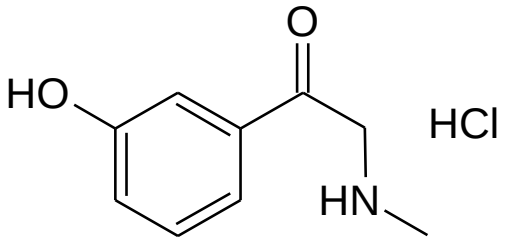
Our Formula. Your Success.

Reference Material Product Information Sheet

Epichem's Quality System conforms to ISO9001:2015 as certified by ECAAS Pty Ltd - Certification number 616061.



Name	3-hydroxy-α-(methylamino)acetophenone hydrochloride
BP/EP Name	Phenylephrine Impurity C hydrochloride
USP Name	Phenylephrine Related Compound C
Synonym(s)	Phenylephrone hydrochloride; α-(methylamino)-3'-hydroxyacetophenone hydrochloride; m-hydroxy-α-(methylamino)acetophenone hydrochloride
Epichem Item #	EPL-AA2 Batch 22
CAS #	94240-17-2
Molecular Formula	$C_9H_{11}NO_2.HCl$
Molecular Weight	201.65 g/mol
Appearance	Pale yellow powder
Melting Point	230.0-232.0°C (decomposition)
Combustion Analysis	Required (%): C:53.6; H:6.0; N:7.0. Found (%): C:53.4; H:6.1; N:6.9.
Purity*	99.2%
Date of Manufacture	3 December 2012
Storage Requirements	Protect from heat, light and moisture.
Special Precautions	**This compound is for laboratory use only. Its toxicological properties may not have been fully established. It should be handled only by suitably qualified personnel.**
Intended Use	This compound is suitable for the identification of impurities and degradants in pharmaceutical materials. T he purity assay is considered as relative contribution.
Date of Shipment	TBA This certificate is valid for one year from the date of shipment provided the substance is stored under the recommended conditions.
Retest Date	TBA (Proper Storage and Handling Required)

** NATA accreditation does not cover the performance of this service*

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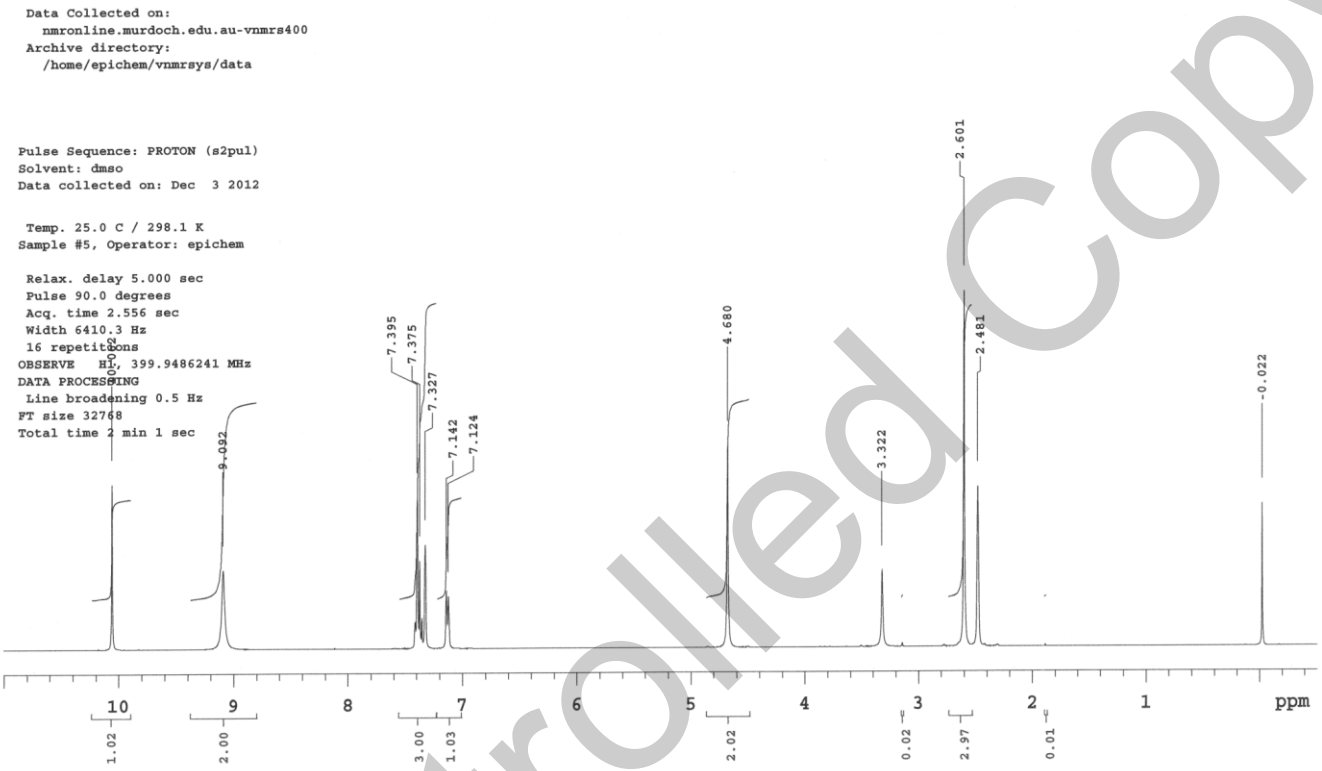
I. Identity

The identity of this product was established using the following analyses:

Ia. ^{1}HNMR Spectrum

Conditions: 400 MHz, DMSO-d_6
^{1}HNMR spectrum consistent with chemical structure.



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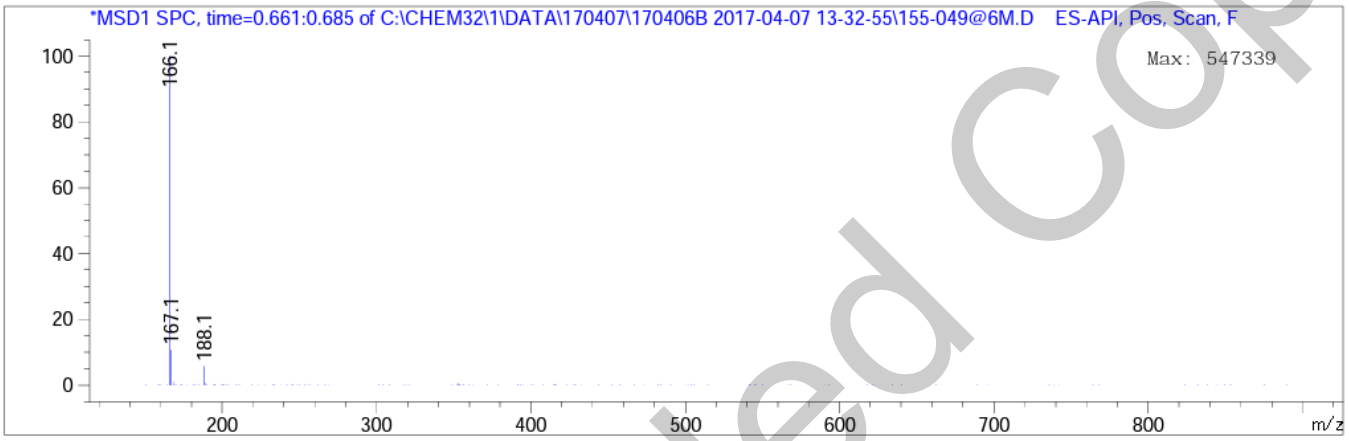
Ib. Mass Spectrum

The mass spectrum of this material was analysed by Liquid Chromatography Mass Spectroscopy (LCMS) using in-house EM005.WI08.

Method: 5% to 100% ACN in water gradient (+0.1% formic acid)

ZORBAX Eclipse XDB-C8, 3.0 x 100mm, 3.5 micron

Retention Time (MS)	MS Area	Mol. Weight or Ion
0.670	2783147	167.10 I
		166.10 I



Theoretical value: 166.1 [M-Cl]+.

The signal of the Mass Spectrum is consistent with the theoretical value and its interpretation is consistent with the structural formula.

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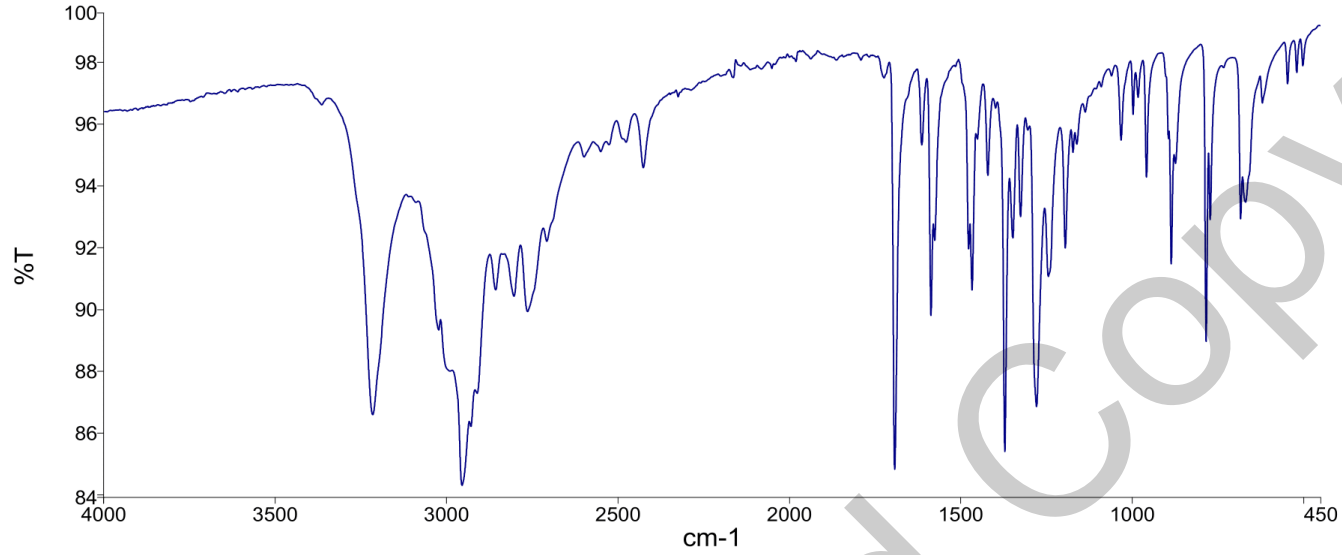
Ic. IR Spectrum

The infra-red spectrum of this material was analysed by Fourier-Transform Infrared Spectroscopy (FTIR) using in-house EM005.WI09.



The interpretation of the signals of the Fourier-Transform Infrared Spectrum is consistent with the structural formula.

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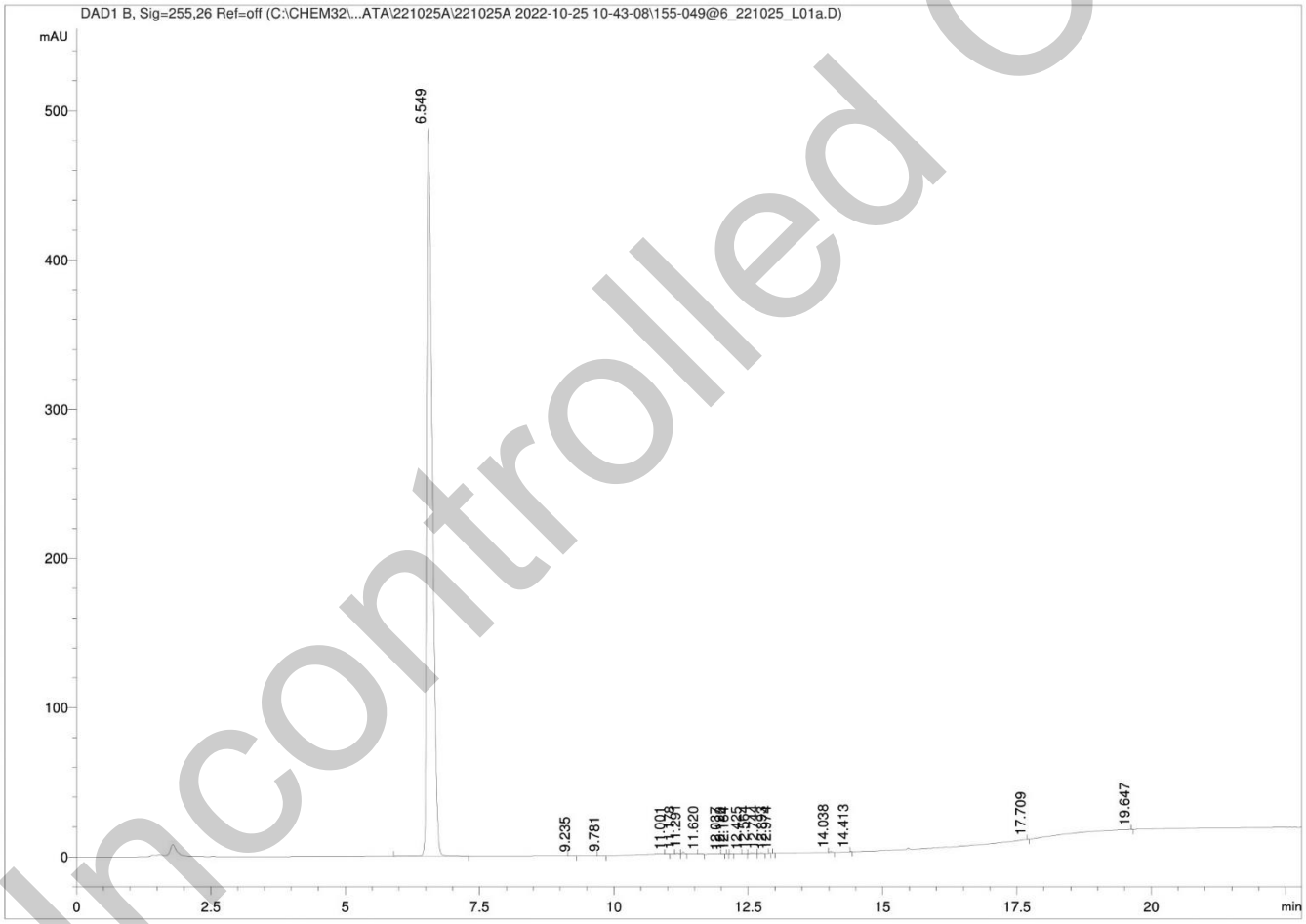
II. Purity

The purity of this material was analysed by high performance liquid chromatography (HPLC) using in-house EM005.WI07.

HPLC Conditions:

Column	Conditions				Detector	Injector
Agilent Poroshell 120 EC-C8 3.0 x 100mm 2.7 micron	25ºC				DAD 255nm	Auto 1.0 µL 0.60 mg/mL in 100% water (+0.1% TFA)
	Time (min)	% Line A (Water + 0.1% (v/v) TFA)	% Line B (Acetonitrile + 0.1% (v/v) TFA)	Flow rate (mL/min)		
	0.00	98	2	0.35		
	6.00	92	8	0.35		
	14.70	5	95	0.35		
	19.70	5	95	0.35		
	20.70	98	2	0.35		
	29.20	98	2	0.35		



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Area Percent Report – Sorted by Signal

Peak Number	Retention Time (rounded)	Area	Area % (rounded)
1	6.55	3568.04	99.61
2	9.23	0.22	0.01
3	9.78	0.49	0.01
4	11.00	0.10	0.00
5	11.18	1.27	0.04
6	11.29	3.60	0.10
7	11.62	1.20	0.03
8	12.04	0.14	0.00
9	12.12	0.03	0.00
10	12.18	0.19	0.01
11	12.42	0.42	0.01
12	12.56	2.30	0.06
13	12.74	1.48	0.04
14	12.89	0.12	0.00
15	12.97	0.27	0.01
16	14.04	1.56	0.04
17	14.41	0.31	0.01
18	17.71	0.16	0.00
19	19.65	0.05	0.00
Totals			100 (rounded)

For the calculation the system peaks were ignored. The content of the analyte was determined as a ratio of the peak area of the analyte and the cumulative areas of the purities, added up to 100%.

Results:

Average 99.6% (average of 10 duplicate runs)

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III. Water Content

Method: Karl-Fischer titration using in-house EM005.WI04.
Results:
Average 0.1%

IV. Ash Content

Method: BP 2012 Ash
Result:
Contains 0.2% ash.

V. Residual Solvents

Method: ^{1}HNMR
Result:
0.1% Methanol by ^{1}HNMR analysis.

VI. Final Result

Chromatographic purity (HPLC)	99.6%
Water content	0.1%
Ash content	0.2%
Residual solvents	0.1%
Purity*	99.2%

This purity is assessed to be 99.2%.

Product Reviewed By:

James Rixson, PhD
Head of Production

Product Released By:

Carol Worth, PhD
Quality Manager
Release Date: 28 October 2022

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The calculation of the purity follows the formula:

$$\text{Purity}(\%) = \frac{((\text{Chromatographicpurity[HPLC]})x(100 - (\text{watercontent} + \text{ashcontent} + \text{volatilecontents})))}{100}$$

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