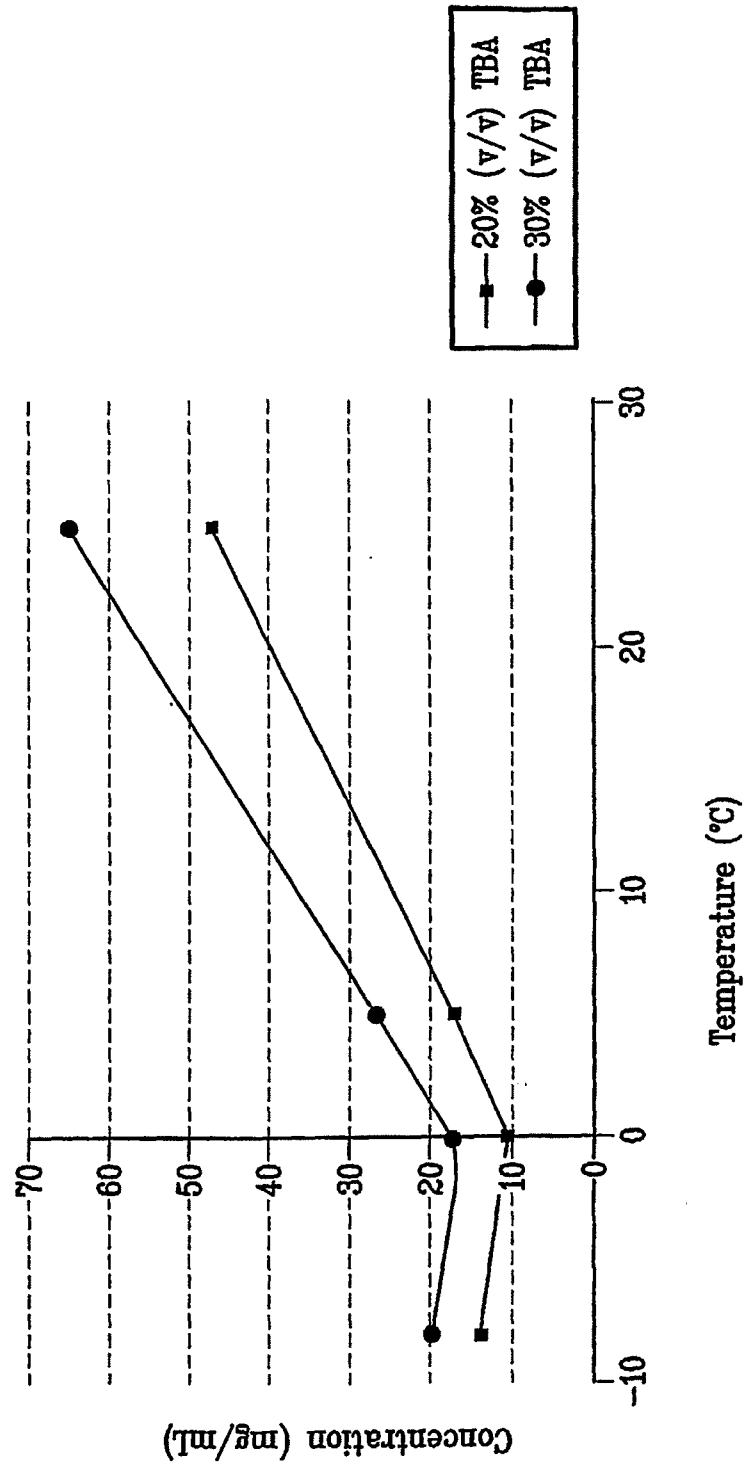

20% (v/v) TBA
30% (v/v) TBA
Concentration (mg/mL)
70
60
50
40
30
20
10
0
Temperature (°C)
30
20
10
0
-10

FIG. 1

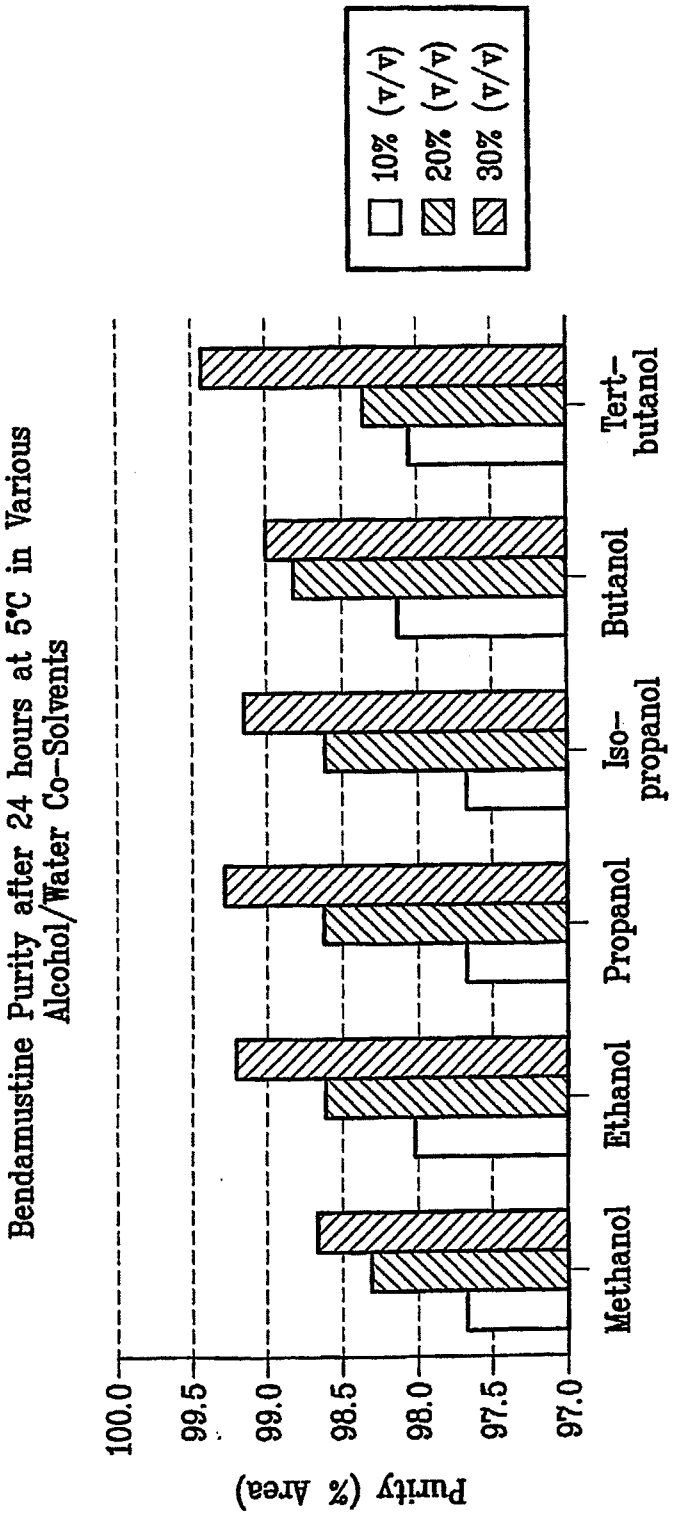

Bendamustine Purity after 24 hours at 5°C in Various Alcohol/Water Co-Solvents
10% (v/v)
20% (v/v)
30% (v/v)
Purity (% Area)
100.0
99.5
99.0
98.5
98.0
97.5
97.0
Methanol
Ethanol
Propanol
Iso-propanol
Butanol
Tert-butanol

FIG. 2

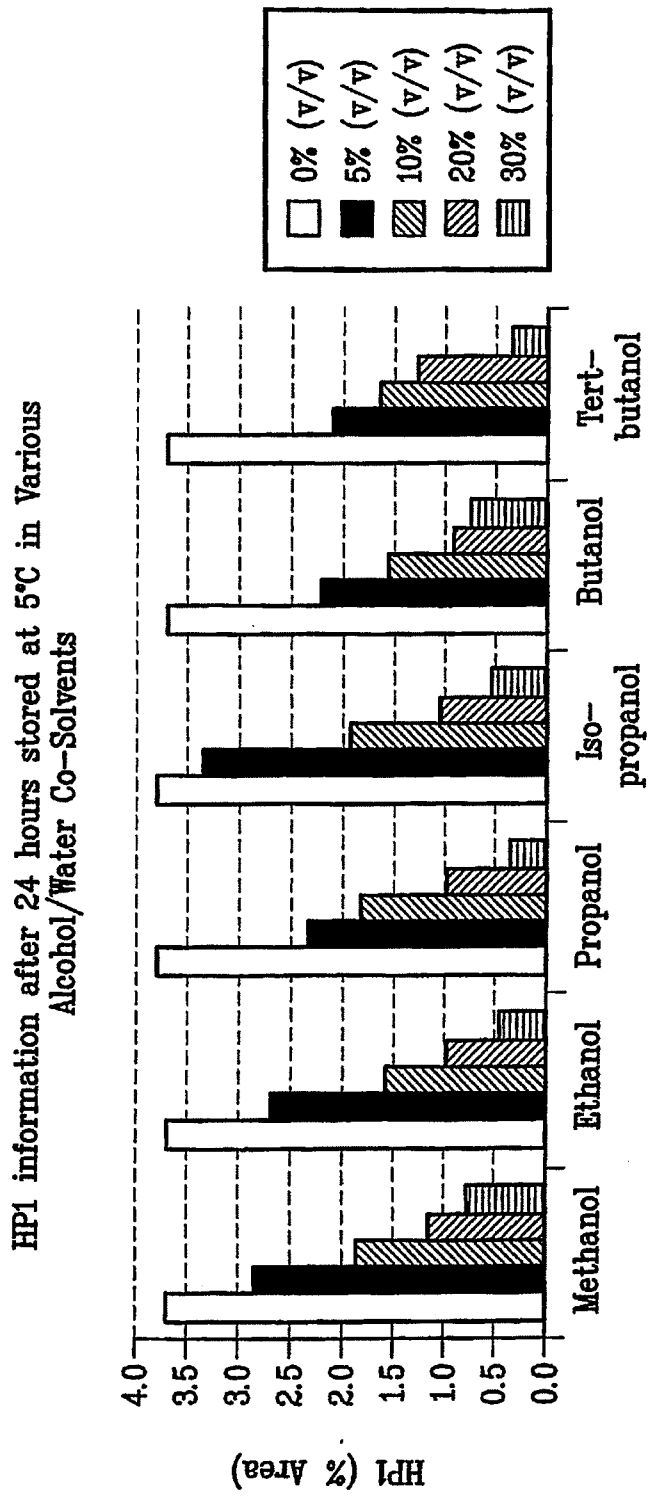

HP1 information after 24 hours stored at 5°C in Various Alcohol/Water Co-Solvents
HP1 (% Area)
4.0
3.5
3.0
2.5
2.0
1.5
1.0
0.5
0.0
0% (v/v)
5% (v/v)
10% (v/v)
20% (v/v)
30% (v/v)
Methanol
Ethanol
Propanol
Iso-propanol
Butanol
Tert-butanol

FIG. 3

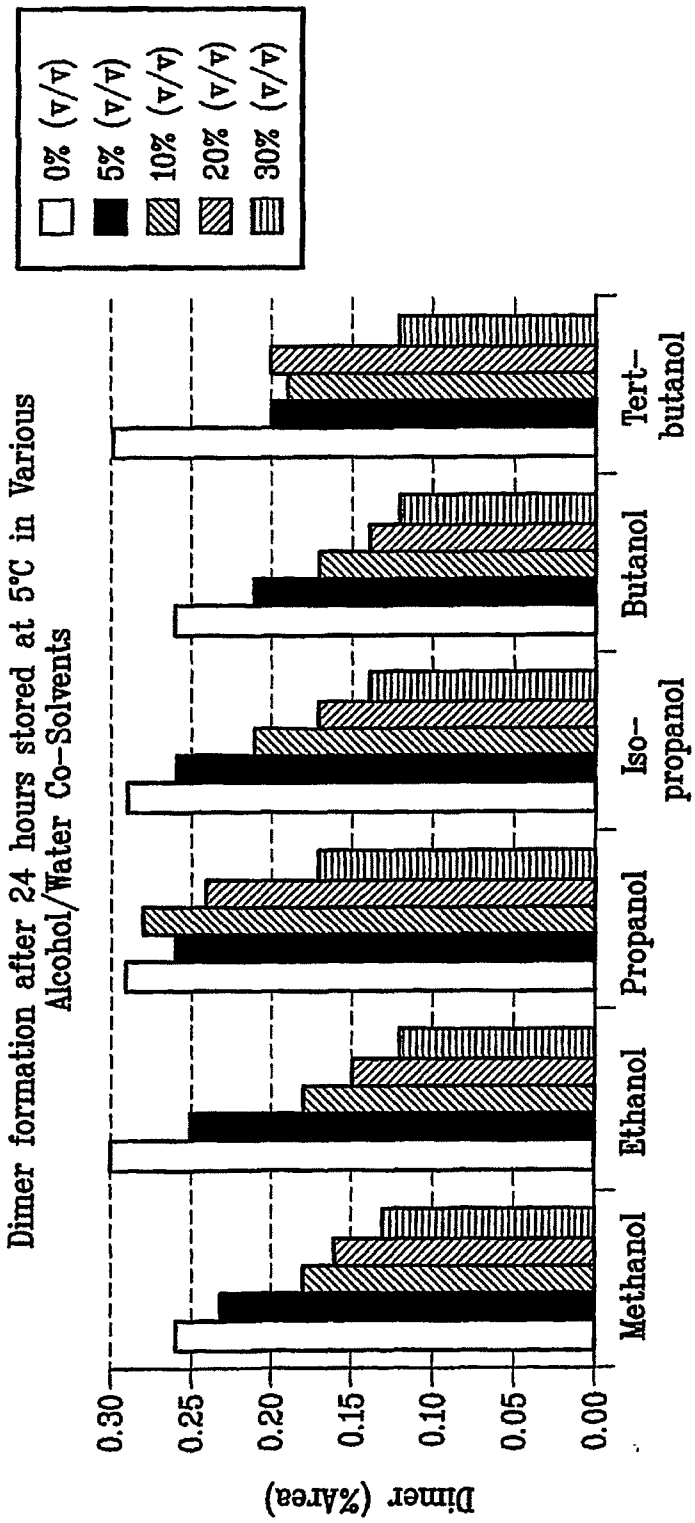

Dimer formation after 24 hours stored at 5°C in Various Alcohol/Water Co-Solvents
0% (v/v)
5% (v/v)
10% (v/v)
20% (v/v)
30% (v/v)
Dimer (%Area)
0.30
0.25
0.20
0.15
0.10
0.05
0.00
Methanol
Ethanol
Propanol
Iso-propanol
Butanol
Tert-butanol

FIG. 4

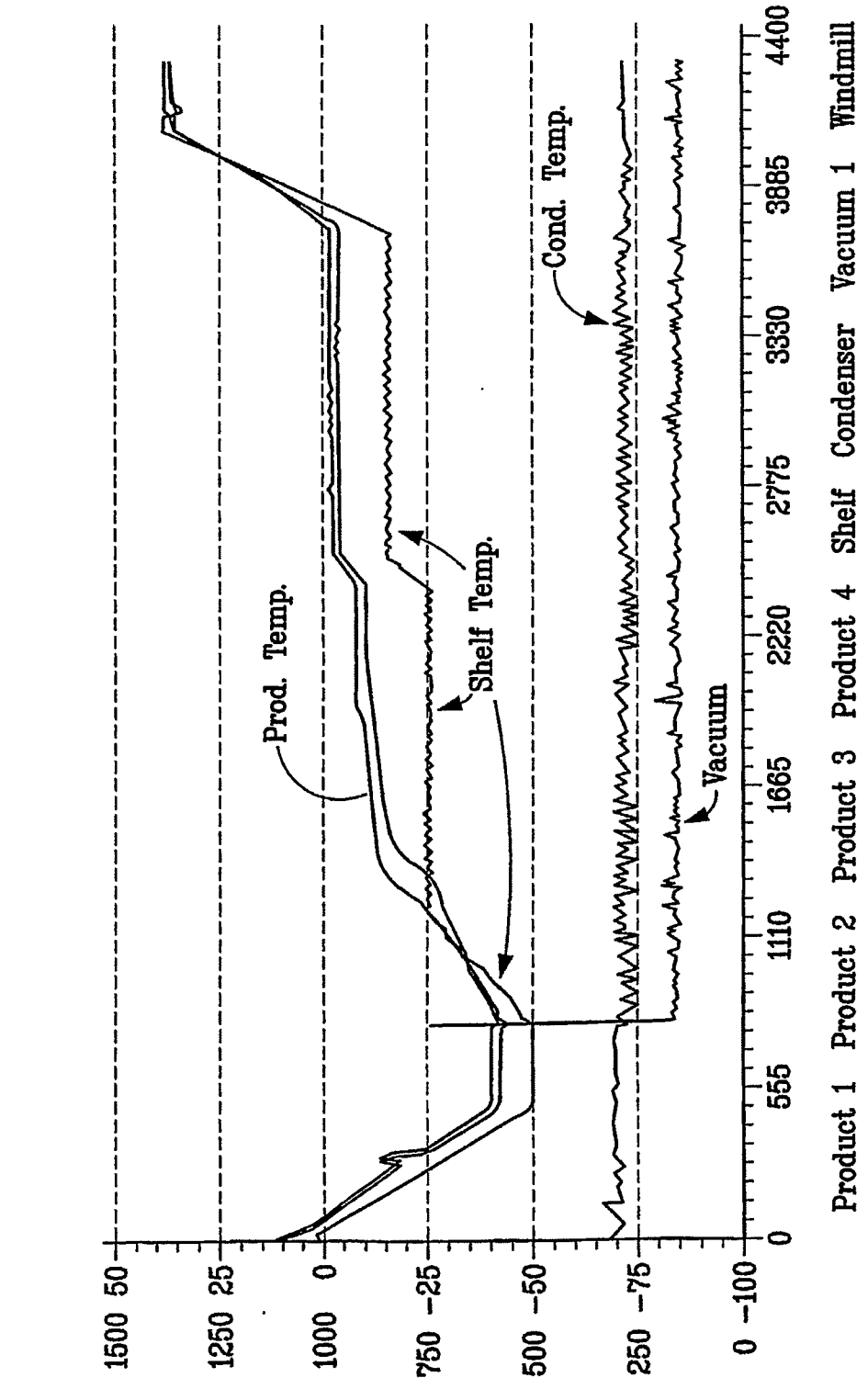

1500 50
1250 25
1000 0
750 -25
500 -50
250 -75
0 -100
0
555
1110
1665
2220
2775
3330
3885
4400
Prod. Temp.
Shelf Temp.
Cond. Temp.
Vacuum
Product 1 Product 2 Product 3 Product 4 Shelf Condenser Vacuum 1 Windmill

FIG. 5

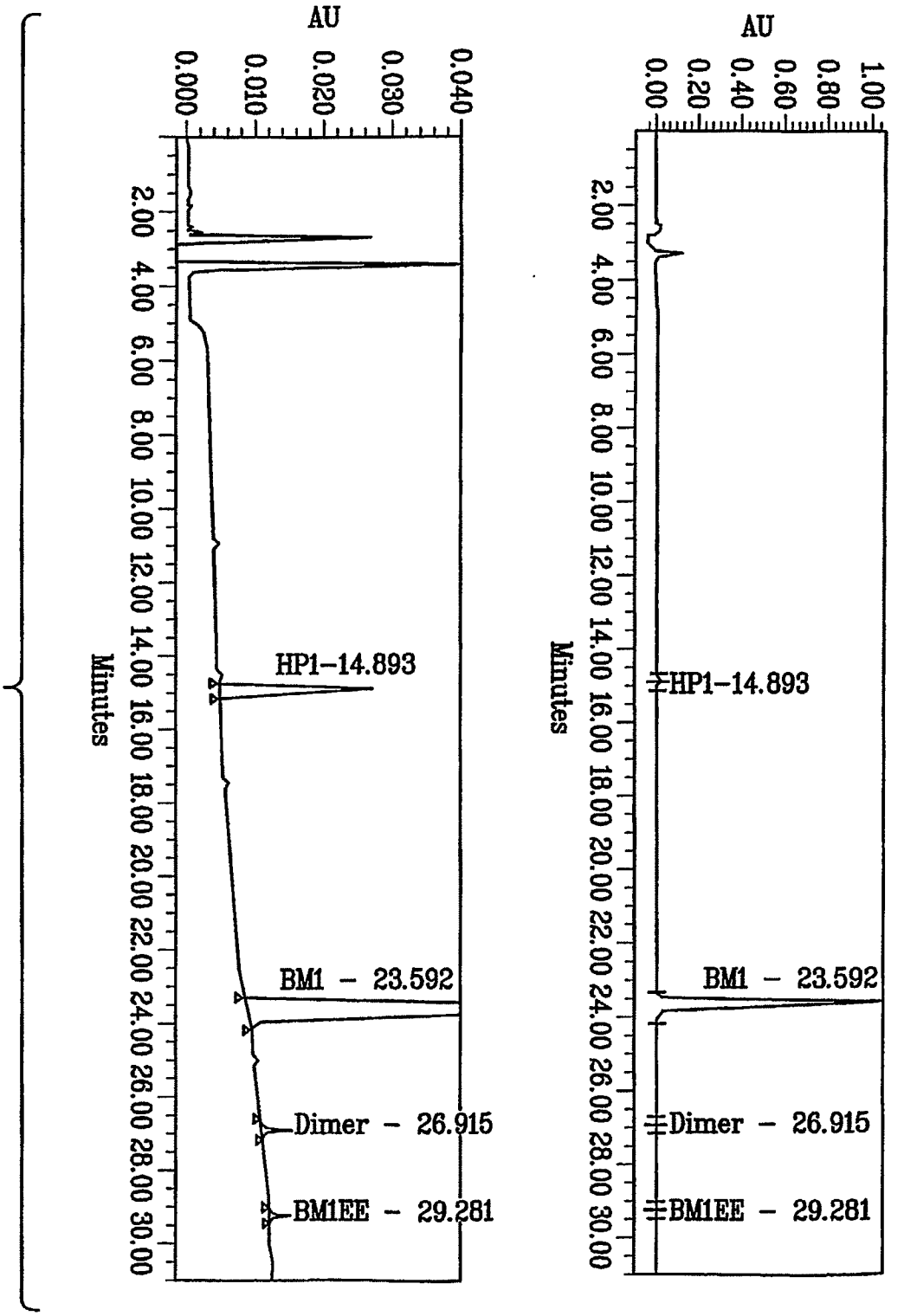

AU
0.000
0.010
0.020
0.030
0.040
2.00
4.00
6.00
8.00
10.00
12.00
14.00
16.00
18.00
20.00
22.00
24.00
26.00
28.00
30.00
Minutes
HP1-14.893
BM1 - 23.592
Dimer - 26.915
BM1EE - 29.281
AU
0.00
0.20
0.40
0.60
0.80
1.00
HP1-14.893
BM1 - 23.592
Dimer - 26.915
BM1EE - 29.281

FIG. 6