Figure 1

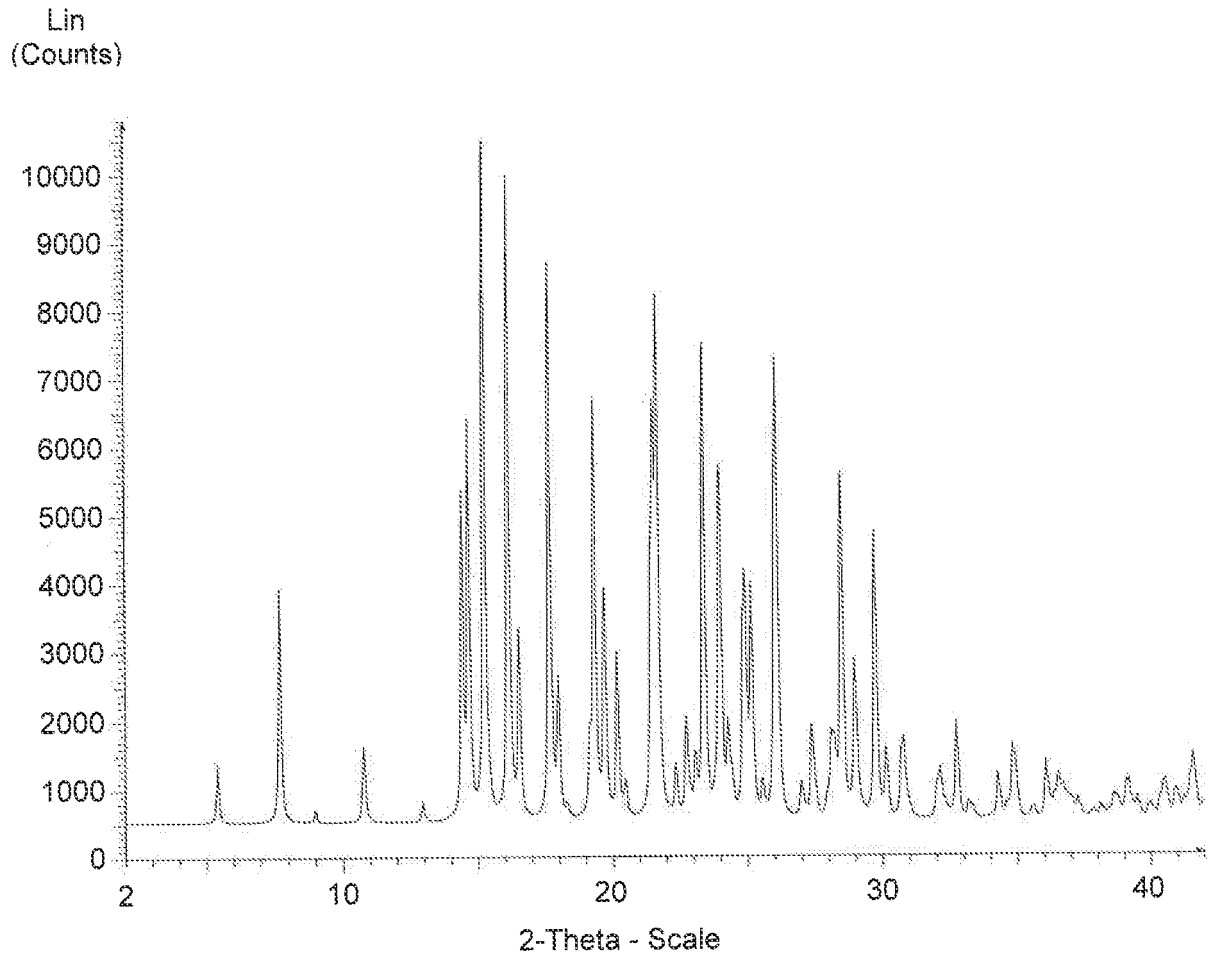

Lin
(Counts)
10000
9000
8000
7000
6000
5000
4000
3000
2000
1000
0
2
10
20
30
40
2-Theta - Scale

Figure 2

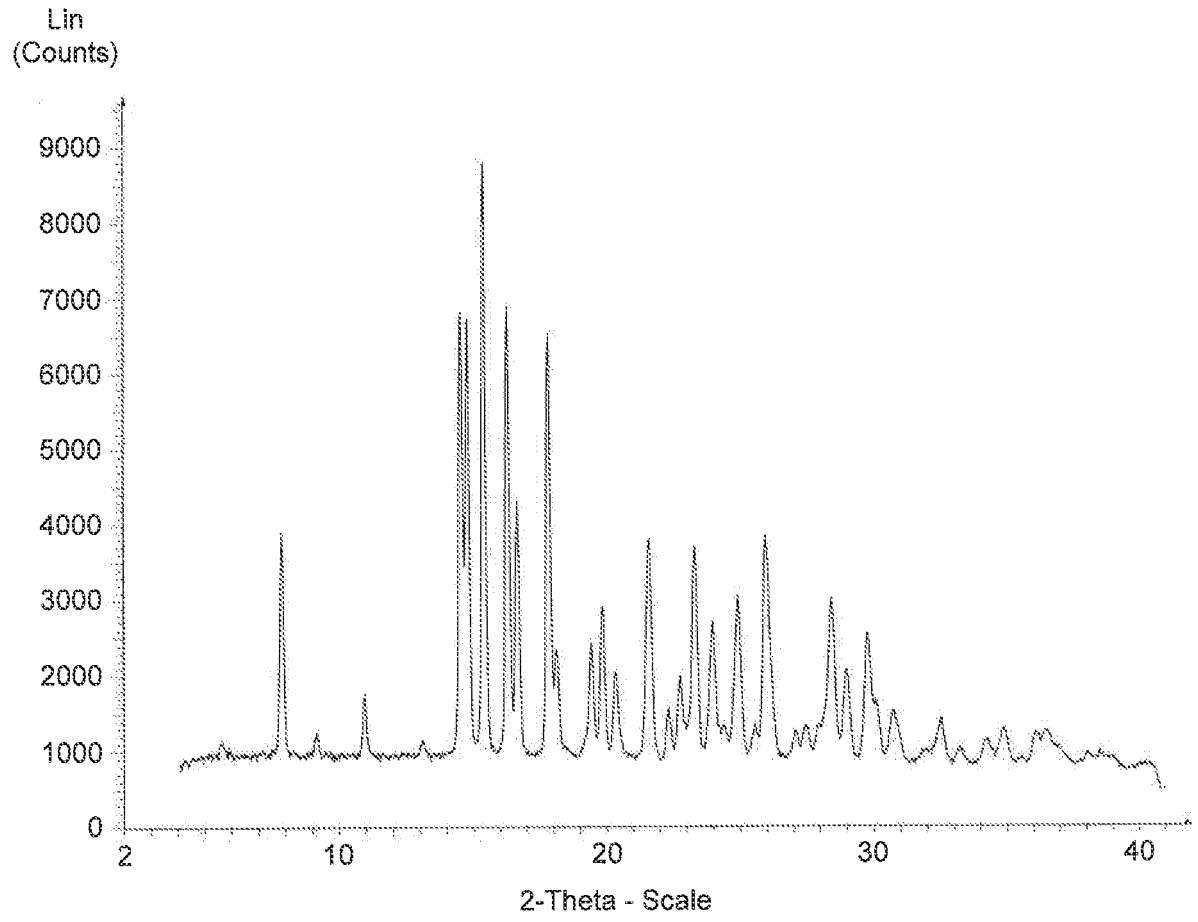

Lin
(Counts)
9000
8000
7000
6000
5000
4000
3000
2000
1000
0
2
10
20
30
40
2-Theta - Scale

Figure 3

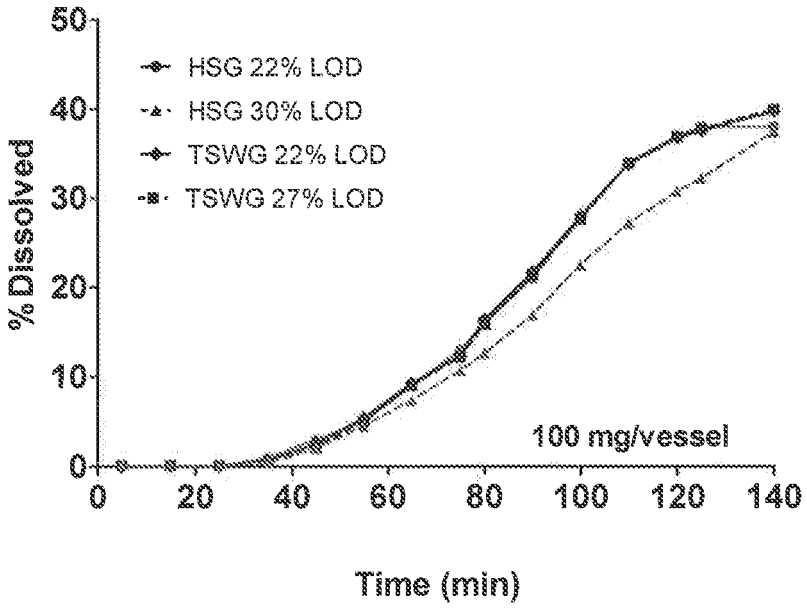

50
40
30
20
10
0
% Dissolved
HSG 22% LOD
HSG 30% LOD
TSWG 22% LOD
TSWG 27% LOD
100 mg/vessel
0
20
40
60
80
100
120
140
Time (min)

Figure 4

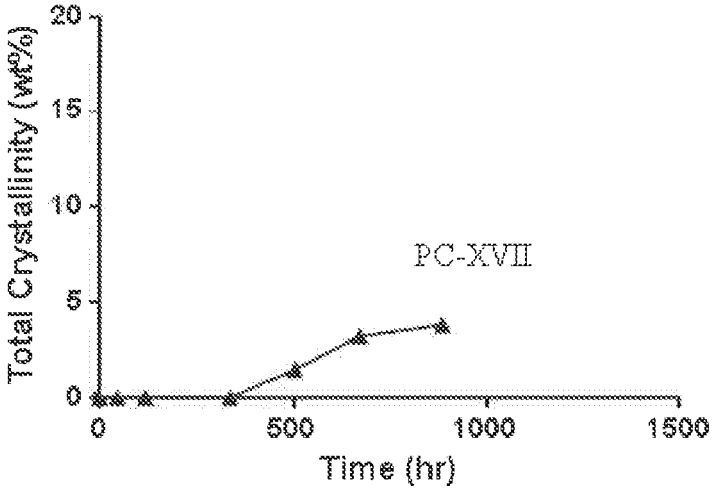

Total Crystallinity (wt%)
20
15
10
5
0
PC-XVII
0
500
1000
1500
Time (hr)

Figure 5

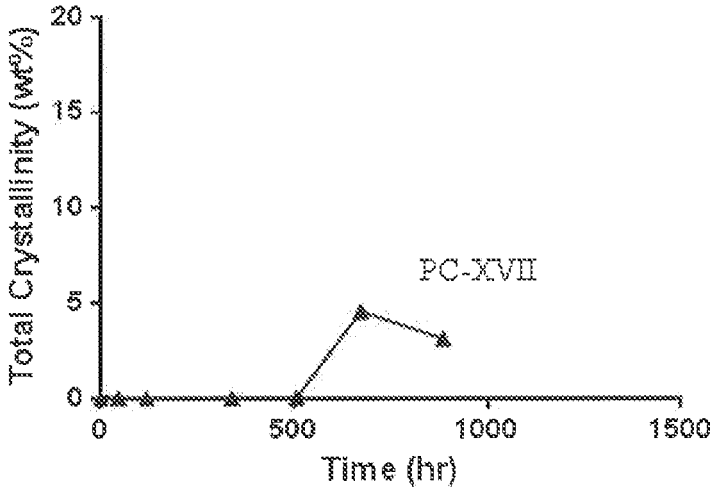

Total Crystallinity (wt%)
20
15
10
5
0
PC-XVII
0
500
1000
1500
Time (hr)

Figure 6

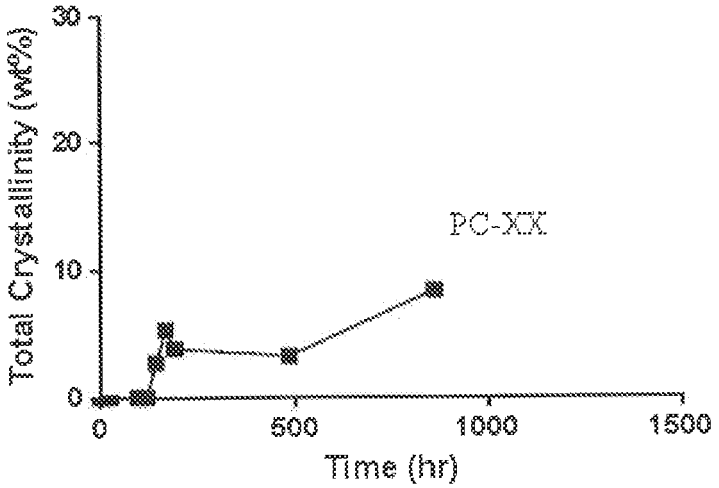


Figure 7

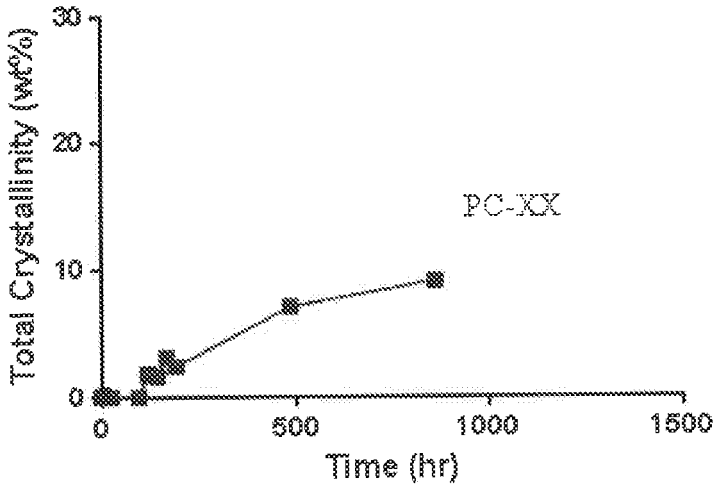


Figure 8

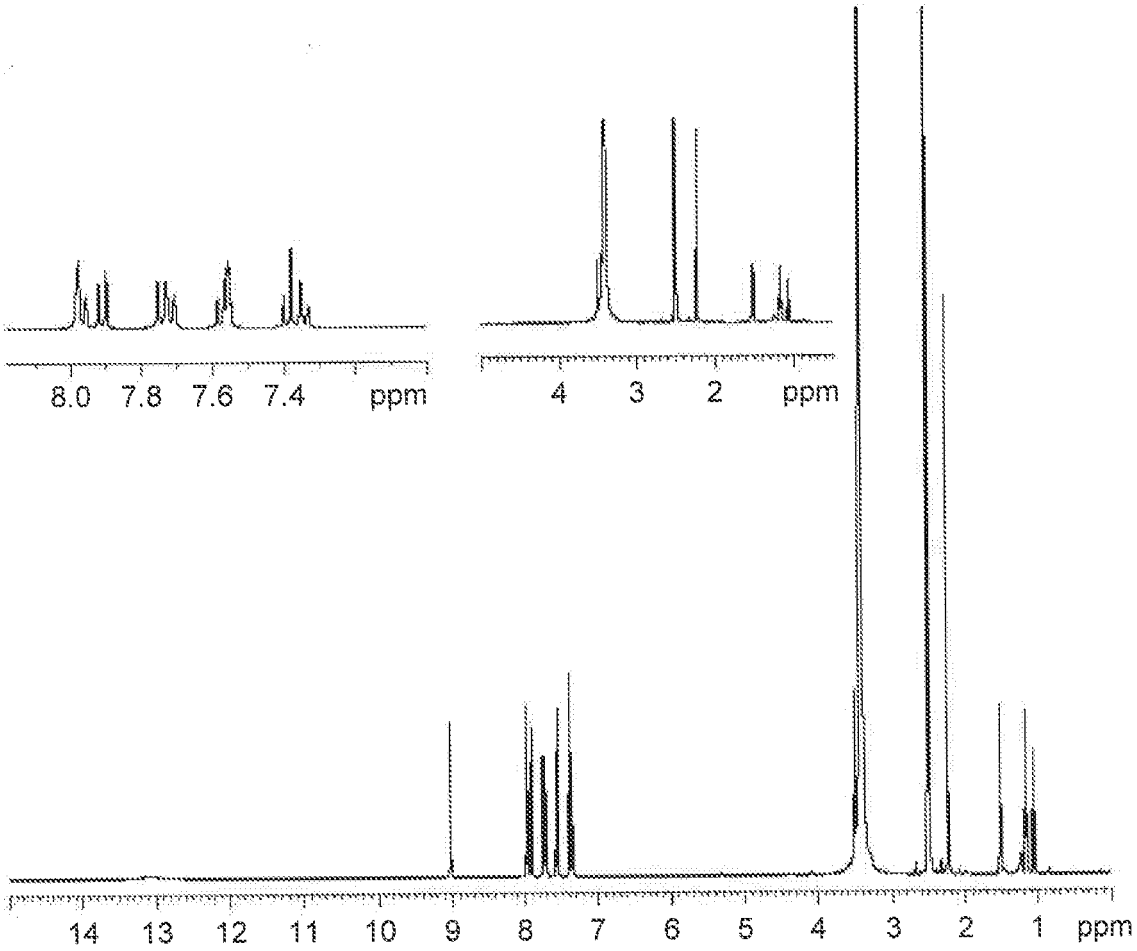


Figure 9

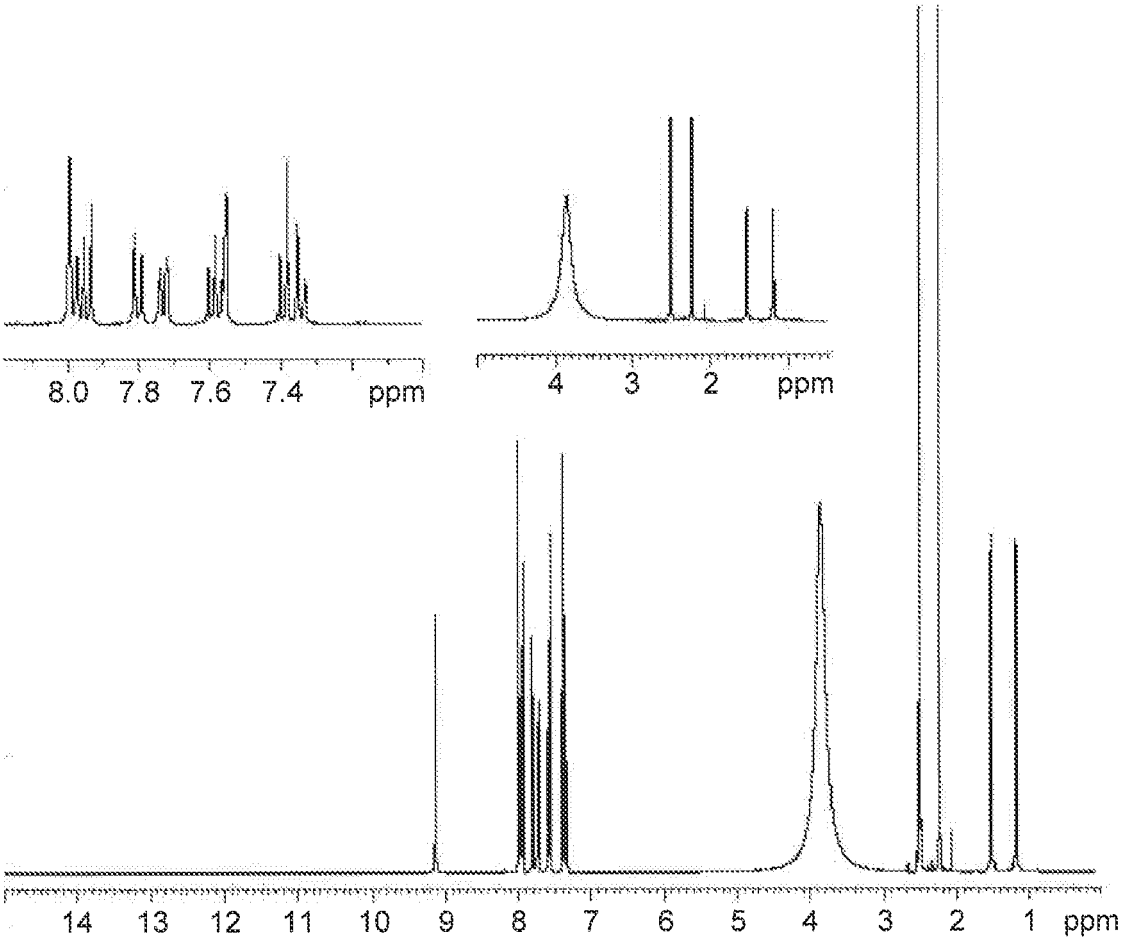


Figure 10

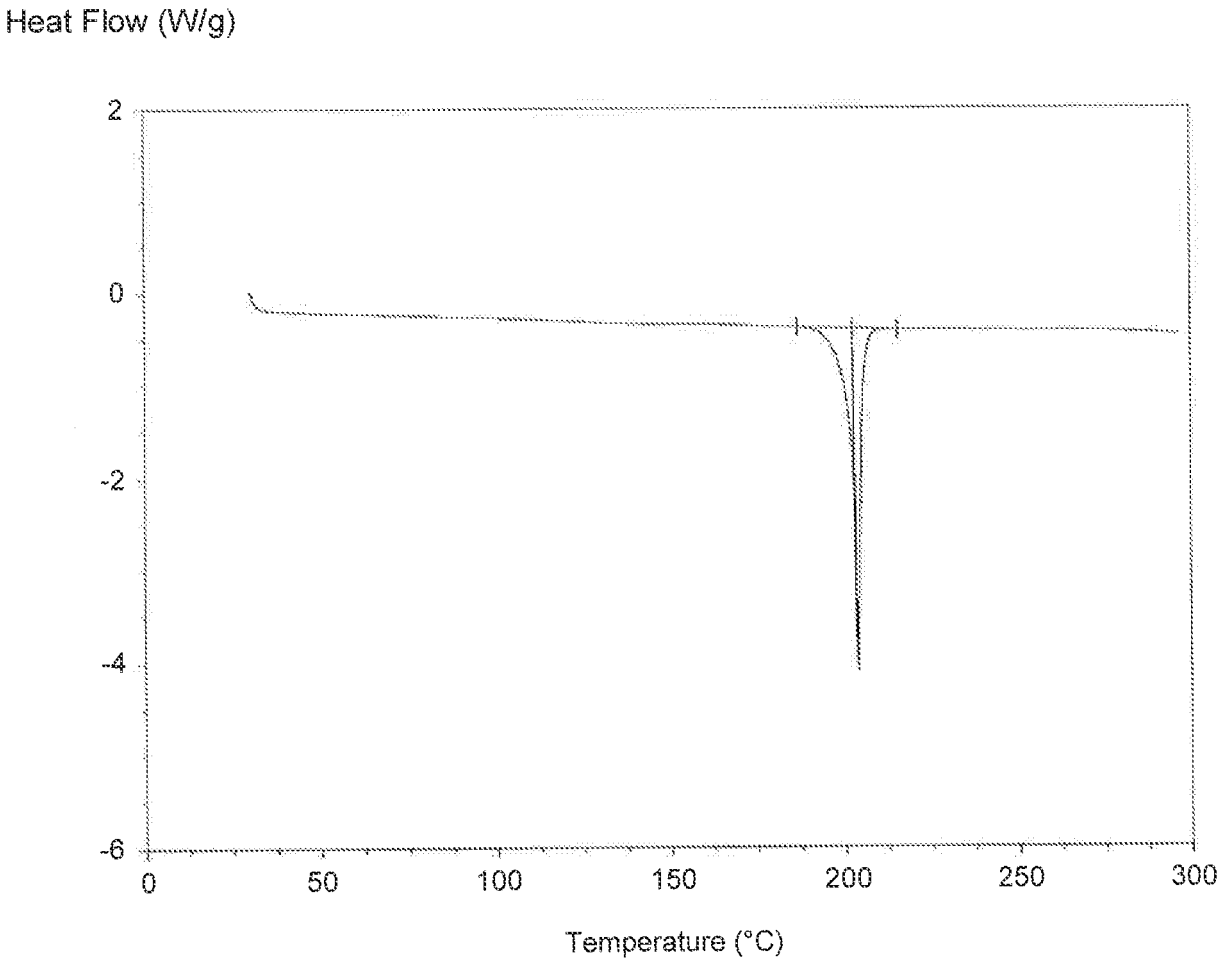


Figure 11

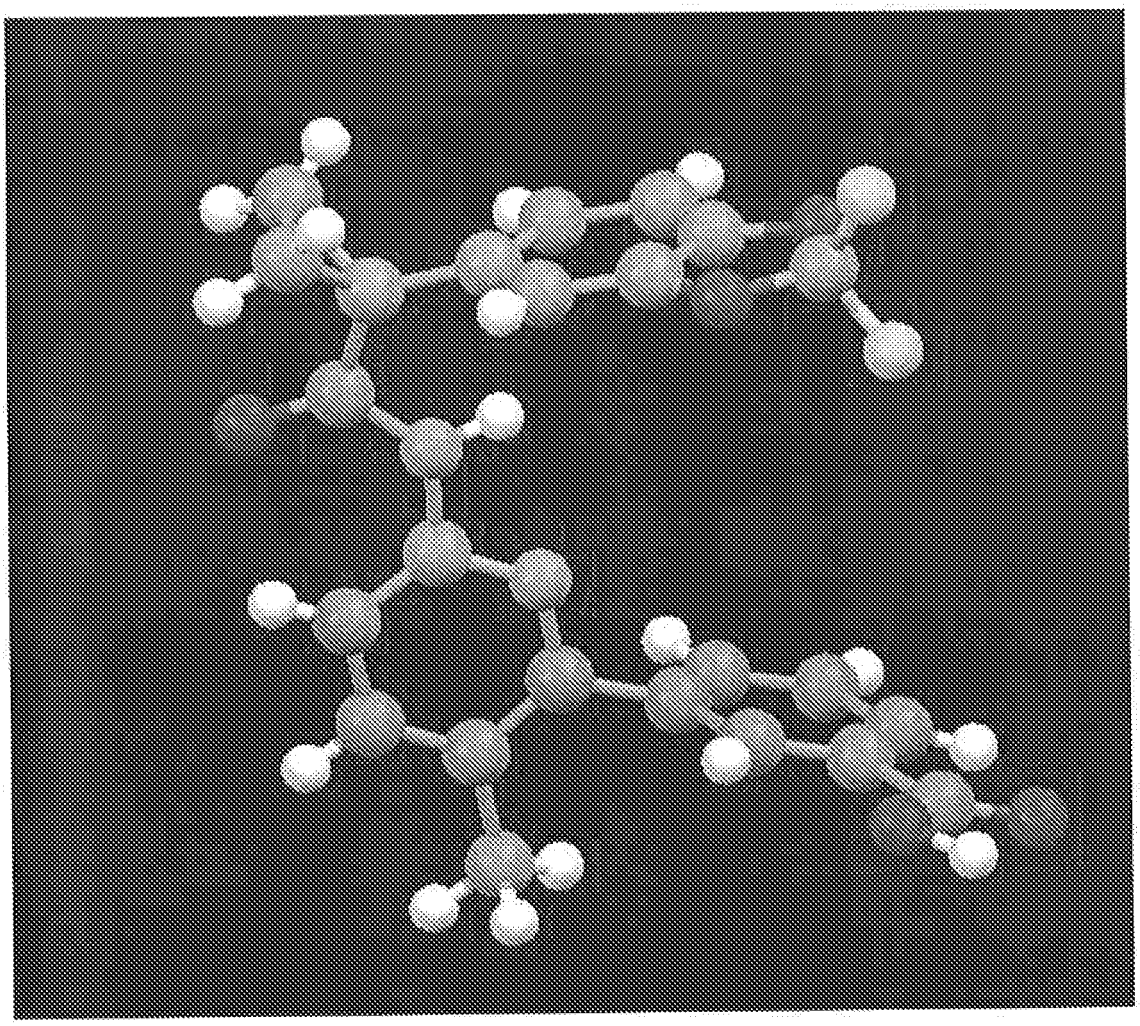


Figure 12

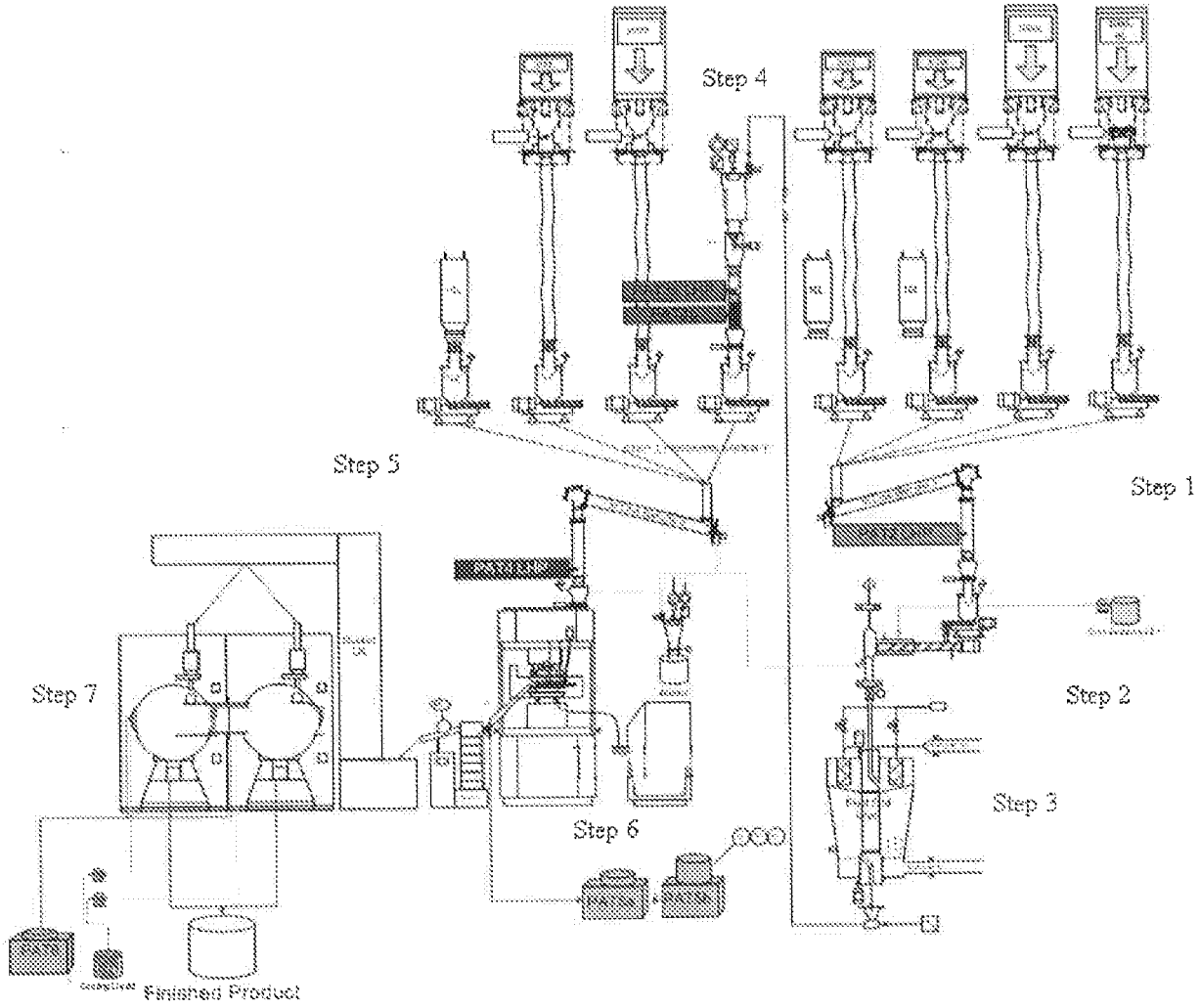
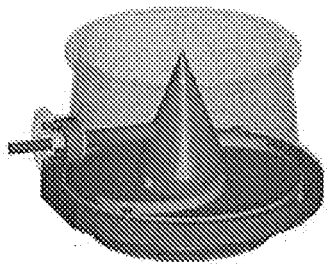

Step 4
Step 5
Step 1
Step 7
Step 2
Step 3
Step 6
Finished Product

Figure 13



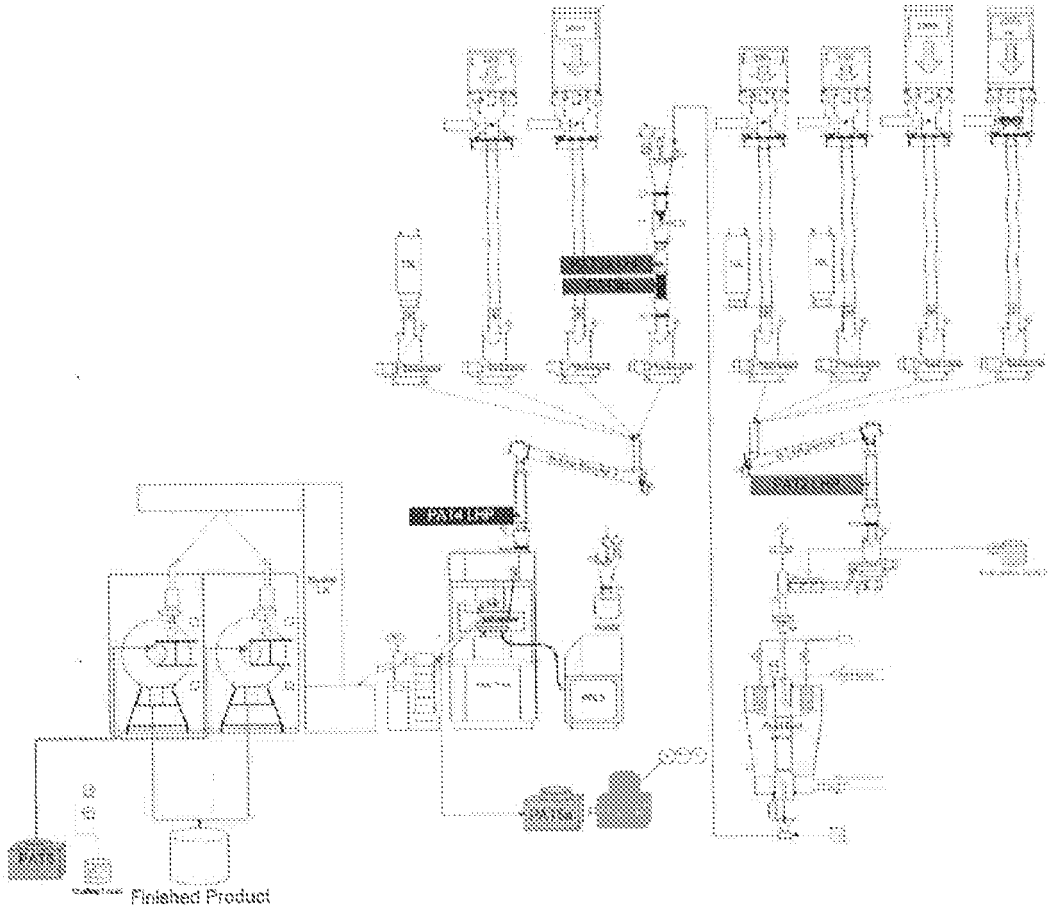


Figure 14

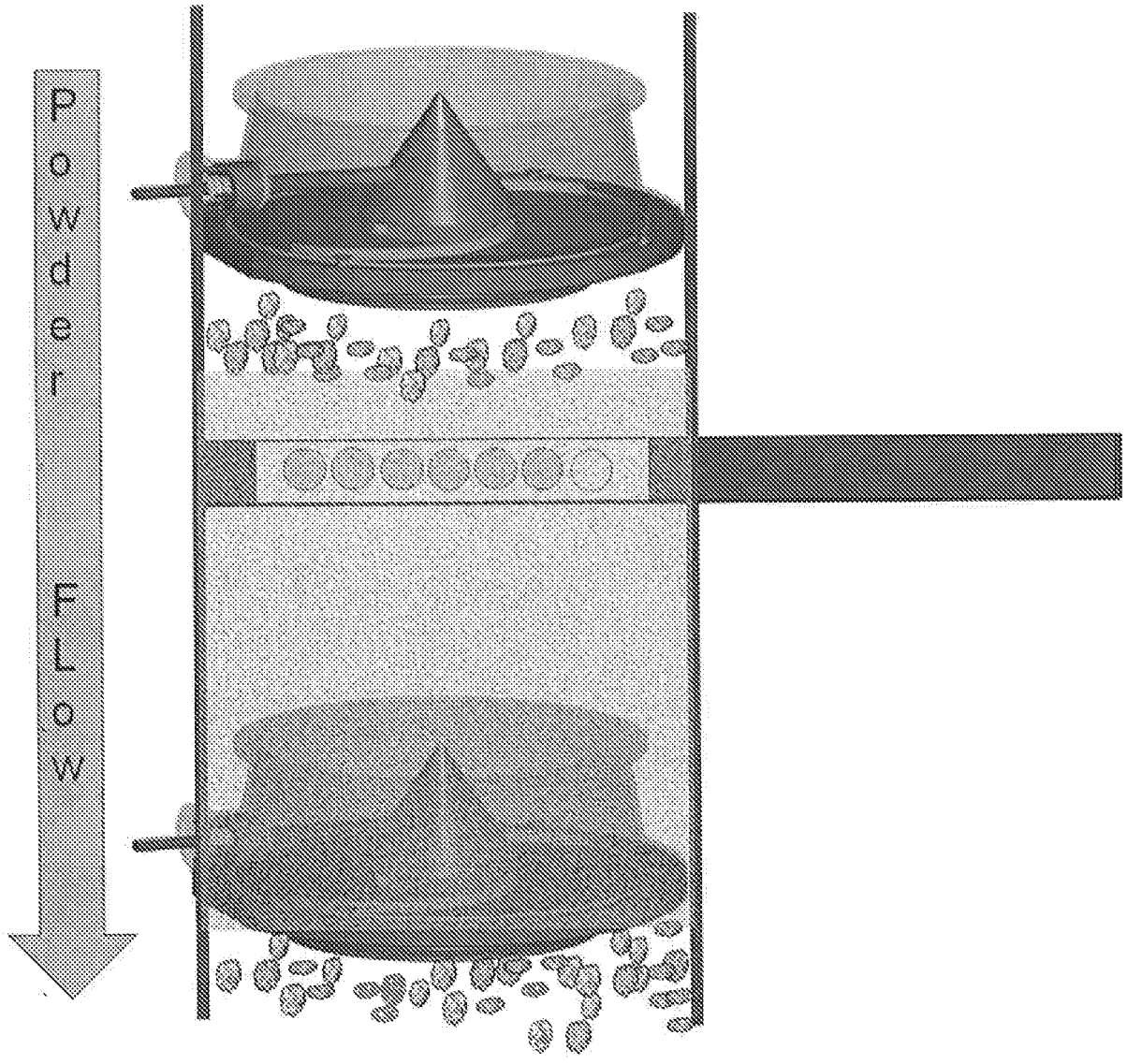


Figure 15

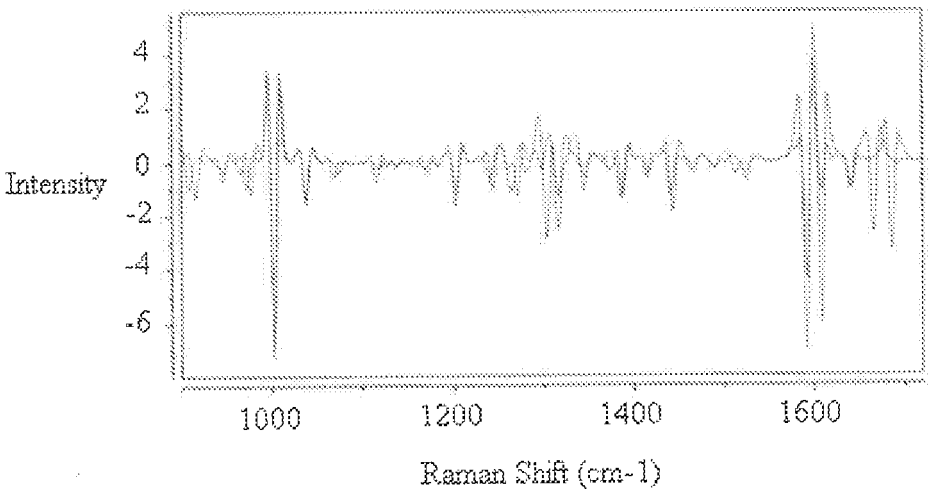

Intensity
4
2
0
-2
-4
-6
1000
1200
1400
1600
Raman Shift (cm-1)
Compound 1 Form I Processed
Compound 1 Form II Processed

Figure 16

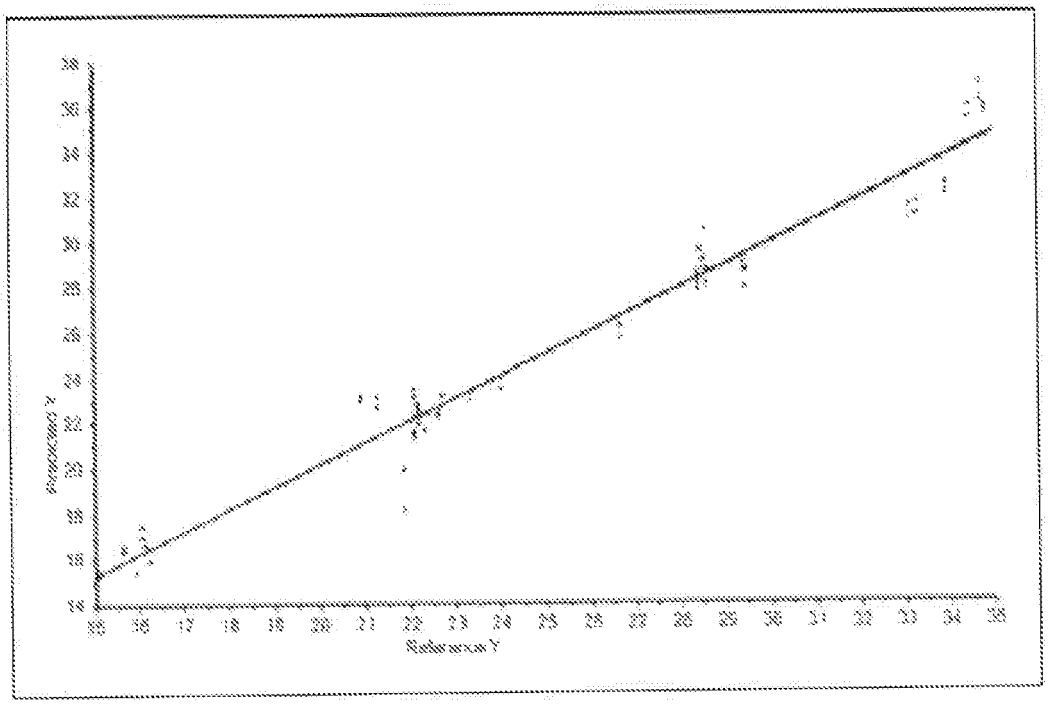


Figure 17

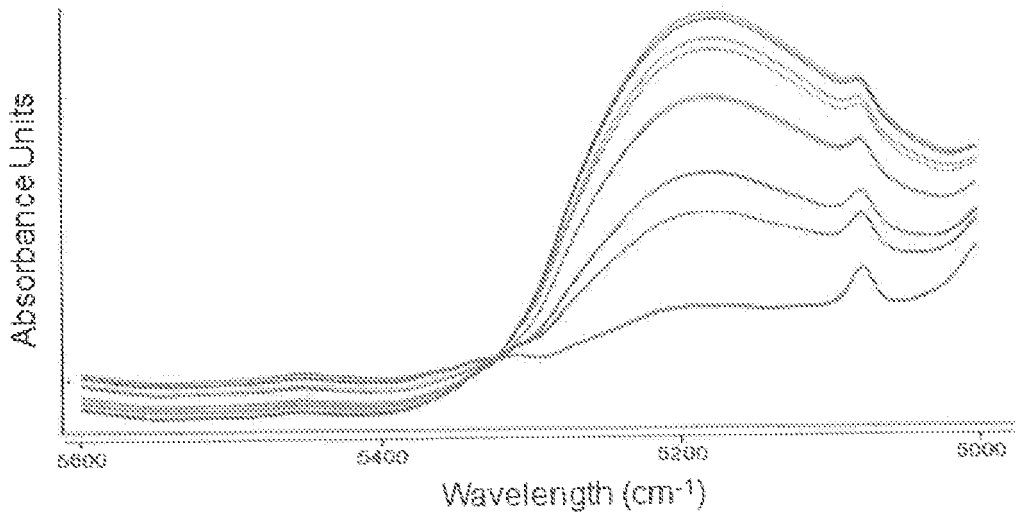


Figure 18

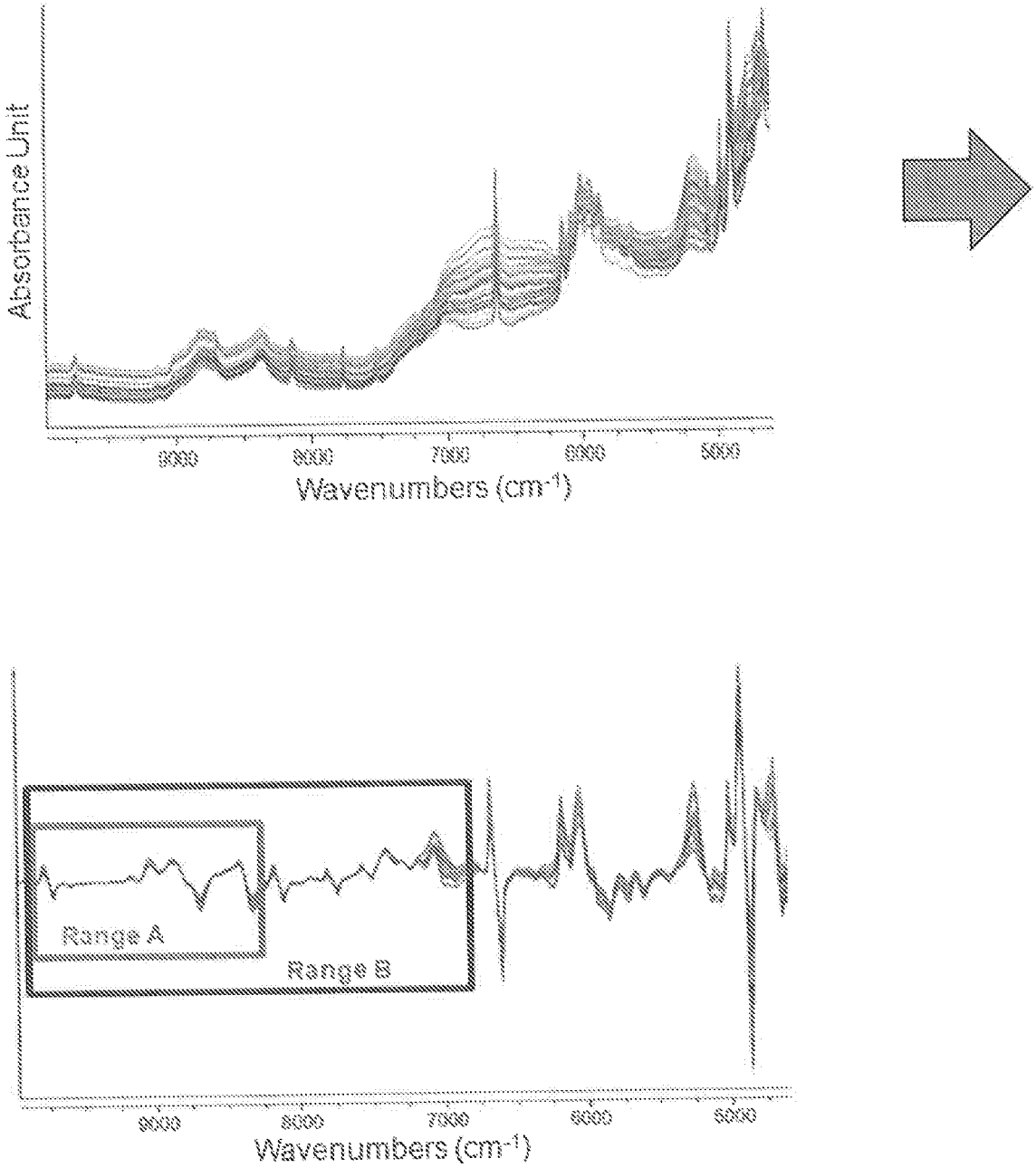

Absorbance Unit
9000
8000
7000
6000
5000
Wavenumbers (cm-1)
Range A
Range B
9000
8000
7000
6000
5000
Wavenumbers (cm-1)

Figure 19

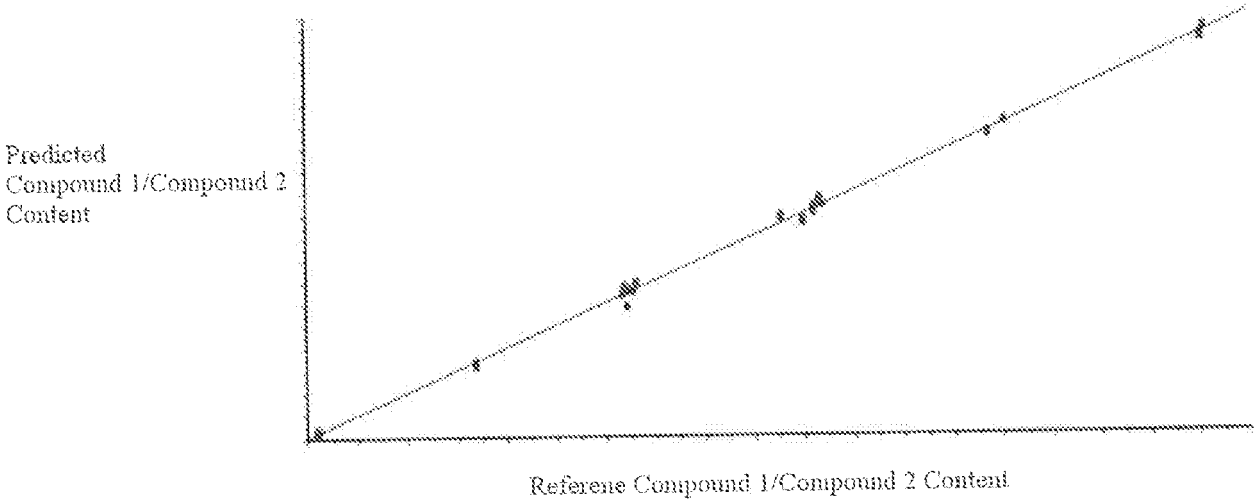

Predicted
Compound 1/Compound 2
Content
Referene Compound 1/Compound 2 Content

Figure 20

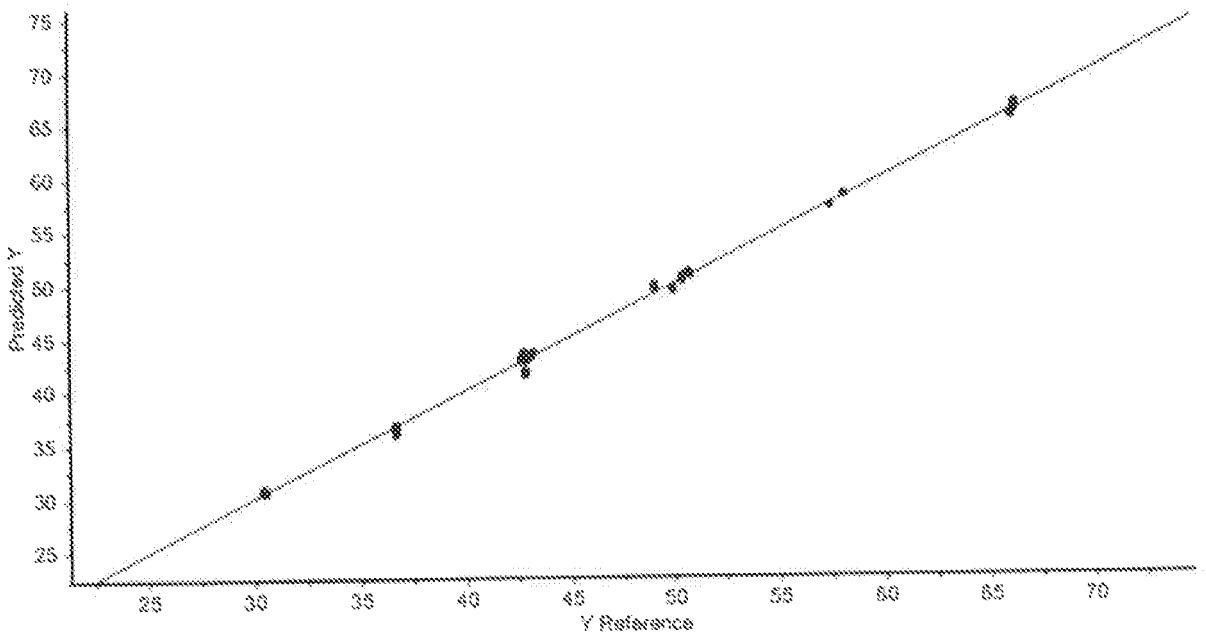

Predicted Y
Y Reference
75
70
65
60
55
50
45
40
35
30
25
25
30
35
40
45
50
55
60
65
70

Figure 21

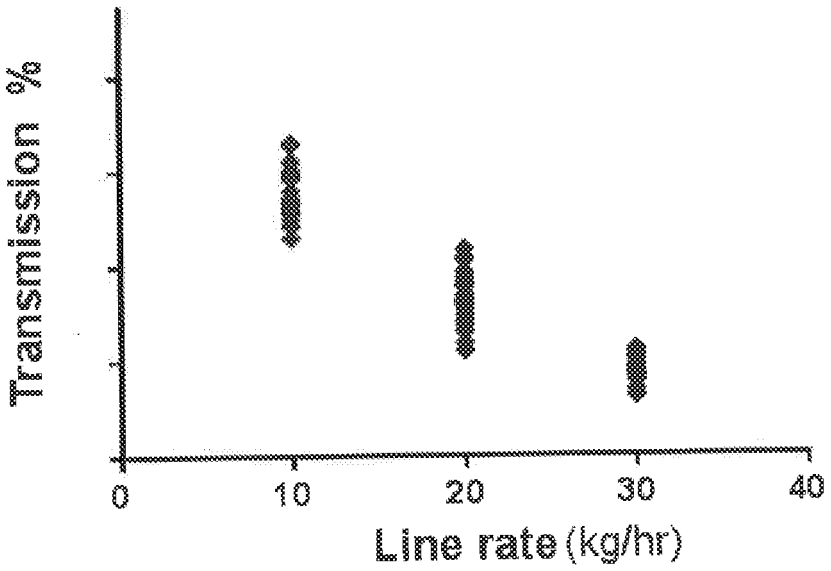


Figure 22

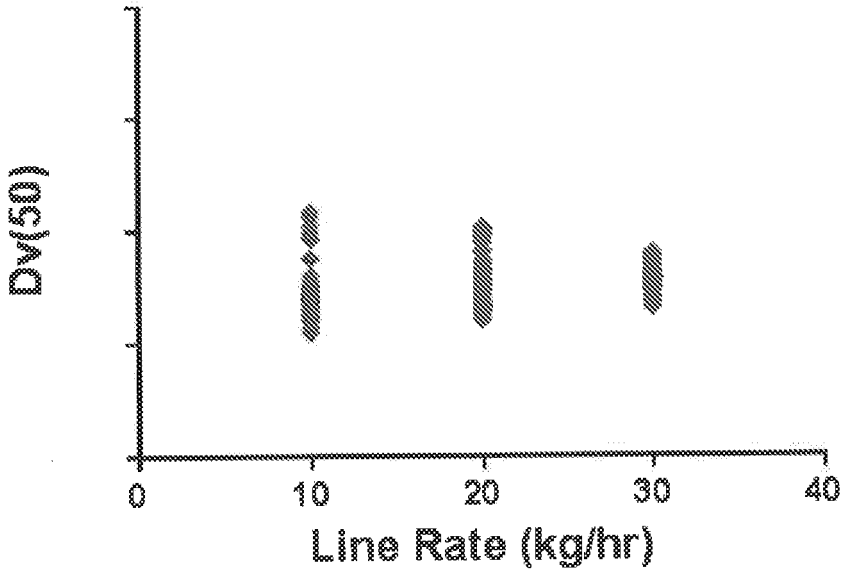


Figure 23

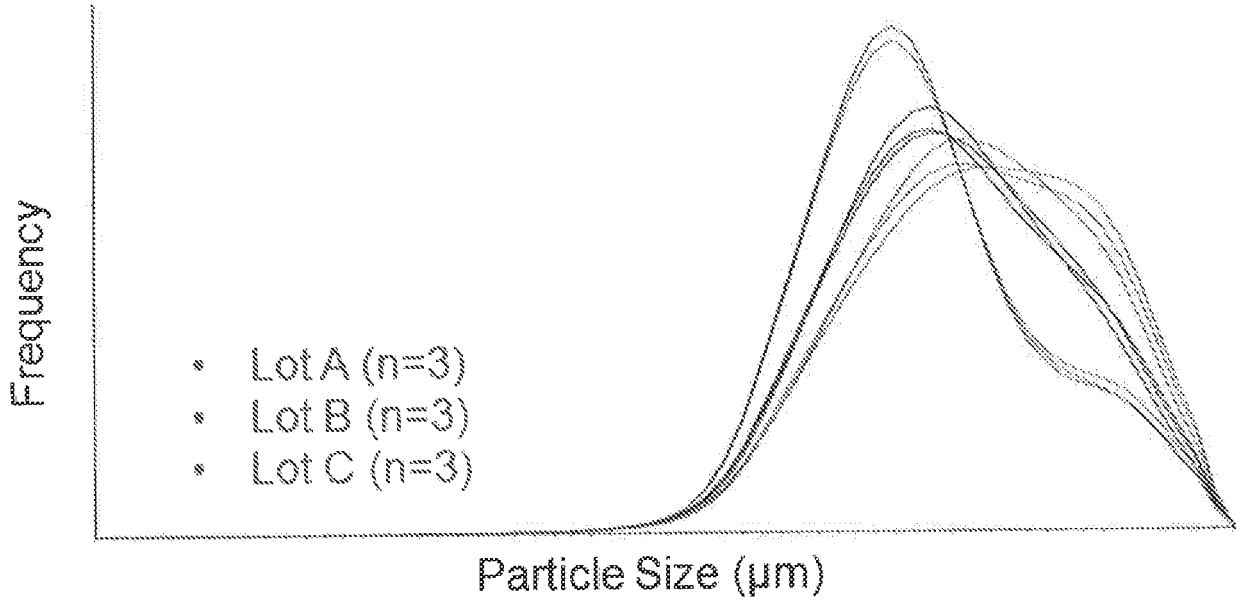


Figure 24

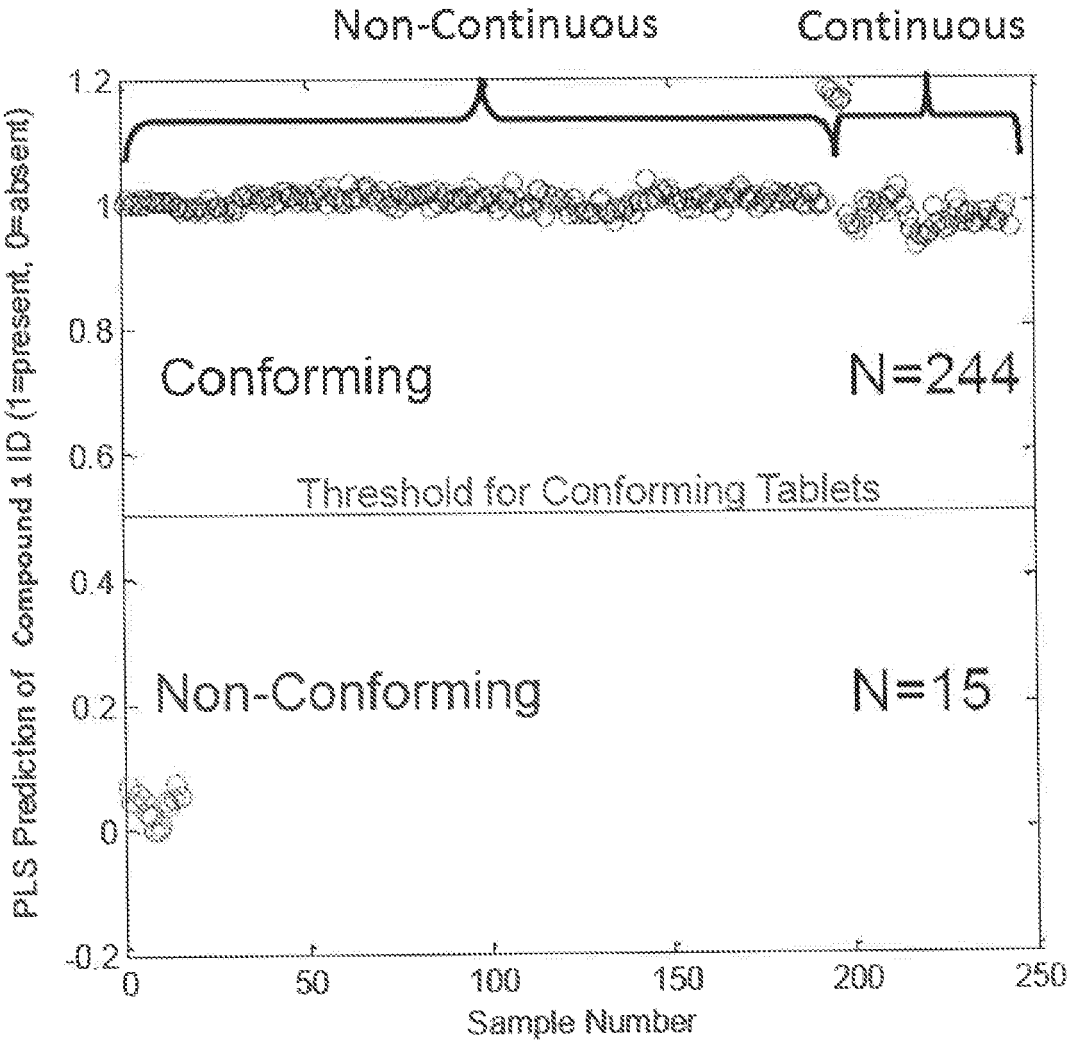
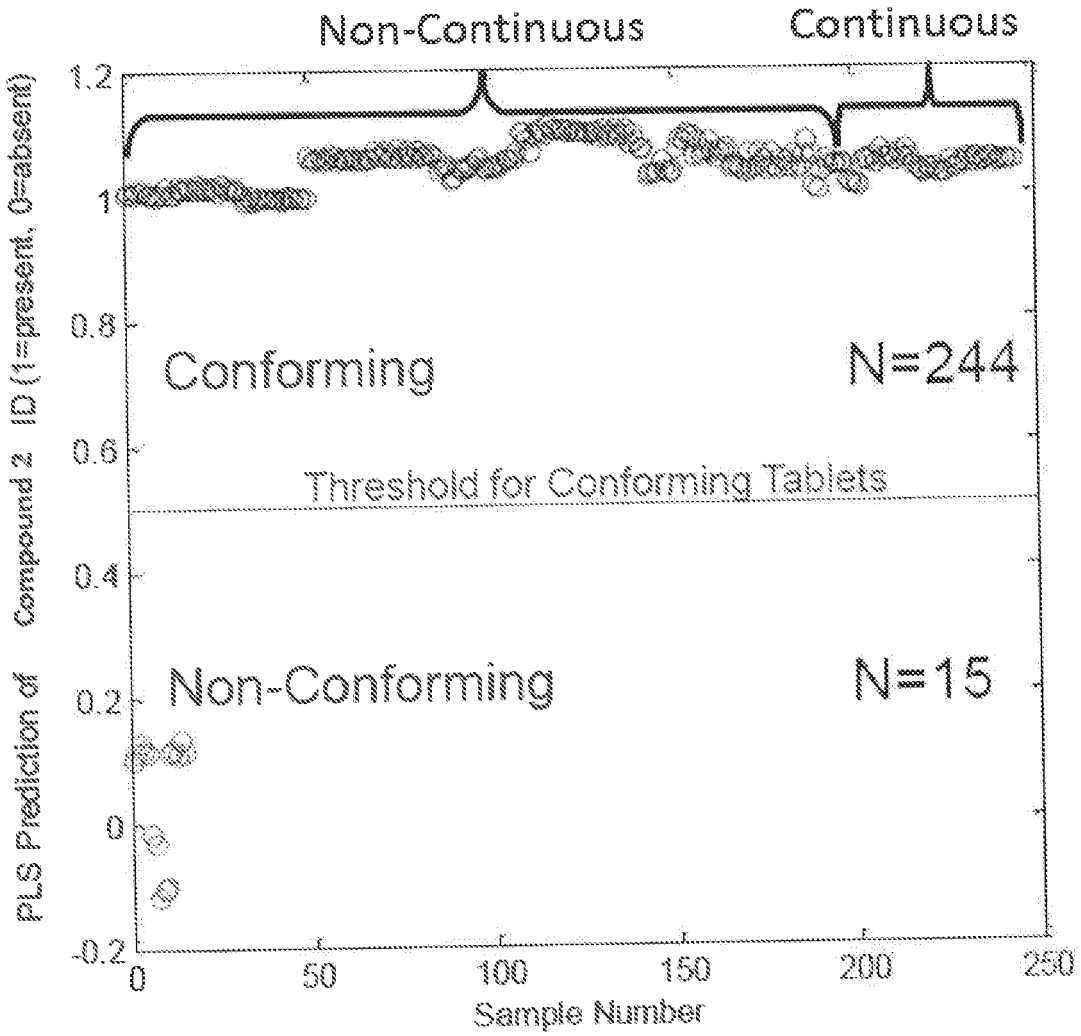

Non-Continuous
Continuous
PLS Prediction of Compound 1 ID (1=present, 0=absent)
1.2
1
0.8
0.6
0.4
0.2
0
-0.2
Conforming
N=244
Threshold for Conforming Tablets
Non-Conforming
N=15
0
50
100
150
200
250
Sample Number

Figure 25


Non-Continuous
Continuous
PLS Prediction of Compound 2 ID (1=present, 0=absent)
1.2
1
0.8
0.6
0.4
0.2
0
-0.2
Conforming
N=244
Threshold for Conforming Tablets
Non-Conforming
N=15
0
50
100
150
200
250
Sample Number