

PARTICULATE COMPOSITION COMPRISING ENSIFETRINE

CROSS-REFERENCE

This application claims the benefit of GB 2309605.0, filed June 26, 2023, which is incorporated herein by reference in its entirety.

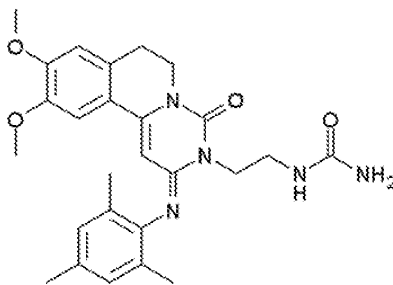
5 FIELD OF THE INVENTION

The present invention relates to a particulate composition comprising ensifentrine, as well as a pharmaceutical composition and a process for producing the particulate composition.

BACKGROUND OF THE INVENTION

- 10 Ensifentrine (*N*-(2-((2*E*)-9,10-dimethoxy-4-oxo-2-[(2,4,6-trimethylphenyl)imino]-6,7-dihydro-2*H*-pyrimido[6,1-*a*]isoquinolin-3(4*H*)-yl)ethyl)urea, also known as RPL554) is a dual PDE3/PDE4 inhibitor and is described in WO 00/58308 A1.

- As a combined PDE3/PDE4 inhibitor, ensifentrine has both bronchodilatory and anti-inflammatory activity and is useful in the treatment of respiratory disorders including
15 chronic obstructive pulmonary disease (COPD). The chemical structure of ensifentrine is shown below.



- Impurities associated with active agents need to be controlled, with only certain levels of specific impurities permitted in pharmaceutical products (with these
20 impurities typically referred to as related substances). It has been found that known processes for producing ensifentrine are associated with undesirable levels of impurities. For instance, the process described in WO 00/58308 A1 in which a urea group is added using sodium cyanate and aqueous hydrochloric produces an

ensifentrine substance containing a biuret impurity which could not readily be removed. WO 2018/020249 A1 discusses several possible reagents which may be used to add a urea group in the final step of the production of ensifentrine, but no detailed discussion of the conditions of the final ureation step is provided.

- 5 It is desirable to develop a synthetic process for the production of ensifentrine which produces a drug substance with a favourable impurity profile without the need for extensive purification and recrystallisation, and in particular where the drug substance comprises low levels of a biuret impurity.

SUMMARY OF THE INVENTION

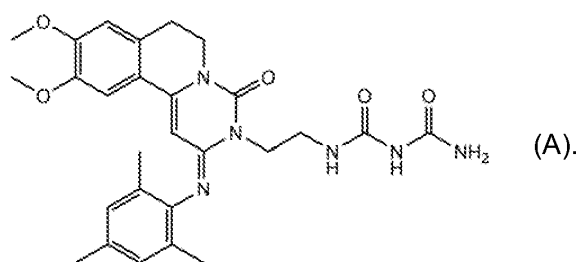
- 10 It has been found that it is possible to produce ensifentrine with a favourable impurity profile, and in particular ensifentrine having low levels of a biuret impurity, by a reaction comprising reacting an amine intermediate with 4-nitrophenyl chloroformate and ammonia in a solvent comprising dichloromethane.

The invention provides a particulate composition comprising ensifentrine, wherein

- 15 the particulate composition further comprises:

from greater than 0.00 wt% to 0.60 wt% of 1,3-bis(2-(2-(mesitylimino)-9,10-dimethoxy-4-oxo-6,7-dihydro-2H-pyrimido[6,1-a]isoquinolin-3(4H)-yl)ethyl)urea (BMIQU) relative to the total weight of ensifentrine; and

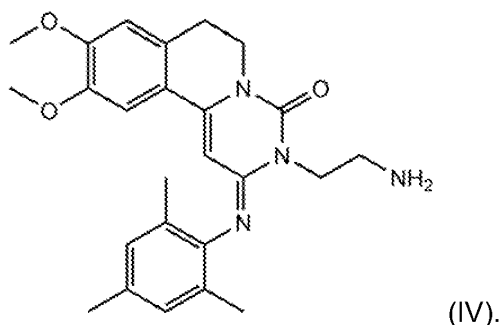
- from 0.00 wt% to 0.50 wt% of a biuret impurity of formula (A) relative to the total weight of ensifentrine:
- 20



The invention also provides a liquid pharmaceutical composition suitable for administration by inhalation comprising (a) the particulate composition and (b) a diluent.

Further provided by the invention is a process for producing the particulate composition, the process comprising: reacting a compound of formula (IV) with 4-nitrophenyl chloroformate and ammonia, wherein the compound of formula (IV), 4-nitrophenyl chloroformate and ammonia are reacted in a solvent comprising

5 dichloromethane,



Further provided herein, in some embodiments, are liquid pharmaceutical compositions, wherein the liquid pharmaceutical composition is a suspension comprising, relative to the total weight of the liquid pharmaceutical composition: (a)

10 1.2 mg/mL ensifentrine; (b) 0.5 mg/ml polysorbate 20; (c) 0.05 mg/ml sorbitan monolaurate; (d) 0.744 mg/ml sodium dihydrogen phosphate; (e) 0.853 mg/ml disodium hydrogen phosphate; (f) 8.6 mg/ml sodium chloride; and (g) water.

Further provided herein, in some embodiments, is a method of (a) treating moderate chronic obstructive pulmonary disease (COPD); (b) treating severe COPD; (c)

15 increasing trough lung function; or (d) reducing frequency of an exacerbation of COPD; in a human subject in need thereof, the method comprising administering to the human subject via inhalation the particulate composition or liquid pharmaceutical composition provided herein.

In some embodiments, provided herein is a kit comprising the particulate

20 composition provided herein or the liquid pharmaceutical composition provided herein.

DETAILED DESCRIPTION OF THE INVENTION

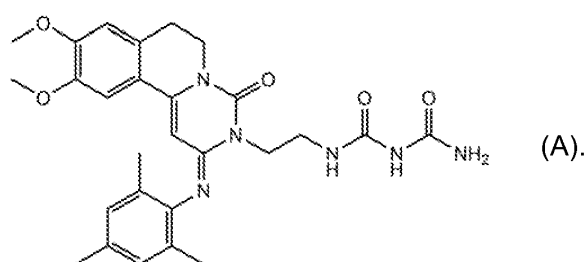
Particulate Composition

The invention provide a particulate composition comprising ensifentrine. The particulate composition is formed of particles comprising ensifentrine. The particulate composition is typically a powder comprising particles of ensifentrine. The particulate composition may be present in combination with a separate medium.

- 5 For instance, the particulate composition may be in the form of a powder comprising ensifentrine, which powder is dispersed in a diluent or which powder is combined with a second particulate composition (for instance a second particulate composition comprising a carrier such a lactose).

- 10 In some instances, the particulate compositions comprise no more than about 0.5 wt% (e.g., no more than about 0.45 wt%, 0.4 wt%, 0.36 wt%, 0.3 wt%, 0.25 wt%, 0.2 wt%, 0.15 wt%, or 0.1 wt%) of other related substances (e.g., substances other than ensifentrine). In some instances, the particulate compositions comprise at least about 0.01 wt% (e.g., at least about 0.02 wt%, 0.04 wt%, 0.08 wt%, 0.1 wt%, 0.12 wt%, 0.14 wt%, 0.18 wt%, 0.2 wt%, 0.25 wt%, 0.3 wt%, 0.35 wt%, 0.4 wt%, 0.45 wt%, or 0.5 wt%) of other related substances (e.g., substances other than ensifentrine). In some embodiments, the particulate compositions comprise from about 0 wt% to about 0.5 wt%, about 0.01 wt% to about 0.4 wt%, about 0.01 wt% to about 0.3 wt%, about 0.05 wt% to about 0.5 wt%, about 0.1 wt% to about 0.5 wt%, or about 0.1 wt% to about 0.4 wt% of other related substances (e.g., substances other than ensifentrine). In some embodiments, particulate compositions comprise about 0.01 wt%, 0.05 wt%, 0.1 wt%, 0.15 wt%, 0.2 wt%, 0.25 wt%, 0.3 wt%, 0.35 wt%, 0.4 wt%, 0.45 wt%, or about 0.5 wt% of other related substances (e.g., substances other than ensifentrine).

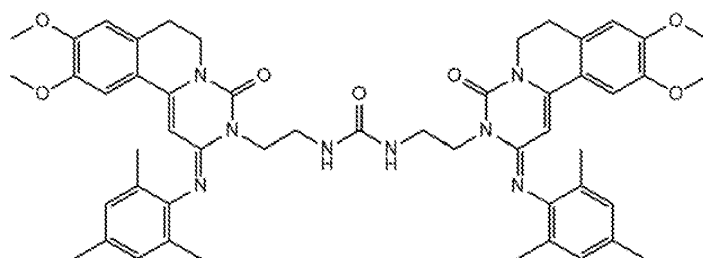
- 25 In addition to ensifentrine, the particulate composition further comprises: from greater than 0.00 wt% to 0.60 wt% of 1,3-bis(2-(2-(mesitylimino)-9,10-dimethoxy-4-oxo-6,7-dihydro-2H-pyrimido[6,1-a]isoquinolin-3(4H)-yl)ethyl)urea (BMIQU) relative to the total weight of ensifentrine; and from 0.00 wt% to 0.50 wt% of a biuret impurity of formula (A) relative to the total weight of ensifentrine:



- In some instances, the particulate compositions comprise a biuret impurity. In some embodiments, the biuret impurity comprises of formula (A). In some embodiments, the particulate compositions comprise from about 0 wt% to about 0.5 wt% of the biuret impurity of formula (A). In some embodiments, the particulate compositions
- 5 comprise at least 0.01 wt% (e.g., at least 0.01 wt%, 0.02 wt%, 0.03 wt%, 0.04 wt% 0.05 wt%, 0.1 wt%, 0.15 wt%, 0.2 wt%, 0.25 wt%, 0.3 wt%, 0.35 wt%, 0.4 wt%, 0.5 wt%) of the biuret impurity of formula (A). In some embodiments, the particulate compositions comprise at most 1 wt% (e.g., at most 0.9 wt%, 0.8 wt%, 0.7 wt%, 0.65 wt%, 0.6 wt%, 0.55 wt%, 0.5 wt%, or 0.4 wt%) of the biuret impurity of formula (A). In
- 10 some embodiments, the particulate compositions comprise from about 0 wt% to about 1 wt%, 0 wt% to about 0.04 wt%, about 0.01 wt% to about 0.5 wt%, 0.02 wt% to about 0.5 wt%, 0.05 wt% to about 0.5 wt%, 0.05 wt% to about 0.6 wt%, 0.05 wt% to about 0.8 wt%, 0.05 wt% to about 1.0 wt%, or about 0.1 wt% to about 0.5 wt% of the biuret impurity of formula (A). In some embodiments, the particulate
- 15 compositions comprise from about 0.01 wt% to about 0.1 wt% of the biuret impurity of formula (A). In some embodiments, the particulate compositions comprise about 0 wt%, 0.01 wt%, 0.02 wt%, 0.03 wt%, 0.04 wt% 0.05 wt%, 0.07 wt%, 0.1 wt%, 0.15 wt%, 0.2 wt%, 0.25 wt%, 0.3 wt%, 0.35 wt%, 0.4 wt%, 0.5 wt%, 0.6 wt%, 0.7 wt%, 0.8 wt%, 0.9 wt% or 1 wt% of the biuret impurity of formula (A).
- 20 The weight percentage is relative to the total weight of ensifentrine in the particulate composition. BMIQU and, if present, the biuret impurity are present in the particles comprising ensifentrine in the particulate composition. The content of BMIQU, the biuret impurity and other related substances or impurities may be as measured by high performance liquid chromatography (HPLC).
- 25 The particulate composition typically comprises from 0.00 wt% to 0.30 wt% of the biuret impurity relative to the total weight of ensifentrine. The particulate composition

may comprises from 0.00 wt% to 0.05 wt% of the biuret impurity relative to the total weight of ensifentrine. The particulate composition may, for instance, comprise from 0.00 wt% to 0.03 wt% of the biuret impurity relative to the total weight of ensifentrine.

The particulate composition may comprise at least 0.005 wt% BMIQU relative to the total weight of ensifentrine. The particulate composition typically comprises from 0.01 wt% to 0.30 wt% of BMIQU relative to the total weight of ensifentrine. The particulate composition may comprise from 0.30 wt% to 0.60 wt% of BMIQU relative to the total weight of ensifentrine. The particulate composition may comprise from 0.02 wt% to 0.06 wt% of BMIQU relative to the total weight of ensifentrine. The structure of BMIQU is shown below.

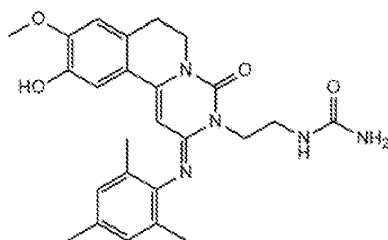


BMIQU

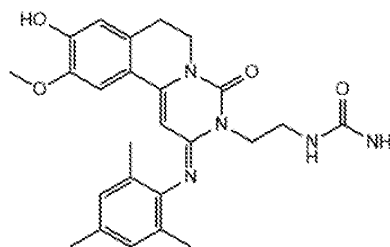
In some embodiments, the particulate composition comprises at least 0.01 wt% (e.g., at least 0.02 wt%, 0.04 wt%, 0.06 wt%, 0.1 wt%, 0.12 wt%, 0.15 wt%, 0.17 wt%, 0.2 wt%, 0.25 wt%, or 0.3 wt%) of BMIQU (e.g., relative to the total weight of ensifentrine). In some embodiments, the particulate composition comprises at most 0.5 wt% (e.g., at most 0.45 wt%, 0.4 wt%, 0.35 wt%, 0.3 wt%, 0.25 wt%, or 0.2 wt%) of BMIQU. In some embodiments, the particulate composition comprises from about 0 wt% to about 1 wt%, 0 wt% to about 0.5 wt%, about 0 wt% to about 0.4 wt%, about 0 wt% to about 0.3 wt%, about 0.01 wt% to about 0.3 wt%, about 0.01 wt% to about 0.2 wt%, 0.02 wt% to about 0.1 wt%, or about 0.01 wt% to about 0.1 wt%. In some embodiments, the particulate composition comprises about 0 wt%, 0.01 wt%, 0.02 wt%, 0.05 wt%, 0.07 wt%, 0.1 wt%, 0.15 wt%, 0.2 wt%, 0.25 wt%, or 0.3 wt% BMIQU. In some instances, the wt% is relative to the total weight of ensifentrine.

The particulate composition optionally further comprises 1-(2-(9-hydroxy-2-(mesitylimino)-10-methoxy-4-oxo-6,7-dihydro-2H-pyrimido[6,1-a]isoquinolin-3(4H)-

yl)ethyl)urea (9-des-methyl impurity) and/or 1-(2-(10-hydroxy-2-(mesitylimino)-9-methoxy-4-oxo-6,7-dihydro-2H-pyrimido[6,1-a]isoquinolin-3(4H)-yl)ethyl)urea (10-des-methyl impurity). The structures of these compounds are shown below.



10-des-methyl impurity



9-des-methyl impurity

- 5 The particulate composition typically further comprises: from greater than 0.00 wt% to 0.10 wt% of the 9-des-methyl impurity; and/or from greater than 0.00 wt% to 0.10 wt% of the 10-des-methyl impurity, relative to the total weight of ensifentrine. The particulate composition may further comprise from 0.01 wt% to 0.10 wt% of the 9-des-methyl impurity and from greater than 0.01 wt% to 0.10 wt% of the 10-des-methyl impurity, relative to the total weight of ensifentrine.
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In some instances, the particulate composition further comprises the 9-des-methyl impurity. In some embodiments, the particulate composition comprises from about 0 to about 0.1 wt% of the 9-des-methyl impurity. In some embodiments, the particulate composition comprises at least 0.01 wt% (e.g., at least 0.02 wt%, 0.03 wt%, 0.04 wt%, 0.05 wt%, 0.06 wt%, 0.07 wt%, 0.08 wt%, 0.09 wt%, 0.1 wt%, 0.15 wt%, or 0.2 wt%) of the 9-des-methyl impurity. In some embodiments, the particulate composition comprises at most 0.3 wt% (e.g., at most 0.28 wt%, 0.26 wt%, 0.24 wt%, 0.22 wt%, 0.2 wt%, 0.18 wt%, 0.15 wt%, or 0.1 wt%) the 9-des-methyl impurity. In some embodiments, the particulate composition comprises from about 0.01 wt% to about 0.3 wt%, 0.01 wt% to about 0.25 wt%, 0.01 wt% to about 0.2 wt%, 0.05 wt% to about 0.2 wt%, 0.01 wt% to about 0.1 wt%, or from about 0.1 wt% to about 0.2 wt% of the 9-des-methyl impurity. In some embodiments, the particulate composition comprises about 0 wt%, 0.01 wt%, 0.04 wt%, 0.06 wt%, 0.1 wt%, 0.12 wt%, 0.14 wt%, 0.16 wt%, 0.18 wt%, 0.2 wt%, 0.24 wt%, 0.28 wt%, or about 0.3 wt% of the 9-des-methyl impurity. In some embodiments, the particulate composition comprise less than about 1 wt% of the 9-des-methyl impurity.

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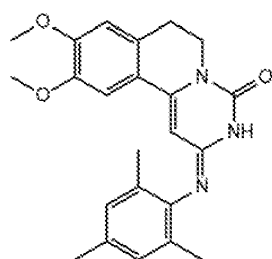
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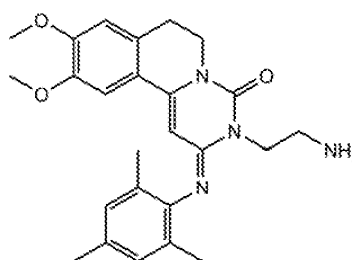
In some instances, the particulate composition further comprises the 10-des-methyl impurity. In some embodiments, the particulate composition comprises from about 0 to about 0.1 wt% of the 10-des-methyl impurity. In some embodiments, the particulate composition comprises at least 0.01 wt% (e.g., at least 0.02 wt%, 0.03 wt%, 0.04 wt%, 0.05 wt%, 0.06 wt%, 0.07 wt%, 0.08 wt%, 0.09 wt%, 0.1 wt%, 0.15 wt%, or 0.2 wt%) of the 10-des-methyl impurity. In some embodiments, the particulate composition comprises at most 0.3 wt% (e.g., at most 0.28 wt%, 0.26 wt%, 0.24 wt%, 0.22 wt%, 0.2 wt%, 0.18 wt%, 0.15 wt%, or 0.1 wt%) the 10-des-methyl impurity. In some embodiments, the particulate composition comprises from about 0.01 wt% to about 0.3 wt%, 0.01 wt% to about 0.25 wt%, 0.01 wt% to about 0.2 wt%, 0.01 wt% to about 0.1 wt%, 0.05 wt% to about 0.2 wt%, or from about 0.1 wt% to about 0.2 wt% of the 10-des-methyl impurity. In some embodiments, the particulate composition comprises about 0 wt%, 0.01 wt%, 0.04 wt%, 0.06 wt%, 0.1 wt%, 0.12 wt%, 0.14 wt%, 0.16 wt%, 0.18 wt%, 0.2 wt%, 0.24 wt%, 0.28 wt%, or about 0.3 wt% of the 10-des-methyl impurity. In some embodiments, the particulate composition comprise less than about 1 wt% of the 10-des-methyl impurity. For example, the particulate composition may comprise: from 0.01 to 0.04 wt% of 10-des-methyl impurity; from 0.05 to 0.09 wt% of the 9-des-methyl impurity; from 0.01 to 0.03 wt% of the biuret impurity; and from 0.02 to 0.06 wt% of BMIQU, wherein the wt% is relative to the total weight of ensifentrine in the particulate composition.

In some embodiments, the particulate composition may comprise: from 0.01 to 0.4 wt% of 10-des-methyl impurity; from 0.05 to 0.9 wt% of the 9-des-methyl impurity; from 0.01 to 0.5 wt% of the biuret impurity; and from 0.02 to 0.6 wt% of BMIQU, wherein the wt% is relative to the total weight of ensifentrine in the particulate composition.

The particulate composition may further comprise (E)-2-(mesitylimino)-9,10-dimethoxy-2,3,6,7-tetrahydro-4H-pyrimido[6,1-a]isoquinolin-4-one (compound (I)) and/or (E)-3-(2-aminoethyl)-2-(mesitylimino)-9,10-dimethoxy-2,3,6,7-tetrahydro-4H-pyrimido[6,1-a]isoquinolin-4-one (compound (IV)), the structures of which are shown below. The particulate composition typically comprises neither compound (I) nor compound (IV), or the particulate composition comprises less than 0.04 wt% total of compound (I) and compound (IV) relative to the total weight of ensifentrine.



compound (I)



compound (IV)

In some instances, the particulate composition comprises compound (I). In some embodiments, the particulate composition comprises from about 0 to about 0.1 wt% of compound (I). In some embodiments, the particulate composition comprises at least 0.01 wt% (e.g., at least 0.02 wt%, 0.03 wt%, 0.04 wt%, 0.05 wt%, 0.06 wt%, 0.07 wt%, 0.08 wt%, 0.09 wt%, 0.1 wt%, 0.15 wt%, or 0.2 wt%) of compound (I). In some embodiments, the particulate composition comprises at most 0.3 wt% (e.g., at most 0.28 wt%, 0.26 wt%, 0.24 wt%, 0.22 wt%, 0.2 wt%, 0.18 wt%, 0.15 wt%, or 0.1 wt%) compound (I). In some embodiments, the particulate composition comprises from about 0.01 wt% to about 0.3 wt%, 0.01 wt% to about 0.25 wt%, 0.01 wt% to about 0.2 wt%, 0.01 wt% to about 0.1 wt%, 0.05 wt% to about 0.2 wt%, or from about 0.1 wt% to about 0.2 wt% of compound (I). In some embodiments, the particulate composition comprises about 0 wt%, 0.01 wt%, 0.04 wt%, 0.06 wt%, 0.1 wt%, 0.12 wt%, 0.14 wt%, 0.16 wt%, 0.18 wt%, 0.2 wt%, 0.24 wt%, 0.28 wt%, or about 0.3 wt% of compound (I). In some embodiments, the particulate composition comprises less than about 1 wt% of compound (I).

In some instances, the particulate composition comprises compound (IV). In some embodiments, the particulate composition comprises from about 0 to about 0.1 wt% of compound (IV). In some embodiments, the particulate composition comprises at least 0.01 wt% (e.g., at least 0.02 wt%, 0.03 wt%, 0.04 wt%, 0.05 wt%, 0.06 wt%, 0.07 wt%, 0.08 wt%, 0.09 wt%, 0.1 wt%, 0.15 wt%, or 0.2 wt%) of compound (IV). In some embodiments, the particulate composition comprises at most 0.3 wt% (e.g., at most 0.28 wt%, 0.26 wt%, 0.24 wt%, 0.22 wt%, 0.2 wt%, 0.18 wt%, 0.15 wt%, or 0.1 wt%) compound (IV). In some embodiments, the particulate composition comprises from about 0.01 wt% to about 0.3 wt%, 0.01 wt% to about 0.25 wt%, 0.01 wt% to about 0.2 wt%, 0.01 wt% to about 0.1 wt%, 0.05 wt% to about 0.2 wt%, or from about 0.1 wt% to about 0.2 wt% of compound (IV). In some embodiments, the

particulate composition comprises about 0 wt%, 0.01 wt%, 0.04 wt%, 0.06 wt%, 0.1 wt%, 0.12 wt%, 0.14 wt%, 0.16 wt%, 0.18 wt%, 0.2 wt%, 0.24 wt%, 0.28 wt%, or about 0.3 wt% of compound (IV). In some embodiments, the particulate composition comprises less than about 1 wt% of compound (IV).

- 5 One or more of the compounds BMIQU, biuret impurity, 9-des-methyl impurity, 10-des-methyl impurity, compound (I) and compound (IV), if present, may optionally be present in the form of salts. Typically, BMIQU, biuret impurity, 9-des-methyl impurity, 10-des-methyl impurity, compound (I) and compound (IV) are present in free base form.
- 10 In some embodiments, the particulate composition comprises less than 15000 ppm (e.g., less than 10000 ppm, 5000 ppm, or 2500 ppm) of residual organic solvents. In some embodiments, the particulate composition comprises from 100 ppm to 15000 ppm (e.g., from 500 ppm to 15000 ppm, from 1000 ppm to 15000 ppm, from 1000 ppm to 10000 ppm, or from 5000 ppm to 15000 ppm) of residual organic solvents.
- 15 In some embodiments, the residual organic solvent is an organic solvent leftover from the methods of preparing ensifentrine. In some embodiments, the residual organic solvent is selected from acetone, acetonitrile, dichloromethane, methanol, toluene, tetrahydrofuran, dimethyl sulfoxide, or a combination thereof. In some embodiments, the residual organic solvent comprises a combination of acetone,
- 20 acetonitrile, dichloromethane, methanol, toluene, tetrahydrofuran, and dimethyl sulfoxide, such as in amounts described herein.

In some embodiments, the amount of residual organic solvent is determined from gas chromatography.

- In some embodiments, the residual organic solvent is acetone. In some
- 25 embodiments, the acetone is present in the particulate composition in an amount of less than 5000 ppm (e.g., less than 3500 ppm, 3000 ppm, 2500 ppm, 2000 ppm, 1500 ppm, or 1000 ppm). In some embodiments, the acetone is present in the particulate composition in an amount of from about 100 ppm to 5000 ppm (e.g., from 500 ppm to 5000 ppm, from 1000 ppm to 5000 ppm, or from 500 ppm to 4000 ppm).

In some embodiments, the residual organic solvent is acetonitrile. In some
embodiments, the acetonitrile is present in the particulate composition in an amount
of less than 410 ppm (e.g., less than 400 ppm, 350 ppm, 300 ppm, 250 ppm, 200
ppm, 150 ppm, or 100 ppm). In some embodiments, the acetonitrile is present in the
5 particulate composition in an amount of from 100 ppm to 410 ppm (e.g., from 100
ppm to 350 ppm, from 200 ppm to 410 ppm, or from 300 ppm to 400 ppm).

In some embodiments, the residual organic solvent is dichloromethane. In some
embodiments, the dichloromethane is present in the particulate composition in an
amount of less than 5000 ppm (e.g., less than 3500 ppm, 3000 ppm, 2500 ppm,
10 2000 ppm, 1500 ppm, or 1000 ppm). In some embodiments, the dichloromethane is
present in the particulate composition in an amount of from about 100 ppm to 5000
ppm (e.g., from 500 ppm to 5000 ppm, from 1000 ppm to 5000 ppm, or from 500
ppm to 4000 ppm).

In some embodiments, the residual organic solvent is methanol. In some
15 embodiments, the methanol is present in the particulate composition at an amount of
less than 3000 ppm (e.g., less than 2500 ppm, 2000 ppm, 1500 ppm, 1000 ppm, or
500 ppm). In some embodiments, the methanol is present in the particulate
composition at an amount of from 500 ppm to 3000 ppm (e.g., 1000 ppm to 3000
ppm, 1500 ppm to 3000 ppm, or from 2000 ppm to 3000 ppm).

20 In some embodiments, the residual organic solvent is toluene. In some
embodiments, the toluene is present in the particulate composition in an amount of
less than 5000 ppm (e.g., less than 3500 ppm, 3000 ppm, 2500 ppm, 2000 ppm,
1500 ppm, or 1000 ppm). In some embodiments, the toluene is present in the
particulate composition in an amount of from about 100 ppm to 5000 ppm (e.g., from
25 500 ppm to 5000 ppm, from 1000 ppm to 5000 ppm, or from 500 ppm to 4000 ppm).

In some embodiments, the residual organic solvent is tetrahydrofuran. In some
embodiments, the tetrahydrofuran is present in the particulate composition in an
amount of less than 720 ppm (e.g., less than 700 ppm, 650 ppm, 600 ppm, 550 ppm,
500 ppm, 450 ppm, or 400 ppm). In some embodiments, the tetrahydrofuran is
30 present in the particulate composition in an amount of from 250 ppm to 720 ppm

(e.g., from 400 ppm to 720 ppm, from 500 ppm to 720 ppm, or from 600 ppm to 720 ppm).

In some embodiments, the residual organic solvent is dimethyl sulfoxide. In some embodiments, the dimethyl sulfoxide is present in the particulate composition in an amount of less than 5000 ppm (e.g., less than 3500 ppm, 3000 ppm, 2500 ppm, 2000 ppm, 1500 ppm, or 1000 ppm). In some embodiments, the dimethyl sulfoxide is present in the particulate composition in an amount of from about 100 ppm to 5000 ppm (e.g., from 500 ppm to 5000 ppm, from 1000 ppm to 5000 ppm, or from 500 ppm to 4000 ppm).

10 In some embodiments, the particulate composition comprises less than 5000 ppm acetone, less than 410 ppm acetonitrile, less than 5000 ppm dichloromethane, less than 3000 ppm methanol, less than less than 5000 pp toluene, less than 720 ppm tetrahydrofuran, and less than 5000 ppm dimethyl sulfoxide.

In some embodiments, the particulate compositions comprise one or more elemental impurities. In some embodiments, the elemental impurities are selected from nickel, arsenic, lead, cadmium, mercury, lithium, or any combination thereof.

15 In some embodiments, the elemental impurity is nickel. In some embodiments, the nickel is present in the particulate composition at an about of less than 200 ppm (e.g., less than 175 ppm, 150 ppm, 125 ppm, or 100 ppm).

20 In some embodiments, the elemental impurity is arsenic. In some embodiments, the arsenic is present in the particulate composition in an amount of less than 0.2 ppm (e.g., less than 0.17 ppm, 0.15 ppm, 0.13 ppm, 0.1 ppm, or less than 0.05 ppm).

In some embodiments, the elemental impurity is lead. In some embodiments, the lead is present in the particulate compositions in an amount of less than 0.5 ppm (e.g., less than 0.4 ppm, 0.3 ppm, 0.25 ppm, 0.2 ppm, 0.1 ppm, or 0.05 ppm).

25 In some embodiments, the elemental impurity is cadmium. In some embodiments, the cadmium is present in the particulate composition in an amount of less than 0.2 ppm (e.g., less than 0.17 ppm, 0.15 ppm, 0.13 ppm, 0.1 ppm, or less than 0.05 ppm).

In some embodiments, the elemental impurity is mercury. In some embodiments, the mercury is present in the particulate composition in an amount of less than 0.1 ppm (e.g., less than 0.08 ppm, 0.06 ppm, 0.05 ppm, 0.04 ppm, or 0.02 ppm).

- 5 In some embodiments, the elemental impurity is lithium. In some embodiments, the lithium is present in the particulate composition at an amount of less than 200 ppm (e.g., less than 175 ppm, 150 ppm, 125 ppm, or 100 ppm).

In some embodiments, the particulate composition comprises less than 200 ppm nickel, less than 0.2 ppm arsenic, less than 0.5 ppm lead, less than 0.2 ppm cadmium, less than 0.1 ppm mercury, and less than 200 ppm lithium.

- 10 The particulate composition typically comprises at least 98.0 wt% of ensifentrine relative to the total weight of the particulate composition. The particulate composition may comprise at least 99.0 wt% of ensifentrine relative to the total weight of the particulate composition, or at least 99.2 wt% of ensifentrine relative to the total weight of the particulate composition.
- 15 In some embodiments, the particulate compositions comprise at least 98 wt% (e.g., at least 98.5 wt%, 98.9 wt%, 99 wt%, 99.2 wt%, 99.4 wt%, 99.6 wt%, 99.8 wt%, or 99.9 wt%) of ensifentrine relative to the total weight of the particulate composition. In some embodiments, the particulate compositions comprise from about 95 wt% to about 99.9 wt%, about 96 wt% to about 99.9 wt%, about 97 wt% to about 99.5 wt%,
20 97 wt% to about 99 wt%, or about 98 wt% to about 99.9 wt% of ensifentrine relative to the total weight of the particulate composition.

The ensifentrine in the particulate composition is ensifentrine free base. In an alternative embodiment, the particulate composition comprises a pharmaceutically acceptable salt of ensifentrine.

- 25 The ensifentrine is typically in crystalline form. Of the ensifentrine present in the particulate composition, typically at least 90 wt% is in the form of ensifentrine free base Form I. Ensifentrine free base Form I is a crystalline polymorph of ensifentrine (crystalline polymorph Form I) which typically has a powder X-ray diffraction pattern comprising characteristic peaks at 10.1° and $12.9^\circ \pm 0.1^\circ 2\theta$. As stated herein,
30 values of 2θ are typically as measured using an X-ray wavelength of $\text{CuK}\alpha$ radiation

($\lambda = 1.5406 \text{ \AA}$). The powder X-ray diffraction pattern of Form I typically further comprises characteristic peaks at 15.3° and $17.6^\circ \pm 0.1^\circ 2\theta$. Form I of ensifentrine may have a powder X-ray diffraction pattern comprising at least 5 characteristic peaks selected from 6.4° , 10.1° , 12.6° , 12.9° , 13.6° , 14.2° , 14.7° , 15.3° , 15.4° ,
5 15.8° , 17.0° , 17.6° , 18.9° , 20.9° , 22.4° , 22.8° and $28.7^\circ \pm 0.1^\circ 2\theta$. Crystalline polymorph Form I typically has a differential scanning calorimetry trace showing a maximum at 248°C .

The particulate composition typically comprises at least 98.0 wt% or at least 99.0 wt% of ensifentrine crystalline polymorph Form I relative to the total weight of the
10 particulate composition.

In some embodiments, the particulate compositions comprise at least 98 wt% (e.g., at least 98.5 wt%, 98.9 wt%, 99 wt%, 99.2 wt%, 99.4 wt%, 99.6 wt%, 99.8 wt%, or 99.9 wt%) of ensifentrine crystalline polymorph Form I relative to the total weight of the particulate composition. In some embodiments, the particulate compositions
15 comprise from about 95 wt% to about 99.9 wt%, about 96 wt% to about 99.9 wt%, about 97 wt% to about 99.5 wt%, 97 wt% to about 99 wt%, or about 98 wt% to about 99.9 wt% of ensifentrine crystalline polymorph Form I relative to the total weight of the particulate composition.

Typically the particulate composition comprises:
20 from 99.4 to 99.9 wt% of ensifentrine;
from 0.01 wt% to 0.30 wt% of BMIQU;
from 0.00 wt% to 0.10 wt% of the biuret impurity;
from 0.01 wt% to 0.20 wt% of the 9-des-methyl impurity; and
from 0.01 wt% to 0.20 wt% of the 10-des-methyl impurity,
25 wherein the wt% is relative to the total weight of the particulate composition.

The particulate composition may comprise:
from 99.5 to 99.9 wt% of ensifentrine;
from 0.02 wt% to 0.10 wt% of BMIQU;
from 0.00 wt% to 0.04 wt% of the biuret impurity;
30 from 0.01 wt% to 0.10 wt% of the 9-des-methyl impurity; and
from 0.01 wt% to 0.10 wt% of the 10-des-methyl impurity,

wherein the wt% is relative to the total weight of the particulate composition.

For instance, the particulate composition may consist of:

- from 99.6 to 99.9 wt% of ensifentrine;
- from 0.02 wt% to 0.10 wt% of BMIQU;
- 5 from 0.00 wt% to 0.04 wt% of the biuret impurity;
- from 0.01 wt% to 0.10 wt% of the 9-des-methyl impurity;
- from 0.01 wt% to 0.10 wt% of the 10-des-methyl impurity; and
- no greater than 0.36 wt% total of other related substances,

wherein the wt% is relative to the total weight of the particulate composition.

- 10 The particulate composition comprises particles comprising ensifentrine and the additional impurity compounds defined above. The particulate composition typically comprises particles of respirable size. The particulate composition typically has a Dv50 of from about 0.2 to about 5.0 μm . The particulate composition may have a Dv50 of from about 1.0 μm to about 2.2 μm .
- 15 The particulate composition may have a Dv50 of at least 0.1 μm (e.g., at least 0.2 μm , 0.3 μm , 0.5 μm , 0.8 μm , 1 μm , 1.3 μm , 1.5 μm , 1.8 μm , 2 μm , 2.2 μm , 2.5 μm , 3 μm , 3.5 μm , or 4 μm). The particulate composition may have a Dv50 of at most 6 μm (e.g., at most 5.8 μm , 5.5 μm , 5.3 μm , 5.2 μm , 5.1 μm , 5 μm , or 4.5 μm).

The particulate composition may have a Dv10 of from about 0.2 μm to about 1 μm .

- 20 The particulate composition may have a Dv10 of at least 0.1 μm (e.g., 0.15 μm , 0.18 μm , 0.2 μm , 0.4 μm , 0.6 μm , 0.8 μm , or 1 μm). The particulate composition may have a Dv10 of at most 1.3 μm (e.g., at most 1.2 μm , 1.1 μm , 1 μm , 0.95 μm , or 0.9 μm).

The particulate composition may have a Dv90 of at least 1.7 μm (e.g., at least 1.8

- 25 μm , 1.9 μm , 2 μm , 2.1 μm , 2.2 μm , 2.3 μm , or 2.4 μm). The particulate composition may have a Dv90 of at most 5.5 μm (e.g., at most 5.4 μm , 5.2 μm , 5 μm , 4.8 μm , 4.6 μm , 4.5 μm , or 4.4 μm).

The particulate composition typically has a Dv10 of from about 0.3 μm to about 0.9 μm and/or a Dv90 of from about 2.3 μm to about 4.5 μm . The particulate

- 30 composition typically may have a Dv50 of from about 1.0 μm to about 2.2 μm , a

Dv10 of from about 0.3 μm to about 0.9 μm , and a Dv90 of from about 2.3 μm to about 4.5 μm

The technique used to measure the Dv50 (and Dv10 and Dv90) values as stated herein is typically laser diffraction. The particle size distribution of the particulate composition may be as measured by laser diffraction using a wet powder dispersion system. For instance, the particle size distribution can be measured by laser diffraction using a Malvern Spraytec in conjunction with a wet dispersion cell. Typically, the instrument parameters for the Malvern Spraytec are as follows:

- particle – standard opaque particle;
- refractive index Particle – 1.50;
- refractive index (imaginary) – 0.50;
- density of particle – 1.00;
- refractive index of dispersant – 1.33;
- controller unit – 1000RPM;
- measurement type – timed;
- initial sampling time – 30s;
- obscuration – 20% - 30%;
- dispersant – 1% Polysorbate 20 in deionised water.

The particulate composition may be produced by any pharmaceutically acceptable size reduction process or particle size controlled production process. For instance, the particles may be produced by size reduction of a solid form of ensifentrine, for example by air jet milling, mechanical micronisation or media milling, or by precipitation from a solution of ensifentrine. The invention also provides a solid form of ensifentrine having a composition as described for the particulate composition above (i.e. comprising ensifentrine and one or more of the stated impurity compounds), which solid form is in the form of a filter cake, a pellet, a block, a layer or a crystal.

Pharmaceutical Composition

The invention also provides a pharmaceutical composition comprising the particulate composition. The pharmaceutical composition may be a dry powder suitable for

administration comprising the particulate composition and a carrier. The carrier may for instance be lactose powder.

Typically, the pharmaceutical composition is a liquid pharmaceutical composition suitable for administration by inhalation comprising (a) the particulate composition
5 and (b) a diluent. The particulate composition is typically suspended in the diluent.

The pharmaceutical composition may comprise any of the related substances (e.g., substances other than ensifentrine) described hereinabove and in the amounts described hereinabove. In some embodiments, the related substances comprise BMIQU, the biuret impurity of formula (A), the 9-des-methyl impurity, and the 10-des-
10 methyl impurity.

The pharmaceutical composition typically comprises no more than 1.00 wt % of BMIQU relative to the total weight of ensifentrine in the pharmaceutical composition. For instance, the liquid pharmaceutical composition may comprise no more than 0.50 wt % or no more than 0.20 wt% of BMIQU relative to the total weight of
15 ensifentrine.

The pharmaceutical composition may comprise no more than 0.10 wt%, or no more than 0.05 wt%, of the biuret impurity relative to the total weight of ensifentrine in the pharmaceutical composition.

In some embodiments, the pharmaceutical compositions provided herein further
20 comprise one or more tonicity adjusters, one or more buffers, and one or more surfactants. In some embodiments, the pharmaceutical composition further comprises one or more tonicity adjusters. In some embodiments, the pharmaceutical composition further comprises one or more buffers. In some embodiments, the pharmaceutical composition further comprises one or more surfactants.

25 In some embodiments, the pharmaceutical compositions provided herein further comprise one or more tonicity adjusters. In some embodiments, the tonicity adjuster comprises sodium chloride. In some embodiments, the tonicity adjuster (e.g., sodium chloride) is present in the pharmaceutical composition at a concentration of at least 1 mg/mL (e.g., 2 mg/mL, 3 mg/mL, 4 mg/mL, 5 mg/mL, 6 mg/mL, 7 mg/mL). In some
30 embodiments, the tonicity adjuster (e.g., sodium chloride) is present in the

pharmaceutical composition at a concentration of at most 15 mg/mL (e.g., 14 mg/mL, 13 mg/mL, 12 mg/mL, 11 mg/mL, 10 mg/mL, 9 mg/mL). In some embodiments, the tonicity adjuster (e.g., sodium chloride) is present in the pharmaceutical composition at a concentration of from about 1 mg/mL to about 15 mg/mL, about 3 mg/mL to about 10 mg/mL, about 4 mg/mL to about 10 mg/mL, about 5 mg/mL to about 11 mg/mL, about 5 mg/mL to about 9 mg/mL, or about 6 mg/mL to about 9 mg/mL. In some embodiments, the tonicity adjuster (e.g., sodium chloride) is present in the pharmaceutical composition at a concentration of about 7 mg/mL to about 10 mg/mL. In some embodiments, the tonicity adjuster (e.g., sodium chloride) is present in the pharmaceutical composition at a concentration of 8 mg/mL to 9 mg/mL. In certain embodiments, the tonicity adjuster (e.g., sodium chloride) is present in the pharmaceutical composition at a concentration of (e.g., about) 8.6 mg/mL.

In some embodiments, the pharmaceutical compositions provided herein further comprise one or more buffers. In some embodiments, the buffer (e.g., sodium dihydrogen phosphate dihydrate and/or disodium hydrogen phosphate dihydrate) is present in the pharmaceutical composition at a concentration of at least 0.1 mg/mL (e.g., 0.2 mg/mL, 0.4 mg/mL, 0.8 mg/mL, 1 mg/mL, or 1.4 mg/mL). In some embodiments, the buffer (e.g., sodium dihydrogen phosphate dihydrate and/or disodium hydrogen phosphate dihydrate) is present in the pharmaceutical composition at a concentration of 4 mg/mL (e.g., 3.8 mg/mL, 3.3 mg/mL, 2.8 mg/mL, 2.5 mg/mL, or 2 mg/mL). In some embodiments, the buffer (e.g., sodium dihydrogen phosphate dihydrate and/or disodium hydrogen phosphate dihydrate) is present in the pharmaceutical composition at a concentration of about 1 mg/mL to about 2 mg/mL, about 1.2 mg/mL to about 1.8 mg/mL, or about 1.4 mg/mL to about 1.7 mg/mL. In some embodiments, the buffer (e.g., sodium dihydrogen phosphate dihydrate and/or disodium hydrogen phosphate dihydrate) is present in the pharmaceutical composition at a concentration of about 1.5 mg/mL to about 1.7 mg/mL.

In some embodiments, the pharmaceutical composition comprises sodium dihydrogen phosphate dihydrate at a concentration of at least 0.1 mg/mL (e.g., 0.2 mg/mL, 0.3 mg/mL, 0.4 mg/mL, 0.5 mg/mL, 0.6 mg/mL). In some embodiments, the pharmaceutical composition comprises sodium dihydrogen phosphate dihydrate at a

- concentration of at most 1.2 mg/mL (e.g., 1.1 mg/mL, 1.0 mg/mL, 0.9 mg/mL, 0.8 mg/mL). In some embodiments, the pharmaceutical composition comprises sodium dihydrogen phosphate dihydrate at a concentration of from about 0.5 mg/mL to about 0.9 mg/mL. In some embodiments, the pharmaceutical composition comprises
- 5 sodium dihydrogen phosphate dihydrate at a concentration of about 0.7 mg/mL to about 0.8 mg/mL. In some embodiments, the pharmaceutical composition comprises sodium dihydrogen phosphate dihydrate at a concentration of about 0.7 mg/mL. In certain embodiments, the pharmaceutical composition comprises sodium dihydrogen phosphate dihydrate at a concentration of (e.g., about) 0.744 mg/mL.
- 10 In some embodiments, the pharmaceutical composition comprises disodium hydrogen phosphate dihydrate at a concentration of at least 0.1 mg/mL (e.g., 0.2 mg/mL, 0.3 mg/mL, 0.4 mg/mL, 0.5 mg/mL, 0.6 mg/mL, 0.7 mg/mL). In some embodiments, the pharmaceutical composition comprises disodium hydrogen phosphate dihydrate at a concentration of at most 1.2 mg/mL (e.g., 1.1 mg/mL, 1.0
- 15 mg/mL, 0.9 mg/mL). In some embodiments, the pharmaceutical composition comprises disodium hydrogen phosphate dihydrate at a concentration of from about 0.7 mg/mL to about 1 mg/mL. In some embodiments, the pharmaceutical composition comprises disodium hydrogen phosphate dihydrate at a concentration of about 0.8 mg/mL to about 0.9 mg/mL. In some embodiments, the pharmaceutical
- 20 composition comprises disodium hydrogen phosphate dihydrate at a concentration of about 0.8 mg/mL. In some embodiments, the pharmaceutical composition comprises disodium hydrogen phosphate dihydrate at a concentration of about 0.9 mg/mL. In certain embodiments, the pharmaceutical composition comprises disodium hydrogen phosphate dihydrate at a concentration of (e.g., about) 0.853 mg/mL.
- 25 In some embodiments, the pharmaceutical composition comprises the one or more surfactants (e.g., polysorbate 20 and/or sorbitan monolaurate) in a concentration of at least 0.05 mg/mL (e.g., 0.1 mg/mL, 0.2 mg/mL, 0.3 mg/mL, 0.4 mg/mL). In some embodiments, the pharmaceutical composition comprises the one or more surfactants (e.g., polysorbate 20 and/or sorbitan monolaurate) in a concentration of
- 30 at most 1 mg/mL (e.g., 0.9 mg/mL, 0.8 mg/mL, 0.7 mg/mL, 0.6 mg/mL). In some embodiments, the pharmaceutical composition comprises the one or more surfactants (e.g., polysorbate 20 and/or sorbitan monolaurate) in a concentration of

from about 0.3 mg/mL to about 0.7 mg/mL. In some embodiments, the pharmaceutical composition comprises the one or more surfactants (e.g., polysorbate 20 and/or sorbitan monolaurate) at a concentration of from about 0.01 mg/mL to 2 mg/mL. In some embodiments, the pharmaceutical composition

5 comprises the one or more surfactants (e.g., polysorbate 20 and/or sorbitan monolaurate) in a concentration of from about 0.4 mg/mL to about 0.6 mg/mL. In some embodiments, the pharmaceutical composition comprises the one or more surfactants (e.g., polysorbate 20 and/or sorbitan monolaurate) at a concentration of about 0.5 mg/mL. In some embodiments, the pharmaceutical composition comprises

10 the one or more surfactants (e.g., polysorbate 20 and/or sorbitan monolaurate) at a concentration of about 0.6 mg/mL. In certain embodiments, the pharmaceutical composition comprises the one or more surfactants (e.g., polysorbate 20 and/or sorbitan monolaurate) in a concentration of (e.g., about) 0.55 mg/mL.

In some embodiments, the pharmaceutical composition comprises polysorbate 20

15 (e.g., Tween 20) in a concentration of at least 0.1 mg/mL (e.g., 0.2 mg/mL, 0.3 mg/mL, 0.4 mg/mL). In some embodiments, the pharmaceutical composition comprises polysorbate 20 (e.g., Tween 20) in a concentration of at most 1 mg/mL (e.g., 0.9 mg/mL, 0.8 mg/mL, 0.7 mg/mL, 0.6 mg/mL). In some embodiments, the pharmaceutical composition comprises polysorbate 20 (e.g., Tween 20) in a

20 concentration of from about 0.3 mg/mL to about 0.7 mg/mL. In some embodiments, the pharmaceutical composition comprises polysorbate 20 (e.g., Tween 20) in a concentration of about 0.4 mg/mL to about 0.6 mg/mL. In certain embodiments, the pharmaceutical composition comprises polysorbate 20 (e.g., Tween 20) in a concentration of about 0.5 mg/mL.

25 In some embodiments, the pharmaceutical composition comprises sorbitan monolaurate (Span 20) in a concentration of at least 0.01 mg/mL (e.g., 0.02 mg/mL, 0.03 mg/mL, 0.04 mg/mL). In some embodiments, the pharmaceutical composition comprises sorbitan monolaurate (Span 20) in a concentration of at most 0.1 mg/mL (e.g., 0.09 mg/mL, 0.08 mg/mL, 0.07 mg/mL, 0.06 mg/mL). In some embodiments,

30 the pharmaceutical composition comprises sorbitan monolaurate (Span 20) in a concentration of from about 0.03 mg/mL to about 0.07 mg/mL. In some embodiments, the pharmaceutical composition comprises sorbitan monolaurate

(Span 20) in a concentration of from about 0.04 mg/mL to about 0.06 mg/mL. In certain embodiments, the pharmaceutical composition comprises sorbitan monolaurate (Span 20) in a concentration of (e.g., about) 0.05 mg/mL.

- 5 The liquid pharmaceutical composition typically comprises, relative to the total weight of the liquid pharmaceutical composition: (i) the particulate composition at a concentration of from 0.8 to 1.6 mg/mL; (ii) one or more surfactants at a total concentration of from 0.1 to 1.0 mg/mL; (iii) one or more buffers at a total concentration of from 1.0 to 2.0 mg/mL; and (iv) water. The liquid pharmaceutical composition optionally further comprises a tonicity adjuster, which may have a concentration of from 1.0 to 20.0 mg/mL, or from 7.0 to 10.0 mg/mL. The tonicity adjuster may be sodium chloride.

- The liquid pharmaceutical composition may comprise, relative to the total weight of the liquid pharmaceutical composition: (i) the particulate composition at a concentration of from 1.0 to 1.4 mg/mL, which particulate composition has a Dv50 of from about 1.0 μm to about 2.2 μm and optionally has a Dv10 of from about 0.3 μm to about 0.9 μm and a Dv90 of from about 2.3 μm to about 4.5 μm ; (ii) one or more surfactants at a total concentration of from 0.4 to 0.7 mg/mL; (iii) one or more buffers at a total concentration of from 1.4 to 1.8 mg/mL; (iv) water; and (v) a tonicity adjuster at a concentration from 7.0 to 10.0 mg/mL.

The liquid pharmaceutical composition may comprise at least 95 wt% or at least 99 wt % of (i), (ii), (iii), (iv) and optionally (v) relative to the total weight of the liquid pharmaceutical composition.

- Examples of buffers include a citrate buffer, a phosphate buffer, an acetate buffer, and a bicarbonate buffer. Preferably, the one or more buffers comprise a phosphate buffer, for instance sodium dihydrogen phosphate dihydrate and/or disodium phosphate dihydrate.

- Examples of surfactants include lecithin, oleic acid, polyoxyethylene glycol alkyl ethers (for instance PEG 300, PEG 600, PEG 1000, Brij 30, Brij 35, Brij 56, Brij 76 and Brij 97), polypropylene glycol (for instance PPG 2000), glucoside alkyl ethers,

polyoxyethylene glycol octylphenol ethers, polyoxyethylene glycol alkylphenol ethers, glycerol alkyl esters, polyoxyethylene glycol sorbitan alkyl esters (polysorbates, for instance polysorbate 20, polysorbate 40, polysorbate 60 and polysorbate 80), sorbitan alkyl esters (for instance sorbitan monolaurate (Span 20), sorbitan monooleate (Span 80) and sorbitan trioleate (Span 85)), cocamide MEA, cocamide DEA, dodecyldimethylamine oxide, block copolymers of polyethylene glycol and polypropylene glycol (poloxamers), block copolymers of polyethylene glycol and polypropylene oxide (for instance Pluronic surfactants), polyvinyl pyrrolidone K25, polyvinyl alcohol, oligolactic acid, sodium dioctyl sulfosuccinate and polyethoxylated tallow amine (POEA).

Preferably, the one or more surfactants comprise a polysorbate and/or a sorbitan alkyl ester. The one or more surfactants may for instance comprise polysorbate 20 (polyoxyethylene (20) sorbitan monolaurate), polysorbate 40 (polyoxyethylene (20) sorbitan monopalmitate), polysorbate 60 (polyoxyethylene (20) sorbitan monostearate) or polysorbate 80 (polyoxyethylene (20) sorbitan monooleate). The one or more surfactants may for instance comprise sorbitan monolaurate (Span 20), sorbitan monooleate (Span 80) or sorbitan trioleate (Span 85). Preferably, the one or more buffers comprise polysorbate 20 (Tween 20) and/or sorbitan monolaurate (Span 20).

The liquid pharmaceutical composition may comprise, relative to the total weight of the liquid pharmaceutical composition: (i) the particulate composition at a concentration of from 1.0 to 1.4 mg/mL, which particulate composition have a Dv50 of from about 1.0 μm to about 2.2 μm and optionally have a Dv10 of from about 0.3 μm to about 0.9 μm and a Dv90 of from about 2.3 μm to about 4.5 μm ; (ii) one or more surfactants at a total concentration of from 0.4 to 0.7 mg/mL, which one or more surfactants are selected from a polysorbate and/or a sorbitan alkyl ester; (iii) one or more buffers at a total concentration of from 1.4 to 1.8 mg/mL, which one or more buffers are selected from phosphate buffers; (iv) water; and (v) sodium chloride at a concentration from 7.0 to 10.0 mg/mL.

The liquid pharmaceutical composition may for example comprise, relative to the total weight of the liquid pharmaceutical composition:

- the particulate composition at a concentration of from 1.0 to 1.4 mg/mL;

- polysorbate 20 (Tween 20) at a concentration of 0.3 to 0.7 mg/mL;
- sorbitan monolaurate (Span 20) at a concentration of 0.0 to 0.1 mg/mL;
- sodium dihydrogen phosphate dihydrate at a concentration of 0.5 to 1.0 mg/mL;
- 5 - disodium hydrogen phosphate dihydrate at a concentration of 0.5 to 1.0 mg/mL;
- sodium chloride at a concentration of 5 to 10 mg/mL; and
- water.

The liquid pharmaceutical composition typically comprises from about 2.0 mg to about 4.0 mg of the particulate composition. As such, the liquid pharmaceutical composition typically comprises from about 2.0 mg to about 4.0 mg of ensifentrine.

In some embodiments, the liquid pharmaceutical composition is sterile. In specific embodiments, the liquid pharmaceutical compositions are sterile according to USP <71>.

The liquid pharmaceutical composition may have a sterility assurance level (SAL) of less than or equal to 10^{-3} , less than or equal to 10^{-6} , or less than or equal to 10^{-9} . For instance, an SAL of 10^{-6} means that the probability that a final product is non-sterile is $1/10^6$. The sterile liquid pharmaceutical composition may have a total bioburden limit of less than or equal to 10 CFU/mL, or less than or equal to 1 CFU/mL. "CFU" is a colony forming unit. The bioburden may be as measured using a plate count method as described in USP 31 <61>, for instance the pour-plate method.

Typically, the sterility of the liquid pharmaceutical composition is as determined in accordance with USP <71> or Ph Eur 2.6.1. The liquid pharmaceutical composition typically meets the acceptance criteria as defined in USP <71> or Ph Eur 2.6.1. In some embodiments, the liquid pharmaceutical compositions are stored in an ampule.

In some embodiments, the liquid pharmaceutical composition stored in an ampule is evaluated for leachates after 18 months at 25°C/60% RH (relative humidity), 6 months at 40°C/75% RH, or 33 months at 25°C/60% RH. In some embodiments, the

liquid pharmaceutical compositions comprise elemental impurities below the ICH Q3D thresholds for daily exposure and do not increase during storage.

In some embodiments, the liquid pharmaceutical composition comprises 3,3-dimethyl-1,5-dioxacycloundecane-6,11-dione and 1,4,7-trioxacyclotridecane-8,13-dione in an amount less than the ICH M7 guideline threshold of toxicological concern. In some embodiments, the liquid pharmaceutical composition comprises 3,3-dimethyl-1,5-dioxacycloundecane-6,11-dione in an amount of less than the ICH M7 guideline threshold of toxicological concern. In some embodiments, the liquid pharmaceutical composition comprises 1,4,7-trioxacyclotridecane-8,13-dione in an amount of less than the ICH M7 guideline threshold of toxicological concern.

Also provided is a nebulizer comprising the liquid pharmaceutical composition. Nebulizer may be a soft mist nebulizer, a vibrating mesh nebulizer, a jet nebulizer and an ultrasonic wave nebulizer. Typically, the nebulizer is a jet nebulizer.

In some embodiments, provided herein are kits comprising the particulate compositions provided herein. In other embodiments, the kits comprise the liquid pharmaceutical compositions provided herein.

In some embodiments, the kits comprise instructions for using any of the particulate compositions or liquid pharmaceutical compositions provided herein.

Methods of Treatment

The liquid pharmaceutical composition is typically for use in the treatment or prevention of a disease or condition selected from chronic obstructive pulmonary disease (COPD), asthma, allergic asthma, hay fever, allergic rhinitis, bronchitis, emphysema, bronchiectasis, adult respiratory distress syndrome (ARDS), steroid resistant asthma, severe asthma, paediatric asthma, cystic fibrosis, lung fibrosis, pulmonary fibrosis, interstitial lung disease, a skin disorder, atopic dermatitis, psoriasis, ocular inflammation, cerebral ischaemia, an inflammatory disease and an auto-immune disease. The disease or condition may be COPD or asthma. Often, the disease or condition is chronic obstructive pulmonary disease (COPD).

COPD

In some instances, the (e.g., liquid) pharmaceutical compositions may be used in methods of treating COPD. In some instances, the COPD is moderate COPD. In some instances, the COPD is severe COPD.

The above stages of COPD can be classified as set out below, where FEV₁ is forced expiratory volume in 1 second and FVC is forced vital capacity.

- Mild COPD: $FEV_1/FVC < 0.7$ and $FEV_1 \geq 80\%$ predicted
 - Moderate COPD: $FEV_1/FVC < 0.7$ and $50\% \leq FEV_1 < 80\%$ predicted
 - Severe COPD: $FEV_1/FVC < 0.7$ and $30\% \leq FEV_1 < 50\%$ predicted
 - Very Severe COPD: $FEV_1/FVC < 0.7$ and $FEV_1 < 30\%$ predicted
- 10 In each case the actual FEV₁ for the human subject is compared with a predicted FEV₁ value based on factors such as age and height of the human subject. These predicted values are readily available to the skilled person, for instance from the National Health and Nutrition Examination Survey III (Hankinson JL, Odencrantz JR, Fedan KB. Spirometry reference values from a sample of the general U.S.
- 15 Population. Am J Respir Crit Care. 1999;159:179-187). Examples of equations for calculating the predicted FEV₁ (in L) for a human subject are as follows, where H is height (cm) and A is age (yrs):
- Males: $0.0430H - 0.0290A - 2.490$
 - Females: $0.0395H - 0.025A - 2.600$
- 20 The FEV₁ and FVC used to determine the severity of COPD in a human subject are measured by carrying out spirometry shortly after the administration of an adequate dose of at least one short-acting inhaled bronchodilator. In some embodiments, measurement of FEV₁ and FVC for determining COPD disease severity is done between 15 and 30 minutes following administration of salbutamol (albuterol).
- 25 In some embodiments, as used herein, FEV₁ and FVC are determined as set out in the article Standardisation of spirometry, Eur J 2005; 26; 319-338.

A human subject may have been determined to have moderate COPD by measuring $FEV_1/FVC < 0.7$ and $50\% \leq FEV_1 < 80\%$ predicted FEV_1 value, where FEV_1 is forced expiratory volume in 1 second and FVC is forced vital capacity as measured between 15 and 30 minutes after a dose of a bronchodilator, optionally wherein the
5 bronchodilator is salbutamol. A human subject may have been determined to have severe COPD by measuring $FEV_1/FVC < 0.7$ and $30\% \leq FEV_1 < 50\%$ predicted, where FEV_1 is forced expiratory volume in 1 second and FVC is forced vital capacity as measured between 15 and 30 minutes after a dose of a bronchodilator, optionally wherein the bronchodilator is salbutamol. The determination of the human subject's
10 COPD severity may take place at least 1 day prior to the first administration of the composition. In some embodiments, treatment with the composition disclosed herein increases average FEV_1 at least about 75, 90, or 100 mL in 12 weeks following administration.

Trough Lung Function

15 In some instances, the (e.g., liquid) pharmaceutical compositions may be used in methods of increasing trough lung function. An increase in trough lung function in a patient suffering from COPD is in some instances determined by measuring in increase in trough FEV_1 , i.e. the FEV_1 of the patient shortly before administration of the composition as part of the maintenance therapy. In some embodiments, trough
20 lung function is increased by at least 30 mL (e.g., at least 35 mL, 40 mL, 45 mL, 50 mL, or 55 mL). In some instances, the increase is measured after a certain period of time following a prior administration of the liquid pharmaceutical composition compared to the FEV_1 of the human subject prior to a first administration of the liquid pharmaceutical composition. In some embodiments, the period of time is about 11.5
25 to about 12 hours.

In some instances, the (e.g., liquid) pharmaceutical compositions may be used to increase morning trough lung function. Morning trough lung function can be measured by determining the FEV_1 of the patient shortly before the morning administration of the composition as part of the maintenance therapy. For instance,
30 FEV_1 may be measured less than an hour before the morning administration of the composition. Morning trough FEV_1 may be the FEV_1 as measured between 11.5 and 12 hours following the prior evening dose.

COPD Exacerbations

In some instances the (e.g., liquid) pharmaceutical compositions may be used in methods of decreasing the frequency and/or severity of COPD exacerbations. In some embodiments, the COPD exacerbations are decreased by at least 30% (e.g.,
5 at least 32%, 34%, 36%, 40%, 45%, or 50%) compared to the frequency of the COPD exacerbation in an untreated subject and not administered the pharmaceutical composition disclosed herein.

In some embodiments, the methods comprise increasing the time to a first COPD exacerbation in the human subject. Accordingly, a subject may not have yet
10 experienced a COPD exacerbation and the pharmaceutical composition disclosed herein may increase the time until the subject experiences a first COPD exacerbation (the first COPD exacerbation is delayed). The pharmaceutical composition may accordingly reduce the risk of COPD exacerbations in a COPD patient. The COPD exacerbations may comprise one or more of dyspnea
15 (breathlessness), increased coughing, increased sputum volume, sputum purulence, wheezing, sore throat, a cold, and fever. Sputum purulence is a change in the colour of spontaneously expectorated samples from uncoloured to yellow-green. The COPD exacerbation may last for at least one day or at least two days.

A COPD exacerbation may comprise (A) worsening of two or more of the following
20 major symptoms for at least two consecutive days: dyspnea, sputum volume and sputum purulence or (B) worsening of any one major symptom together with any one of the following minor symptoms for at least two consecutive days: sore throat, colds (nasal discharge and/or nasal congestion), fever (oral temperature $>37.5^{\circ}\text{C}$) without other cause and increased cough. For instance, a COPD exacerbation may
25 comprise worsening of two or more of the major symptoms (dyspnea, sputum volume and sputum purulence) for at least two consecutive days.

A COPD exacerbation may be a moderate COPD exacerbation or a severe COPD exacerbation. A moderate exacerbation is defined as worsening symptoms of COPD (as defined above) requiring a minimum of three days of treatment with oral/systemic
30 corticosteroids and/or antibiotics. A severe exacerbation is defined as worsening symptoms of COPD (as defined above) requiring in-patient hospitalization. The

composition may reduce the severity of COPD exacerbations in a patient, and accordingly the composition may be for use in preventing severe COPD exacerbations in a patient. For instance, the patient may experience no severe COPD exacerbations in the year following first administration of the composition.

5 ***Regimen***

The liquid pharmaceutical composition may be administered once, twice or three times a day, or may be administered twice, three times, four times or five times a week. For instance, the pharmaceutical composition may be administered twice a day.

- 10 The methods may comprise administering two doses of the (e.g., liquid) pharmaceutical composition comprising about 3 mg ensifentrine free base to a human subject per day by inhalation. The method may comprise administering a dose of about 3 mg of the pharmaceutical composition to the human subject twice a day (3 mg BID) by inhalation. In some instances, the method comprises
- 15 administering by nebuliser a dose of about 3 mg the pharmaceutical composition to the human subject twice a day. Each dose may be 3.0 mg free base ensifentrine administered by nebulizer.

- In some embodiments, the human subject may be male. In some embodiments, the human subject may be female. The human subject may have an age of greater than
- 20 or equal to 65 years. The human subject may have an age of less than 65 years. The human subject may be taking a background medication selected from one or more of a long-acting muscarinic antagonist (LAMA), a long-acting beta-agonist (LABA) and an inhaled corticosteroid (ICS). In some embodiments, the human subject is taking a LAMA. In some embodiments, the human subject is taking a
- 25 LABA. In some embodiments, the human subject is taking an ICS.

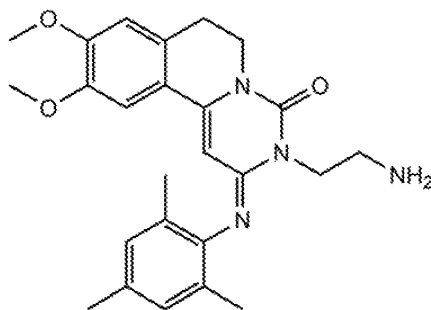
- In some cases, the human subject is not receiving a background medication. For instance, the human subject may not be taking a background medication, which background medication is a long-acting muscarinic antagonist (LAMA), a long-acting beta-agonist (LABA) or an inhaled corticosteroid (ICS). In some embodiments, the
- 30 human subject is not taking a LAMA. In some embodiments, the human subject is not taking a LABA. In some embodiments, the human subject is not taking an ICS.

The (e.g., liquid) pharmaceutical compositions may be used as a maintenance therapy. In some embodiments, the method comprises administering the pharmaceutical composition to the human subject at least once per day for at least 8 weeks. The pharmaceutical composition may be administered to the human subject at least once per day for at least 16 weeks or at least 24 weeks. The method may comprise administering the pharmaceutical composition to the human subject for at least 1 year. The method may comprise administering the composition to the human subject at least once every 24 hours, at least twice every 24 hours, for at least 8 weeks, for at least 16 weeks, or for at least 24 weeks.

10 Methods of Preparation

Provided herein are methods of producing the particulate composition described herein.

The process for producing the particulate composition may comprise reacting a compound of formula (IV) with 4-nitrophenyl chloroformate and ammonia, wherein the compound of formula (IV), 4-nitrophenyl chloroformate and ammonia are reacted in a solvent comprising dichloromethane,



(IV).

The solvent typically comprises dichloromethane and water.

In some embodiments, the solvent comprises dichloromethane. In some embodiments, the solvent comprises water.

For instance, the solvent may comprise from 30 to 60 vol% dichloromethane and from 30 to 60 vol% water, relative to the total volume of the solvent.

The solvent may comprise about 30 vol%, about 35 vol%, about 40 vol%, about 45 vol%, about 50 vol%, about 55 vol%, or about 60 vol% of dichloromethane. The solvent may comprise about 30 vol%, about 35 vol%, about 40 vol%, about 45 vol%, about 50 vol%, about 55 vol%, or about 60 vol% of water.

- 5 The solvent may comprise from 40 to 55 vol% dichloromethane and from 40 to 55 vol% water, relative to the total volume of the solvent. The total content of dichloromethane and water in the solvent is typically at least 90 vol% or at least 95 vol% based on the total volume of the solvent.

- 10 1 eqv of the compound of formula (IV) is typically reacted with from 0.8 to 1.5 eqvs of 4-nitrophenyl chloroformate.

- 15 In some embodiments, the compound of formula (IV) is reacted with about 0.8 eqvs, about 0.85 eqvs, about 0.9 eqvs, about 0.95 eqvs, about 1 eqvs, about 1.05 eqvs, about 1.1 eqvs, about 1.15 eqvs, about 1.2 eqvs, about 1.25 eqvs, about 1.3 eqvs, about 1.35 eqvs, about 1.4 eqvs, about 1.45 eqvs, or about 1.5 eqvs of 4-nitrophenyl chloroformate.

The compound of formula (IV) may be reacted with from 1.0 to 1.2 eqvs of 4-nitrophenyl chloroformate.

The compound of formula (IV) may be reacted with 4-nitrophenyl chloroformate and ammonia at a temperature of from 20 to 40°C for at least 1 hour.

- 20 The process may comprise: (i) combining the compound of formula (IV) with dichloromethane in a reactor; (ii) then adding an aqueous solution of a base to the reactor; (iii) then adding a solution of 4-nitrophenyl chloroformate in dichloromethane to the reactor; and (iv) then adding a solution of ammonia to the reactor. The solution of ammonia is typically an aqueous solution of ammonia, for instance 25% aqueous ammonia. The base in step (ii) is typically potassium bicarbonate.

- 30 In some instances, the process comprises combining the compound of formula (IV) with dichloromethane in a reactor. In some instances, the process comprises adding an aqueous solution of a base to the reactor. In some instances, the process comprises adding a solution of 4-nitrophenyl chloroformate in dichloromethane to the

reactor. In some instances, the process comprises adding a solution of ammonia to the reactor.

The organic phase product of steps (i) to (iv) is typically isolated, concentrated and
5 then combined with methanol to produce a suspension of the particulate composition. The process may further comprise drying, recrystallisation and optionally particle size reduction of the particulate composition.

The invention is described in more detail by the following Examples.

EXAMPLES

Methods

Ultra-High Performance Liquid Chromatography (UPLC)

- Column: Acquity UPLC BEH Phenyl 100 mm x 2.1 mm, 1.7 µm
- 5 • Detector Wavelength: 254 nm
- Retractive index detector sensitivity: N/AP
- Retractive index detector temperature: N/AP
- Column temperature: 35°C
- Autosampler temperature: N/AP
- 10 • Flow: 0.53 mL/min
- Injection volume: 1 µL
- Run time: 11.10 min
- Gradient program:

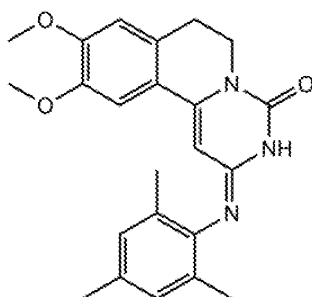
Time (min)	% Mobile Phase A	% Mobile Phase B
0	97	3
2.27	70	30
4.86	55	45
6.48	5	95
7.45	5	95
8.1	97	3
11.1	97	3

- Mobile Phase, Washing Solutions and Dissolution Mixture
 - 15 ○ Mobile Phase A: Water/trifluoroacetic acid (100/0.1, v/v) (Accurately transfer 1000 mL of water and 1 mL of trifluoroacetic acid into a suitable flask, mix well and degas prior to use.)
 - Mobile Phase B: Acetonitrile/trifluoroacetic acid (100/0.1, v/v) (Accurately transfer 1000 mL of acetonitrile and 1 mL of trifluoroacetic acid into a suitable flask, mix well and degas prior to use.)
 - 20 ○ Dissolution Mixture (diluent): Acetonitrile/Water (50/50, v/v) (Transfer 500 mL acetonitrile into a suitable flask and add 500 mL of water. Mix well to homogenize and degas prior to use.)

- Needle Wash: Acetonitrile/Water (50/50, v/v) (Transfer 500 mL of acetonitrile into a suitable flask and add 500 mL of water. Mix well to homogenize and degas prior to use.)
- Seal and Column Wash: Acetonitrile/Water (10/90, v/v) (Transfer 900 mL of water into a suitable flask and add 100 mL of acetonitrile. Mix well to homogenize and degas prior to use.)
- Equipment Wash (column storage): Acetonitrile/Water (90/10, v/v) (Transfer 900 mL of acetonitrile into a suitable flask and add 100 mL of water. Homogenize and degas prior to use.)

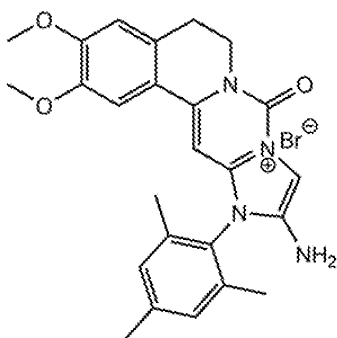
10 Example 1 – preparation of ensifentrine

Preparation of (E)-3-(2-aminoethyl)-2-(mesitylimino)-9,10-dimethoxy-2,3,6,7-tetrahydro-4H-pyrimido[6,1-a]isoquinolin-4-one



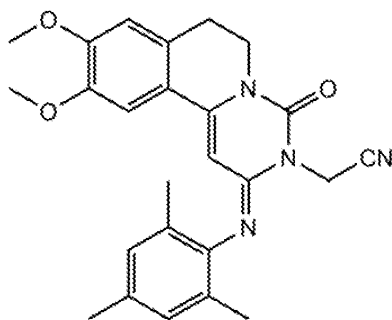
(1)

- 15 A mixture of 10 g of compound (I), 3.21 g of lithium carbonate, 155 mL of acetonitrile and 4.29 g of bromoacetonitrile was refluxed until the reaction was completed. The solids were removed by filtration and the filtrate solution was concentrated by distillation under reduced pressure with the addition of tetrahydrofuran. The solid product formed was isolated by filtration.
- 20 NMR and single crystal X-ray diffraction analysis showed that the product was a cyclic ammonium bromide salt (II) with the following structure.



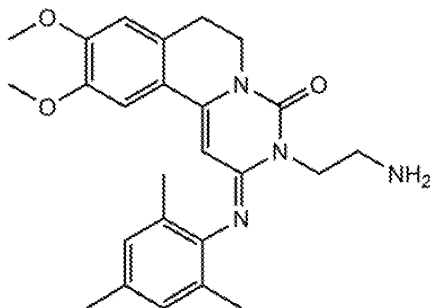
(II)

Under hydrogenation conditions using Raney Ni and 7N methanolic ammonia, the cyclic ammonium bromide salt (II) ring-opened to produce (E)-2-(2-(mesitylimino)-9,10-dimethoxy-4-oxo-6,7-dihydro-2H-pyrimido[6,1-a]isoquinolin-3(4H)-yl)acetonitrile (compound (III))

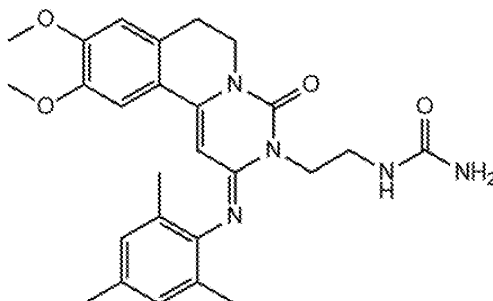


(III),

which was reduced *in situ* to produce (E)-3-(2-aminoethyl)-2-(mesitylimino)-9,10-dimethoxy-2,3,6,7-tetrahydro-4H-pyrimido[6,1-a]isoquinolin-4-one (compound (IV)).



(IV)

Production of ensifentrine from compound (IV) using sodium cyanate

(V)

- 5 Compound (IV) was converted to ensifentrine (compound (V)) with sodium cyanate using the following procedure.

- 70.4 mL of methanol was added to 8.0 g of compound (IV). A solution of 1.80 g of sodium cyanate (1.5 eq) in 18.4 mL of deionized water (2.3 vol) was added over thirty minutes. The mixture was heated to between 55 and 65°C. A solution of 1.68 mL hydrochloric acid (1.1 eq) and 24.0 mL deionized water (3 vol) was added over 10 15 minutes, while maintaining the temperature between 55 and 65°C. The suspension was stirred at reflux for at least two hours. The suspension was cooled to between 0 and 5°C and stirred for an hour. The suspension was filtered and the cake was washed with deionized water. The cake was then dried under vacuum to 15 produce the product.

The product obtained was analysed by UPLC. The composition of the product is set out in Table 1 below.

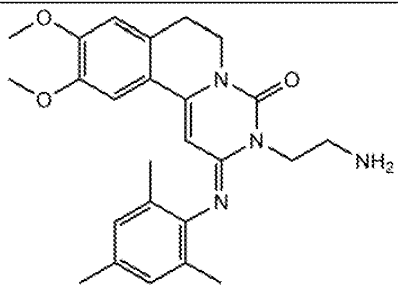
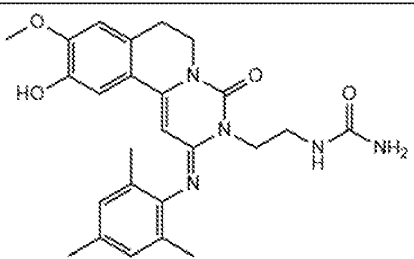
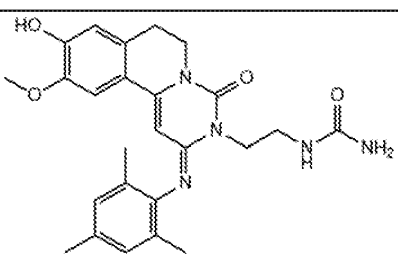
RRT	Area (%)	Species
0.78	0.63	(E)-3-(2-aminoethyl)-2-(mesitylimino)-9,10-dimethoxy-2,3,6,7-tetrahydro-4H-pyrimido[6,1-a]isoquinolin-4-one (compound (IV))
0.84	0.07	(E)-1-(2-(10-hydroxy-2-(mesitylimino)-9-methoxy-4-oxo-6,7-dihydro-2H-pyrimido[6,1-a]isoquinolin-3(4H)-yl)ethyl)urea (10-des-methyl)
0.86	0.07	(E)-1-(2-(9-hydroxy-2-(mesitylimino)-10-methoxy-4-oxo-6,7-dihydro-2H-pyrimido[6,1-a]isoquinolin-3(4H)-yl)ethyl)urea (9-des-methyl)
0.96	0.20	(E)-2-(mesitylimino)-9,10-dimethoxy-2,3,6,7-tetrahydro-4H-pyrimido[6,1-a]isoquinolin-4-one (compound (I))

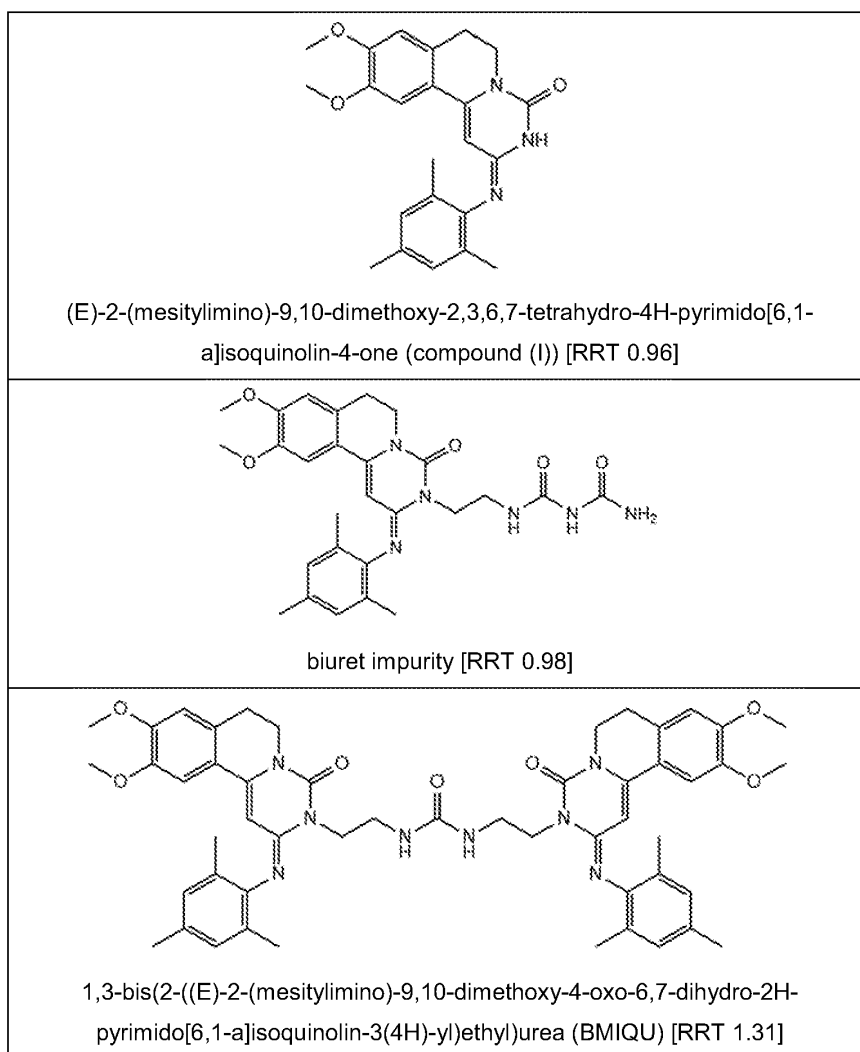
0.98	0.76	biuret impurity
1.00	97.03	ensifentrine
1.31	0.09	1,3-bis(2-((E)-2-(mesitylimino)-9,10-dimethoxy-4-oxo-6,7-dihydro-2H-pyrimido[6,1-a]isoquinolin-3(4H)-yl)ethyl)urea (BMIQU)

Table 1

The biuret impurity (RRT 0.98) could not readily be removed by recrystallisation.

The structures of the impurities are shown below.

 (E)-3-(2-aminoethyl)-2-(mesitylimino)-9,10-dimethoxy-2,3,6,7-tetrahydro-4H-pyrimido[6,1-a]isoquinolin-4-one (compound (IV)) [RRT 0.78]
 (E)-1-(2-(10-hydroxy-2-(mesitylimino)-9-methoxy-4-oxo-6,7-dihydro-2H-pyrimido[6,1-a]isoquinolin-3(4H)-yl)ethyl)urea (10-des-methyl) [RRT 0.84]
 (E)-1-(2-(9-hydroxy-2-(mesitylimino)-10-methoxy-4-oxo-6,7-dihydro-2H-pyrimido[6,1-a]isoquinolin-3(4H)-yl)ethyl)urea (9-des-methyl) [RRT 0.86]



Production of ensifentrine from compound (IV) using nitrophenyl chloroformate and ammonia

Compound (IV) was converted to ensifentrine with nitrophenyl chloroformate and ammonia using the following procedure.

660.0 mL of dichloromethane (5 vol) was added to a reactor with 132.0 g of compound (IV). A solution of 153.12 g of potassium bicarbonate in 1320.0 mL of deionized water (10 vol) was added to the reactor and the mixture was cooled to a temperature between 0 and 5°C. A solution of 660.0 mL of dichloromethane (5 vol) and 73.47 g of 4-nitrophenyl chloroformate (1.2 eq) was then added, keeping the temperature between 0 and 10°C. The mixture was then stirred at a temperature of

between 5 and 10°C for at least 2 hours before addition of 1320.0 mL of 25% aqueous ammonia (10 vol). The mixture was then stirred at a temperature of between 25 and 35°C overnight. Stirring was stopped and the phases were allowed to separate for at least 15 minutes. The organic phase contained the product. The aqueous phase was extracted with 660 mL dichloromethane and the combined organic phases washed with 660 mL of deionized water. The organic phase was filtered and the reactor and filter were washed with 132.0 mL of dichloromethane. The filtrate was then concentrated, before addition of methanol. The resulting suspension was heated and stirred. The suspension was cooled to a temperature of 15 to 25 °C and the suspension was filtered. The filter cake was washed with methanol before being dried under vacuum to obtain the product.

The product obtained was analysed by UPLC. The composition of the product is set out in Table 2 below.

RRT	Area (%)	Species
0.78	0.01	(E)-3-(2-aminoethyl)-2-(mesitylimino)-9,10-dimethoxy-2,3,6,7-tetrahydro-4H-pyrimido[6,1-a]isoquinolin-4-one (compound (IV))
0.84	0.07	(E)-1-(2-(10-hydroxy-2-(mesitylimino)-9-methoxy-4-oxo-6,7-dihydro-2H-pyrimido[6,1-a]isoquinolin-3(4H)-yl)ethyl)urea (10-des-methyl)
0.86	0.07	(E)-1-(2-(9-hydroxy-2-(mesitylimino)-10-methoxy-4-oxo-6,7-dihydro-2H-pyrimido[6,1-a]isoquinolin-3(4H)-yl)ethyl)urea (9-des-methyl)
0.96	0.00	(E)-2-(mesitylimino)-9,10-dimethoxy-2,3,6,7-tetrahydro-4H-pyrimido[6,1-a]isoquinolin-4-one (compound (I))
0.98	0.02	biuret impurity
1.00	98.55	ensifentrine
1.31	0.51	1,3-bis(2-((E)-2-(mesitylimino)-9,10-dimethoxy-4-oxo-6,7-dihydro-2H-pyrimido[6,1-a]isoquinolin-3(4H)-yl)ethyl)urea (BMIQU)

Table 2

Only very low quantities of the biuret impurity (RRT 0.98) were generated.

Example 2 – preparation of a larger batch of ensifentrine

A larger batch of ensifentrine was produced using 4-nitrophenyl chloroformate and ammonia. The drug substance obtained was analysed by UPLC. The main impurities present in the drug substance are set out in Table 3 below.

Area (%)	Species
0.02	(E)-1-(2-(10-hydroxy-2-(mesitylimino)-9-methoxy-4-oxo-6,7-dihydro-2H-pyrimido[6,1-a]isoquinolin-3(4H)-yl)ethyl)urea (10-des-methyl impurity)
0.08	(E)-1-(2-(9-hydroxy-2-(mesitylimino)-10-methoxy-4-oxo-6,7-dihydro-2H-pyrimido[6,1-a]isoquinolin-3(4H)-yl)ethyl)urea (9-des-methyl impurity)
0.02	biuret impurity
99.80	ensifentrine
0.04	1,3-bis(2-((E)-2-(mesitylimino)-9,10-dimethoxy-4-oxo-6,7-dihydro-2H-pyrimido[6,1-a]isoquinolin-3(4H)-yl)ethyl)urea (BMIQU)

Table 3

Example 3 – preparation of aqueous suspension formulation

- The drug substance obtained from Example 2 was micronised and dry heat treated at 160°C for at least 120 minutes to produced sterilised ensifentrine particles. The sterilised ensifentrine particles obtained by dry heat treatment were combined with a suspension vehicle under aseptic conditions to obtain a sterile suspension formulation comprising ensifentrine, having the composition shown in Table 4.

Constituent	Concentration (mg/mL)
Sterilised ensifentrine particles (RPL554)	1.2
Polysorbate 20 (Tween 20)	0.50
Sorbitan Monolaurate (Span 20)	0.05
Sodium Dihydrogen Phosphate Dihydrate	0.744
Disodium Hydrogen Phosphate Dihydrate	0.853
Sodium Chloride	8.60
Water	q.s. to 1 mL

Table 4

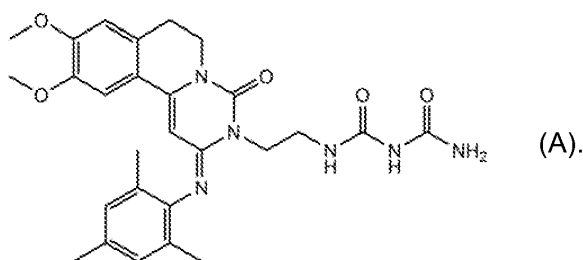
- The suspension formulation was assessed by HPLC and the content of the impurity bis-(mesitylisoquinolinone)urea (BMIQU) was found to be no greater than 0.6 wt% relative to the total amount of ensifentrine in the suspension formulation.

CLAIMS

1. A particulate composition comprising ensifentrine, wherein the particulate composition further comprises:

5 from greater than 0.00 wt% to 0.60 wt% of 1,3-bis(2-(2-(mesitylimino)-9,10-dimethoxy-4-oxo-6,7-dihydro-2H-pyrimido[6,1-a]isoquinolin-3(4H)-yl)ethyl)urea (BMIQU) relative to the total weight of ensifentrine; and

from 0.00 wt% to 0.50 wt% of a biuret impurity of formula (A) relative to the total weight of ensifentrine:



10

2. A particulate composition according to claim 1, wherein the particulate composition comprises from 0.00 wt% to 0.30 wt% of the biuret impurity relative to the total weight of ensifentrine.

15 3. A particulate composition according to claim 1 or claim 2, wherein the particulate composition comprises from 0.00 wt% to 0.05 wt% of the biuret impurity relative to the total weight of ensifentrine.

4. A particulate composition according to any one of the preceding claims,
20 wherein the particulate composition comprises from 0.01 wt% to 0.30 wt% of BMIQU relative to the total weight of ensifentrine.

5. A particulate composition according to any one of the preceding claims,
wherein the particulate composition comprises from 0.02 wt% to 0.06 wt% of BMIQU
25 relative to the total weight of ensifentrine.

6. A particulate composition according to any one of the preceding claims, wherein the particulate composition further comprises:

from greater than 0.00 wt% to 0.10 wt% of 1-(2-(9-hydroxy-2-(mesitylimino)-10-methoxy-4-oxo-6,7-dihydro-2H-pyrimido[6,1-a]isoquinolin-3(4H)-yl)ethyl)urea (9-des-methyl impurity); and/or

from greater than 0.00 wt% to 0.10 wt% of 1-(2-(10-hydroxy-2-(mesitylimino)-9-methoxy-4-oxo-6,7-dihydro-2H-pyrimido[6,1-a]isoquinolin-3(4H)-yl)ethyl)urea (10-des-methyl impurity).

7. A particulate composition according to any one of the preceding claims, wherein the particulate composition comprises at least 98.0 wt% of ensifentrine relative to the total weight of the particulate composition.

8. A particulate composition according to any one of the preceding claims, wherein the particulate composition comprises at least 99.0 wt% of ensifentrine relative to the total weight of the particulate composition, optionally at least 99.2 wt% of ensifentrine relative to the total weight of the particulate composition.

9. A particulate composition according to any one of the preceding claims, wherein the particulate composition comprises:
from 99.4 to 99.9 wt% of ensifentrine;
from 0.01 wt% to 0.30 wt% of BMIQU;
from 0.00 wt% to 0.10 wt% of the biuret impurity;
from 0.01 wt% to 0.20 wt% of the 9-des-methyl impurity; and
from 0.01 wt% to 0.20 wt% of the 10-des-methyl impurity,
wherein the wt% is relative to the total weight of the particulate composition.

10. A particulate composition according to any one of the preceding claims, wherein the particulate composition comprises:
from 99.5 to 99.9 wt% of ensifentrine;
from 0.02 wt% to 0.10 wt% of BMIQU;
from 0.00 wt% to 0.04 wt% of the biuret impurity;
from 0.01 wt% to 0.10 wt% of the 9-des-methyl impurity; and
from 0.01 wt% to 0.10 wt% of the 10-des-methyl impurity,
wherein the wt% is relative to the total weight of the particulate composition.

11. A particulate composition according to any one of the preceding claims,
wherein the particulate composition consists of:
from 99.6 to 99.9 wt% of ensifentrine;
from 0.02 wt% to 0.10 wt% of BMIQU;
5 from 0.00 wt% to 0.04 wt% of the biuret impurity;
from 0.01 wt% to 0.10 wt% of the 9-des-methyl impurity;
from 0.01 wt% to 0.10 wt% of the 10-des-methyl impurity; and
no greater than 0.36 wt% total of other related substances,
wherein the wt% is relative to the total weight of the particulate composition.
- 10 12. A particulate composition according to any one of the preceding claims,
wherein the particulate composition has a Dv50 of from about 0.2 to about 5.0 μm .
13. A particulate composition according to claim 12, wherein the particulate
15 composition has a Dv50 of from about 1.0 μm to about 2.2 μm .
14. A particulate composition according to any one of the preceding claims,
wherein the particulate composition has a Dv10 of from about 0.3 μm to about 0.9
 μm and/or a Dv90 of from about 2.3 μm to about 4.5 μm .
- 20 15. A liquid pharmaceutical composition suitable for administration by inhalation
comprising (a) the particulate composition as defined in any one of the preceding
claims and (b) a diluent.
- 25 16. A liquid pharmaceutical according to claim 15, wherein the particulate
composition is suspended in the diluent.
17. A liquid pharmaceutical composition according to claim 15 or claim 16,
wherein the liquid pharmaceutical composition comprises no more than 1.00
30 wt % of BMIQU relative to the total weight of ensifentrine.
18. A liquid pharmaceutical composition according to claim 17,
wherein the liquid pharmaceutical composition comprises no more than 0.50
wt % of BMIQU relative to the total weight of ensifentrine.

19. A liquid pharmaceutical composition according to any one of claims 15 to 18, wherein the liquid pharmaceutical composition comprises, relative to the total weight of the liquid pharmaceutical composition:
- 5 a) the particulate composition at a concentration of from 0.8 to 1.6 mg/mL;
b) one or more surfactants at a total concentration of from 0.1 to 1.0 mg/mL;
c) one or more buffers at a total concentration of from 1.0 to 2.0 mg/ml; and
d) water.
- 10 20. The liquid pharmaceutical composition according to any one claims 15 to 19, wherein the liquid pharmaceutical composition comprises, relative to the total weight of the liquid pharmaceutical composition:
- a) the particulate composition at a concentration of from 1.0 to 1.4 mg/mL;
b) polysorbate 20 (Tween 20) at a concentration of 0.3 to 0.7 mg/mL;
15 c) sorbitan monolaurate (Span 20) at a concentration of 0.0 to 0.1 mg/mL;
d) sodium dihydrogen phosphate dihydrate at a concentration of 0.5 to 1.0 mg/mL;
e) disodium hydrogen phosphate dihydrate at a concentration of 0.5 to 1.0 mg/mL;
20 f) sodium chloride at a concentration of 5 to 10 mg/mL; and
g) water.
21. A liquid pharmaceutical composition according to any one claims 15 to 20, wherein the liquid pharmaceutical composition comprises from about 2.0 mg to about
25 4.0 mg of the particulate composition.
22. The liquid pharmaceutical composition according to any one claims 15 to 21, wherein the liquid pharmaceutical composition is a suspension comprising, relative to the total weight of the liquid pharmaceutical composition:
- 30 a) 1.2 mg/mL ensifentrine;
b) 0.5 mg/ml polysorbate 20;
c) 0.05 mg/ml sorbitan monolaurate;
d) 0.744 mg/ml sodium dihydrogen phosphate;
e) 0.853 mg/ml disodium hydrogen phosphate;

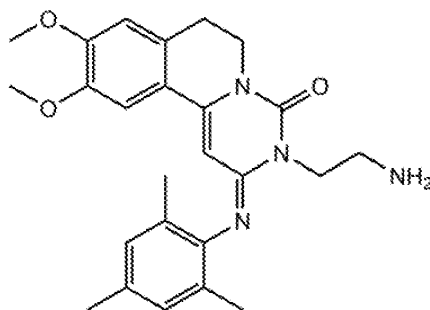
- f) 8.6 mg/ml sodium chloride; and
- g) water.

23. A method of:

- 5 a) treating moderate chronic obstructive pulmonary disease (COPD),
 - b) treating severe COPD,
 - c) increasing trough lung function, or
 - d) reducing frequency of an exacerbation of COPD;
- in a human subject in need thereof, the method comprising administering to
- 10 the human subject via inhalation the particulate composition of any one of claims 1-14 or the liquid pharmaceutical composition of any one of claims 15-22.

24. A process for producing a particulate composition as defined in any one of claims 1 to 14, the process comprising:

reacting a compound of formula (IV) with 4-nitrophenyl chloroformate and ammonia, wherein the compound of formula (IV), 4-nitrophenyl chloroformate and ammonia are reacted in a solvent comprising dichloromethane,



(IV).

25. A process according to claim 24, wherein 1 eqv of the compound of formula (IV) is reacted with from 0.8 to 1.5 eqvs of 4-nitrophenyl chloroformate, optionally with from 1.0 to 1.2 eqvs of 4-nitrophenyl chloroformate.

26. A process according to claim 24 or claim 25, wherein the process comprises:

- (i) combining the compound of formula (IV) with dichloromethane in a reactor;
- (ii) adding an aqueous solution of a base to the reactor;
- (iii) adding a solution of 4-nitrophenyl chloroformate in dichloromethane to
- 5 the reactor; and
- (iv) adding a solution of ammonia to the reactor.

27. A process according to claim 26, wherein the base in step (ii) is potassium bicarbonate.

10

28. A kit comprising the particulate composition of any one of claims 1-14 or the liquid pharmaceutical composition of any one of claims 15- 22.

15