated on a Buchner funnel. The wet cake was found to be crystalline methanol solvate Ig. It was dried under vacuum at 30°C. The resultant powder lost crystallinity.

10 [00140] Yield = 1.7 g = 74.5% (corrected). Characterization XRD pattern of crystals: Figure 10.

[00141] The so formed crystalline MeOH solvate Ig may be used in place of compound B in the preparation of crystalline compound Ia as described in Example 6.

15

EXAMPLE 10

Preparation of Crystalline 1,4-Butyne-diol Solvate If from Compound B in Toluene/Ethyl Acetate using Seeds

[00142] 1,4-Butyne-diol solvate can be crystallized in an alkyl acetate (e.g. ethyl, propyl or butyl acetate), alcohol (e.g. isopropanol, butanol) or even water. Toluene
20 and heptane act as anti-solvents when crystallized in alkyl acetate.

[00143] 50g (90.3 weight%) Compound B was dissolved in 675mL toluene. The solution was heated to 60°C and 75mL ethyl acetate added. 1.5 eq 2-butyne-1,4-diol (= 13.3g) was added and the mixture held at 60°C until the butyne diol dissolved. The solution was cooled to 55°C and 0.1% seeds (50mg) of 1,4-butyne-diol
25 compound If was added. The mixture was held for 1 hour at 55°C. Compound If started crystallizing. The mixture was cooled to 25°C over 6 hours. The resulting slurry was stirred for 3 hours before isolating (mother liquor conc was < 3mg/mL), filtered and washed with 180mL toluene + 20mL ethyl acetate, and dried under vacuum at 45°C to yield crystals of 1,4-butyne-diol solvate If.

30 [00144] HPLC AP = 99.5%. Potency = 80.7 weight% (Expected potency = 83.6% for 1:1 solvate). Yield = 95%.

EXAMPLE 11

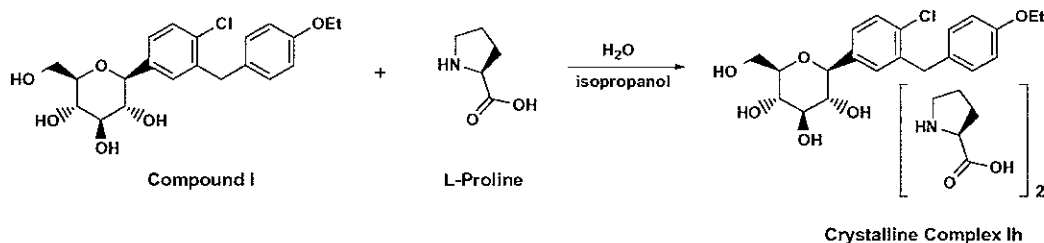
Preparation of Crystalline 1,4-Butyne-diol Solvate If from Compound B in Butyl Acetate/Heptane

[00145] 0.5g Compound B (91 weight%) was dissolved in 3.5mL butyl acetate +
 5 3.5mL heptane at 60°C. 1.5 eq 2-Butyne-1,4-diol was added and the mixture cooled to room temperature. The resulting slurry was stirred for 12 hours, filtered and washed with 1mL 1:1 butyl acetate: heptane, and dried under vacuum at 50°C to yield crystals of 1,4-butyne-diol solvate If. Potency = 85.1%. Yield = 90%.

[00146] The 1,4-butyne-diol solvate If may be employed in place of compound B
 10 and employing the Lewis acid $\text{BF}_3 \cdot 2\text{CH}_3\text{COOH}$ in place of BF_3OEt_2 to form the crystalline compound Ia.

EXAMPLE 12

Preparation of 1:2 Crystalline Complex with L-Proline - Structure Ih, Form 3

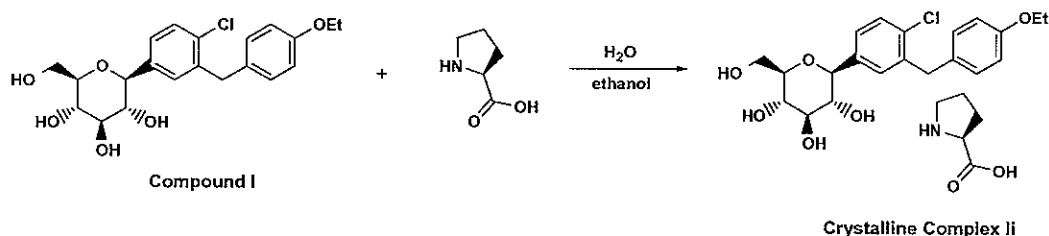


15

[00147] A solution of L-proline (11.5 g, 100 mmol) in 10 mL of water was heated to 80°C and 100 mL and isopropanol was added. To the rapidly stirred solution of L-proline was added a room temperature solution of compound I (21.4 g, 50 mmol) in 100 mL of isopropanol. Solids formed, and the solution was cooled slowly to room
 20 temperature. The solution was filtered and the resulting solids were washed with isopropanol followed by hexanes. The solids were dried under vacuum oven to give 30.4 g of a white solid containing compound I as a 1:2 crystalline complex with L-proline (structure Ih, form 3).

EXAMPLE 13

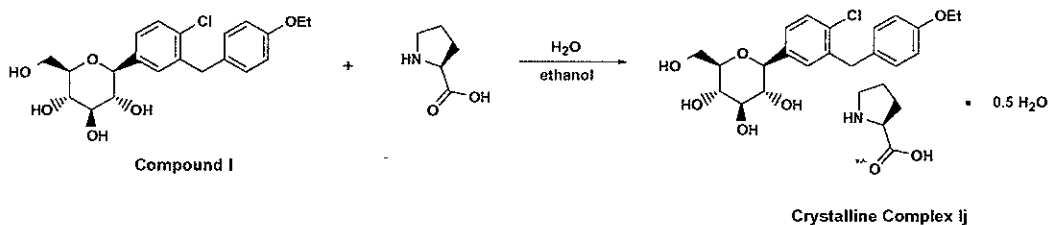
Preparation of 1:1 Crystalline Complex with L-Proline - Structure Ii, Form 6



- [00148] A solution of L-proline (0.23 g, 0.2 mmol) in 1.1 mL of 90% ethanol/water was briefly heated to boiling and a solution of compound I (0.4 g, 1 mmol) in 4 mL of ethanol was added. The resulting solution was cooled to -20°C for 2 h during which time solids formed. The solution was stored at room temperature for 2 days. The vessel was centrifuged and the supernatant was removed. The remaining solids were washed in 1 mL of MTBE, and the solids were dried under vacuum to give 0.025 g of a white solid containing compound I in a 1:1 crystalline complex with L-proline (structure Ii, form 6).

EXAMPLE 14

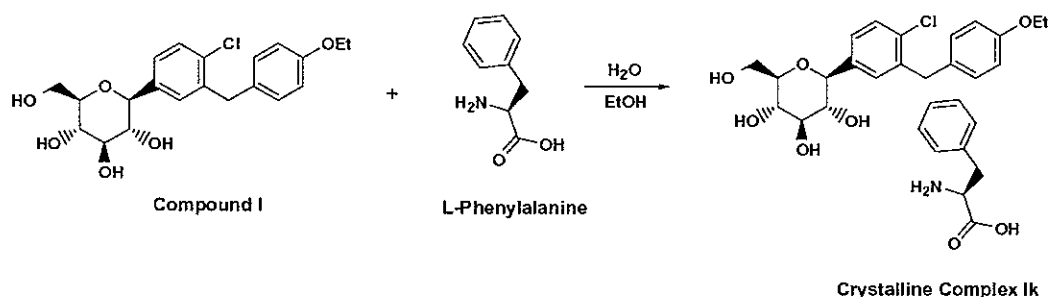
Preparation of Crystalline Form H.5-2 of L-Proline Compound I Hemihydrate - Structure Ij



- [00149] A solution of L-proline (0.23 g, 2 mmol) and compound I (4.34 g, 10 mmol) in 31 mL of 97% ethanol/water was briefly heated to 70°C to give a clear solution. The resulting solution was cooled to -20°C and seed crystals of compound I 1:1 complex with L-proline structure Ii form 6 were added. After 3 days at -20°C, solids were collected via filtration, and the filter cake was washed with cold (-20°C) ethanol. The resulting solids were suspended in 5 mL of heptane, followed by filtration and washing with heptane to give 0.3 g of a white solid. The material (0.02 g) was further crystallized from 20/1 EtOH/H₂O with slow evaporation of solvent and

slight heating/cooling to grow larger X-ray quality crystals containing a ratio of 4 molecules of compound I, 4 molecules of L-proline and 2 molecules of water per unit cell, hemihydrate of 1:1 complex with L-proline (structure Ij form H.5-2).

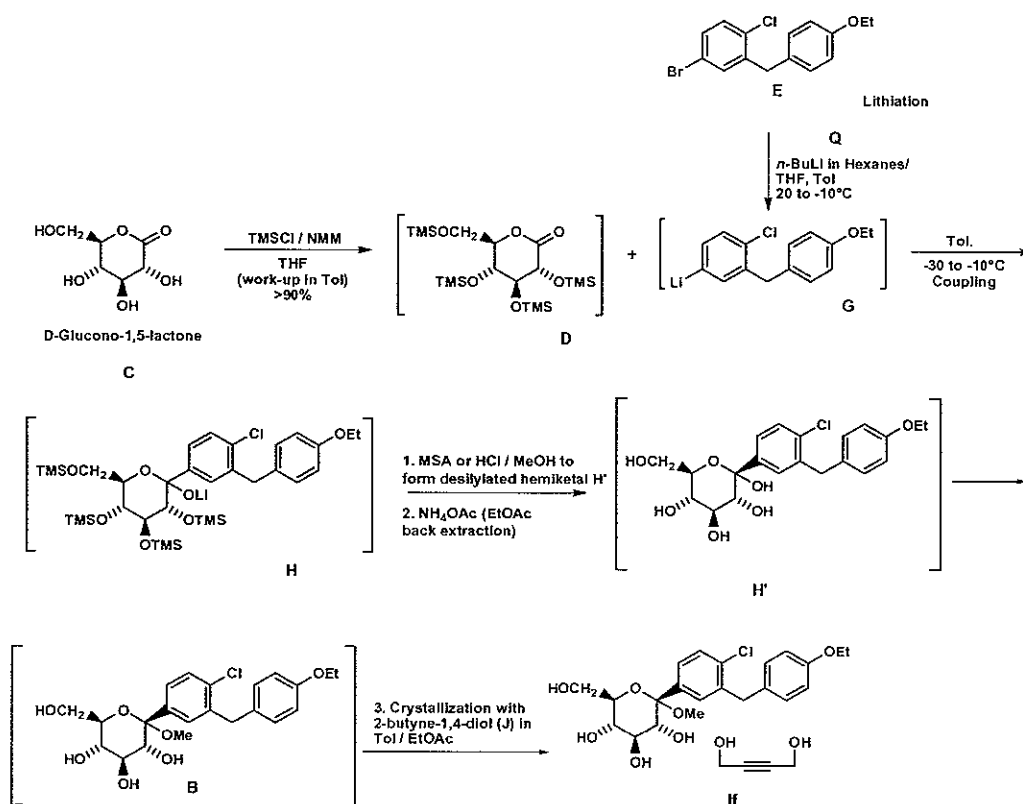
5

EXAMPLE 15**Preparation of 1:1 Crystalline Complex with L-Phenylalanine - Structure Ik,****Form 2**

- [00150] L-phenylalanine (424 mg, 2.56 mmol) was dissolved in 6 mL of water at 80°C. The resulting solution was filtered and added to an ethanol solution (6.5 mL) containing 1 gram of compound I (2.36 mmol). The resulting solution was heated to 80°C and allowed to cool slowly to room temperature (crystal formation was first observed at 55°C). The solution was stored at 4°C. The solution was filtered and the crystals were washed with 20% water/ethanol to give a complex of L-Phe:compound I. This material was further recrystallized from 10 mL of 50% water/ethanol as above to give 910 mg of a white solid identified as 1:1.3 complex of compound I with L-Phe (64%) structure Ik, form 2 as determined by ¹H NMR integration.

EXAMPLE 16

Preparation of Compound If via Continuous Lithiation and Coupling Reactions



[00151] A reaction scheme similar to that shown in Scheme IVA and Figure 22 was employed.

[00152] A -30°C chiller for the lithiation reactor 5 (jacketed static mixer 5) was set up.

[00153] A -30°C chiller for the coupling reactor 22 (jacketed static mixer 22) and a pre-cooling heat exchanger (not shown in Figure 22) for the compound D/toluene

10 feed was set up.

Continuous Lithiation

[00154] The two feeds of E/THF/toluene (2.74 ml/min) and Q, namely, $n\text{-BuLi}$ in hexane (0.41 ml/min), were mixed and combined through jacketed static mixer 5

15 (-30°C).

[00155] Before pumping the D/toluene feed, toluene (2.96 ml/min) was sent into the system as a make-up flow to maintain the overall flow constant at 6.1 ml/min.

[00156] Samples at the outlet of the lithiation static mixer **5** for HPLC analysis were collected. Samples were taken before (a) the onset of the coupling reaction, and (b) after the collection of the reaction mixture into the MSA-MeOH reactor.

5 **Continuous Coupling Reaction**

[00157] The D/toluene feed (2.96 ml/min) was pre-cooled via a heat exchanger before mixing with the lithiation stream.

[00158] The two streams namely G and D were mixed and combined through a jacketed static mixer **22** (between -24°C and -30°C).

10 [00159] The reaction stream appeared yellowish in color.

[00160] Samples were collected at the outlet of the mixer **22** for HPLC analysis. Samples were taken before and after the collection into the MSA-MeOH reactor **25**.

Methyl Glycosidation

15 [00161] The coupling reaction stream **24** was fed to a 500-ml reactor **25** containing MSA and methanol or HCl/MeOH at <-10°C with stirring.

[00162] After the collection were finished, the reaction mixture was kept at <-10°C with stirring for another hour.

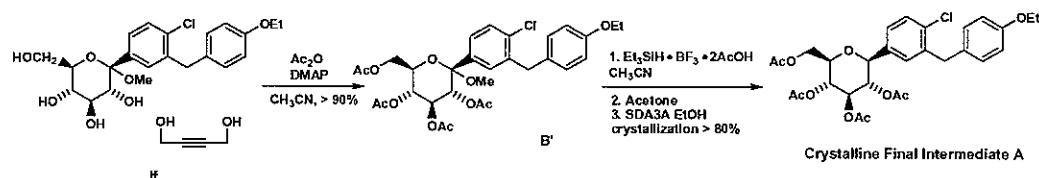
[00163] The reaction mixture was heated up to 35°C. The reaction was deemed
20 complete (about 6 hrs) until HPLC analysis indicated that desilylated hemiketal H' RAP < 0.3 %. The reaction was cooled to room temperature (20°C) and the reaction mixture was held for 16 hrs to form compound B.

Formation of Crystals of If

25 [00164] B was crystallized with 2-butyne-1,4-diol (J) in toluene/EtOAc to yield crystals of If.

EXAMPLE 17

Preparation of Intermediate A



- [00165] Solid compound If (50.0 g), solid DMAP (1.2 g), liquid acetonitrile (450 mL), and liquid acetic anhydride (63 mL) were charged to a 250 ml flask reactor.
- [00166] The batch (77°C) was heated and held until reaction complete.
- [00167] The batch was cooled (5°C).
- [00168] Triethylsilane (72 mL), and boron trifluoride acetic acid complex (63 mL) were charged to the reactor.
- 10 [00169] After completion of the reaction, acetone (36 mL) was added.
- [00170] The batch (21°C) was warmed and held until triethylsilane was consumed.
- [00171] Aqueous NH₄OAc (33 wt%, 450 mL) was added and the batch was mixed, allowed to settle until upper and lower phases formed.
- [00172] Batch volume of product in the rich upper phase was reduced by distilling off acetonitrile to minimum agitation. Ethanol SDA3A (1 L) was charged at elevated
- 15 [00173] The product was crystallized by cooling or cooling with seeding (5 wt% based on compound If wet-milled, nitrogen jet milled, or a previous batch). The product was typically isolated in > 75% yield.
- 20 [00174] The product was recrystallized as either a wet or dry cake from ethanol SDA3A.

CRYSTAL STRUCTURE CHARACTERIZATION

- [00175] Crystal structures equivalent to the crystal structures described below and
- 25 claimed herein may demonstrate similar, yet non-identical, analytical characteristics within a reasonable range of error, depending on test conditions, purity, equipment and other common variables known to those skilled in the art.
- [00176] Accordingly, it will be apparent to those skilled in the art that various modifications and variations can be made in the present invention without departing

from the scope and spirit of the invention. Other embodiments of the invention will be apparent to those skilled in the art from consideration of the specification and practice of the invention disclosed herein. Applicants intend that the specification and examples be considered as exemplary, but not limiting in scope.

5

X-ray Powder Diffraction

[00177] One of ordinary skill in the art will appreciate that a powder X-ray diffraction pattern may be obtained with a measurement error that is dependent upon the measurement conditions employed. In particular, it is generally known that intensities in a X-ray powder diffraction pattern may fluctuate depending upon measurement conditions employed. It should be further understood that relative intensities may also vary depending upon experimental conditions and, accordingly, the exact order of intensity should not be taken into account. Additionally, a measurement error of diffraction angle for a conventional powder X-ray powder diffraction pattern is typically about 5% or less, and such degree of measurement error should be taken into account as pertaining to the aforementioned diffraction angles. Consequently, it is to be understood that the crystal structures of the instant invention are not limited to the crystal structures that provide X-ray diffraction patterns completely identical to the X-ray powder diffraction patterns depicted in the accompanying Figures disclosed herein. Any crystal structures that provide powder X-ray diffraction patterns substantially identical to those disclosed in the accompanying Figures fall within the scope of the present invention. The ability to ascertain substantial identities of X-ray powder diffraction patterns is within the purview of one of ordinary skill in the art.

25

(S)-PG (form SC-3) Ia, (R)-PG Ib, 1,4-Butyne-diol Solvate If and Dimethanol Solvate Ig, Hemihydrate of 1:1 L-Proline Complex Ij (H.5-2), 1:2 L-Proline Complex Ih and 1:1 L-Proline Complex Ii Structures

[00178] About 200 mg were packed into a Philips powder X-ray diffraction (PXRD) sample holder. The sample was transferred to a Philips MPD unit (45 KV, 40 mA, Cu K α_1). Data were collected at room temperature in the 2 to 32 2-theta range

30

(continuous scanning mode, scanning rate 0.03 degrees/sec., auto divergence and anti scatter slits, receiving slit: 0.2 mm, sample spinner : ON).

- [00179] Powder X-ray diffraction patterns for the (S)-PG (Ia), (R)-PG (Ib) structures are illustrated in Figures 1 and 2, respectively. Powder X-ray diffraction patterns for the 1,4-butyne-diol solvate If and the dimethanol solvate Ig are illustrated in Figures 9 and 10, respectively. Powder X-ray diffraction patterns for the 1:2 L-proline complex Ih, 1:1 L-proline complex Ii, and the 1:1 L-proline hemihydrate complex Ij structures are illustrated in Figures 13, 14 and 15, respectively. Selected diffraction peak positions (degrees $2\theta \pm 0.2$) for the (S)-PG (Ia), (R)-PG (Ib) hemihydrate of 1:1 L-proline complex Ij (H.5-2), 1:2 L-proline complex Ih and 1:1 L-proline complex Ii structures are shown in Table 1 below. Characteristic diffraction peak positions (degrees $2\theta \pm 0.1$) at RT, are based on a high quality pattern collected with a diffractometer (CuK α) with a spinning capillary with 2θ calibrated with a National Institute of Standards and Technology methodology, and other suitable standard known to those skilled in the art. The relative intensities, however, may change depending on the crystal size and morphology.

TABLE 1
Selected PXRD Peaks ($2\theta \pm 0.2^\circ$)

(S)-PG (Ia)	(R)-PG (Ib)	H.5-2, 1:1 L-proline (hemihydrate) (Ij)	N-1, 1:2 L-proline (Ih)	N-1 1:1 L-proline (Ii)
3.8	3.9	3.9	3.3	3.9
7.6	8.0	8.8	6.5	9.5
8.1	8.7	15.5	8.6	15.4
8.7	15.3	15.8	15.7	15.7
15.2	15.6	16.5	16.4	15.9
15.7	17.2	17.8	17.2	17.5
17.1	19.2	19.4	18.9	18.7
18.9	19.9	19.7	19.8	19.7
20.1	20.3	20.8	20.2	20.3

Solid-State Nuclear Magnetic Resonance

[00180] The structures of (S)-PG (Ia), (R)-PG (Ib), 1,4-butyne-diol solvate If and dimethanol solvate Ig were characterized by solid state NMR techniques.

[00181] All solid-state C-13 NMR measurements were made with a Bruker DSX-400, 400 MHz NMR spectrometer. High resolution spectra were obtained using high-power proton decoupling and the TPPM pulse sequence and ramp amplitude cross-polarization (RAMP-CP) with magic-angle spinning (MAS) at approximately 12 kHz (A.E. Bennett et al, *J. Chem. Phys.*, 1995, 103, 6951; G. Metz, X. Wu and S.O. Smith, *J. Magn. Reson. A.*, 1994, 110, 219-227). Approximately 70 mg of sample, packed into a canister-design zirconia rotor was used for each experiment. Chemical shifts (δ) were referenced to external adamantane with the high frequency resonance being set to 38.56 ppm (W.L. Earl and D.L. VanderHart, *J. Magn. Reson.*, 1982, 48, 35-54).

[00182] The resulting ^{13}C NMR CPMAS spectrum for structure (S)-PG and (R)-PG are shown in Figures 3 and 4 respectively.

[00183] The major resonance peaks for the solid state carbon spectrum of (S)-PG and (R)-PG are listed below in Table 1A and Table 2 and for 1,4-butyne-diol solvate If and dimethanol solvate Ig are listed below in Tables 2A and 2B, respectively. Crystal structures demonstrating substantially similar ^{13}C NMR peak positions, wherein "substantially similar" means 10 to 15% of dimensionless value, are deemed to fall within the scope of the invention (i.e., equivalent to the structures illustrated below).

TABLE 1A

Proton NMR Peak Positions for (S)-Propylene Glycol Solvate Ia

[00184] ^1H NMR (400 MHz, d_6 -DMSO) δ 1.00 (d, 3H, $J = 6.25$ Hz, PG- CH_3), 1.29 (t, 3H, $J = 6.98$ Hz, $-\text{CH}_2\text{CH}_3$), 3.0-3.30 (m, 4H, H2, H3, H4, H-5), 3.43 (m, 1H, H-6a), 3.53 (m, 1H), 3.69 (bdd, H, $J = 4.4$ Hz, H-6b), 3.9-4.1 (m, 5H, H-1, $-\text{CH}_2$, $-\text{CH}_2$), 4.38 (d, 1H, $J = 4.5$ Hz, OH), 4.44 (dt, 2H, $J = 2.2$ Hz, $J = 5.7$ Hz), 4.82 (d, 1H, $J = 5.7$ Hz, -OH), 4.94 and 4.95 (2d, 2H, 2-OH), 6.82 (d, 2H, $J = 8.6$ Hz, Ar-H), 7.09 (d, 2H, $J = 8.6$ Hz, Ar-H), 7.22 (dd, 1H, $J = 1.97$ Hz, 8.25 Hz, Ar-H), 7.31 (bd, 1H, 1.9 Hz, Ar-H), 7.36 (d, 1H, $J = 8.2$ Hz, Ar-H).

TABLE 2
SSNMR Peak Positions / δ (in ppm) Relative to TMS (Tetramethyl Silane)

(S)-PG	(R)-PG
δ / ppm	δ / ppm
16.2	15.8
17.6	17.6
39.3	39.0
60.9	60.9
63.3	63.2
69.8	67.4
76.9	69.7
78.7	77.3
79.4	79.2
113.8	79.8
123.6	113.3
129.3	123.6
130.5	129.0
132.0	130.4
135.7	132.0
139.1	135.6
158.0	139.2
	157.9

[00185] These data are strictly valid for a 400 MHz spectrophotometer.

5

TABLE 2A

Proton NMR Peak Positions for 1,4-Butyne-diol Solvate If

[00186] ^1H NMR (400 MHz, CDCl_3) δ 1.33 (t, 3H, $J = 7.1$ Hz, $-\text{CH}_3$), 2.90 (s, 2H, $-\text{CH}_2$), 3.39 (s, 9H, $-\text{OCH}_3$), 3.4-3.65 (m, 3H), 3.81 (bm, 2H), 3.91 (q, 2H, $J = 7.1$ Hz, $-\text{CH}_2$), 3.97 (m, 1H), 6.73 (d, 1H, $J = 8.6$ Hz, Ar-H), 7.02 (d, 2H, $J = 8.4$ Hz, Ar-H), 7.25 (s, 2H, Ar-H), 7.34 (s, 1H, Ar-H); ^{13}C (CDCl_3) δ 14.78, 38.43, 49.14, 50.57, 61.84, 63.34, 69.98, 72.53, 74.63, 100.95, 114.36, (2), 126.64, 129.19, 129.59, 129.71, 131.38, 134.30, 136.61, 138.50, 157.27. M.P. 103.08°C.

10

TABLE 2B

Proton NMR Peak Positions for Dimethanol Solvate Ig

[00187] ^1H NMR (400 MHz, DMSO- D_6) δ 1.26 (t, 3H, $J = 7.1$ Hz, $-\text{CH}_3$), 2.38-2.54 (m, 1H), 2.5 (s, 2H, $-\text{CH}_2$), 3.2 (m, 1H), 3.35 (m, 3H, $-\text{OCH}_3$), 3.16-3.39 (m, 1H, H-6), 3.41-3.42 (m, 1H, H-6), 3.9 (q, 2H, $J=7.2$ Hz, CH_2), 4.05 (d, 4H, $-\text{CH}_2$), 4.52 (t, 1H), 4.75 (m, 2H), 4.95 (d, 2H), 5.23 (t, 2H), 6.82 (d, 2H, $J=8.6$ Hz, Ar-H), 7.07 (d, 2H, $J = 8.6$ Hz, Ar-H) 7.4 (s, 2H, Ar-H), 7.50 (s, 1H, Ar-H); ^{13}C (CDCl_3) δ 14.69, 48.28, 49.02, 60.81, 62.84, 70.05, 74.02, 76.81, 83.97, 100.64, 114.23, 127.40, 128.2, 129.44, 131.2, 131.4, 132.45, 137.38, 138.57, 156.84. Elemental analysis

10 Calculated for $\text{C}_{26}\text{H}_{33}\text{ClO}_9$: Calc C 59.48, H6.34, Cl 6.75; Found C 59.35, H5.97, Cl 6.19.

Thermal Gravimetric Analysis

[00188] Thermal gravimetric analysis (TGA) experiments were performed in a TA Instruments™ model Q500. The sample (about 10-30 mg) was placed in a platinum pan previously tared. The weight of the sample was measured accurately and recorded to a thousand of a milligram by the instrument. The furnace was purged with nitrogen gas at 100mL/min. Data were collected between room temperature and 300°C at 10°C/min heating rate.

20 [00189] TGA curves for the (S)-PG Ia and (R)-PG Ib structures are shown in Figures 5 and 6, respectively. Weight loss corresponds to one mole of water and one mole of propylene glycol per mole of structure analyzed.

[00190] TGA curves for the 1:2 L-proline complex Ih, the 1:1 L-proline complex Ii and the 1:1 L-proline hemihydrate complex Ij structures are shown in Figures 16, 17 and 18, respectively. Weight loss corresponds to one mole of water and one mole of L-proline per mole of structure analyzed.

Differential Scanning Calorimetry

[00191] The solid state thermal behavior of the (S)-PG Ia, (R)-PG Ib, 1,4-butyne-diol solvate If, dimethanol solvate Ig, 1:2 L-proline Ih, the 1:1 L-proline Ii and the 1:1 L-proline hemihydrate Ij structures were investigated by differential scanning calorimetry (DSC). The DSC curves for the (S)-PG Ia and (R)-PG Ib structures are

shown in Figures 7 and 8, respectively. The DSC curves for the 1,4-butyne-diol solvate If and the dimethanol solvate Ig structures are shown in Figures 11 and 12, respectively. The DSC curves for the 1:2 L-proline complex Ih, the 1:1 L-proline complex Ii and the 1:1 L-proline hemihydrate Ij structures are shown in Figures 19, 20 and 21, respectively.

[00192] Differential scanning calorimetry (DSC) experiments were performed in a TA Instruments™ model Q1000. The sample (about 2-6 mg) was weighed in an aluminum pan and recorded accurately recorded to a hundredth of a milligram, and transferred to the DSC. The instrument was purged with nitrogen gas at 50mL/min. Data were collected between room temperature and 300°C at 10°C/min heating rate. The plot was made with the endothermic peaks pointing down.

[00193] One of skill in the art will however, note that in DSC measurement there is a certain degree of variability in actual measured onset and peak temperatures, depending on rate of heating, crystal shape and purity, and other measurement parameters.

Single Crystal X-ray Analysis

[00194] A single crystal for the (S)-PG Ia, structure, and for the 1,4-butyne-diol solvate If, dimethanol solvate Ig, 1:2 L-proline Ih, 1:1 L-proline Ii and 1:1 L-proline hemihydrate Ij structures were obtained and investigated by x-ray diffraction.

[00195] Data were collected on a Bruker-Nonius¹ CAD4 serial diffractometer. Unit cell parameters were obtained through least-squares analysis of the experimental diffractometer settings of 25 high-angle reflections. Intensities were measured using Cu K α radiation ($\lambda = 1.5418 \text{ \AA}$) at a constant temperature with the Θ -2 Θ variable scan technique and were corrected only for Lorentz-polarization factors. Background counts were collected at the extremes of the scan for half of the time of the scan. Alternately, single crystal data were collected on a Bruker-Nonius Kappa CCD 2000 system using Cu K α radiation ($\lambda = 1.5418 \text{ \AA}$). Indexing and processing of the

¹ BRUKER AXS, Inc., 5465 East Cheryl Parkway Madison, WI 53711 USA

measured intensity data were carried out with the HKL2000 software package² in the Collect program suite.³

[00196] When indicated, crystals were cooled in the cold stream of an Oxford cryo system⁴ during data collection.

- 5 [00197] The structures were solved by direct methods and refined on the basis of observed reflections using either the SDP⁵ software package with minor local modifications or the crystallographic package, MAXUS.⁶

[00198] The derived atomic parameters (coordinates and temperature factors) were refined through full matrix least-squares. The function minimized in the refinements
10 was $\sum_w (|F_o| - |F_c|)^2$. R is defined as $\sum ||F_o| - |F_c|| / \sum |F_o|$ while $R_w = [\sum_w (|F_o| - |F_c|)^2 / \sum_w |F_o|]^2$ where w is an appropriate weighting function based on errors in the observed intensities. Difference maps were examined at all stages of refinement. Hydrogens were introduced in idealized positions with isotropic temperature factors, but no hydrogen parameters were varied.

- 15 [00199] Unit cell parameters for the (S)-PG structure Ia form SC-3 are listed below in Table 3. As used herein, the unit cell parameter "molecules/per cell" refers to the number of molecules of Compound in the unit cell.

TABLE 3

Unit Cell Data for (S)-PG (Ia)

20

Structure	T	a(Å)	b(Å)	c(Å)	α°	β°	γ°	V_m	Z'	SG	Dcalc	R
Ia (S)-PG	25	11.2688(8)	4.8093(3)	46.723(3)	90	90	90	633	1	P2 ₁ 2 ₁ 2 ₁	1.319	.069

T = temp (°C) for the crystallographic data.

Z' = number of drug molecules per asymmetric unit

$V_m = V(\text{unit cell}) / (Z \text{ drug molecules per cell})$

² Otwinowski, Z. & Minor, W. (1997) in *Macromolecular Crystallography*, eds. Carter, W.C. Jr & Sweet, R.M. (Academic, NY), Vol. 276, pp.307-326

³ Collect Data collection and processing user interface: Collect: Data collection software, R. Hooft, Nonius B.V., 1998

⁴ Oxford Cryosystems Cryostream cooler: J. Cosier and A.M. Glazer, J. Appl. Cryst., 1986, 19, 105

⁵ SDP, Structure Determination Package, Enraf-Nonius, Bohemia NY 11716

Scattering factors, including f' and f'' , in the SDP software were taken from the "International Tables for Crystallography", Kynoch Press, Birmingham, England, 1974; Vol. IV, Tables 2.2A and 2.3.1

R = residual index ($I > 2\sigma(I)$)

D_{calc} = density of crystal calculated

SG = space group

- 5 [00200] Table 4 below sets forth the positional parameters for the (S)-PG Ia structure at 25°C.

TABLE 4
Positional Parameters for (S)-PG at T= 25°C

Atom	X	Y	Z
CL	0.7313	0.4674	-0.2101
O5	0.8119	0.5766	-0.0701
O4	0.7202	0.5458	0.0056
O3	0.5115	0.3666	-0.0246
O6	0.9646	0.2671	-0.0316
O2	0.4895	0.5889	-0.0811
C2	0.6024	0.5045	-0.0697
C12	0.7946	0.4228	-0.1261
C5	0.8198	0.6301	-0.0398
O17	0.1633	0.2154	-0.2179
C8	0.6391	0.7665	-0.1320
C6	0.9425	0.5628	-0.0299
C3	0.5984	0.5441	-0.0373
C1	0.7059	0.6639	-0.0829
C7	0.7147	0.6097	-0.1148
C4	0.7190	0.4796	-0.0240
C10	0.7203	0.5412	-0.1732
C17	0.2586	0.3689	-0.2079
C19	0.4171	0.6835	-0.2198
C11	0.7959	0.3822	-0.1562
C9	0.6397	0.7259	-0.1622
C13	0.5535	0.8771	-0.1822
C14	0.4508	0.6852	-0.1907
C15	0.3841	0.5376	-0.1712
C16	0.2861	0.3765	-0.1788
C20	0.1012	0.0595	-0.1979
C18	0.3232	0.5239	-0.2279
C21	0.0030	-0.0944	-0.2137

⁶ maXus solution and refinement software suite: S. Mackay, C.J. Gilmore, C. Edwards, M. Tremayne, N. Stewart, K. Shankland. maXus: a computer program for the solution and refinement of crystal structures from diffraction data.

Atom	X	Y	Z
O89	0.3708	0.0977	-0.0854
O88	0.1294	0.2019	-0.0742
C88	0.1652	-0.0245	-0.0920
C89	0.2791	0.0335	-0.1051
C87	0.0645	-0.1005	-0.1124
O99	0.2722	0.4482	-0.0319
H21	0.6171	0.2877	-0.0753
H121	0.8544	0.3092	-0.1123
H51	0.7993	0.8404	-0.0347
H81	0.5805	0.9176	-0.1225
H61	0.9563	0.6296	-0.0070
H62	1.0096	0.6774	-0.0422
H31	0.5776	0.7529	-0.0321
H11	0.6920	0.8863	-0.0793
H41	0.7271	0.2607	-0.0265
H191	0.4656	0.8069	-0.2353
H111	0.8552	0.2316	-0.1658
H131	0.5284	1.0619	-0.1717
H132	0.6093	0.9308	-0.2010
H151	0.4086	0.5437	-0.1488
H161	0.2335	0.2640	-0.1632
H201	0.1483	-0.1065	-0.1854
H202	0.0535	0.1811	-0.1804
H181	0.2987	0.5193	-0.2503
H211	-0.0606	-0.2245	-0.2014
H212	-0.0562	0.0572	-0.2256
H213	0.0387	-0.2305	-0.2306
H2	0.4362	0.4237	-0.0836
H3	0.4297	0.4310	-0.0299
H4	0.7387	0.3750	0.0172
H6	0.9827	0.1877	-0.0122
H881	0.1809	-0.2154	-0.0792
H891	0.2662	0.2151	-0.1200
H892	0.3059	-0.1396	-0.1196
H871	0.0875	-0.2595	-0.1270
H872	-0.0137	-0.1453	-0.1008
H873	0.0462	0.0938	-0.1255
H89	0.4203	-0.0719	-0.0817
H88	0.0653	0.1382	-0.0608
H991	0.2473	0.6301	-0.0234
H992	0.2108	0.3906	-0.0463

[00201] Unit cell parameters for the mono-ethanol dihydrate (ethanol or EtOH structure) form SA-1, formula Ic are listed below in Table 5.

TABLE 5

Unit Cell Data for Ethanol SA-1 (Ic)

Form	T°	a(Å)	b(Å)	c(Å)	α°	β°	γ°	Z'	SG	V _m	R	D _{calc}
Ic SA-1	-50	11.519(1)	4.799(1)	22.648(1)	-	94.58(1)	-	1	P2 ₁	624	1.307	0.05

T = temp (°C) for crystallographic data

5 Z' = number of drug molecules per asymmetric unit

V_m = V (unit cell)/(Z drug molecules per cell)

R = residual index (I>3sigma(I))

D_{calc} = density of crystal calculated

SG = space group

10

[00202] Table 6 below sets forth the positional parameters for the form SA-1 (mono- ethanol-dihydrate), Ic at -50°C.

TABLE 6

Fractional Atomic Coordinates for Form SA-1 at T=-50°C

15

Atom	X	Y	Z
CL	0.7673	0.0854	-0.4142
O2	0.8652	0.6413	-0.1468
O5	0.8652	0.6413	-0.1468
O6	1.0613	0.9910	-0.0876
C2	0.6634	0.5087	-0.1420
O3	0.5964	0.4528	-0.0442
C1	0.7531	0.6504	-0.1782
O17	0.1965	-0.2110	-0.3797
O4	0.7928	0.7549	0.0061
C7	0.7605	0.5175	-0.2375
C3	0.6679	0.6209	-0.0790
C14	0.4816	0.3213	-0.3866
C10	0.7629	0.2551	-0.3461
C13	0.5827	0.5268	-0.3868
C8	0.6801	0.5902	-0.2843
C9	0.6770	0.4593	-0.3397
C6	0.9968	0.7646	-0.0652
C12	0.8423	0.3089	-0.2459
C4	0.7906	0.6184	-0.0498
C5	0.8704	0.7698	-0.0896
C15	0.4335	0.2531	-0.3337

Atom	X	Y	Z
C11	0.8449	0.1815	-0.3008
C17	0.2911	-0.0396	-0.3851
C20	0.141	-0.3384	-0.4319
C19	0.4321	0.2052	-0.4377
C18	0.3377	0.0255	-0.4384
C16	0.3405	0.0751	-0.3330
C21	0.0431	-0.5128	-0.4132
O98	0.3643	0.6071	-0.0516
O88	0.2324	-0.2097	-0.1501
C89	0.1155	-0.3014	-0.2376
C88	0.2065	-0.4150	-0.1969
O99	0.4409	0.0604	-0.1784
H21	0.6816	0.2833	-0.1387
H11	0.7283	0.8620	-0.1864
H31	0.6356	0.8307	-0.0805
H131	0.6184	0.5131	-0.4303
H132	0.5505	0.7308	-0.3806
H81	0.6182	0.7524	-0.2770
H61	1.0365	0.5668	-0.0787
H62	1.0037	0.7711	-0.0175
H121	0.9040	0.2455	-0.2092
H41	0.8196	0.4009	-0.0436
H51	0.8385	0.9826	-0.0936
H151	0.4692	0.3444	-0.2915
H111	0.9111	0.0214	-0.3081
H201	0.1146	-0.1875	-0.4650
H202	0.2075	-0.4764	-0.4514
H191	0.4703	0.2491	-0.4794
H181	0.3000	-0.0606	-0.4802
H161	0.3071	0.0128	-0.2910
H3	0.5153	0.5297	-0.0473
H2	0.5091	0.3623	-0.1752
H211	-0.0028	-0.6153	-0.4507
H212	0.0724	-0.6675	-0.3807
H213	-0.0204	-0.3772	-0.3928
H6	1.1241	0.9168	-0.1118
H4	0.8466	0.6527	0.0359
H981	0.3836	0.7445	-0.0185
H982	0.3063	0.4696	-0.0382
H891	0.0626	-0.4601	-0.2593
H892	0.0592	-0.1642	-0.2133
H893	0.1534	-0.1727	-0.2709
H881	0.2834	-0.4603	-0.2200
H882	0.1765	-0.6100	-0.1783
H88	0.2806	-0.2965	-0.1158

Atom	X	Y	Z
H991	0.3630	-0.0141	-0.1685
H992	0.4889	-0.1137	-0.1762

[00203] Unit cell parameters for the ethylene glycol form SB-1, formula Id are listed below in Table 7.

5

TABLE 7

Unit Cell Data for EG-SB-1 (Id)

Form	T°	a(Å)	b(Å)	c(Å)	α°	β°	γ°	Z'	SG	V _m	R	D _{calc}
Id SB-1	-50	11.593(8)	4.766(5)	22.78(3)	-	93.38(9)	-	1	P2 ₁	628	.19	1.340

T = temp (°C) for crystallographic data

Z' = number of drug molecules per asymmetric unit

V_m = V (unit cell)/(Z drug molecules per cell)

10 R = residual index ($I > 3\sigma(I)$)

D_{calc} = density of crystal calculated

SG = space group

[00204] Table 8 below sets forth the positional parameters for the form SB-1

15 (ethylene glycol) Id at -50°C.

TABLE 8

Fractional Atomic Coordinates for Form SB-1 at T=-50°C

Atom	X	Y	Z
CL	0.7590	0.0820	-0.4198
O5	0.8631	0.5990	-0.1537
O17	0.1901	-0.1911	-0.3791
C13	0.5791	0.5319	-0.3885
O3	0.5941	0.4849	-0.0439
C11	0.8381	0.1410	-0.3059
O4	0.7851	0.8250	-0.0026
C10	0.7531	0.2610	-0.3514
O2	0.5470	0.4971	-0.1739
C18	0.3341	0.0390	-0.4399
C14	0.4851	0.3559	-0.3849
C1	0.7451	0.6551	-0.1789
C12	0.8281	0.2849	-0.2539

Atom	X	Y	Z
C5	0.8711	0.7820	-0.0959
C19	0.4311	0.2230	-0.4349
C17	0.2810	-0.0380	-0.3919
C4	0.7791	0.6341	-0.0569
C7	0.7530	0.4769	-0.2399
C8	0.6751	0.5781	-0.2889
C9	0.6671	0.4150	-0.3429
C2	0.6601	0.4859	-0.1429
C15	0.4250	0.2791	-0.3379
C20	0.1391	-0.3181	-0.4309
C21	0.0331	-0.4761	-0.4109
C3	0.6660	0.6460	-0.0839
C16	0.3341	0.1049	-0.3399
O6	1.0280	0.4331	-0.0685
O98	0.3689	0.6530	-0.0551
O99	0.4310	0.0080	-0.1639
C6	0.9880	0.6960	-0.0759
O88	0.1661	-0.7610	-0.1669
O89	0.0461	-0.2291	-0.2249
C88	0.1970	-0.5606	-0.1946
C89	0.1423	-0.4698	-0.2450
H89	-0.0093	-0.1368	-0.2011
H88	0.0999	-0.9161	-0.1930
H2	0.5081	0.3212	-0.1695
H3	0.5158	0.5512	-0.0479
H6	1.0592	0.3693	-0.1043
H981	0.3142	0.5218	-0.0410
H982	0.3908	0.7860	-0.0248
H991	0.4708	-0.1672	-0.1673
H992	0.3887	0.0065	-0.1290
H41	0.8040	0.4214	-0.0458
H31	0.6366	0.8606	-0.0878
H51	0.8478	0.9977	-0.1052
H21	0.6886	0.2707	-0.1389
H11	0.7300	0.8758	-0.1869
H61	1.0435	0.7903	-0.1069
H62	1.0031	0.7943	-0.0335
H81	0.6253	0.7679	-0.2848
H111	0.8971	-0.0296	-0.3127
H121	0.8920	0.2316	-0.2193
H151	0.4529	0.3653	-0.2956
H161	0.2954	0.0652	-0.2987
H181	0.3033	-0.0383	-0.4826
H191	0.4696	0.2685	-0.4759
H201	0.1135	-0.1601	-0.4631

Atom	X	Y	Z
H202	0.1990	-0.4618	-0.4495
H211	-0.0104	-0.5787	-0.4482
H212	0.0603	-0.6313	-0.3784
H213	-0.0253	-0.3295	-0.3920
H891	0.0986	-0.6418	-0.2678
H892	0.2033	-0.3761	-0.2733
H881	0.2163	-0.3858	-0.1655
H882	0.2762	-0.6665	-0.2039
H131	0.6119	0.5248	-0.4319
H132	0.5566	0.7453	-0.3781

[00205] Unit cell parameters for the ethylene glycol form SB-2, formula Ie are listed below in Table 9.

5

TABLE 9

Unit Cell Data for EG-SB-2 (Ie)

Form	T°	a(Å)	b(Å)	c(Å)	α°	β°	γ°	Z'	SG	V _m	R	D _{calc}
Ie SB-2	-50	11.4950(1)	4.7443(1)	44.4154(5)	-	-	-	1	P2 ₁ 2 ₁ 2 ₁	606	.050	1.390

T = temp (°C) for crystallographic data

Z' = number of drug molecules per asymmetric unit

V_m = V (unit cell)/(Z drug molecules per cell)

10 R = residual index (I>3sigma(I))

D_{calc} = density of crystal calculated

SG = space group

[00206] Table 10 below sets forth the positional parameters for the form SB-2
15 (ethylene glycol) Id at -50°C.

TABLE 10

Fractional Atomic Coordinates for Form SB-2 at T=-50°C

Atom	X	Y	Z
CL	0.7374	0.5149	-0.2111
O1	0.8133	0.9822	-0.0746
O2	0.5013	0.9285	-0.0845
O4	0.7289	1.0601	0.0035
O3	0.5256	0.8247	-0.0225

Atom	X	Y	Z
C13	0.5550	0.9627	-0.1935
O6	0.9728	0.7735	-0.0353
C4	0.7265	0.9455	-0.0262
C3	0.6074	0.9836	-0.0396
C8	0.6428	0.9915	-0.1422
C5	0.8145	1.0938	-0.0449
C2	0.6104	0.8706	-0.0710
C1	0.7042	1.0158	-0.0896
O17	0.1616	0.2406	-0.1894
C10	0.7254	0.6663	-0.1761
C14	0.4505	0.7632	0.1926
C12	0.7921	0.6786	-0.1254
C7	0.7155	0.8961	-0.1199
C17	0.2595	0.4115	-0.1926
C9	0.6431	0.8746	-0.1706
C11	0.7977	0.5663	-0.1538
C18	0.3043	0.4904	-0.2191
C6	0.9384	1.0646	-0.0348
C21	0.0106	-0.0544	-0.2044
C15	0.4002	0.6700	-0.1674
C16	0.3062	0.5028	-0.1664
C19	0.4048	0.6705	-0.2196
C20	0.1094	0.1211	-0.2133
O89	0.1914	0.1344	-0.0851
O88	0.0643	-0.3997	-0.0870
C88	0.0717	-0.2076	-0.1097
C89	0.1793	-0.0404	-0.1104
O98	0.2861	-0.0622	-0.0315
O99	0.3991	0.4406	-0.0899
H131	0.5987	0.9339	-0.2163
H132	0.5342	1.1796	-0.1916
H41	0.7470	0.7230	-0.0250
H31	0.5865	1.2077	-0.0378
H81	0.5800	1.1634	-0.1366
H51	0.7979	1.3174	-0.0455
H21	0.6251	0.6488	-0.0697
H11	0.6844	1.2377	-0.0920
H121	0.8481	0.5958	-0.1080
H111	0.8591	0.3889	-0.1576
H181	0.2593	0.4179	-0.2399
H151	0.4420	0.7303	-0.1453
H161	0.2700	0.4433	-0.1446
H191	0.4500	0.7270	-0.2410
H61	0.9486	1.1532	-0.0124
H62	0.9940	1.1868	-0.0502

Atom	X	Y	Z
H201	0.0802	0.2769	-0.2296
H202	0.1742	-0.0142	-0.2253
H211	-0.0281	-0.1580	-0.2236
H212	0.0418	-0.2183	-0.1889
H213	-0.0522	0.0728	-0.1931
H2	0.4568	0.7450	-0.0867
H3	0.4455	0.9047	-0.0257
H6	0.9900	0.7115	-0.0140
H4	0.7487	0.9051	0.0180
H891	0.1791	0.0911	-0.1307
H892	0.2524	-0.1815	-0.1307
H881	0.0688	-0.3227	-0.1317
H882	-0.0006	-0.0646	-0.1095
H89	0.1389	0.3052	-0.0871
H88	0.0278	-0.3039	-0.0685
H981	0.2546	-0.0138	-0.0523
H991	0.3186	0.3564	-0.0924
H992	0.4542	0.2696	-0.0893

[00207] Unit cell parameters for the 1,4-butyne-diol solvate If are listed below in Table 11.

5

TABLE 11

Unit Cell Data for 1,4-Butyne-diol Solvate If

Form	T	a(Å)	b(Å)	c(Å)	α°	β°	γ°	Z'	SG	V _m	R	D _{calc}
YD-1 (If)	25	21.576(7)	6.755(1)	18.335(5)	-	102.96(1)	-	1	C2	651	.055	1.339
YD-1 (If)	-50	21.537(4)	6.7273(6)	18.267(3)	-	102.924(7)	-	1	C2	645	.054	1.352

T = temp (°C) for the crystallographic data

Z' = number of drug molecules per asymmetric unit

V_m = V(unit cell)/(Z drug molecules per cell)

10 R = residual index (I>2sigma(I))

D_{calc} = density of crystal calculated

SG = space group

[00208] Table 12 below sets forth the positional parameters for the 1,4-butyne-diol solvate If at 25°C.

15

TABLE 12
Table of Fractional Atomic Coordinates for
1,4-Butyne-diol Solvate If at T = 25°C

Atom	X	Y	Z
CL1	0.4766	0.0404	0.0954
O1	0.4009	0.0489	0.4240
O2	0.2487	0.0360	0.2866
O3	0.3361	0.3116	0.3700
O4	0.2980	-0.0335	0.5564
C1	0.4341	-0.0386	0.2933
C2	0.2694	-0.0045	0.4212
C3	0.3808	0.0618	0.4929
O5	0.2184	-0.1421	0.4159
O6	0.1438	0.7685	0.0893
C4	0.3553	0.1186	0.3597
C5	0.4405	0.0690	0.1713
C6	0.4608	-0.0547	0.2314
C7	0.2958	-0.0113	0.3508
C8	0.3662	0.2182	0.2312
C9	0.3737	0.3483	0.1029
O7	0.4545	-0.2052	0.5425
C10	0.3205	-0.0595	0.4899
C11	0.1993	0.4901	0.0635
C12	0.3137	0.4646	0.1010
C13	0.3863	0.0987	0.2935
C14	0.3927	0.2100	0.1692
C15	0.4368	-0.0055	0.5534
C16	0.2546	0.3872	0.0663
C17	0.2011	0.6771	0.0960
C18	0.3867	0.4541	0.3863
C19	0.3147	0.6507	0.1327
C20	0.2589	0.7579	0.1310
C21	0.0758	1.0412	0.0907
C22	0.1428	0.9704	0.1110
O8	0.1617	0.3320	0.3009
C23	0.0884	0.7849	0.2826
C24	0.1613	0.4969	0.2531
C25	0.1208	0.6569	0.2679
C26	0.0508	0.9415	0.3041
O9?*	0.0699	1.0883	0.3388
O10*	0.0921	0.9885	0.3889
H1	0.4482	-0.1199	0.3347
H2	0.2539	0.1293	0.4275
H3	0.3717	0.2007	0.5020
H4	0.4923	-0.1485	0.2306

Atom	X	Y	Z
H5	0.3090	-0.1481	0.3449
H6	0.3335	0.3078	0.2311
H7	0.4083	0.4406	0.1034
H8	0.3681	0.2711	0.0573
H9	0.3310	-0.1996	0.4860
H10	0.1605	0.4349	0.0399
H11	0.4728	0.0808	0.5536
H12	0.4259	0.0056	0.6018
H13	0.2525	0.2624	0.0444
H14	0.4194	0.4073	0.4272
H15	0.3705	0.5779	0.3998
H16	0.4041	0.4724	0.3430
H17	0.3536	0.7062	0.1557
H18	0.2607	0.8821	0.1533
H19	0.0586	1.0179	0.0384
H20	0.0746	1.1804	0.1009
H21	0.0510	0.9710	0.1197
H22	0.1691	1.0491	0.0855
H23	0.1594	0.9831	0.1645
H24	0.2242	0.1281	0.2970
H25	0.1826	-0.0801	0.4013
H26	0.2934	0.0916	0.5641
H27	0.4478	-0.2782	0.5791
H28	0.1742	0.3703	0.3468
H30	0.0208	0.9935	0.2512
H31	0.0199	0.8683	0.3354
H32	0.2091	0.5518	0.2594
H33	0.1436	0.4493	0.1953

* Atomic occupancy factor is 0.5 due to disorder of 2-butyne-1,4-diol solvent in the crystal structure.

[00209] Table 13 below sets forth unit cell parameters for the dimethanol solvate

5 Ig.

TABLE 13

Unit Cell Data for Dimethanol Solvate Ig

Form	T	a(Å)	b(Å)	c(Å)	α°	β°	γ°	Z'	SG	V _m	R	D _{calc}
M2-1 (Ig)	-50	20.948(3)	6.794(2)	18.333(2)	-	102.91(2)	-	1	C2	636	.038	1.314

T = temp (°C) for the crystallographic data

Z' = number of drug molecules per asymmetric unit

5 V_m = V(unit cell)/(Z drug molecules per cell)

R = residual index (I>2sigma(I))

D_{calc} = density of crystal calculated

SG = space group

10 [00210] Table 14 below sets forth the positional parameters for the dimethanol solvate Ig at -50°C.

TABLE 14

Table of Fractional Atomic Coordinates for Dimethanol Solvate Ig at T = -50°C

Atom	X	Y	Z
CL1	0.4845	0.0519	0.0975
O1	0.3999	0.0334	0.4222
O2	0.2438	0.0327	0.2837
O3	0.2919	-0.0365	0.5534
O4	0.2111	-0.1509	0.4115
O5	0.1409	0.7749	0.0877
O6	0.3348	0.2998	0.3692
C1	0.3785	0.0495	0.4912
O7	0.4528	-0.2193	0.5428
C2	0.4372	-0.0463	0.2932
C3	0.3958	0.2046	0.1690
C4	0.3540	0.1054	0.3588
C5	0.2917	-0.0207	0.3471
C6	0.2638	-0.0141	0.4180
C7	0.4666	-0.0556	0.2324
C8	0.4348	-0.0197	0.5521
C9	0.3871	0.0889	0.2923
C10	0.3148	0.4622	0.1014
C11	0.3669	0.2102	0.2310
C12	0.1971	0.4955	0.0616
C13	0.3756	0.3437	0.1035
C14	0.3159	-0.0680	0.4873

Atom	X	Y	Z
C15	0.2003	0.6811	0.0949
C16	0.2533	0.3883	0.0643
C17	0.4459	0.0675	0.1722
C18	0.3162	0.6471	0.1342
C19	0.2592	0.7551	0.1318
C20	0.3858	0.4414	0.3857
C21	0.0747	1.0555	0.0906
C22	0.1419	0.9708	0.1140
O8	0.1606	0.3410	0.3030
C23	0.1681	0.4908	0.2528
O9?*	0.0905	1.0537	0.3488
C24	0.0506	0.9411	0.3047
O10*	0.0871	0.9637	0.3888
H1	0.3698	0.1882	0.5000
H2	0.4508	-0.1297	0.3339
H3	0.3403	-0.1573	0.3401
H4	0.2477	0.1190	0.4240
H5	0.5002	-0.1450	0.2324
H6	0.4724	0.0642	0.5527
H7	0.4230	-0.0062	0.6000
H8	0.3330	0.2987	0.2309
H9	0.1568	0.4439	0.0375
H10	0.4115	0.4344	0.1041
H11	0.3694	0.2681	0.0576
H12	0.3262	-0.2083	0.4845
H13	0.2507	0.2654	0.0414
H14	0.3563	0.7000	0.1585
H15	0.2614	0.8773	0.1551
H16	0.4247	0.3814	0.4147
H17	0.3726	0.5474	0.4136
H18	0.3943	0.4912	0.3398
H19	0.0589	1.0375	0.0377
H20	0.0760	1.1934	0.1022
H21	0.0460	0.9899	0.1168
H22	0.1725	1.0486	0.0933
H23	0.1560	0.9729	0.1681
H24	0.2910	0.0922	0.5653
H25	0.1707	-0.0975	0.3970
H26	0.4393	-0.3086	0.5727
H27	0.2166	0.1321	0.2895
H28	0.1613	0.6164	0.2738
H29	0.1368	0.4726	0.2064
H30	0.2119	0.4855	0.2441
H31	0.1761	0.3807	0.3503
H32*	0.1139	1.1530	0.3322

Atom	X	Y	Z
H33*	0.0293	0.8376	0.3371
H34*	0.0122	1.0286	0.2705
H35*	0.0765	0.8620	0.2691
H36?*	0.0718	0.8698	0.4154
H37?*	0.0679	1.0520	0.2715
H38?*	0.0601	0.7968	0.2848
H39?*	-0.0015	0.9590	0.2996

* Atomic occupancy factor is 0.5 due to disorder of methanol solvent in the crystal structure.

[00211] Unit cell paramaters for the 1:2 L-proline complex form 3, formula Ih are listed below in Table 15.

TABLE 15

Unit Cell Data for 1:2 L-Proline Complex (Ih)

Form	T°	a(Å)	b(Å)	c(Å)	α°	β°	γ°	Z'	SG	V _m	R	D _{calc}
N-1 (Ih)	-60	10.311(1)	11.334(1)	27.497(1)	95.94	99.22	90	4	P ₁	789	0.1	1.343

T = temp (°C) for crystallographic data

10 Z' = number of drug molecules per asymmetric unit

V_m = V (unit cell)/(Z drug molecules per cell)

R = residual index ($I > 3\sigma(I)$)

D_{calc} = density of crystal calculated

SG = space group

15

[00212] Table 15A below sets forth the positional parameters for the 1:2 L-proline complex (Ih) neat form N-1 at T = -60°C.

TABLE 15A
Table of Fractional Atomic Coordinates for Compound 1h 1:2 Complex
with L-Proline (Form N-1)

Atom	X	Y	Z
C11	0.8511	0.3142	0.4683
O2	0.1890	0.4635	0.4796
O3	0.7564	0.4104	0.2284
O4	0.4729	0.5010	0.2885
O5	0.4376	0.6313	0.2067
O6	0.8989	0.3300	0.1500
C7	0.2926	0.3792	0.4153
C8	0.6818	0.2711	0.3799
C9	0.5724	0.5066	0.2584
C10	0.7120	0.3675	0.3085
C11	0.6191	0.5325	0.1740
O12	0.5675	0.5324	0.1226
C13	0.8659	0.4113	0.3834
C14	0.6573	0.3919	0.2567
C15	0.7888	0.3318	0.4049
C16	0.3975	0.3524	0.4995
C17	0.5114	0.5240	0.2053
C18	0.7053	0.4187	0.1784
C19	0.2907	0.3910	0.4630
C20	0.4894	0.2664	0.4264
C21	0.4996	0.2842	0.4793
C22	0.8273	0.4301	0.3341
C23	0.2056	0.4854	0.5344
C24	0.8279	0.4316	0.1519
C25	0.3898	0.3142	0.3967
C26	0.5990	0.1967	0.4055
C27	0.6395	0.2861	0.3305
C28	0.0776	0.5599	0.5411
Cl29	0.8615	0.7651	0.4622
O30	0.4735	1.0020	0.2917
O31	0.4387	1.1337	0.2094
O32	0.7479	0.9028	0.2288
O33	0.8902	0.8251	0.1497
C34	0.8261	0.9016	0.3336
C35	0.6485	0.8878	0.2580
O36	0.5610	1.0347	0.1249
C37	0.6759	0.7507	0.3797
C38	0.5079	1.0262	0.2062
C39	0.4780	0.7554	0.4220
C40	0.6312	0.7804	0.3315
O41	0.1584	0.9450	0.4656

Atom	X	Y	Z
C42	0.7041	0.8583	0.3076
C43	0.3624	0.6994	0.4359
C44	0.8678	0.8769	0.3809
C45	0.5696	1.0064	0.2602
C46	0.6975	0.9154	0.1787
C47	0.3635	0.9472	0.4341
C48	0.6156	1.0330	0.1758
C49	0.2666	0.7602	0.4513
C50	0.2689	0.8865	0.4494
C51	0.4642	0.8736	0.4176
C52	0.8214	0.9316	0.1526
C53	0.5864	0.6836	0.4051
C54	0.7948	0.8027	0.4039
C55	0.1465	1.0758	0.4752
C56	0.2078	1.0792	0.5264
C73	0.7131	0.5906	0.5918
C74	0.6549	0.5814	0.5389
Cl75	0.0092	0.3008	0.6072
O76	0.1209	0.5563	0.8403
O77	0.3970	0.6243	0.7788
C78	0.2253	0.5273	0.8121
C79	0.3613	0.6922	0.8623
C80	0.1934	0.3303	0.6884
C81	0.1674	0.4723	0.7614
C82	0.2412	0.3835	0.7390
C83	-0.0019	0.4492	0.6892
O84	0.4278	0.7982	0.8605
O85	-0.0213	0.5180	0.9192
C86	0.0441	0.5055	0.7380
O87	0.7087	0.4793	0.6025
C88	0.1729	0.5956	0.8909
C89	0.4982	0.4992	0.6339
C90	0.5097	0.2528	0.6324
C91	0.3008	0.6402	0.8083
C92	0.3983	0.4301	0.6518
O93	0.3078	0.7393	0.9449
C94	0.2809	0.2490	0.6650
C95	0.3930	0.3137	0.6470
C96	0.0746	0.3688	0.6663
C97	0.6122	0.3067	0.6180
C98	0.2545	0.7117	0.8934
C99	0.6095	0.4314	0.6189
C100	0.0478	0.6254	0.9173
Cl10	0.0184	0.8459	0.6019
O102	0.3952	1.1247	0.7804

Atom	X	Y	Z
O103	0.1147	1.0661	0.8415
O104	0.6781	0.9872	0.5898
O105	0.4317	1.2935	0.8633
C106	0.5806	0.9279	0.6059
C107	0.4768	0.8827	0.6738
C108	0.1859	0.8490	0.6890
C109	0.5840	0.9396	0.6532
C110	0.3778	0.8134	0.5924
C111	0.2988	1.1454	0.8102
O112	0.3053	1.2394	0.9473
O113	-0.0298	1.0236	0.9198
C114	0.1616	0.9797	0.7616
C115	0.4712	0.8729	0.5711
C116	0.1655	1.0994	0.8923
C117	0.2173	1.0311	0.8129
C118	0.2502	1.2127	0.8951
C119	0.3763	0.8179	0.6434
C120	0.0002	0.9826	0.6866
C121	0.6693	0.9881	0.5388
C122	0.2312	0.8864	0.7377
C123	0.3605	1.1913	0.8637
C124	0.0428	1.0292	0.7357
C125	0.7936	1.0536	0.5306
C126	0.0458	1.1266	0.9182
C127	0.0732	0.8975	0.6629
C128	0.2697	0.7610	0.6655
O129	0.1176	0.8835	0.2145
N130	0.2152	0.6016	0.2596
C131	0.1172	0.6843	0.2345
O132	0.2914	0.8241	0.2651
C133	0.1853	0.8095	0.2384
C134	0.1980	0.6021	0.3121
C135	0.0814	0.6857	0.3187
C136	0.0075	0.6839	0.2657
O137	0.5811	0.9560	0.8015
O138	0.7490	1.0434	0.8543
C139	0.7527	0.8332	0.8327
C140	0.6889	0.9523	0.8297
N141	0.6668	0.7335	0.8097
C142	0.6961	0.7064	0.7572
C143	0.8711	0.8236	0.8064
C144	0.8046	0.7903	0.7522
O145	0.2901	0.3199	0.2689
N146	0.2077	0.0992	0.2607
C147	0.1849	0.3081	0.2401

Atom	X	Y	Z
O148	0.1224	0.3825	0.2158
C149	0.1134	0.1822	0.2345
C150	-0.0001	0.1822	0.2639
C151	0.1765	0.0951	0.3122
C152	0.0624	0.1788	0.3149
C153	0.7503	0.3375	0.8345
O154	0.7509	0.5453	0.8549
O155	0.5797	0.4581	0.8039
N156	0.6576	0.2389	0.8101
C157	0.6884	0.4556	0.8306
C158	0.8656	0.3215	0.8057
C159	0.7926	0.2957	0.7527
C160	0.6813	0.2179	0.7580
O57	0.2706	0.6596	0.1242
O58	0.4116	0.7306	0.0823
N59	0.2962	0.9340	0.0695
C60	0.3243	0.7268	0.1018
C61	0.2366	0.8510	0.0985
C62	0.2021	0.9562	0.0266
C63	0.0946	0.8269	0.0685
C64	0.0736	0.9268	0.0393
O65	0.2708	0.1591	0.1241
O66	0.4177	0.2319	0.0834
N67	0.2949	0.4330	0.0684
C68	0.2341	0.3504	0.0971
C69	0.3311	0.2307	0.1033
C70	0.0690	0.4256	0.0394
C71	0.1944	0.4576	0.0266
C72	0.0916	0.3239	0.0659
C161	0.5540	0.4526	0.9706
O162	0.4543	0.4603	0.9840
O163	0.6026	0.3671	0.9467
N164	0.5722	0.6674	0.9975
C165	0.7962	0.6796	1.0284
C166	0.7705	0.5623	1.0029
C167	0.6633	0.7048	1.0426
C168	0.6369	0.5668	0.9718
N169	0.5736	1.1664	0.9988
C170	0.6413	1.0706	0.9734
C171	0.6566	1.2036	1.0440
C172	0.7913	1.1762	1.0303
C173	0.7728	1.0572	1.0049
O174	0.5984	0.8670	0.9446
O175	0.4528	0.9612	0.9826
C176	0.5532	0.9542	0.9687

Atom	X	Y	Z
H104	0.4098	0.4245	0.2757
H1	0.5933	0.3154	0.2391
H11	0.6757	0.6123	0.1863
H25	0.3866	0.3009	0.3571
H7	0.2181	0.4202	0.3906
H16	0.4003	0.3732	0.5389
H21	0.5801	0.2482	0.5031
H231	0.2065	0.4036	0.5514
H230	0.2944	0.5361	0.5495
H260	0.5550	0.1248	0.3793
H261	0.6617	0.1611	0.4357
H22	0.8817	0.4891	0.3161
H27	0.5549	0.2379	0.3095
H13	0.9521	0.4556	0.4051
H24B	0.8905	0.5029	0.1720
H24A	0.7945	0.4527	0.1146
H18	0.6455	0.3409	0.1637
H9	0.6364	0.5818	0.2730
H17	0.4471	0.4497	0.1897
H6O	0.9902	0.3430	0.1754
H5O	0.3733	0.6344	0.1718
H12	0.5145	0.6132	0.1167
H730	0.4058	0.9277	0.2777
H35	0.5824	0.8169	0.2387
H34	0.8870	0.9544	0.3141
H48	0.6718	1.1140	0.1882
H43	0.3564	0.6038	0.4332
H49	0.1884	0.7171	0.4650
H51	0.5357	0.9155	0.4000
H47	0.3640	1.0426	0.4342
H550	0.2010	1.1248	0.4533
H551	0.0459	1.1049	0.4708
H53A	0.5434	0.6098	0.3796
H53B	0.6443	0.6506	0.4370
H44	0.9590	0.9156	0.4010
H40	0.5387	0.7432	0.3119
H46	0.6347	0.8402	0.1631
H45	0.6370	1.0795	0.2743
H52B	0.8851	1.0006	0.1739
H52A	0.7895	0.9562	0.1157
H38	0.4415	0.9538	0.1901
H33O	0.9838	0.8359	0.1739
H36	0.5133	1.1183	0.1197
H31	0.3740	1.1406	0.1748
H78	0.2893	0.4626	0.8307

Atom	X	Y	Z
H91	0.2300	0.7037	0.7933
H79	0.4290	0.6296	0.8786
H73A	0.8131	0.6240	0.5975
H73B	0.6558	0.6475	0.6139
H97	0.6926	0.2563	0.6062
H90	0.5135	0.1579	0.6334
H92	0.3254	0.4776	0.6699
H89	0.4904	0.5936	0.6319
H94B	0.3235	0.1904	0.6915
H94A	0.2237	0.1976	0.6335
H83	-0.0976	0.4703	0.6701
H86	-0.0138	0.5707	0.7560
H82	0.3324	0.3549	0.7591
H98	0.1908	0.7806	0.8796
H88	0.2352	0.5280	0.9067
H100	-0.0156	0.6845	0.8964
H101	0.0795	0.6672	0.9544
H77O	0.4635	0.5569	0.7921
H84O	0.4937	0.8202	0.8949
H93O	0.3569	0.8249	0.9503
H85O	-0.1149	0.5173	0.8950
H117	0.2800	0.9658	0.8316
H123	0.4233	1.1238	0.8797
H111	0.2317	1.2108	0.7948
H228	0.3143	0.7048	0.6931
H128	0.2074	0.7050	0.6363
H12A	0.6658	0.8985	0.5209
H12B	0.5824	1.0343	0.5241
H915	0.4621	0.8772	0.5316
H909	0.6624	0.9895	0.6775
H107	0.4780	0.8924	0.7134
H910	0.3024	0.7608	0.5678
H124	-0.0101	1.0987	0.7537
H120	-0.0905	1.0129	0.6667
H122	0.3164	0.8472	0.7576
H116	0.2250	1.0292	0.9073
H926	-0.0153	1.1891	0.8983
H826	0.0798	1.1653	0.9557
H118	0.1903	1.2849	0.8822
H902	0.4593	1.0560	0.7941
H105	0.4954	1.3127	0.8984
H112	0.3566	1.3240	0.9528
H113	-0.1207	1.0256	0.8942
H130	0.0880	0.6513	0.1960
H930	0.1989	0.5128	0.2411

Atom	X	Y	Z
H131	0.3065	0.6289	0.2579
H936	-0.0527	0.7614	0.2616
H137	-0.0535	0.6049	0.2555
H136	0.0202	0.6522	0.3427
H935	0.1160	0.7743	0.3334
H134	0.1753	0.5137	0.3200
H135	0.2861	0.6352	0.3365
H944	0.9296	0.9035	0.8114
H143	0.9361	0.7508	0.8190
H244	0.8750	0.7504	0.7303
H144	0.7682	0.8708	0.7360
H139	0.7802	0.8212	0.8719
H742	0.7271	0.6158	0.7513
H842	0.6099	0.7203	0.7306
H541	0.6871	0.6572	0.8300
H641	0.5726	0.7555	0.8089
H952	0.0994	0.2669	0.3315
H252	-0.0039	0.1476	0.3381
H150	-0.0603	0.2607	0.2596
H250	-0.0651	0.1042	0.2518
H151	0.1486	0.0063	0.3177
H152	0.2600	0.1251	0.3397
H460	0.1968	0.0115	0.2409
H461	0.3000	0.1287	0.2626
H149	0.0881	0.1498	0.1958
H161	0.7059	0.1256	0.7481
H160	0.5948	0.2388	0.7319
H159	0.7564	0.3753	0.7372
H259	0.8547	0.2500	0.7286
H153	0.7784	0.3252	0.8732
H958	0.9256	0.4012	0.8101
H959	0.9261	0.2481	0.8168
H957	0.6775	0.1597	0.8286
H956	0.5646	0.2627	0.8110
H620	0.2066	1.0481	0.0198
H62	0.2205	0.9003	-0.0057
H640	0.0377	1.0016	0.0607
H64	0.0037	0.9030	0.0061
H63	0.0897	0.7441	0.0449
H630	0.0231	0.8249	0.0931
H61	0.2352	0.8932	0.1354
H590	0.3226	1.0165	0.0923
H59	0.3766	0.8979	0.0586
H68	0.2264	0.3961	0.1333
H710	0.1967	0.5506	0.0213

Atom	X	Y	Z
H71	0.2110	0.4051	-0.0068
H700	0.0336	0.4977	0.0623
H70	-0.0021	0.4046	0.0062
H72	0.0901	0.2437	0.0409
H720	0.0195	0.3163	0.0900
H670	0.3256	0.5143	0.0915
H67	0.3726	0.3954	0.0559
H666	0.8439	0.5395	0.9797
H766	0.7706	0.4978	1.0292
H665	0.8720	0.6797	1.0604
H765	0.8229	0.7417	1.0042
H767	0.6538	0.7982	1.0537
H667	0.6468	0.6543	1.0723
H168	0.6429	0.5849	0.9344
H664	0.4798	0.6384	1.0063
H764	0.5568	0.7339	0.9761
H170	0.6545	1.0931	0.9372
H673	0.7695	0.9914	1.0304
H773	0.8485	1.0349	0.9826
H672	0.8184	1.2380	1.0061
H772	0.8655	1.1783	1.0629
H671	0.6469	1.2971	1.0548
H771	0.6369	1.1536	1.0734
H669	0.5570	1.2393	0.9763
H769	0.4876	1.1366	1.0054

[00213] Unit cell parameters for the 1:1 L-proline complex neat form N-1 (form 6), formula Ii are listed below in Table 16.

TABLE 16
Unit Cell Data for 1:1 L-Proline Complex (Ii)

Form	T°	a(Å)	b(Å)	c(Å)	α°	β°	γ°	Z'	SG	V _m	R	D _{calc}
N-1 (Ii)	-40	11.441(1)	10.235(1)	45.358(1)	90	90	90	2	P2 ₁ 2 ₁ 2 ₁	664	0.08	1.311

T = temp (°C) for crystallographic data

Z' = number of drug molecules per asymmetric unit

5 V_m = V (unit cell)/(Z drug molecules per cell)

R = residual index (I>3sigma(I))

D_{calc} = density of crystal calculated

SG = space group

10 [00214] Table 16A below sets forth the positional parameters for the 1:1 L-proline complex (Ii) neat form N-1 at T = -40°C.

TABLE 16A
Table of Fractional Atomic Coordinates for Compound Ii 1:1 Complex
with L-Proline

15

Atom	X	Y	Z
Cl1	0.4598	-0.1973	0.4564
C1	0.5901	-0.2370	0.3766
C2	0.4455	-0.0618	0.3755
C3	0.4764	-0.1649	0.4212
C4	0.5631	-0.2563	0.4083
C5	0.5270	-0.1401	0.3597
C6	0.4236	-0.0847	0.4052
C7	0.3350	0.0181	0.4193
C8	0.4043	0.1572	0.4619
C9	0.4038	0.1366	0.4305
C10	0.4700	0.2275	0.4154
O1	0.5531	-0.2303	0.3104
C11	0.6684	-0.0473	0.3232
C12	0.6871	-0.1530	0.2745
O2	0.6765	0.0755	0.3403
C13	0.5634	-0.2137	0.2780
C14	0.5532	-0.1047	0.3260
C15	0.6982	-0.0231	0.2901
C16	0.5401	-0.3394	0.2628
O3	0.7021	-0.1304	0.2442
O4	0.8064	0.0378	0.2896

Atom	X	Y	Z
O5	0.5831	0.4559	0.4668
C17	0.5134	0.3474	0.4583
C18	0.6039	0.5020	0.4977
C19	0.6740	0.6076	0.4990
O6	0.6178	-0.4307	0.2703
C20	0.4646	0.2450	0.4744
C21	0.5212	0.3364	0.4270
Cl2	-0.1014	-0.2193	0.4531
O7	0.0403	-0.2096	0.3126
C22	0.0502	-0.0977	0.3307
C23	-0.0026	-0.1191	0.3614
C24	0.1707	-0.0312	0.3288
C25	0.0641	-0.1848	0.2832
C26	0.1903	-0.1171	0.2772
C27	0.0159	-0.2652	0.4010
C28	0.0413	-0.3076	0.2646
O8	0.1732	0.0766	0.3473
C29	0.0527	-0.2262	0.3719
C30	-0.0488	-0.1911	0.4174
O9	0.2066	-0.1046	0.2477
C31	-0.1057	-0.0845	0.4057
C32	-0.0805	-0.0464	0.3769
C33	-0.1758	0.0315	0.4210
C34	-0.0962	0.3657	0.4497
C35	0.0119	0.1514	0.4289
C36	-0.1670	0.2596	0.4419
O10	0.0892	0.4864	0.4561
C37	0.0235	0.3777	0.4487
C38	0.0796	0.2657	0.4373
C39	0.2088	0.4743	0.4694
C40	0.2378	0.6027	0.4670
C41	-0.1056	0.1472	0.4292
O11	0.3103	0.0473	0.2955
C42	0.1927	-0.0117	0.2972
O12	0.1209	-0.4060	0.2699
C43	-0.1355	0.5267	0.3371
C44	-0.1317	0.4102	0.3168
N1	-0.2217	0.3229	0.3311
C45	-0.1578	0.4809	0.3661
C46	-0.2328	0.3526	0.3628
O13	0.0687	0.4002	0.3090
O14	-0.0027	0.2411	0.3344
C47	-0.0235	0.3422	0.3215
C48	0.3738	0.4173	0.3220
C49	0.3666	0.5397	0.3405

Atom	X	Y	Z
C50	0.3232	0.5141	0.3706
O15	0.5678	0.3983	0.3126
O16	0.4793	0.2316	0.3356
N2	0.2751	0.3408	0.3341
C51	0.2568	0.3858	0.3637
C52	0.4900	0.3392	0.3227
C53	0.1894	0.5037	0.4979
H1	0.2977	-0.0348	0.4380
H2	0.5158	0.5126	0.5088
H3	0.6427	0.4151	0.5106
H4	0.4640	0.2425	0.4980
H5	0.3557	0.0952	0.4743
H6	0.4028	0.0143	0.3656
H7	0.4846	-0.0412	0.3172
H8	0.7354	-0.1139	0.3309
H9	0.6383	0.0438	0.2803
H10	0.7509	-0.2206	0.2829
H11	0.4937	-0.1547	0.2692
H12	0.4535	-0.3750	0.2689
H13	0.5440	-0.3256	0.2395
H14	0.5987	0.1273	0.3371
H15	0.5850	-0.4862	0.2863
H16	0.2740	0.0426	0.4038
H17	0.7825	-0.0885	0.2400
H18	0.8274	0.0552	0.2680
H19	0.4902	0.2088	0.3946
H20	0.5540	0.4072	0.4143
H21	0.6504	-0.2925	0.3665
H22	0.6030	-0.3278	0.4194
H23	0.2586	-0.1789	0.2863
H24	0.1267	0.0606	0.2892
H25	0.2335	-0.1001	0.3377
H26	0.0060	-0.0175	0.3198
H27	-0.0022	-0.1194	0.2737
H28	-0.0459	-0.3511	0.2701
H29	0.0431	-0.2942	0.2411
H30	0.1118	-0.2782	0.3606
H31	-0.1170	0.0351	0.3696
H32	0.0467	-0.3485	0.4096
H33	-0.2543	0.2691	0.4432
H34	-0.1353	0.4445	0.4589
H35	0.0544	0.0664	0.4241
H36	0.1640	0.2598	0.4365
H37	-0.2417	0.0673	0.4058
H38	-0.2171	0.0017	0.4412

Atom	X	Y	Z
H39	0.2698	-0.0400	0.2435
H40	0.3320	0.0534	0.2734
H41	0.1058	0.1381	0.3420
H42	0.0874	-0.4719	0.2852
H43	-0.1506	0.4388	0.2950
H44	-0.0541	0.5810	0.3377
H45	-0.2055	0.5941	0.3310
H46	-0.0797	0.4553	0.3782
H47	-0.2106	0.5460	0.3796
H48	-0.3210	0.3680	0.3662
H49	-0.1958	0.2728	0.3734
H50	-0.2972	0.3381	0.3195
H51	-0.1983	0.2279	0.3269
H52	0.3544	0.4339	0.2980
H53	0.2791	0.3273	0.3822
H54	0.1634	0.4233	0.3683
H55	0.4032	0.5053	0.3835
H56	0.2799	0.6038	0.3764
H57	0.4555	0.5795	0.3393
H58	0.3097	0.6065	0.3283
H59	0.2013	0.3456	0.3219
H60	0.2977	0.2420	0.3345

[00215] Unit cell parameters for the 1:1 L-proline hemihydrate complex H.5-2 Ij are listed below in Table 17.

5

TABLE 17

Unit Cell Data for Compound I Complex with
L-Proline Hemihydrate Form H.5-2

Form	T°C	a(Å)	b(Å)	c(Å)	α°	β°	γ°	Z'	SG	V _m	R	D _{calc}
H.5-2	-40	11.539	10.199	23.183	103.96	97.16	90.25	4	P ₁	656	.06	1.349

T = temp (°C) for crystallographic data

Z' = number of drug molecules per asymmetric unit

10 V_m = V (unit cell)/(Z drug molecules per cell)

R = residual index ($I > 2\sigma(I)$)

D_{calc} = density of crystal calculated

SG = space group

- 5 [00216] Table 18 below sets forth the positional parameters for the 1:1 L-proline hemihydrate form H.5-2 Ij.

TABLE 18

Table of Fractional Atomic Coordinates for Compound Ij 1:1 Complex with

L-Proline Hemihydrate Form H.5-2 at T = -40°C

10

Atom	X	Y	Z
CL1	-0.3207	0.2999	0.1007
O2	-0.0812	0.4445	0.3860
O3	0.1266	0.3986	0.5119
O4	0.0226	0.1123	0.3131
O5	0.1988	0.2024	0.4116
C6	-0.0400	0.4518	0.4471
C7	0.0829	0.3978	0.4505
C8	0.0836	0.2539	0.4134
O9	0.0185	0.6897	0.4693
C10	0.0320	0.2460	0.3495
C11	-0.1475	0.3075	0.2867
C12	-0.0536	0.5937	0.4833
C13	-0.2858	0.1976	0.1996
O14	-0.1314	-0.4139	0.0970
C15	-0.0913	0.3083	0.3494
C16	-0.2316	0.2099	0.2582
C17	-0.1691	0.4011	0.2002
C18	-0.1786	-0.0508	0.1507
C19	-0.3006	-0.0480	0.1494
C20	-0.3629	-0.1768	0.1287
C21	-0.1830	-0.2916	0.1133
C22	-0.1179	0.4052	0.2576
C23	-0.1249	-0.1696	0.1325
C24	-0.2541	0.3000	0.1727
C25	-0.3658	0.0787	0.1687
C26	-0.3038	-0.2938	0.1114
C27	-0.0150	-0.4216	0.0824
C28	-0.0248	-0.4143	0.0214
CL29	0.6985	0.3144	0.9332
O30	0.9914	0.4113	0.6104

Atom	X	Y	Z
O31	0.7834	0.1123	0.6447
O32	0.8541	0.4766	0.7040
C33	0.7408	0.2570	0.7376
O34	0.9142	0.1720	0.5162
O35	0.7084	-0.1271	0.5485
C36	0.7611	0.2500	0.6736
O37	0.8359	0.9717	0.9453
C38	0.7967	0.0998	0.5824
C39	0.8661	0.3408	0.6732
C40	0.8113	-0.0517	0.5552
C41	0.6608	0.3487	0.7637
C42	0.8842	0.3295	0.6081
C43	0.7928	0.2013	0.8324
C44	0.6478	0.3693	0.8244
C45	0.9041	0.1825	0.5787
C46	0.7116	0.2945	0.8580
C47	0.7693	0.8565	0.9247
C48	0.6523	0.6699	0.9393
C49	0.6372	0.6130	0.8784
C50	0.6886	0.6798	0.8418
C51	0.8079	0.1861	0.7731
C52	0.7539	0.8018	0.8657
C53	0.7171	0.7906	0.9638
C54	0.8594	1.0293	1.0095
C55	0.5690	0.4784	0.8512
C56	0.9344	1.1572	1.0187
CL57	0.1318	0.2860	0.9213
O58	0.2325	0.1474	0.6392
O59	0.3774	0.4788	0.7078
O60	0.3769	0.1826	0.5107
O61	0.5074	0.3673	0.6076
C62	0.2155	0.2845	0.7366
C63	0.2440	0.2856	0.6735
C64	0.2590	0.1866	0.7641
C65	0.3642	0.3439	0.6737
C66	0.1310	0.6369	0.8752
C67	0.3659	0.1865	0.5718
C68	0.2203	-0.0149	0.5444
C69	0.2495	0.6414	0.8737
C70	0.2339	0.1891	0.8206
C71	0.2440	0.1366	0.5760
C72	0.2691	0.8826	0.9099
C73	0.3878	0.3310	0.6097
C74	0.0797	0.7646	0.8952
C75	0.1225	0.3883	0.8232

Atom	X	Y	Z
O76	0.0935	-0.0372	0.5272
C77	0.1466	0.3834	0.7646
C78	0.1643	0.2886	0.8500
C79	0.3160	0.7598	0.8907
O80	0.3243	1.0074	0.9263
C81	0.0564	0.5089	0.8537
C82	0.1501	0.8831	0.9123
C83	0.4517	1.0168	0.9429
C84	0.4736	1.0085	1.0039
CL85	0.2353	0.2852	0.0943
O86	0.4643	0.4578	0.3847
O87	0.6924	0.1640	0.4142
C88	0.4307	0.3235	0.3510
O89	0.6471	0.3804	0.5135
C90	0.5401	0.2370	0.3503
O91	0.4314	0.6909	0.4760
C92	0.5025	0.4655	0.4471
C93	0.3782	0.3234	0.2879
O94	0.3688	-0.3850	0.0770
C95	0.2412	0.2163	0.2011
O96	0.5177	0.1054	0.3143
C97	0.5871	0.2380	0.4145
C98	0.5309	0.6092	0.4771
C99	0.6100	0.3805	0.4525
C100	0.3806	0.3946	0.1963
C101	0.2856	0.2342	0.2611
C102	0.3122	-0.2671	0.0968
C103	0.1491	0.1041	0.1716
C104	0.2436	-0.2032	0.0581
C105	0.2886	0.3016	0.1694
C106	0.3259	-0.2129	0.1566
C107	0.4243	0.4052	0.2556
C108	0.1916	-0.0835	0.0830
C109	0.3595	-0.4411	0.0145
C110	0.2039	-0.0262	0.1455
C111	0.2741	-0.0939	0.1807
C112	0.4263	-0.5693	0.0039
O113	0.6465	0.6039	0.6797
O114	0.7349	0.7473	0.6386
N115	0.4575	0.7439	0.6955
C116	0.6529	0.7073	0.6592
C117	0.5581	0.9376	0.6856
C118	0.4708	0.8468	0.7558
C119	0.5406	0.7887	0.6584
C120	0.5558	0.9548	0.7523

Atom	X	Y	Z
O121	0.1830	0.6331	0.6898
O122	0.2453	0.7852	0.6450
N123	-0.0372	0.6985	0.6789
C124	0.0468	0.7797	0.6565
C125	0.0382	0.9228	0.6945
C126	0.1683	0.7269	0.6638
C127	0.0337	0.8955	0.7569
C128	-0.0365	0.7591	0.7436
N129	-0.3701	-0.1217	0.3442
C130	-0.1562	-0.1273	0.3652
O131	-0.1554	-0.0439	0.3345
O132	-0.0663	-0.1700	0.3912
C133	-0.2876	-0.3360	0.3362
C134	-0.2710	-0.1891	0.3727
C135	-0.3924	-0.1926	0.2793
C136	-0.3216	-0.3192	0.2720
O137	0.4232	-0.1933	0.3831
O138	0.3366	-0.0501	0.3332
C139	0.2187	-0.2024	0.3678
N140	0.1226	-0.1310	0.3394
C141	0.3337	-0.1410	0.3604
C142	0.1992	-0.3502	0.3341
C143	0.1599	-0.3386	0.2693
C144	0.0885	-0.2109	0.2771
O145	0.2926	0.5997	0.5452
O146	0.5342	-0.0128	0.4878
H150	-0.0975	0.3899	0.4641
H151	0.1418	0.4590	0.4337
H152	0.0313	0.1936	0.4337
H154	0.0862	0.3044	0.3298
H155	-0.1430	0.6195	0.4745
H156	-0.0310	0.5943	0.5295
H157	-0.1495	0.2477	0.3663
H158	-0.2539	0.1367	0.2824
H159	-0.1435	0.4768	0.1772
H160	-0.1255	0.0440	0.1660
H161	-0.4573	-0.1862	0.1271
H162	-0.0551	0.4859	0.2809
H163	-0.0294	-0.1642	0.1321
H164	-0.4249	0.0580	0.1988
H165	-0.4172	0.0974	0.1293
H166	-0.3545	-0.3888	0.0944
H167	0.0443	-0.3425	0.1127
H168	0.0247	-0.5195	0.0867
H169	0.0584	-0.4150	0.0027

Atom	X	Y	Z
H170	-0.0829	-0.4910	-0.0091
H171	-0.0634	-0.3139	0.0169
H176	0.6840	0.2850	0.6494
H177	0.7179	0.1342	0.5591
H178	0.9431	0.3006	0.6953
H179	0.8770	-0.0884	0.5846
H180	0.8408	-0.0648	0.5117
H181	0.6098	0.4044	0.7359
H182	0.8091	0.3693	0.5861
H183	0.8427	0.1385	0.8583
H184	0.9803	0.1446	0.6000
H185	0.6091	0.6187	0.9683
H186	0.6794	0.6399	0.7942
H187	0.8728	0.1192	0.7530
H188	0.7902	0.8541	0.8361
H189	0.7271	0.8353	1.0122
H190	0.7735	1.0569	1.0277
H191	0.8986	0.9597	1.0334
H192	0.5005	0.4927	0.8176
H193	0.5288	0.4505	0.8873
H194	0.9545	1.2094	1.0658
H195	1.0166	1.1315	1.0008
H196	0.8915	1.2288	0.9952
H200	0.1797	0.3464	0.6531
H201	0.3128	0.1093	0.7423
H202	0.4283	0.2823	0.6914
H203	0.4309	0.1186	0.5873
H204	0.2676	-0.0437	0.5075
H205	0.2503	-0.0734	0.5778
H206	0.2938	0.5478	0.8573
H207	0.2667	0.1115	0.8435
H208	0.1813	0.2008	0.5579
H209	0.3311	0.3978	0.5902
H210	-0.0167	0.7728	0.8951
H212	0.1131	0.4619	0.7424
H213	0.4107	0.7527	0.8914
H214	0.0235	0.4869	0.8923
H215	-0.0164	0.5268	0.8227
H216	0.1131	0.9807	0.9295
H217	0.5000	0.9375	0.9142
H218	0.4930	1.1146	0.9386
H219	0.5658	1.0153	1.0225
H220	0.4299	1.0899	1.0326
H221	0.4370	0.9127	1.0082
H223	0.3659	0.2811	0.3724

Atom	X	Y	Z
H225	0.6059	0.2835	0.3311
H227	0.4295	0.4306	0.4673
H229	0.5247	0.1893	0.4346
H230	0.5953	0.6489	0.4536
H231	0.5686	0.6221	0.5232
H232	0.6812	0.4246	0.4357
H233	0.4161	0.4554	0.1692
H234	0.2450	0.1769	0.2870
H235	0.0958	0.0890	0.2045
H236	0.0943	0.1338	0.1355
H237	0.2331	-0.2409	0.0101
H238	0.3791	-0.2651	0.1858
H239	0.4960	0.4787	0.2767
H240	0.1390	-0.0325	0.0529
H241	0.2692	-0.4672	-0.0046
H242	0.3958	-0.3734	-0.0080
H243	0.2899	-0.0523	0.2290
H244	0.4221	-0.6177	-0.0443
H245	0.5184	-0.5490	0.0216
H246	0.3917	-0.6427	0.0251
H248	0.4793	0.6449	0.7024
H249	0.6424	0.9714	0.6756
H250	0.4899	0.9910	0.6668
H251	0.3871	0.8958	0.7636
H252	0.4974	0.8010	0.7924
H253	0.4998	0.7712	0.6119
H254	0.6437	0.9322	0.7755
H255	0.5346	1.0526	0.7757
H257	-0.1244	0.7021	0.6547
H258	0.0245	0.7713	0.6086
H259	0.1125	0.9882	0.6931
H260	-0.0412	0.9702	0.6791
H261	0.1221	0.8814	0.7786
H262	-0.0061	0.9737	0.7872
H263	-0.1266	0.7806	0.7533
H264	0.0003	0.6937	0.7698
H265	-0.4482	-0.1282	0.3648
H267	-0.2055	-0.3921	0.3406
H268	-0.3541	-0.3919	0.3515
H269	-0.2776	-0.1726	0.4197
H270	-0.4835	-0.2219	0.2664
H271	-0.3651	-0.1301	0.2520
H272	-0.2450	-0.3036	0.2505
H273	-0.3737	-0.4037	0.2429
H275	0.2126	-0.1876	0.4150

Atom	X	Y	Z
H276	0.0471	-0.1254	0.3631
H277	0.2819	-0.4071	0.3370
H278	0.1354	-0.4038	0.3515
H279	0.2344	-0.3225	0.2459
H280	0.1069	-0.4219	0.2420
H281	-0.0019	-0.2405	0.2681
H282	0.1098	-0.1545	0.2449
H4O	-0.0494	0.0591	0.3246
H5O	0.2411	0.2106	0.4570
H3O	0.1948	0.4772	0.5288
H9O	-0.0304	0.7367	0.4370
H91O	0.4288	0.7378	0.4387
H89O	0.5701	0.3737	0.5359
H87O	0.7447	0.1972	0.4579
H96O	0.4441	0.0598	0.3281
H32O	0.7685	0.5088	0.6888
H30	1.0223	0.3832	0.5666
H34	0.9788	0.0971	0.5019
H35O	0.7109	-0.1813	0.5836
H60O	0.4380	0.1072	0.4941
H61	0.5322	0.4602	0.6402
H59O	0.2991	0.5325	0.6984
H76	0.0757	-0.1438	0.5063
H29N	-0.3483	-0.0232	0.3484
H40N	0.1520	-0.0373	0.3393
H15N	0.3746	0.7405	0.6748
H23N	-0.0113	0.6018	0.6728
H946	0.4919	-0.0828	0.4471
H1W	0.2742	0.6734	0.5848
H846	0.6016	-0.0665	0.5089
H2W	0.3486	0.6479	0.5212

UTILITIES AND COMBINATIONS

A. Utilities

- [00217] The compound of the present invention possesses activity as an inhibitor
- 5 of the sodium dependent glucose transporters found in the intestine and kidney of mammals. Preferably, the compound of the invention is a selective inhibitor of renal SGLT2 activity, and therefore may be used in the treatment of diseases or disorders associated with SGLT2 activity.

[00218] Accordingly, the compound of the present invention can be administered to mammals, preferably humans, for the treatment of a variety of conditions and disorders, including, but not limited to, treating or delaying the progression or onset of diabetes (including Type I and Type II, impaired glucose tolerance, insulin resistance, and diabetic complications, such as nephropathy, retinopathy, neuropathy and cataracts), hyperglycemia, hyperinsulinemia, hypercholesterolemia, dyslipidemia, elevated blood levels of free fatty acids or glycerol, hyperlipidemia, hypertriglyceridemia, obesity, wound healing, tissue ischemia, atherosclerosis and hypertension. The compound of the present invention may also be utilized to increase the blood levels of high density lipoprotein (HDL).

[00219] In addition, the conditions, diseases, and maladies collectively referenced to as "Syndrome X" or Metabolic Syndrome as detailed in Johannsson, *J. Clin. Endocrinol. Metab.*, 82, 727-34 (1997), may be treated employing the compound of the present invention.

[00220] The crystalline compounds (S)-PG (SC-3) (Ia), (R)-PG (SD-3) (Ib), SA-1 (Ic), SB-1 (Id), SB-2 (Ie) 1:2 L-proline complex form 3 (Ih), 1:1 L-proline complex form 6 (Ii) 1:1 L-proline hemihydrate complex form H.5-2 (Ij) and 1:1.3 L-phenylalanine complex form 2 (Ik) may be administered in dosage forms and in dosages as disclosed in U. S. Patent No. 6,515,117 the disclosure of which in its entirety is incorporated herein by reference.

B. Combinations

[00221] The present invention includes within its scope pharmaceutical compositions comprising, as an active ingredient, a therapeutically effective amount of a compound of formula I, including (S)-PG (form SC-3, Ia), (R)-PG (form SD-3, Ib), SA-1 (Ic), SB-1 (Id), SB-2 (Ie), 1:2 L-proline complex form 3 (Ih), 1:1 L-proline complex form 6 (Ii), 1:1 L-proline hemihydrate complex form H.5-2 (Ij), and 1:1.3 L-phenylalanine complex form 2 (Ik), alone or in combination with a pharmaceutical carrier or diluent. Optionally, the compound of the present invention can be utilized as an individual treatment, or utilized in combination with one or more other therapeutic agent(s).

[00222] Other "therapeutic agent(s)" suitable for combination with the compound of the present invention include, but are not limited to, known therapeutic agents useful in the treatment of the aforementioned disorders including: anti-diabetic agents; anti-hyperglycemic agents; hypolipidemic/lipid lowering agents; anti-obesity agents; anti-hypertensive agents and appetite suppressants.

[00223] Examples of suitable anti-diabetic agents for use in combination with the compound of the present invention include biguanides (e.g., metformin or phenformin), glucosidase inhibitors (e.g., acarbose or miglitol), insulins (including insulin secretagogues or insulin sensitizers), meglitinides (e.g., repaglinide),
10 sulfonylureas (e.g., glimepiride, glyburide, gliclazide, chlorpropamide and glipizide), biguanide/glyburide combinations (e.g., Glucovance[®]), thiazolidinediones (e.g., troglitazone, rosiglitazone and pioglitazone), PPAR-alpha agonists, PPAR-gamma agonists, PPAR alpha/gamma dual agonists, glycogen phosphorylase inhibitors, inhibitors of fatty acid binding protein (aP2), glucagon-like peptide-1 (GLP-1) or
15 other agonists of the GLP-1 receptor, and dipeptidyl peptidase IV (DPP4) inhibitors.

[00224] It is believed that the use of the compound of formula I in combination with at least one or more other antidiabetic agent(s) provides antihyperglycemic results greater than that possible from each of these medicaments alone and greater than the combined additive anti-hyperglycemic effects produced by these
20 medicaments.

[00225] Other suitable thiazolidinediones include Mitsubishi's MCC-555 (disclosed in U.S. Patent No. 5,594,016), Glaxo-Wellcome's faraglitazar (GI-262570), englitazone (CP-68722, Pfizer) or darglitazone (CP-86325, Pfizer, isaglitazone (MIT/J&J), reglitazar (JTT-501) (JPNT/P&U), rivoglitazone (R-119702)
25 (Sankyo/WL), liraglutide (NN-2344) (Dr. Reddy/NN), or (Z)-1,4-bis-4-[(3,5-dioxo-1,2,4-oxadiazolidin-2-yl-methyl)]phenoxybut-2-ene (YM-440, Yamanouchi).

[00226] Examples of PPAR-alpha agonists, PPAR-gamma agonists and PPAR alpha/gamma dual agonists include muraglitazar, peliglitazar, tesaglitazar AR-HO39242 Astra/Zeneca, GW-501516 (Glaxo-Wellcome), KRP297 (Kyorin Merck) as
30 well as those disclosed by Murakami et al, "A Novel Insulin Sensitizer Acts As a Coligand for Peroxisome Proliferation - Activated Receptor Alpha (PPAR alpha) and PPAR gamma. Effect on PPAR alpha Activation on Abnormal Lipid Metabolism in

Liver of Zucker Fatty Rats", Diabetes, 47, 1841-1847 (1998), WO 01/21602 and in U.S. patent 6,653,314, the disclosure of which is incorporated herein by reference, employing dosages as set out therein, which compounds designated as preferred are preferred for use herein.

- 5 **[00227]** Suitable aP2 inhibitors include those disclosed in U.S. application Serial No. 09/391,053, filed September 7, 1999, and in U.S. application Serial No. 09/519,079, filed March 6, 2000, employing dosages as set out herein.
- [00228]** Suitable DPP4 inhibitors include those disclosed in WO 99/38501, WO 99/46272, WO 99/67279 (PROBIODRUG), WO 99/67278 (PROBIODRUG), WO 99/61431 (PROBIODRUG), NVP-DPP728A (1-[[[2-[(5-cyanopyridin-2-yl)amino]ethyl]amino]acetyl]-2-cyano-(S)-pyrrolidine) (Novartis) as disclosed by Hughes et al., Biochemistry, 38(36), 11597-11603, 1999, TSL-225 (tryptophyl-1,2,3,4-tetrahydroisoquinoline-3-carboxylic acid (disclosed by Yamada et al., Bioorg. & Med. Chem. Lett. 8 (1998) 1537-1540), 2-cyanopyrrolidides and 4-
- 10 cyanopyrrolidides, as disclosed by Ashworth et al., Bioorg. & Med. Chem. Lett., Vol. 6, No. 22, pp. 1163-1166 and 2745-2748 (1996), the compounds disclosed in U.S. application Serial No. 10/899,641, WO 01/68603 and U.S. patent 6,395,767, employing dosages as set out in the above references.
- [00229]** Other suitable meglitinides include nateglinide (Novartis) or KAD1229
- 20 (PF/Kissei).
- [00230]** Examples of suitable anti-hyperglycemic agents for use in combination with the compound of the present invention include glucagon-like peptide-1 (GLP-1) such as GLP-1(1-36) amide, GLP-1(7-36) amide, GLP-1(7-37) (as disclosed in U.S. Patent No. 5,614,492), as well as exenatide (Amylin/Lilly), LY-315902 (Lilly), MK-
- 25 0431 (Merck), liraglutide (NovoNordisk), ZP-10 (Zealand Pharmaceuticals A/S), CJC-1131 (Conjuchem Inc), and the compounds disclosed in WO 03/033671.
- [00231]** Examples of suitable hypolipidemic/lipid lowering agents for use in combination with the compound of the present invention include one or more MTP inhibitors, HMG CoA reductase inhibitors, squalene synthetase inhibitors, fibric acid
- 30 derivatives, ACAT inhibitors, lipoxygenase inhibitors, cholesterol absorption inhibitors, ileal Na⁺/bile acid co-transporter inhibitors, up-regulators of LDL receptor activity, bile acid sequestrants, cholesterol ester transfer protein (e.g., CETP

inhibitors, such as torcetrapib (CP-529414, Pfizer) and JTT-705 (Akros Pharma)), PPAR agonists (as described above) and/or nicotinic acid and derivatives thereof.

[00232] MTP inhibitors which may be employed as described above include those disclosed in U.S. Patent No. 5,595,872, U.S. Patent No. 5,739,135, U.S. Patent No. 5,712,279, U.S. Patent No. 5,760,246, U.S. Patent No. 5,827,875, U.S. Patent No. 5,885,983 and U.S. Patent No. 5,962,440.

[00233] The HMG CoA reductase inhibitors which may be employed in combination with one or more compound of formula I include mevastatin and related compounds, as disclosed in U.S. Patent No. 3,983,140, lovastatin (mevinolin) and related compounds, as disclosed in U.S. Patent No. 4,231,938, pravastatin and related compounds, such as disclosed in U.S. Patent No. 4,346,227, simvastatin and related compounds, as disclosed in U.S. Patent Nos. 4,448,784 and 4,450,171. Other HMG CoA reductase inhibitors which may be employed herein include, but are not limited to, fluvastatin, disclosed in U.S. Patent No. 5,354,772, cerivastatin, as disclosed in U.S. Patent Nos. 5,006,530 and 5,177,080, atorvastatin, as disclosed in U.S. Patent Nos. 4,681,893, 5,273,995, 5,385,929 and 5,686,104, atavastatin (Nissan/Sankyo's nisvastatin (NK-104)), as disclosed in U.S. Patent No. 5,011,930, visastatin (Shionogi-Astra/Zeneca (ZD-4522)), as disclosed in U.S. Patent No. 5,260,440, and related statin compounds disclosed in U.S. Patent No. 5,753,675, pyrazole analogs of mevalonolactone derivatives, as disclosed in U.S. Patent No. 4,613,610, indene analogs of mevalonolactone derivatives, as disclosed in PCT application WO 86/03488, 6-[2-(substituted-pyrrol-1-yl)-alkyl]pyran-2-ones and derivatives thereof, as disclosed in U.S. Patent No. 4,647,576, Searle's SC-45355 (a 3-substituted pentanedioic acid derivative) dichloroacetate, imidazole analogs of mevalonolactone, as disclosed in PCT application WO 86/07054, 3-carboxy-2-hydroxy-propane-phosphonic acid derivatives, as disclosed in French Patent No. 2,596,393, 2,3-disubstituted pyrrole, furan and thiophene derivatives, as disclosed in European Patent Application No. 0221025, naphthyl analogs of mevalonolactone, as disclosed in U.S. Patent No. 4,686,237, octahydronaphthalenes, such as disclosed in U.S. Patent No. 4,499,289, keto analogs of mevinolin (lovastatin), as disclosed in European Patent Application No. 0142146 A2, and quinoline and pyridine derivatives, as disclosed in U.S. Patent No. 5,506,219 and 5,691,322.

[00234] Preferred hypolipidemic agents are pravastatin, lovastatin, simvastatin, atorvastatin, fluvastatin, cerivastatin, atavastatin and ZD-4522.

[00235] In addition, phosphinic acid compounds useful in inhibiting HMG CoA reductase, such as those disclosed in GB 2205837, are suitable for use in combination
5 with the compound of the present invention.

[00236] The squalene synthetase inhibitors suitable for use herein include, but are not limited to, α -phosphono-sulfonates disclosed in U.S. Patent No. 5,712,396, those disclosed by Biller et al., J. Med. Chem., 1988, Vol. 31, No. 10, pp. 1869-1871, including isoprenoid (phosphinyl-methyl)phosphonates, as well as other known
10 squalene synthetase inhibitors, for example, as disclosed in U.S. Patent No. 4,871,721 and 4,924,024 and in Biller, S.A., Neuenschwander, K., Ponpipom, M.M., and Poulter, C.D., Current Pharmaceutical Design, 2, 1-40 (1996).

[00237] In addition, other squalene synthetase inhibitors suitable for use herein include the terpenoid pyrophosphates disclosed by P. Ortiz de Montellano et al, J.
15 Med. Chem., 1977, 20, 243-249, the farnesyl diphosphate analog A and presqualene pyrophosphate (PSQ-PP) analogs as disclosed by Corey and Volante, J. Am. Chem. Soc., 1976, 98, 1291-1293, phosphinylphosphonates reported by McClard, R.W. et al., J.A.C.S., 1987, 109, 5544 and cyclopropanes reported by Capson, T.L., PhD dissertation, June, 1987, Dept. Med. Chem. U of Utah, Abstract, Table of Contents,
20 pp 16, 17, 40-43, 48-51, Summary.

[00238] The fibric acid derivatives which may be employed in combination the compound of formula I include fenofibrate, gemfibrozil, clofibrate, bezafibrate, ciprofibrate, clinofibrate and the like, probucol, and related compounds, as disclosed in U.S. Patent No. 3,674,836, probucol and gemfibrozil being preferred, bile acid
25 sequestrants, such as cholestyramine, colestipol and DEAE-Sephadex (Secholex[®], Policexide[®]), as well as lipostabil (Rhone-Poulenc), Eisai E-5050 (an N-substituted ethanolamine derivative), imanixil (HOE-402), tetrahydrolipstatin (THL), istigmastanylphos-phorylcholine (SPC, Roche), aminocyclodextrin (Tanabe Seiyoku), Ajinomoto AJ-814 (azulene derivative), melinamide (Sumitomo), Sandoz 58-035,
30 American Cyanamid CL-277,082 and CL-283,546 (disubstituted urea derivatives), nicotinic acid, acipimox, acifran, neomycin, p-aminosalicylic acid, aspirin, poly(diallylmethylamine) derivatives, such as disclosed in U.S. Patent No. 4,759,923,

quaternary amine poly(diallyldimethylammonium chloride) and ionenes, such as disclosed in U.S. Patent No. 4,027,009, and other known serum cholesterol lowering agents.

- [00239] The ACAT inhibitor which may be employed in combination the
5 compound of formula I include those disclosed in Drugs of the Future 24, 9-15 (1999), (Avasimibe); "The ACAT inhibitor, CI-1011 is effective in the prevention and regression of aortic fatty streak area in hamsters", Nicolosi et al., Atherosclerosis (Shannon, Irel). (1998), 137(1), 77-85; "The pharmacological profile of FCE 27677: a novel ACAT inhibitor with potent hypolipidemic activity mediated by selective
10 suppression of the hepatic secretion of ApoB100-containing lipoprotein", Ghiselli, Giancarlo, Cardiovasc. Drug Rev. (1998), 16(1), 16-30; "RP 73163: a bioavailable alkylsulfanyl-diphenylimidazole ACAT inhibitor", Smith, C., et al, Bioorg. Med. Chem. Lett. (1996), 6(1), 47-50; "ACAT inhibitors: physiologic mechanisms for hypolipidemic and anti-atherosclerotic activities in experimental animals", Krause et
15 al, Editor(s): Ruffolo, Robert R., Jr.; Hollinger, Mannfred A., Inflammation: Mediators Pathways (1995), 173-98, Publisher: CRC, Boca Raton, Fla.; "ACAT inhibitors: potential anti-atherosclerotic agents", Sliskovic et al., Curr. Med. Chem. (1994), 1(3), 204-25; "Inhibitors of acyl-CoA:cholesterol O-acyl transferase (ACAT) as hypocholesterolemic agents. 6. The first water-soluble ACAT inhibitor with lipid-
20 regulating activity. Inhibitors of acyl-CoA:cholesterol acyltransferase (ACAT). 7. Development of a series of substituted N-phenyl-N'-[(1-phenylcyclopentyl)methyl]ureas with enhanced hypocholesterolemic activity", Stout et al., Chemtracts: Org. Chem. (1995), 8(6), 359-62, or TS-962 (Taisho Pharmaceutical Co. Ltd).
- 25 [00240] The hypolipidemic agent may be an up-regulator of LD2 receptor activity, such as 1(3H)-isobenzofuranone,3-(13-hydroxy-10-oxotetradecyl)-5,7-dimethoxy-(MD-700, Taisho Pharmaceutical Co. Ltd) and cholestan-3-ol,4-(2-propenyl)-(3a,4a,5a)- (LY295427, Eli Lilly).

- [00241] Examples of suitable cholesterol absorption inhibitor for use in
30 combination with the compound of the invention include SCH48461 (Schering-Plough), as well as those disclosed in Atherosclerosis 115, 45-63 (1995) and J. Med. Chem. 41, 973 (1998).

[00242] Examples of suitable ileal Na⁺/bile acid co-transporter inhibitors for use in combination with the compound of the invention include compounds as disclosed in Drugs of the Future, 24, 425-430 (1999).

[00243] The lipoxygenase inhibitors which may be employed in combination the
5 compound of formula I include 15-lipoxygenase (15-LO) inhibitors, such as benzimidazole derivatives, as disclosed in WO 97/12615, 15-LO inhibitors, as disclosed in WO 97/12613, isothiazolones, as disclosed in WO 96/38144, and 15-LO inhibitors, as disclosed by Sendobry et al "Attenuation of diet-induced atherosclerosis in rabbits with a highly selective 15-lipoxygenase inhibitor lacking significant
10 antioxidant properties", Brit. J. Pharmacology (1997) 120, 1199-1206, and Cornicelli et al, "15-Lipoxygenase and its Inhibition: A Novel Therapeutic Target for Vascular Disease", Current Pharmaceutical Design, 1999, 5, 11-20.

[00244] Examples of suitable anti-hypertensive agents for use in combination with the compound of the present invention include beta adrenergic blockers, calcium
15 channel blockers (L-type and T-type; e.g. diltiazem, verapamil, nifedipine, amlodipine and mybefradil), diuretics (e.g., chlorothiazide, hydrochlorothiazide, flumethiazide, hydroflumethiazide, bendroflumethiazide, methylchlorothiazide, trichloromethiazide, polythiazide, benzthiazide, ethacrynic acid tricrynafen, chlorthalidone, furosemide, musolimine, bumetanide, triamtrenene, amiloride,
20 spironolactone), renin inhibitors, ACE inhibitors (e.g., captopril, zofenopril, fosinopril, enalapril, ceranopril, cilazopril, delapril, pentopril, quinapril, ramipril, lisinopril), AT-1 receptor antagonists (e.g., losartan, irbesartan, valsartan), ET receptor antagonists (e.g., sitaxsentan, atrsentan and compounds disclosed in U.S. Patent Nos. 5,612,359 and 6,043,265), Dual ET/AII antagonist (e.g., compounds
25 disclosed in WO 00/01389), neutral endopeptidase (NEP) inhibitors, vasopepsidase inhibitors (dual NEP-ACE inhibitors) (e.g., omapatrilat and gemopatrilat), and nitrates.

[00245] Examples of suitable anti-obesity agents for use in combination with the compound of the present invention include a beta 3 adrenergic agonist, a lipase
30 inhibitor, a serotonin (and dopamine) reuptake inhibitor, a thyroid receptor beta drug, 5HT_{2C} agonists, (such as Arena APD-356); MCHR1 antagonists such as Synaptic SNAP-7941 and Takeda T-226926, melanocortin receptor (MC4R) agonists, melanin-

- concentrating hormone receptor (MCHR) antagonists (such as Synaptic SNAP-7941 and Takeda T-226926), galanin receptor modulators, orexin antagonists, CCK agonists, NPY1 or NPY5 antagonist, NPY2 and NPY4 modulators, corticotropin releasing factor agonists, histamine receptor-3 (H3) modulators, 11-beta-HSD-1 inhibitors, adipopectin receptor modulators, monoamine reuptake inhibitors or releasing agents, a ciliary neurotrophic factor (CNTF, such as AXOKINE® by Regeneron), BDNF (brain-derived neurotrophic factor), leptin and leptin receptor modulators, cannabinoid-1 receptor antagonists (such as SR-141716 (Sanofi) or SLV-319 (Solvay)), and/or an anorectic agent.
- 10 [00246] The beta 3 adrenergic agonists which may be optionally employed in combination with compound of the present invention include AJ9677 (Takeda/Dainippon), L750355 (Merck), or CP331648 (Pfizer,) or other known beta 3 agonists, as disclosed in U.S. Patent Nos. 5,541,204, 5,770,615, 5,491,134, 5,776,983 and 5,488,064.
- 15 [00247] Examples of lipase inhibitors which may be optionally employed in combination with compound of the present invention include orlistat or ATL-962 (Alizyme).
- [00248] The serotonin (and dopamine) reuptake inhibitor (or serotonin receptor agonists) which may be optionally employed in combination with a compound of the present invention may be BVT-933 (Biovitrum), sibutramine, topiramate (Johnson & Johnson) or axokine (Regeneron).
- 20 [00249] Examples of thyroid receptor beta compounds which may be optionally employed in combination with the compound of the present invention include thyroid receptor ligands, such as those disclosed in WO 97/21993 (U. Cal SF), WO 99/00353 (KaroBio) and WO 00/039077 (KaroBio).
- 25 [00250] The monoamine reuptake inhibitors which may be optionally employed in combination with compound of the present invention include fenfluramine, dexfenfluramine, fluvoxamine, fluoxetine, paroxetine, sertraline, chlorphentermine, cloforex, clortermine, picilorex, sibutramine, dexamphetamine, phentermine,
- 30 phenylpropanolamine or mazindol.

[00251] The anorectic agent which may be optionally employed in combination with the compound of the present invention include topiramate (Johnson & Johnson), dexamphetamine, phentermine, phenylpropanolamine or mazindol.

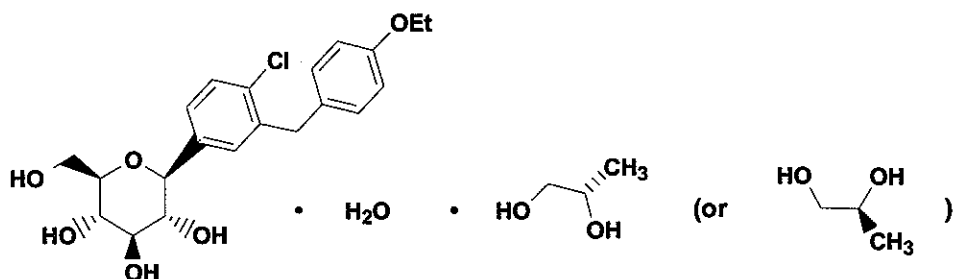
[00252] The aforementioned patents and patent applications are incorporated
5 herein by reference.

[00253] The above other therapeutic agents, when employed in combination with the compound of the present invention may be used, for example, in those amounts indicated in the Physicians' Desk Reference, as in the patents set out above or as otherwise determined by one of ordinary skill in the art.

10

Claims

1. A crystalline (S)-propylene glycol ((S)-PG) solvate compound Ia (form SC-3)



Compound Ia

2. The crystalline (S)-PG compound Ia (form SC-3) according to claim 1 characterized by unit cell parameters substantially equal to the following:

Cell dimensions:

$$a = 11.2688(8) \text{ \AA}$$

$$b = 4.8093(3) \text{ \AA}$$

$$c = 46.723(3) \text{ \AA}$$

$$\alpha = 90 \text{ degrees}$$

$$\beta = 90 \text{ degrees}$$

$$\gamma = 90 \text{ degrees}$$

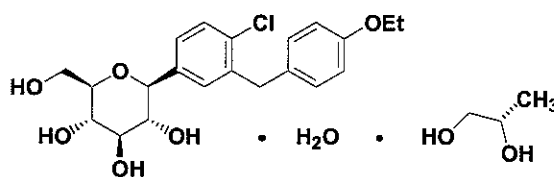
$$\text{Space group} = P2_12_12_1$$

$$\text{Molecules/asymmetric unit} = 1$$

wherein measurement of said crystalline structure is at room temperature and characterized by fractional atomic coordinates substantially as listed in Table 4.

3. The crystalline compound of claim 1 wherein said compound is in substantially pure form.
4. The crystalline (S)-PG compound Ia (form SC-3) according to claim 1 characterized by peaks in the powder x-ray diffraction pattern at 2θ values of 3.8 ± 0.1 , 7.6 ± 0.1 , 8.1 ± 0.1 , 8.7 ± 0.1 , 15.2 ± 0.1 , 15.7 ± 0.1 , 17.1 ± 0.1 , 18.9 ± 0.1 and 20.1 ± 0.1 .

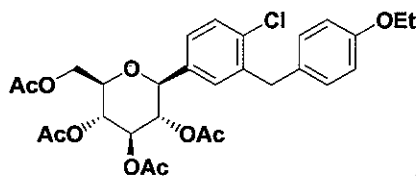
5. The crystalline (S)-PG compound Ia (form SC-3) according to claim 1 characterized by a solid state ^{13}C NMR spectrum having substantially similar peak positions at 16.2, 17.6, 39.3, 60.9, 63.3, 69.8, 76.9, 78.7, 79.4, 113.8, 123.6, 129.3, 130.5, 132.0, 135.7, 139.1 and 158.0 ppm.
6. The crystalline (S)-PG compound Ia (form SC-3) according to claim 1 characterized by a differential scanning calorimetry thermogram having an endotherm in the range of about 50°C to about 78°C or as shown in Figure 7.
7. The crystalline (S)-PG compound Ia (form SC-3) according to claim 5 characterized by a thermal gravimetric analysis curve with about 18.7% weight loss from about room temperature up to about 240°C or as shown in Figure 5.
8. A process of preparing crystalline compound Ia (form SC-3)



Ia (form SC-3, (S)-PG)

comprising:

treating compound A

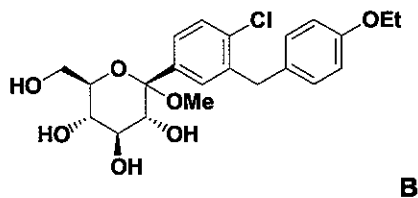


A

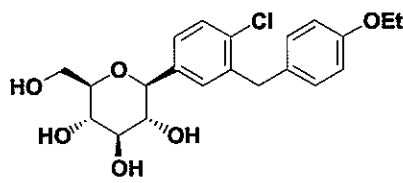
in an organic solvent with base and (S)-propylene glycol, optionally adding seeds of (S)-PG crystalline compound Ia (form SC-3), to provide (S)-PG crystalline compound Ia (form SC-3).

9. The process according to claim 8 wherein seeds of (S)-PG crystalline compound Ia (form SC-3) are added to the reaction mixture

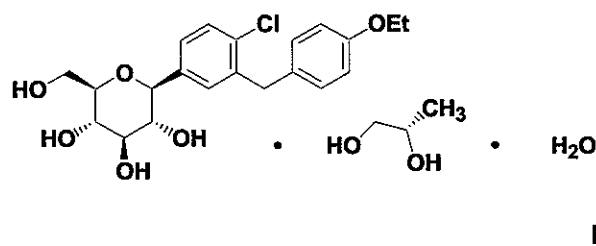
10. A process for preparing a crystalline compound Ia (form SC-3), which comprises treating compound B



with a reducing agent in the presence of an activating group to provide compound I



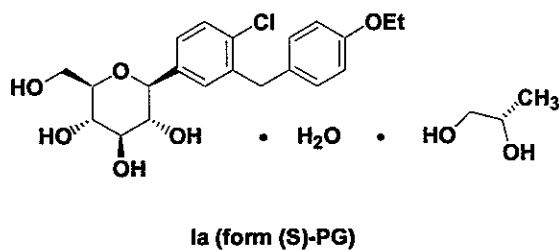
treating compound I with (S)-propylene glycol, optionally adding seeds of crystalline compound Ia (form SC-3) to the reaction mixture, in the presence of an organic solvent to provide crystalline compound Ia (form SC-3)



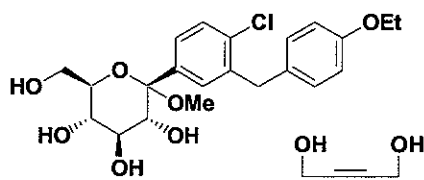
11. The process according to claim 10 wherein the reducing agent is an alkylsilyl hydride and the activating group is a Lewis acid.

12. The process according to claim 10 wherein the reducing agent is triethylsilane and the activating group is BF_3OEt_2 or $\text{BF}_3 \cdot 2\text{CH}_3\text{COOH}$.

13. A process of preparing crystalline compound Ia (form SC-3)

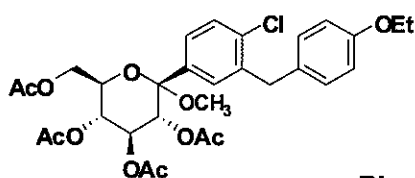


which comprises treating compound If



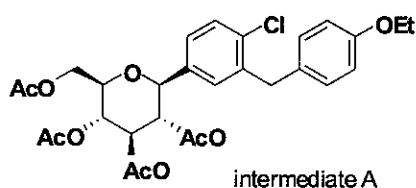
If

with acetic anhydride in the presence of dimethylaminopyridine CH_3CN to provide compound B'



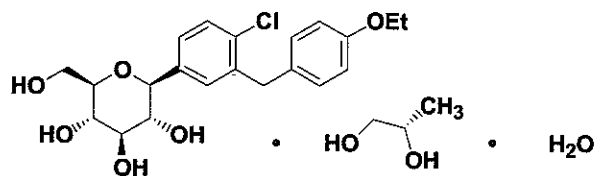
B'

treating compound B' with a reducing agent in the presence of an activating group and CH_3CN to provide intermediate A



intermediate A

treating intermediate A with a base and then with (S)-propylene glycol, optionally adding seeds of crystalline compound Ia (form SC-3) to the reaction mixture, in the presence of an organic solvent to provide crystalline compound Ia (form SC-3)



Ia

14. The process according to claim 13 wherein the reducing agent is an alkylsilyl hydride and the activating group is a Lewis acid.

15. The process according to claim 13 wherein the reducing agent is triethylsilane and the activating group is BF_3OEt_2 or $\text{BF}_3 \cdot 2\text{CH}_3\text{COOH}$.