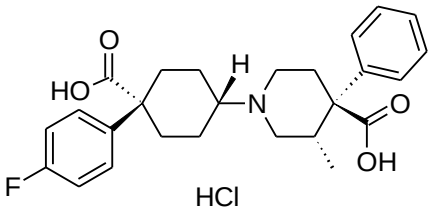
Our Formula. Your Success.

Reference Material Product Information Sheet

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



Name	(3*S*,4*R*)-1-[cis-4-carboxy-4-(4-fluorophenyl)cyclohexyl]-3-methyl-4-phenyl-4-piperidinecarboxylic acid hydrochloride
Other name(s)	Levocabastine diacid impurity
Epichem Item #	EPL-AA262 Batch 1
CAS #	Not available
Molecular Formula	$C_{26}H_{30}FNO_4.HCl$
Molecular Weight	475.99 g/mol
Appearance	White powder
Melting Point	278.1-310.7°C (decomposition)
Combustion Analysis	Required (%): C:65.6; H:6.6; N:2.9. Found (%): C:64.6; H:7.1; N:3.0.
Purity*	91.5%
Date of Manufacture	16 July 2020
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. The 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 unopened and stored under the recommended conditions.
Retest Date	TBA (Proper Storage and Handling Required)

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

EPL-AA262 Batch 1

I. Identity

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

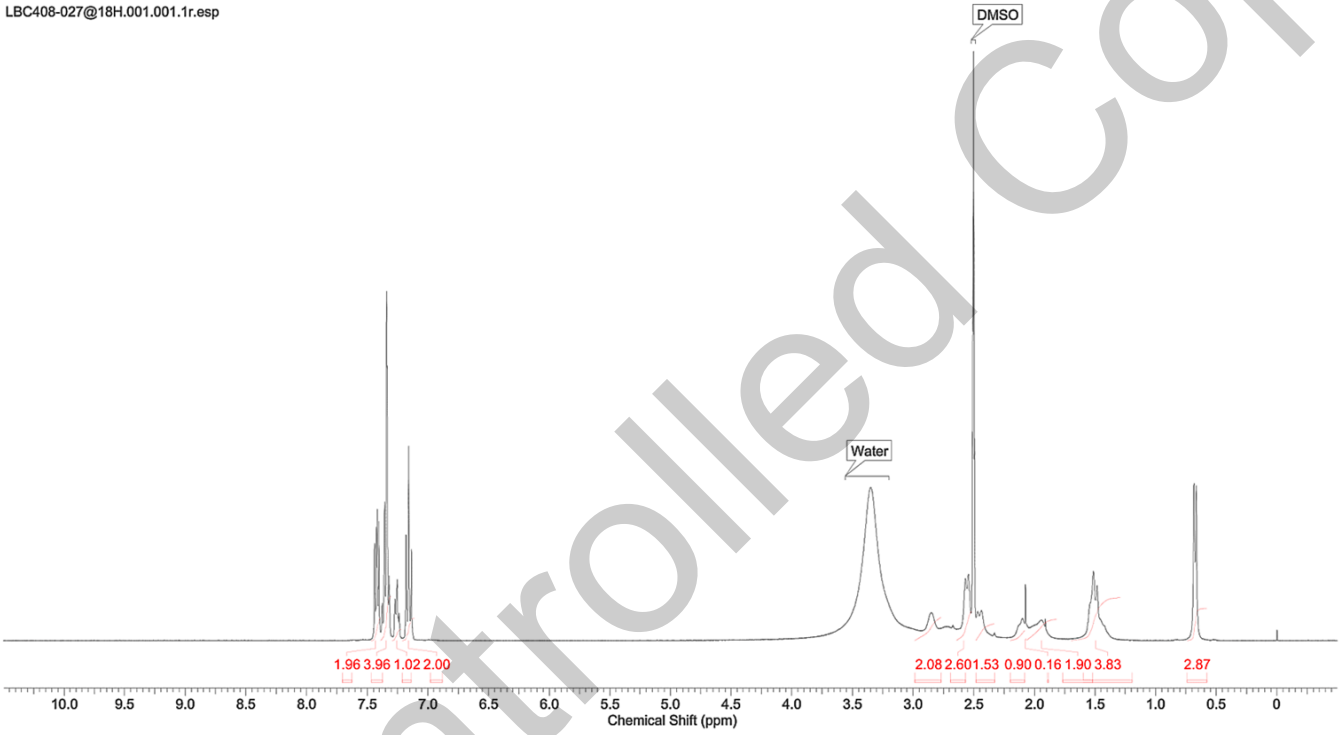
Ia. ^{1}HNMR Spectrum

Conditions: 400 MHz, DMSO-d_6

0.48% acetonitrile by ^{1}H NMR analysis.

Acquisition Time (sec)	3.7547	*Comment*	LBC408-027@18H 1H DMSO {E:\dataexternal\epichem} cygoh 23				
Date	15 Jul 2020 17:29:36			*Date Stamp*	15 Jul 2020 17:29:36		
File Name	\\naphthalene\company\NMR files\LBC408-027@18H\1\pdata\1\1r					*Frequency (MHz)*	400.13
Nucleus	1H	*Number of Transients*	8	*Origin*	spect	*Original Points Count*	24038
Owner	nmr	*Points Count*	32768	*Pulse Sequence*	zg	*Receiver Gain*	114.00
SW(cyclical) (Hz)	6402.05	*Solvent*	DMSO-d6	*Spectrum Offset (Hz)*	2798.1606	*Spectrum Type*	STANDARD
Sweep Width (Hz)	6401.85	*Temperature (degree C)*	24.996				

LBC408-027@18H.001.001.1r.esp



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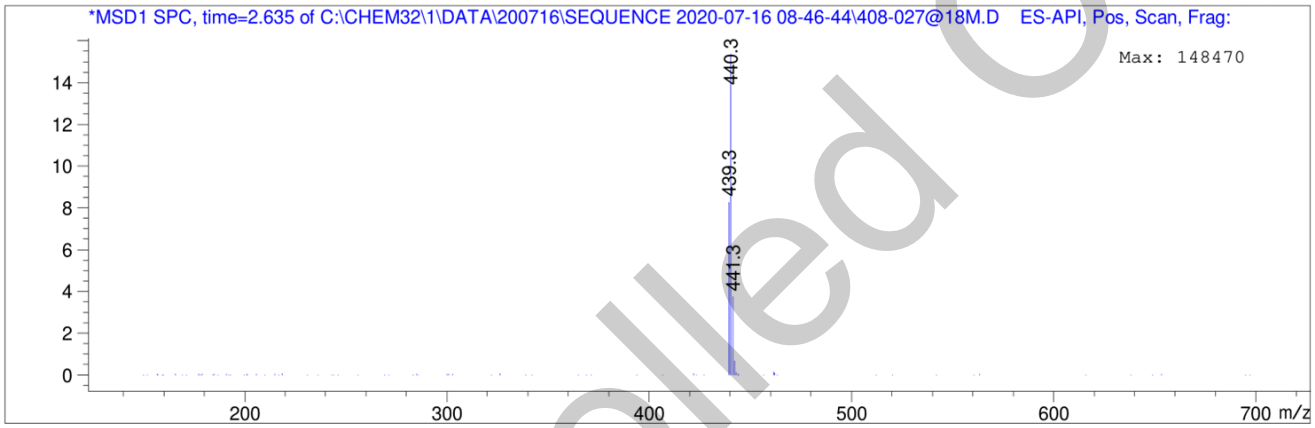
Ib. Mass Spectrum

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

Method: ACN/water gradient (+ 0.1% formic acid).

ZORBAX SB-C8, 4.6 x 30 mm, 3.5 micron.

Retention Time (MS)	MS Area	Mol. Weight or Ion
2.635	1004751	441.30 I
		440.30 I
		439.30 I
2.752	20898214	441.25 I
		440.20 I



Theoretical value: 440.3 $[M\text{-}Cl^-]+$.

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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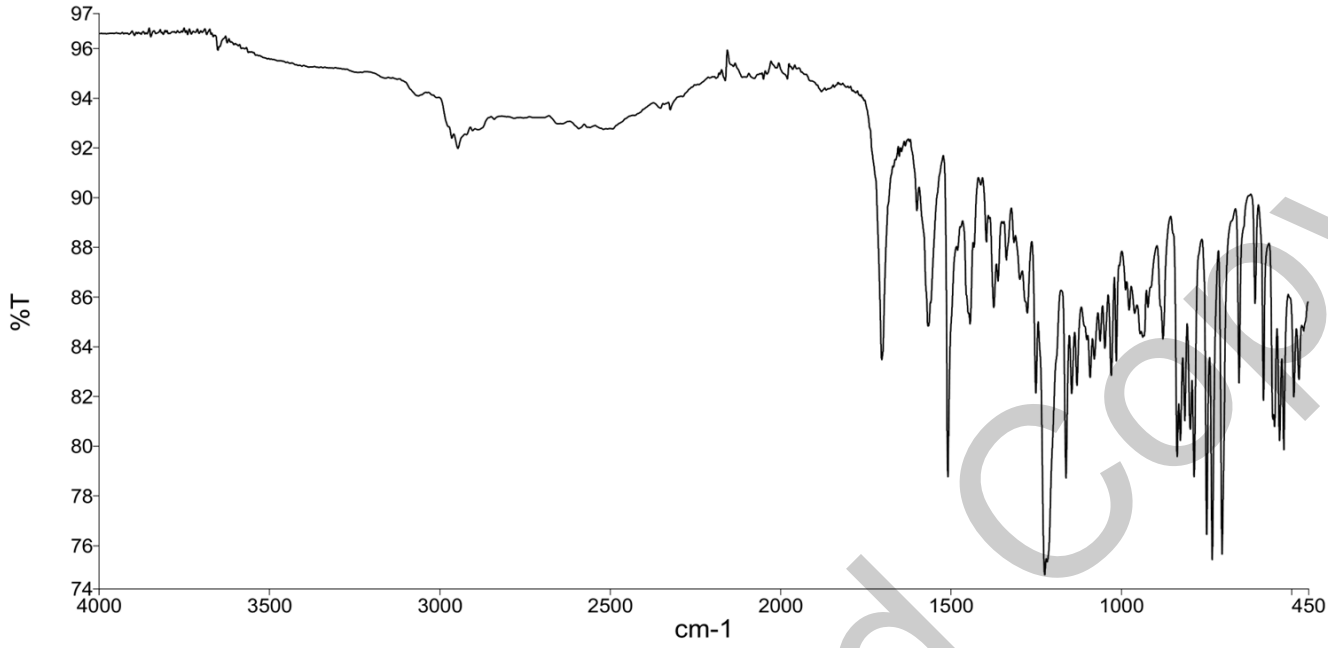
Ic. IR Spectrum

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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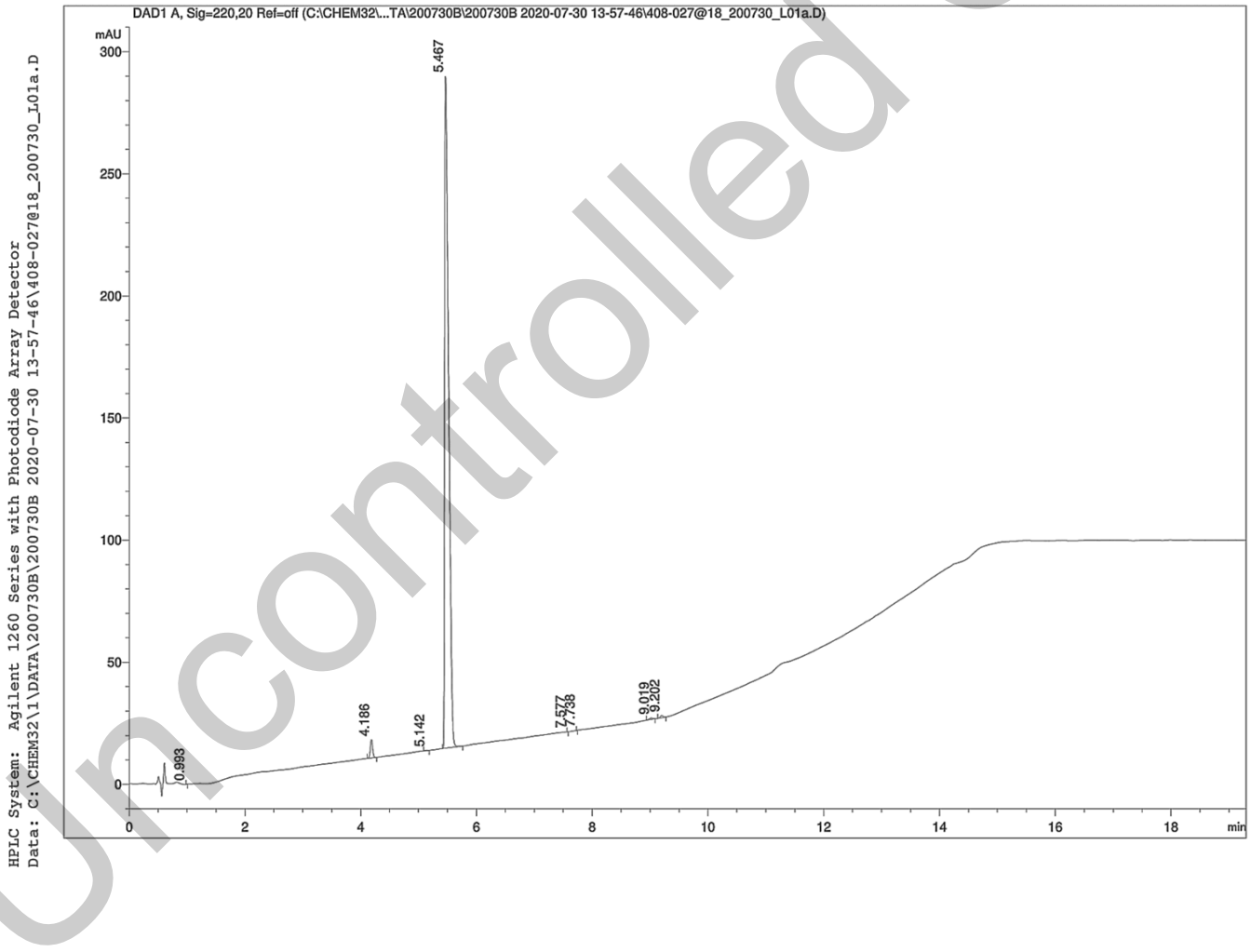
II. Purity

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-C18 4.6 x 50mm 2.7 micron	25ºC				DAD 220nm	Auto 5.0 µL 0.25 mg/mL in 20% acetonitrile 80% 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	80	20	1.0		
	8.00	56	44	1.0		
	13.10	5	95	1.0		
	18.10	5	95	1.0		
	19.10	80	20	1.0		
	22.10	80	20	1.0		



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Area Percent Report – Sorted by Signal

Peak Number	Retention Time (rounded)	Area	Area % (rounded)
1	0.99	0.02	0.00
2	4.19	21.24	1.60
3	5.14	0.45	0.03
4	5.47	1296.08	97.93
5	7.58	0.10	0.01
6	7.74	0.05	0.00
7	9.02	2.31	0.17
8	9.20	3.18	0.24
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 98.0% (average of 10 duplicate analyses)

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III. Water Content

Method: Karl-Fischer titration using in-house EM005.WI04.

Results:

Average 5.1%

IV. Ash Content

Method: BP2020 Ash Appendix XI J Method II

Result:

Contains 1.0% ash.

V. Residual Solvents

Method: ^{1}HNMR

Result:

0.5% acetonitrile by ^{1}H NMR analysis.

VI. Final Result

Chromatographic purity (HPLC)	98.0%
Water content	5.1%
Ash content	1.0%
Residual solvents	0.5%
Purity*	91.5%

This purity is assessed to be 91.5%.

Product Reviewed By:

James Rixson, PhD
Head of Fine Chemicals & Technical Services

Product Released By:

Boon Tan
Quality Manager

Release Date: 6 August 2020

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