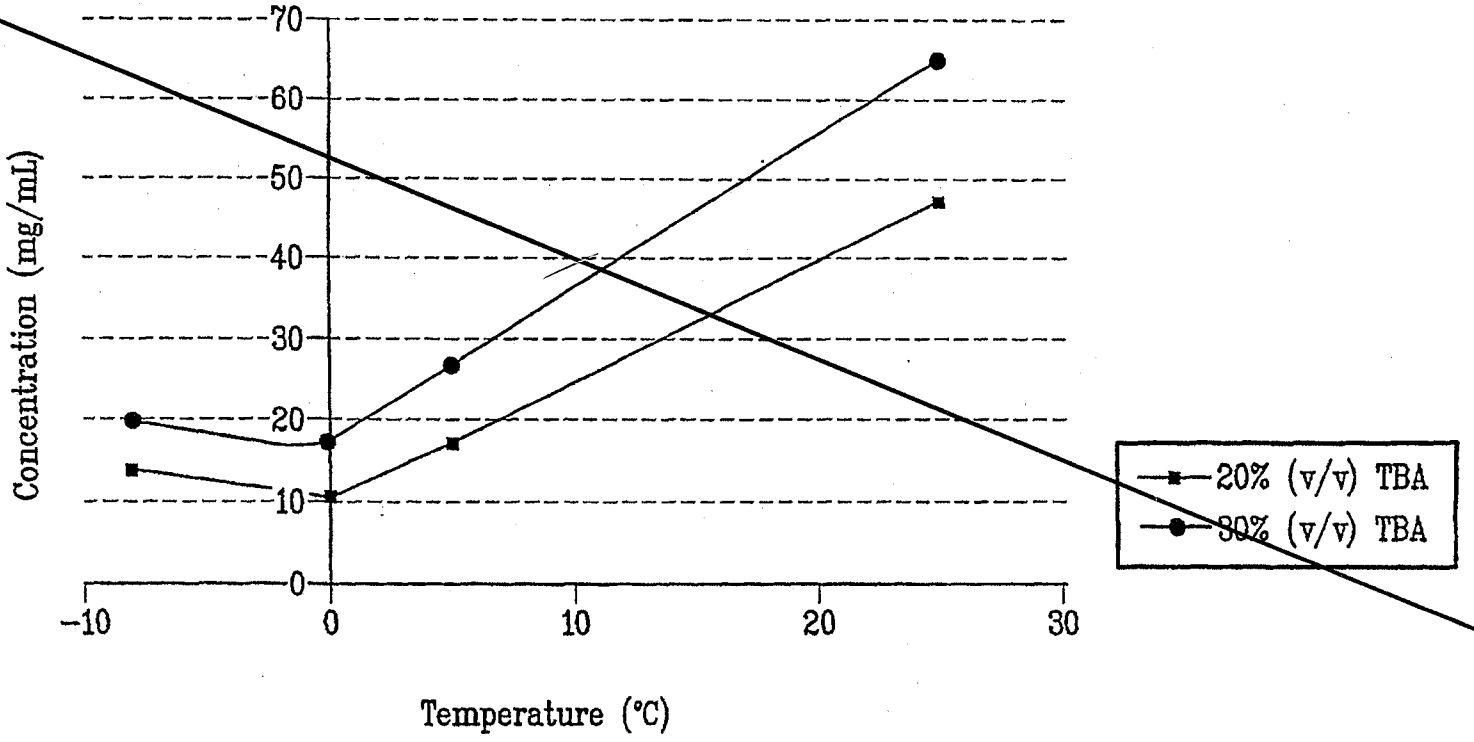

70
60
50
40
30
20
10
0
Concentration (mg/mL)
−10
0
10
20
30
Temperature (°C)
20% (v/v) TBA
30% (v/v) TBA

FIG. 1

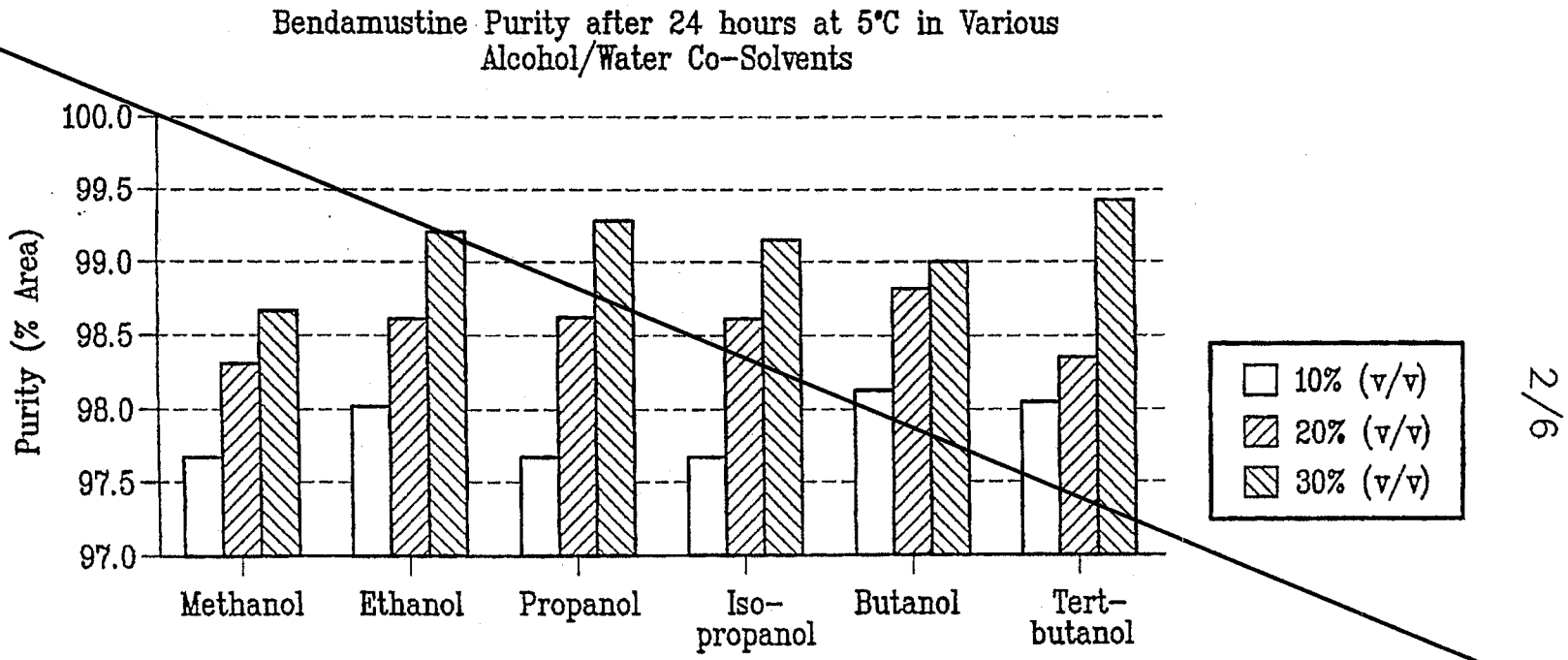

Bendamustine Purity after 24 hours at 5°C in Various Alcohol/Water Co-Solvents
Purity (% Area)
100.0
99.5
99.0
98.5
98.0
97.5
97.0
Methanol
Ethanol
Propanol
Iso-propanol
Butanol
Tert-butanol
10% (v/v)
20% (v/v)
30% (v/v)

FIG. 2

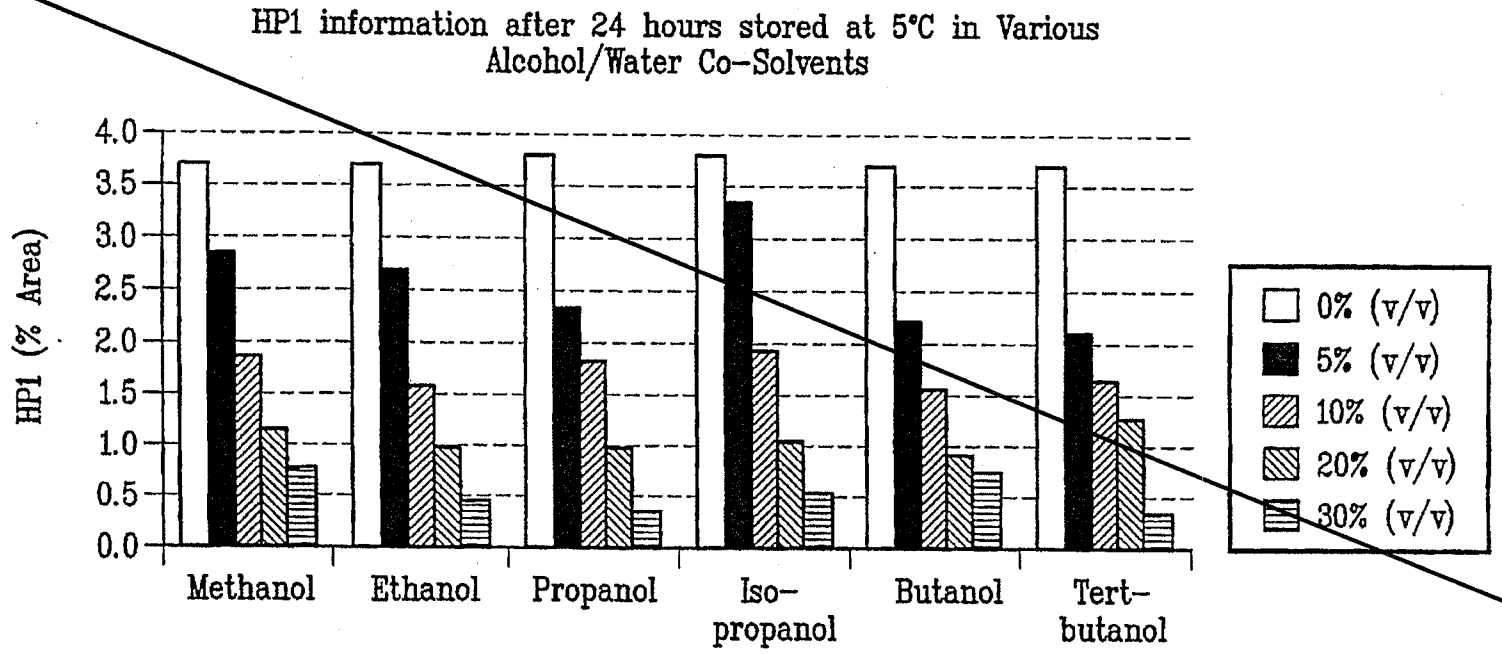

HP1 information after 24 hours stored at 5°C in Various Alcohol/Water Co-Solvents
HP1 (% Area)
4.0
3.5
3.0
2.5
2.0
1.5
1.0
0.5
0.0
Methanol
Ethanol
Propanol
Iso-propanol
Butanol
Tert-butanol
0% (v/v)
5% (v/v)
10% (v/v)
20% (v/v)
30% (v/v)

FIG. 3

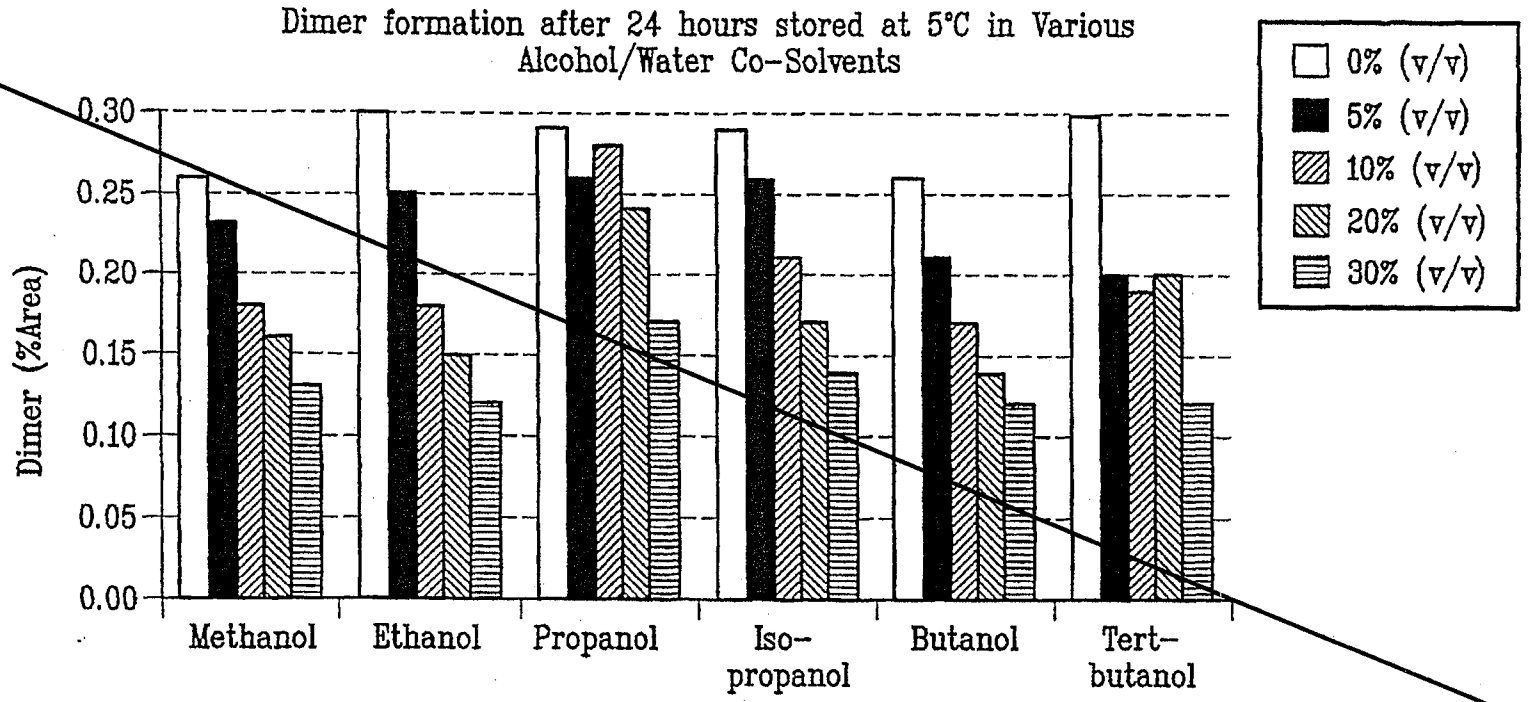

Dimer formation after 24 hours stored at 5°C in Various Alcohol/Water Co-Solvents
Dimer (%Area)
0.30
0.25
0.20
0.15
0.10
0.05
0.00
Methanol
Ethanol
Propanol
Iso-propanol
Butanol
Tert-butanol
0% (v/v)
5% (v/v)
10% (v/v)
20% (v/v)
30% (v/v)

FIG. 4

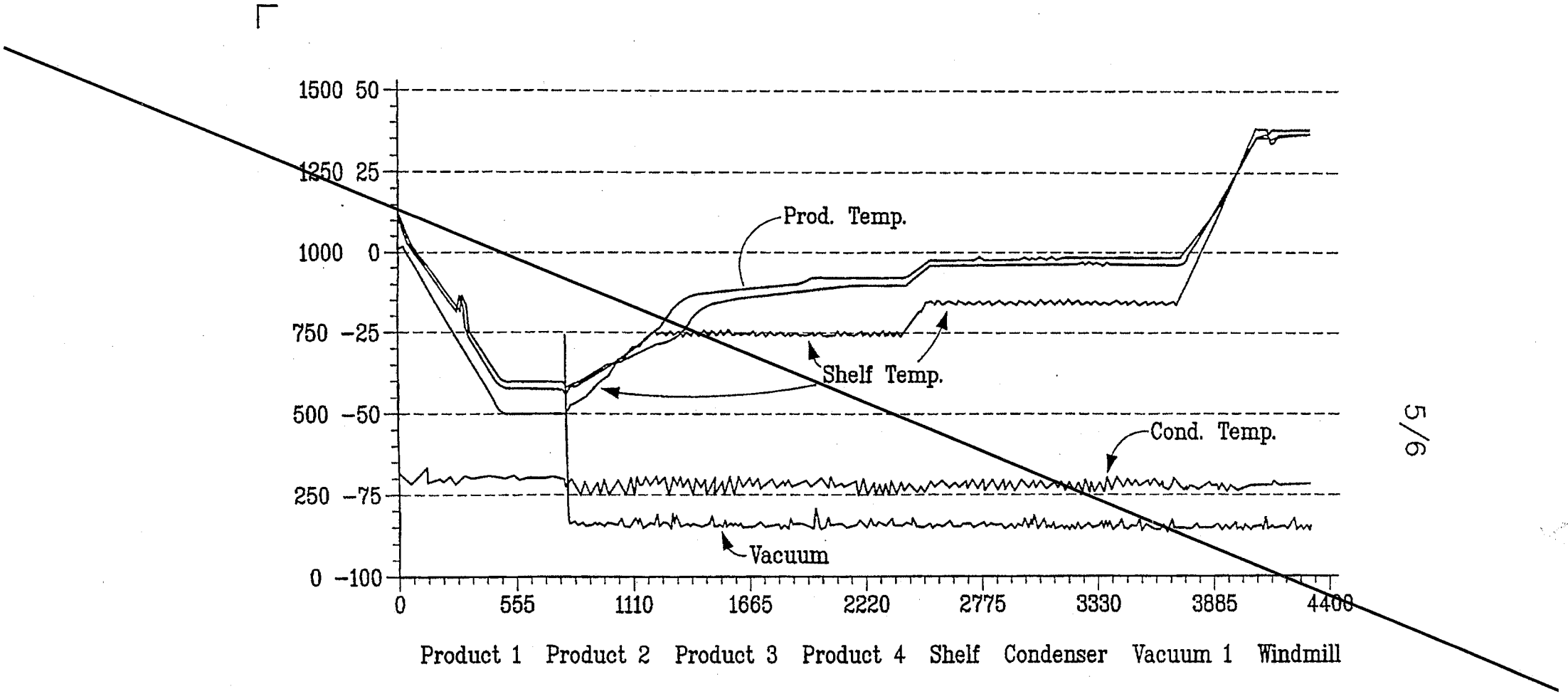

1500 50
1250 25
1000 0
750 -25
500 -50
250 -75
0 -100
0
555
1110
1665
2220
2775
3330
3885
4400
Prod. Temp.
Shelf Temp.
Cond. Temp.
Vacuum
Product 1 Product 2 Product 3 Product 4 Shelf Condenser Vacuum 1 Windmill

FIG. 5

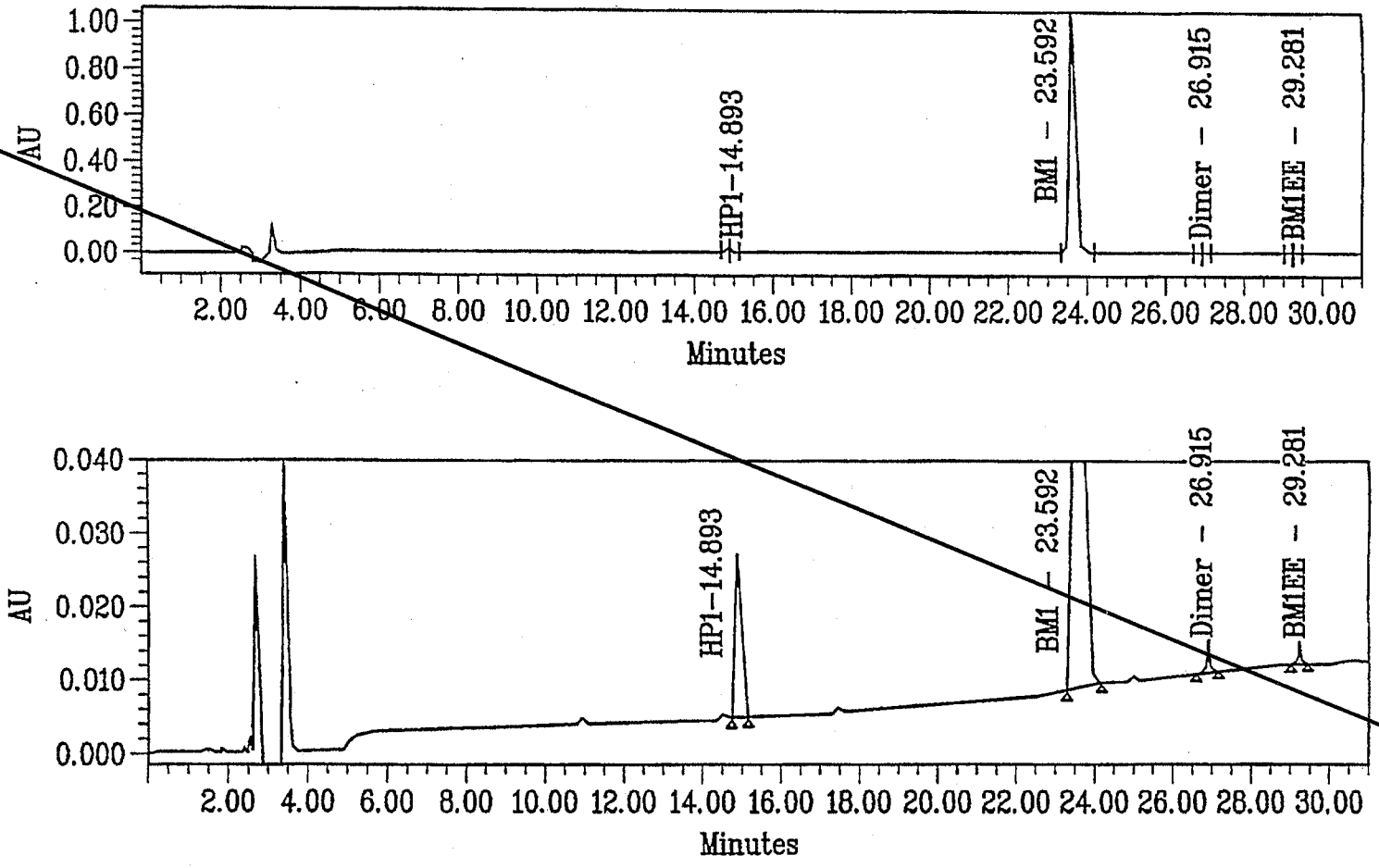

1.00
0.80
0.60
0.40
0.20
0.00
AU
HP1-14.893
BM1 - 23.592
Dimer - 26.915
BM1EE - 29.281
2.00 4.00 6.00 8.00 10.00 12.00 14.00 16.00 18.00 20.00 22.00 24.00 26.00 28.00 30.00
Minutes
0.040
0.030
0.020
0.010
0.000
AU
HP1-14.893
BM1 - 23.592
Dimer - 26.915
BM1EE - 29.281
2.00 4.00 6.00 8.00 10.00 12.00 14.00 16.00 18.00 20.00 22.00 24.00 26.00 28.00 30.00
Minutes

FIG. 6

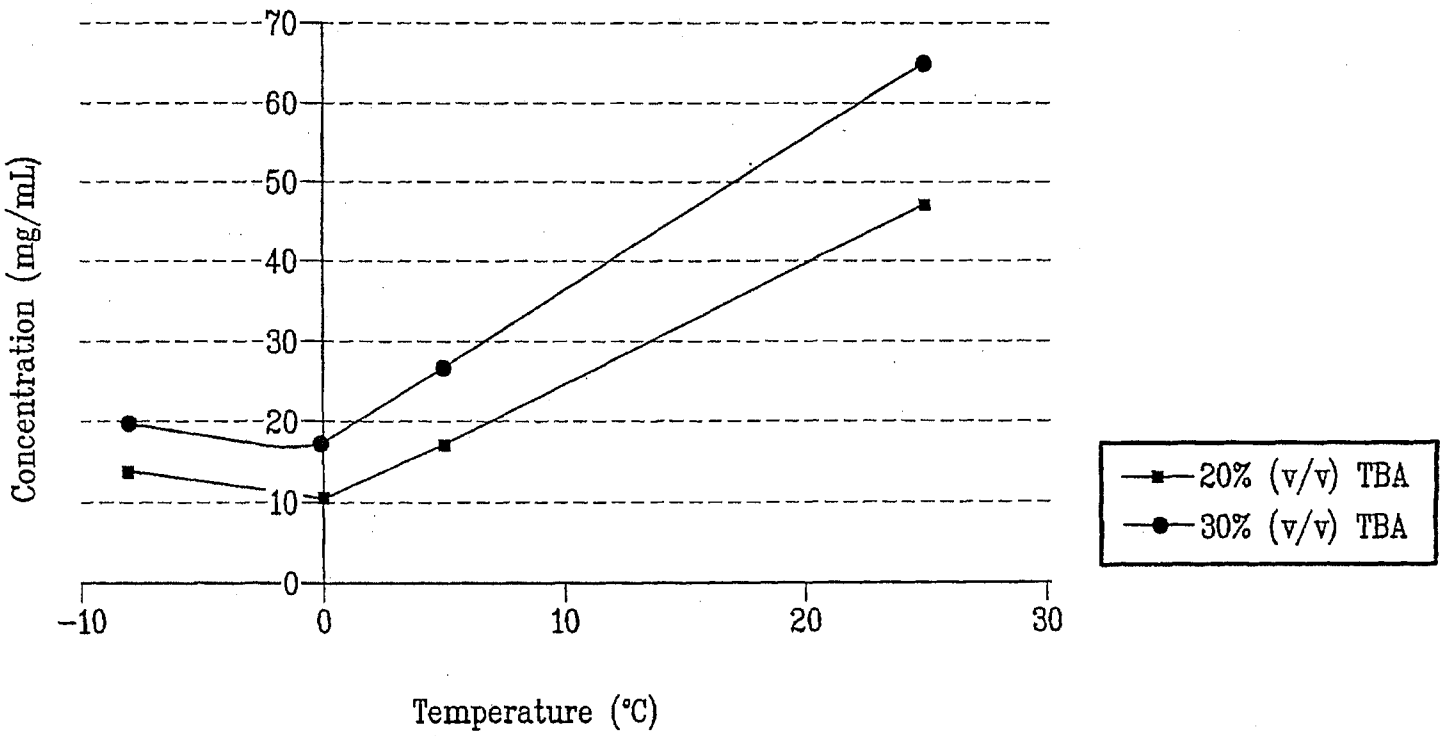

70
60
50
40
30
20
10
0
Concentration (mg/mL)
−10
0
10
20
30
Temperature (°C)
20% (v/v) TBA
30% (v/v) TBA

FIG. 1

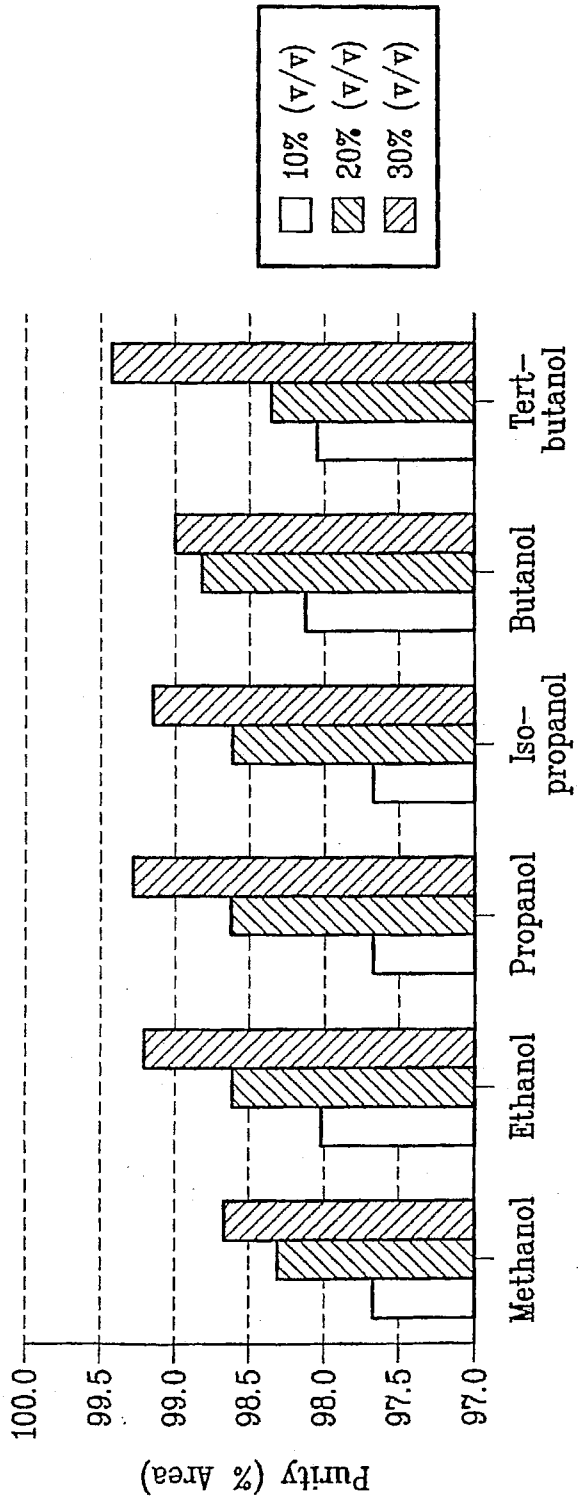

Bendamustine Purity after 24 hours at 5°C in Various Alcohol/Water Co-Solvents
10% (v/v)
20% (v/v)
30% (v/v)
Purity (% Area)
100.0
99.5
99.0
98.5
98.0
97.5
97.0
Methanol
Ethanol
Propanol
Iso-propanol
Butanol
Tert-butanol

FIG. 2

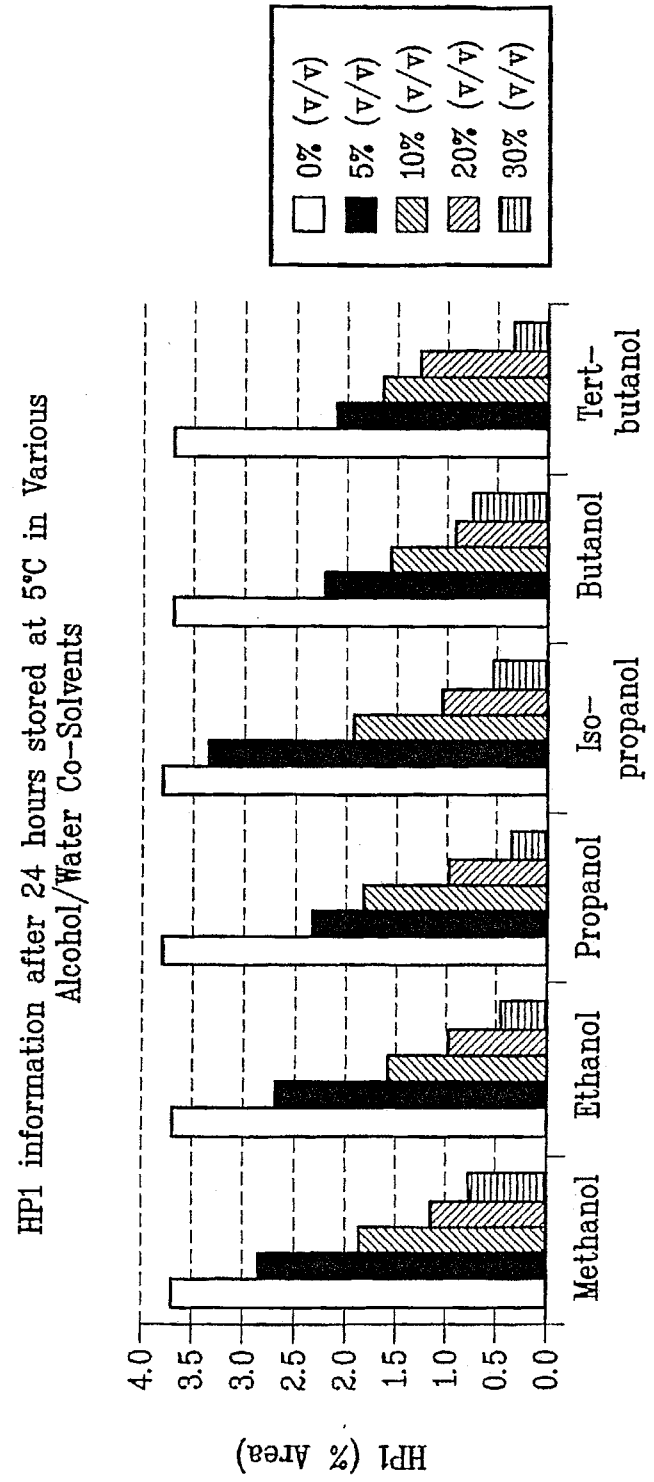

HP1 information after 24 hours stored at 5°C in Various Alcohol/Water Co-Solvents
HPI (% Area)
4.0
3.5
3.0
2.5
2.0
1.5
1.0
0.5
0.0
0% (v/v)
5% (v/v)
10% (v/v)
20% (v/v)
30% (v/v)
Methanol
Ethanol
Propanol
Iso-propanol
Butanol
Tert-butanol

FIG. 3

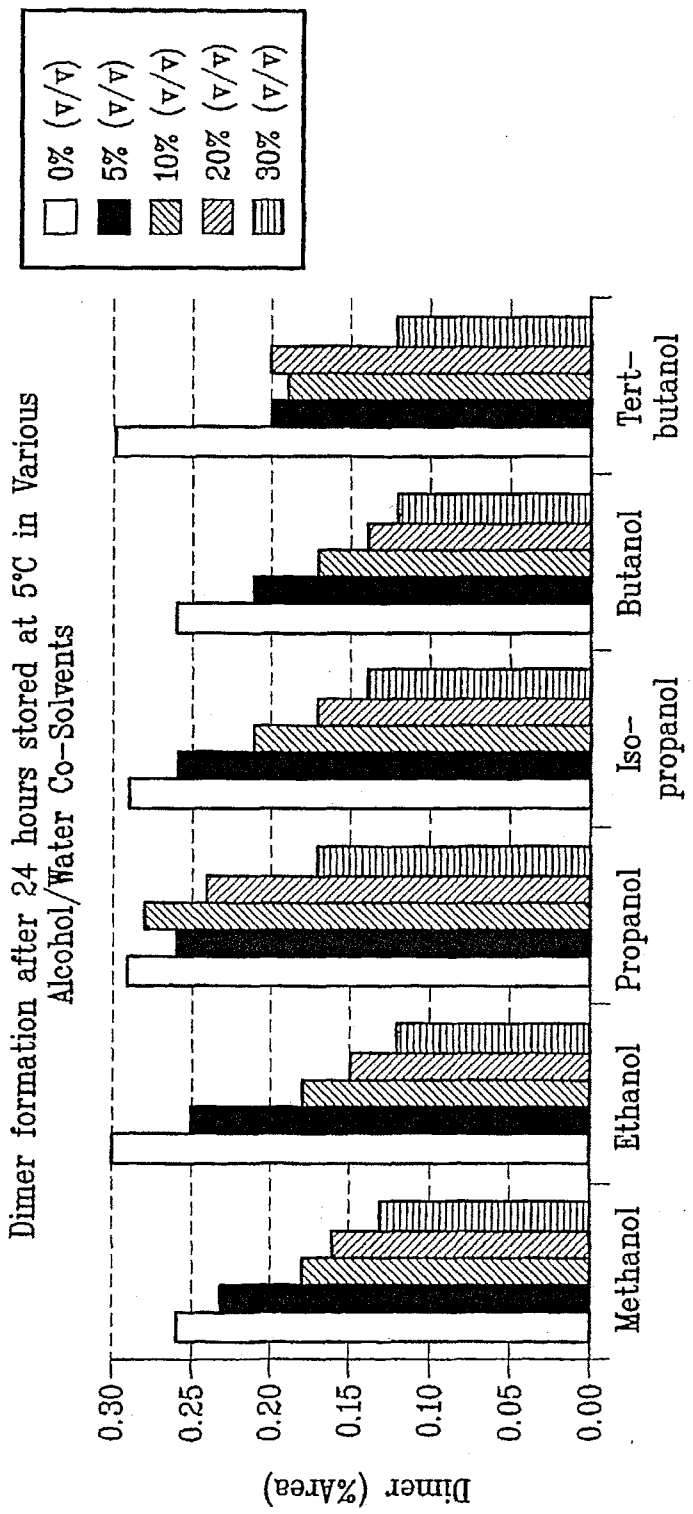

Dimer formation after 24 hours stored at 5°C in Various Alcohol/Water Co-Solvents
0% (v/v)
5% (v/v)
10% (v/v)
20% (v/v)
30% (v/v)
Dimer (%Area)
0.30
0.25
0.20
0.15
0.10
0.05
0.00
Methanol
Ethanol
Propanol
Iso-propanol
Butanol
Tert-butanol

FIG. 4

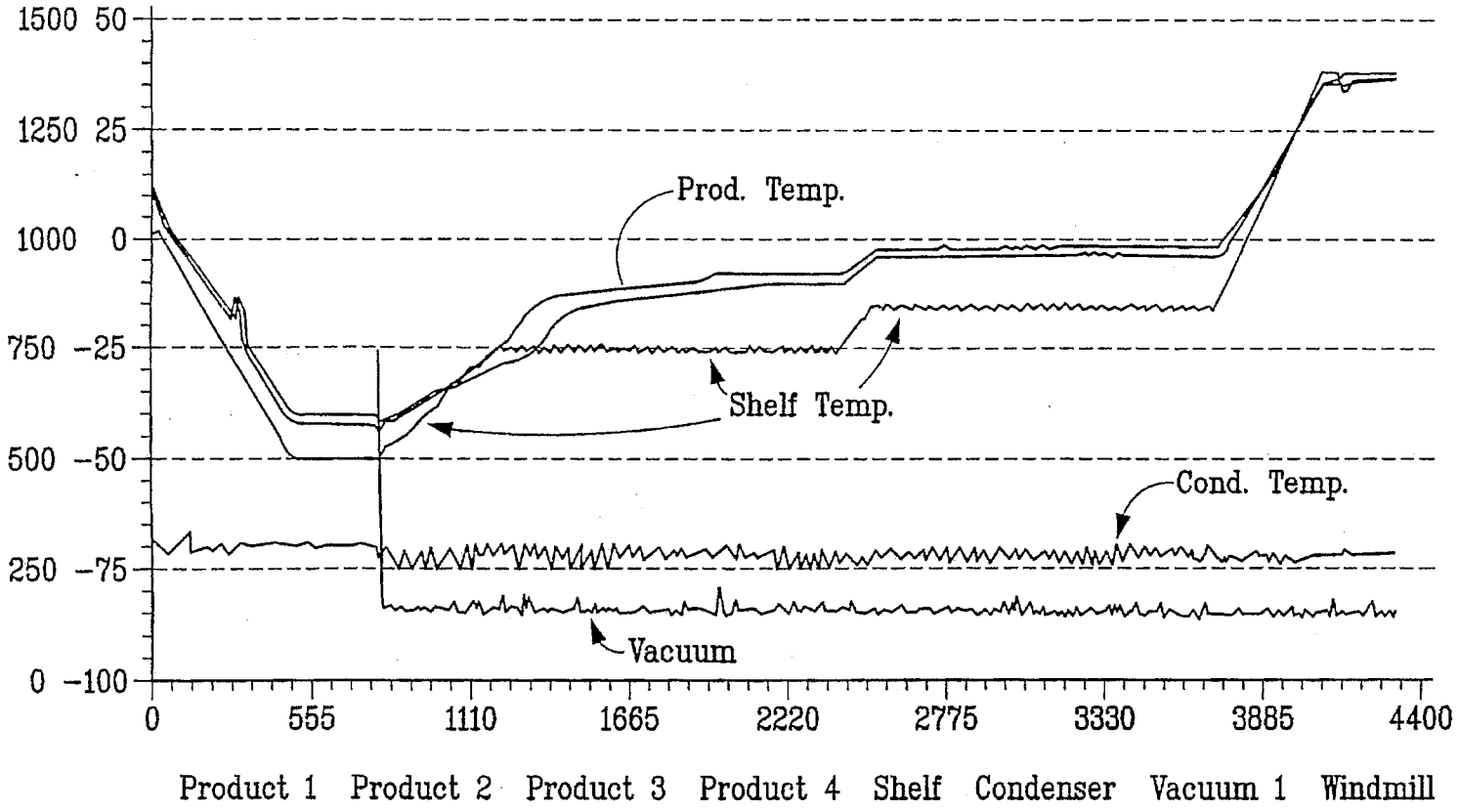

1500 50
1250 25
1000 0
750 -25
500 -50
250 -75
0 -100
0
555
1110
1665
2220
2775
3330
3885
4400
Prod. Temp.
Shelf Temp.
Cond. Temp.
Vacuum
Product 1
Product 2
Product 3
Product 4
Shelf
Condenser
Vacuum 1
Windmill

FIG. 5

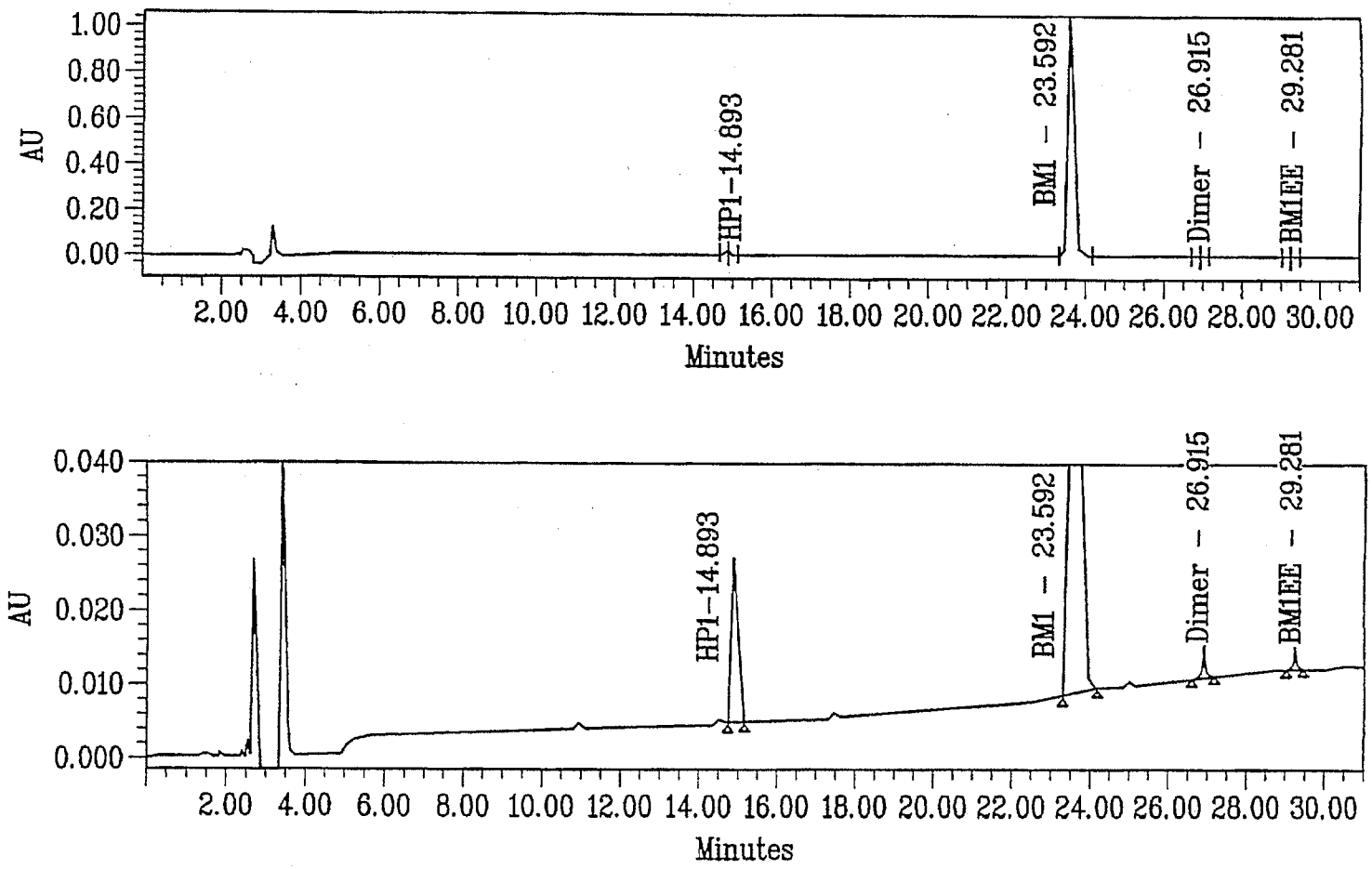

1.00
0.80
0.60
0.40
0.20
0.00
AU
HP1-14.893
BM1 - 23.592
Dimer - 26.915
BM1EE - 29.281
2.00 4.00 6.00 8.00 10.00 12.00 14.00 16.00 18.00 20.00 22.00 24.00 26.00 28.00 30.00
Minutes
0.040
0.030
0.020
0.010
0.000
AU
HP1-14.893
BM1 - 23.592
Dimer - 26.915
BM1EE - 29.281
2.00 4.00 6.00 8.00 10.00 12.00 14.00 16.00 18.00 20.00 22.00 24.00 26.00 28.00 30.00
Minutes

FIG. 6