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Control and Prediction of Solid-State of Pharmaceuticals

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Rajni M. Bhardwaj

Control and Prediction of Solid-State of Pharmaceuticals

Experimental and Computational Approaches

Doctoral Thesis accepted by
the University of Strathclyde, Scotland, UK

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Supervisor's Foreword

Crystallisation is an important process for purification and isolation of active pharmaceuticals and other chemicals, yet the critical factors that dictate the outcome for a given molecule under any given set of process conditions often remain unclear. Hence the identification and selection of potential crystalline forms during the development of new products still largely relies on empirical relationships and user experience to select initial experimental conditions and maximise the number of solid forms discovered. Whilst crystal structure prediction can be applied to increasingly complex molecular systems (flexible molecules; multi-component systems), it is still far from routine, and has the potential to inform experimental approaches by revealing the structural features and trends in feasible crystal packing arrangements. The work presented in this thesis seeks to develop improved experimental approaches for exploring physical form diversity in molecular systems and to exploit computational methods to provide a better understanding of the outcomes of such investigations as well as novel, computationally inexpensive, predictive capabilities. The work focuses on a structurally related series of molecules and provides insights into the differences that can result in crystallisation from small changes in molecular structure in such related systems.

Cost-effective, safe, rapid and sustainable methods for exploring solid-state diversity are of significant interest in academic research as well as industry. The development of a small-scale screening approach using manual multiwall plate preparation and Raman microscopy for effective salt, polymorph and solvate screening provides an effective means to generate structural diversity from only small amounts of material. The quality of this work has been recognised by the RSC "Duncan Bryant Prize" prize in 2012. The next experimental chapter shows the potential to build predictive capability based on the outcomes of such systematic experimental studies. At present we have no means of assessing 'crystallizability' of molecules-based molecular structure alone and so can be surprised by individual molecules' behaviour. The crystallizability prediction tool developed in this work emphasises the potential for multivariate statistical approaches combined with systematic experimentation to provide some useful predictive capability. In the

context of solid form discovery and preclinical development, if such approaches can be extended to cover a diverse range of molecules then there are considerable benefits in the early identification of problem compounds. The work on olanzapine solvates also highlights the potential to further extend the application of these tools to understand the crystal structure and molecular packing obtained from experimental tools and build a useful knowledge base that can inform future experiments for successful outcomes. The success of the work in this thesis has ensured that these approaches continue to be developed for application in other molecular systems. The detailed study on polymorphism and crystal packing in olanzapine is a showcase for the potential for combined crystal structure prediction, molecular modelling, packing analysis and intermolecular interactions to reveal the key features directing crystal structure. Crucially, this work also reveals key structure–property relationships enabling the rationalisation of the observed stability of solvated forms.

Overall, the work illustrates the potential for computationally assisted experimentation not just to provide more data, but also better information describing the factors that influence crystallisation and crystal structure. Moreover, it highlights the possibilities to improve the efficiency of early stage solid form discovery and selection. Whilst challenges remain for first principles prediction from molecular structure alone, there is still much more that can be achieved with existing tools. The work presented here continues to influence research in our group that seeks to extend the development and application of statistical models to assess completeness of physical form screens and enhance our understanding of crystal structure outcomes. It has also influenced our approach to training and skills development for researchers in this area to enable the increased use of multivariate analysis tools, molecular modelling and structure prediction alongside careful experimentation and analysis.

Glasgow, Scotland, UK
December 2015

Prof. Alastair J. Florence Ph.D

Abstract

This thesis illustrates techniques for discovery of solid-state forms and for probing the relationship between molecular structure and crystallisability. Also, the value of combined experimental and computational approaches to provide better understanding of the key factors underpinning the structural diversity in two groups each comprising of two structurally related pharmaceutical compounds is demonstrated.

An effective methodology of high throughput crystallisation and analysis for polymorph, solvate and salt screening using quartz 96/48 multi-well plate with an automated system for collecting high quality Raman spectra was developed and validated. Using this efficient technique, 10 novel salts of amoxapine, 3 novel physical forms of clozapine and 16 novel solid forms of olanzapine were obtained by utilising a total of only ~640 mgs of API and ~65 ml of solvents.

A statistical model with ~70 % prediction accuracy was built for predicting the crystallisability of small organic molecules. This model is the first of its kind and provides an opportunity to identify problematic systems at early stages and allows early targeting for improvements.

Structurally related molecules within each group were found to have markedly different experimental solid-state diversity after comprehensive physical form screening using multiple crystallisation techniques selected to maximise the crystallisation search space. Crystal structure prediction studies have proved to be an important tool in rationalisation of the observed solid-state diversity. PIXEL calculations revealed that the largest contribution to crystal stabilisation comes from dispersion energy and enabled the identification of dominant intermolecular interactions in the crystal structures. Structural packing analysis using XPac and mercury enabled the structural relationship amongst all the crystal structures to be investigated. In the case of olanzapine solvates XPac analysis provides a rationale for desolvation products by highlighting the close relationships between the forms and desolvated 'end product'. Statistical modelling analysis revealed that the physicochemical properties of the solvents were directing the crystal packing in olanzapine solvates.

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Abbreviations

API	Active Pharmaceutical Ingredient
AXPN	Amoxapine
CBZ	Carbamazepine
CSD	Cambridge Structure Database
CSP	Crystal Structure Prediction
CT	Chlorothiazide
CZPN	Clozapine
DOE	Design of Experiment
E_C	Coulombic Energy
E_d	Dispersion Energy
E_p	Polarisation Energy
E_r	Repulsive Energy
E_{tot}	Total Lattice Energy
HCT	Hydrochlorothiazide
HTC	High Throughput Crystallisation
HTCAA	High Throughput Crystallisation and Analysis
LXPN	Loxapine
MWP	Multi-well Plate
OZPN	Olanzapine
PCA	Principal Component Analysis
QbD	Quality by Design
RF	Random Forests
RH	Relative Humidity
SC	Supramolecular Construct
SDPD	Structure Determination from Powder data
SXD	Single Crystal X-ray Diffraction
VT-XRPD	Variable Temperature X-ray Powder Diffraction
XRPD	X-ray Powder Diffraction

Chapter 1

Introduction

1.1 Background

Pharmaceutical products frequently display multiple solid-state forms of the same chemical entity including polymorphs, salts, solvates, co-crystals and amorphous solids. According to one literature report based on 245 screens carried out by SSCI (a division of Aptuit Inc.), ~80 % of the screened compounds exhibited multiple solid-state forms (Stahly 2007). Sometimes, the properties of two solid forms of a drug do not show substantial differences however they can, and often do, vary substantially with potentially significant impact on important physicochemical properties including solubility that may impact on the ease of manufacturing, stability of the drug in a formulated dosage form as well as bioavailability (Huang and Tong 2004; Llinàs and Goodman 2008). A fundamental impact of a change in solid-state structure is on aqueous solubility, which is a prerequisite for the efficient absorption of drug (Tian et al. 2007; Koradia et al. 2011) from the gastrointestinal tract (GIT). Thus, establishing biological activity with minimal side effects is not enough to enable molecules to progress to the clinical development stage: bio-pharmaceutical properties are also vitally important and the solid-state form of the drug is a considerable part of this and must be characterised and controlled (Aaltonen et al. 2009).

The crystallisation behaviour of active pharmaceutical ingredients (APIs) needs to be fully explored and understood to enable control over purity, crystal form, particle size, particle size distribution, degree of crystallinity and crystal habit. All of these properties can affect bulk properties such as compaction, tableting, flowability and mixing (Pfeiffer et al. 1970) and ultimately product performance.

For commercial pharmaceutical products, the most thermodynamically stable crystalline form under ambient conditions is typically the most desirable one (Miller et al. 2005). There are exceptions to this practice, e.g. some marketed formulations of norfloxacin contain a metastable form (Barbas et al. 2007). Whilst metastable polymorphs can offer advantages such as enhanced solubility, they also can revert

to more stable less soluble forms. A well-documented example of catastrophic transition from a metastable to stable polymorphic form is that of Ritonavir (Norvir™, Abbot Laboratories). The formulation (Norvir™) consisted of the only known polymorph of ritonavir at that time and was marketed and distributed for 18 months. Later on, the appearance of a more thermodynamically stable and less soluble form during manufacturing resulted in reduced bioavailability of the final product. The product had to be reformulated with the new polymorph to achieve the desired bioavailability (Bauer et al. 2001). Had information on the various forms of ritonavir and their properties been known prior to marketing of the product, the market recall and subsequent expense to manufacturer and risk to patients could have been avoided. Therefore, in order to assure that the correct form with known defined properties is used, there is a need to explore all potential solid-state forms of a given molecule (Llinàs and Goodman 2008). However, even after selecting the appropriate solid-state form, phase transformations (polymorphic changes or desolvation or amorphisation) that occur during processing or storage cannot be completely ruled out. Hence, it is necessary to identify and characterise the phase changes to avoid the risk of transformation of active solid form to less/non-active solid form (Koradia et al. 2011).

In addition to physical changes, alternative solid-state forms can display different chemical stability (Byrn 1982) with different rates of solid-state chemical reactions and consequent variations in the relative proportion of degradation product(s). For example, NCEX, a dual peroxisome proliferator-activated receptors (PPAR) agonist exists in two monotropically related polymorphs, form I and II with melting points of 160 and 140 °C, respectively. Form I and II showed 0.3 and 6.0 % total degradation respectively after 4 weeks of storage at 40 °C and 75 % RH (accelerated stability storage conditions). The amorphous form showed much higher degradation (20 %) under similar conditions. (Huang and Tong 2004). Due to different microenvironmental pH and molecular arrangements in the crystal lattice, photochemical stability

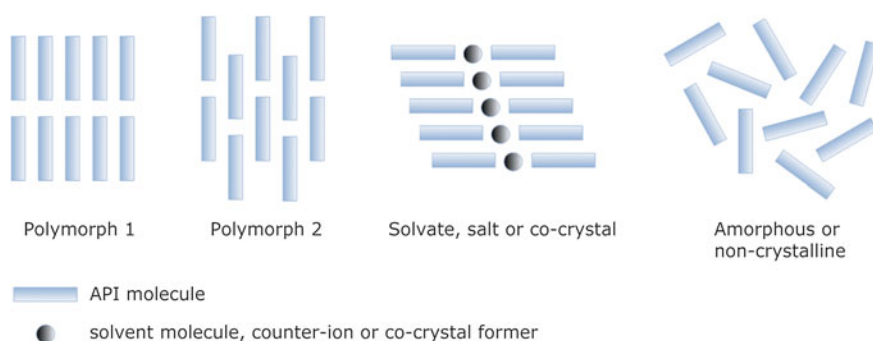


Fig. 1.1 Schematic illustration of molecular arrangements of different solid forms showing ordered arrangement in crystalline forms and molecule disorder in amorphous form. Reproduced from reference (Florence 2009)

of the salt formulations may vary (Huang and Tong 2004). For example, the hydrochloride salt of GG818 showed higher photostability as compared to the free base (Tong et al. 1999).

Polymorphs and solvates/hydrates are encountered frequently (Kitamura 2005) during drug development and there is still a considerable challenge in control and prediction of the appearance of all possible solid-state forms. The various solid forms that may be encountered for a given organic solid include polymorphs, solvates, salts, co-crystals and non-crystalline or amorphous forms (Fig. 1.1).

1.2 Polymorphism

Polymorphs are chemically identical crystalline forms of a chemical entity in which the constituent molecules have different packing arrangements and/or conformations in the crystal lattices (Vippagunta et al. 2001). Conformational flexibility and hydrogen bonding are the most important factors responsible for polymorphism (Yu et al. 2000). However, predicting the polymorphic behaviour or number of polymorphs of a compound is still a challenging task (Grzesiak et al. 2003; Price 2008a; Lutker and Matzger 2010; Bardwell et al. 2011).

Packing polymorphism arises when constituent molecules with specific rigid conformation are packed in different arrangements which may or may not have same intermolecular binding motifs. Packing polymorphism has been reported in five polymorphs of carbamazepine (CBZ) (Fig. 1.2) in which forms I–IV are based on amide-amide hydrogen bonded dimers (Grzesiak et al. 2003), whereas form V is based on N-H...O = C catemeric motif (Arlin et al. 2011).

Conformational polymorphism is observed when constituent flexible molecules with different molecular conformations are packed in different arrangements (Nangia 2008). L-glutamic acid for example exhibits conformational polymorphism, in which the β -polymorph is based on an extended conformation and α -polymorph is based on a twisted conformation (Fig. 1.3) (Davey et al. 1997).

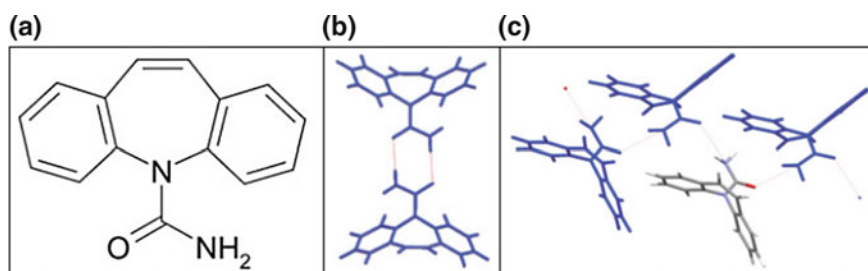


Fig. 1.2 **a** Molecular structure of carbamazepine, **b** dimer motif of carbamazepine present in form I–IV (Florence et al. 2006), and **c** catemeric motif of carbamazepine present in form V (Arlin et al. 2011)

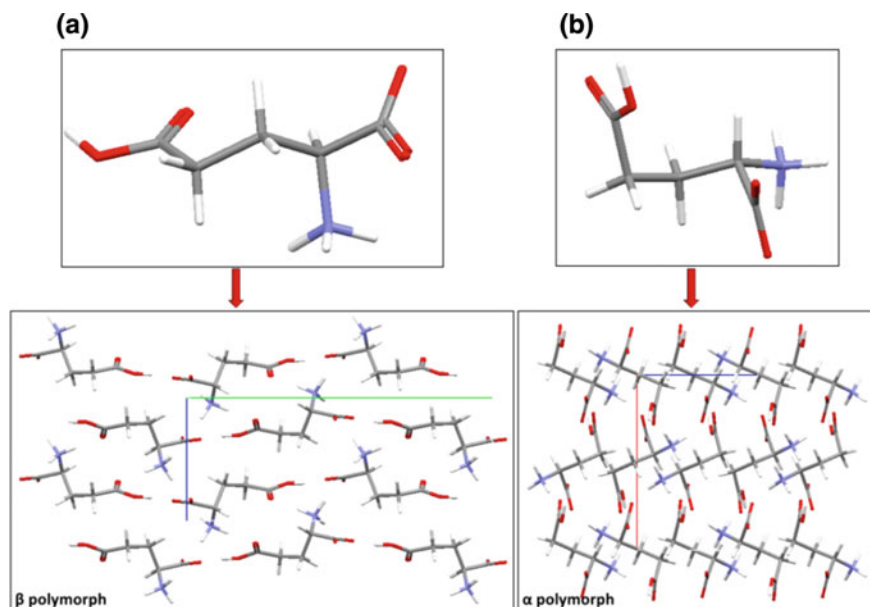


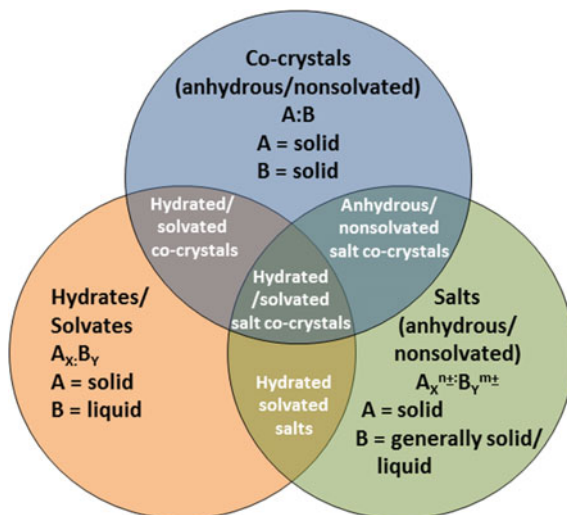
Fig. 1.3 **a** Extended conformation of L-glutamic acid which leads to the β -polymorph (CSD refcode: LGLUAC11), and **b** twisted conformation of L-glutamic acid which leads to α -polymorph (CSD refcode: LGLUAC03)

1.3 Multi-component Crystalline Systems: Solvates, Salts and Co-crystals

Multi-component systems (solvates, salts and co-crystals) have more than one type of molecule in the crystal lattice (Fig. 1.4) (Almarsson and Zaworotko 2004). These multi-component systems can also display polymorphism, adding to the complexity of the experimental crystal energy landscape.

Solvates are crystalline solids in which the stoichiometry of the constituent chemical species is A_xB_y , where A and B are the higher and lower molecular weight components, respectively (Angelo 2007). This definition coincides with the traditional definition of a solvate, where B is liquid at the room temperature (RT). X is a small integer and Y is any integer number greater than 0 (Angelo 2007). Generally, solvent molecules from the solvent of crystallisation are incorporated in the crystal lattice with the organic solute or API. When the solvent is water the structure is known as a hydrate. Hydrates have particular pharmaceutical relevance and roughly 75 % of the pharmaceutical compounds form hydrates (Infantes et al. 2003). Some examples of the marketed pharmaceutical hydrates are ciprofloxacin hexahydrate, morphine hydrochloride hydrate, naloxone hydrochloride dihydrate and rosiglitazone maleate hydrate.

Fig. 1.4 Multi-component systems and their overlap with each other. Reproduced from reference (Aitipamula et al. 2012)



Salts are $A_x^{n\pm} B_y^{m\pm}$ solids, where A is the higher molecular weight component with an integer charge and B is a counterion (Angelo 2007) (Fig. 1.4). There is a proton transfer from acid to base resulting in neutralisation of charge. Approximately two-third of the APIs are ionisable (weakly acidic or basic entities) and therefore, salt formation provides a significant opportunity to improve the physicochemical properties without altering the molecular structure and the mode of action of the API (Gould 1986).

The introduction of a charge on the molecule enhances aqueous solubility, however other properties such as melting point as well as the polymorphic profile of the molecule may also change. Each new salt is a new chemical entity and therefore polymorph screening must be carried out on each salt form of interest. For acidic molecules, sodium, potassium and calcium are the most commonly used counter ions while for basic molecules chloride is the most prevalent counter ion (Bernstein 2002). Also sodium salts can often form hydrates as a result of the sodium ion seeking to satisfy its coordination shell creating more complexity in the crystal structure landscape (Marcus 1991). Some examples of drugs which are marketed as salts are naltrexone, diclofenac, flurbiprofen, cimetidine, and phenytoin (Bernstein 2002).

Co-crystals are comprised of two or more species, similar to salts, except that the molecules are non-ionised. Both co-crystals and solvates are comprised of two or more neutral species; however co-crystals formation has been subjected increasingly to efforts to achieve an element of design (Bernstein 2005), i.e. intended structural or physical properties as a result of rational design or crystal engineering approaches. Co-crystals can be used to alter the physicochemical properties like aqueous solubility or melting point and stability as compared to parent compound (Trask et al. 2006; Aakeröy et al. 2009).

There is some debate on the formal definition of a co-crystal in the scientific literature. Desiraju has referred to these systems as molecular complexes

(Desiraju 2003), however solvates and hydrates can also be considered as co-crystals as per this definition. Later, according to Aakeroy and Salmon, all co-crystals components should be solid at RT (Aakeroy and Salmon 2005). Although this definition excludes systems where one component is a liquid or gas by intent (Bond 2007) and Stahly debated that the physicochemical properties of the co-crystal components should not be important (Stahly 2007).

In December 2011, FDA proposed a definition of co-crystal in a draft guidance as “solids that are crystalline materials composed of two or more molecules in the same crystal lattice”. The guidance recommends that co-crystals should be classified within the Agency’s current regulatory framework as dissociable “API-excipient” molecular complexes (with the neutral guest compound being the excipient). Molecular association of API and the excipient(s) occurs within the crystal lattice and co-crystal may be treated as a drug product intermediate rather than as a drug (USFDA 2011). This proposed definition has prompted further debate and a universal definition remains to be established (Aitipamula et al. 2012).

1.4 Amorphous Solids

An amorphous material is a non-crystalline solid which does not possess long-range internal molecular order. In their diffraction patterns, they give only a diffuse scattering halo with no Bragg diffraction peaks. Crystallisation of amorphous form provides an alternate route of obtaining different polymorphs. For example different polymorphs of indomethacin were obtained by crystallisation of amorphous solid at various temperatures. This study also showed that the polymorphic outcome was affected by the small variations in sample handling of generated amorphous form (Bhugra et al. 2008). Various polymer surfaces can also be used as a template to direct the crystallisation of amorphous form. For example, α -polymorph of indomethacin was selectively obtained from recrystallisation of super cooled melt of indomethacin and polymer substrate (Grzesiak et al. 2006; McKellar et al. 2012).

1.5 Importance of Solid-State Form for Pharmaceutical Industry

Physical form screening has become a standard procedure in the pharmaceutical industry. The phenomenon of polymorphism has been known since the early 19th century but study of polymorphism was not a standard procedure until the last decade of the 20th century. The production problems such as sudden appearance of thermodynamically more stable polymorph of Ritonavir (NorvirTM, Abbot Laboratories) with low solubility and bioavailability (Chemburkar et al. 2000), patent cases (Bernstein 2002) and enormously expensive Hatch-Waxman

agreement between innovator and generic pharmaceutical companies (Bulow 2004) acted as a motivation for the pharmaceutical industry to take polymorphism seriously (Aaltonen et al. 2009).

The famous patent litigation case between Glaxo and Genpharm/Novopharm for Ranitidine hydrochloride (Zantac[®]) brought to attention the concept of role of solvent, heating, stirring and seeding techniques to control polymorphic form and the relative stability of polymorphic forms. This litigation case also highlighted the importance of development and use of analytical methods for full characterisation of polymorphic forms (Bernstein June 19, 2004). Regulatory authorities now ask for full characterisation of the solid-state forms during drug approval. Therefore, to avoid the risks associated with latent polymorphism, phase transformation during processing or storage and expensive patent litigations, comprehensive understanding and control of the solid-state behaviour of API's has become an integral part of the drug development for innovator pharmaceutical companies.

1.6 Crystallisation

Crystallisation is the formation of solid crystals consisting of 3-D periodic arrangement of atoms and molecules, which are held together by a wide variety of intermolecular interactions. Some interactions such as the hydrogen bonds (H-bonds) act over a short range and are directional in nature. Whilst other interactions act over longer ranges and are non-directional. All these intermolecular interactions are responsible for molecular recognition, self-assembly, cohesion of molecules in a periodic arrangement and the solid-state properties. Although crystals can be obtained from melt or gas states, crystallisation from solution is the most common and is often the method of choice for purification for industrial processes (Mullin 1971; Ejgenberg and Mastai 2012).

Crystallisation from solution consists of three stages: supersaturation, nucleation, and growth of the nuclei into crystals. Supersaturation is described as when a solution contains higher concentration of solute than an equilibrium concentration of the solute (Laudise 1970). Supersaturation can be achieved by various methods including different rate of solvent evaporation, antisolvent addition, different rate of cooling, pH change, varying concentration or temperature change (Rodríguez-hornedo and Murphy 1999). All these methods are practised with the purpose of manoeuvring solute concentration.

The next stage after achieving supersaturation is nucleation which can be defined as the assembly of ordered molecules into viable nuclei. Critical number of ordered molecules per assembly is required to prevent dissolution and produce a feasible nucleus, which acts as a template for crystal growth. With time the nucleus grows and more solute molecules join the assembly thereby increasing the adhesive solute-solute (internal) interactions which outweigh the disruptive solute-solvent (surface) interactions, leading to cessation of re-dissolution and promotion of crystal growth.

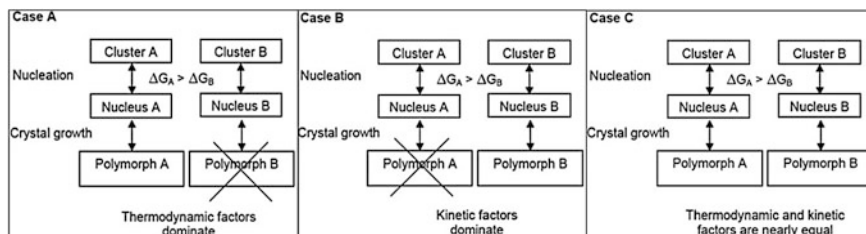


Fig. 1.5 Plausible scenarios of crystallisation outcome in a dimorphic system under different circumstances. Polymorph A has higher free energy barrier (ΔG) to nucleation than polymorph B and is the stable form. Adapted from reference (Aaltonen et al. 2009)

Nucleation events decide the number of particles, particle size and physical form resulting from crystallisation (Davey et al. 2002). Despite the great efforts in the field of fundamental mechanisms that drive the crystal form diversity, the nucleation phenomena are not well understood (Davey 2004). This in part is due to the fact that there are no reliable methods that can detect nucleation experimentally at present (Hursthouse et al. 2009). New approaches for detection and analysis of molecular clusters at low concentrations in solution are desirable to have a better understanding of nucleation (Davey et al. 2013).

In polymorphic systems, the resulting outcome of crystallisation is the consequence of the kinetic relationship between nucleation and crystal growth. The polymorph which nucleates first during crystallisation is thought to come from the assembly with faster nucleation rate as a result of its lowest free energy barrier to nucleation. However, the final crystallisation outcome, i.e. polymorph, would be determined by the combination of relative nucleation and crystal growth rates of the polymorphs (Khoshkhoo and Anwar 1993; Bernstein et al. 1999).

The nuclei of different polymorphs can form and coexist in solution and a mixture of polymorphs can be obtained when kinetic factors prevent accomplishment of equilibrium. Therefore, as a general rule, under thermodynamic conditions (e.g. slow cooling), stable polymorphic form will be obtained and under kinetic conditions (e.g. fast cooling) a metastable form is anticipated. Therefore, it is necessary to investigate the interplay between thermodynamic and kinetics factors to discover all the relevant physical forms of a compound (Aaltonen et al. 2009). Schematic illustration of plausible scenarios of crystallisation outcomes in case of a dimorphic system is shown in Fig. 1.5.

1.7 Crystallisation Techniques

The statement made by the late Walter McCrone in 1965 that, “The number of forms of a given molecule is proportional to the time, money and experiments spent on that compound” (McCrone 1965) has gained credence in recent years, as

illustrated by the significant increase in reported physical form diversity of pharmaceutical solids (Morissette et al. 2004).

The aim of comprehensive physical form screening is to achieve the maximum coverage of experimental crystallisation space possible within the constraints of available time, material and resources. To maximise the probability of encountering all relevant forms it is highly desirable to utilise multiple crystallisation approaches and therefore sample the nucleation/crystallisation outcomes from a broad range of conditions (Morissette et al. 2004; Aaltonen et al. 2009).

In general, crystallisation techniques based on standard solution crystallisation (cooling, evaporation, anti-solvent and slurry) and solid phase methods (sublimation, mechanical grinding, desolvation and recrystallisation from melt) are the methods of choice for physical form screening (Guillory 1999; Morissette et al. 2004). Multiple crystallisation techniques used in this work for solid form screening are described in Sect. 3.2.1. Timescale of various crystallisation experiments is shown in Fig. 1.6. This figure also highlights the qualitative relationship between the time required to generate a crystal form and the stability of that form, i.e. tendency to obtain metastable crystal forms is higher from faster crystallisation processes than those that are slow (Llinàs and Goodman 2008; Bernstein 2011).

Crystallisation from solution is the most widely adopted method for physical form screening for various reasons. Firstly, various polymorphs and solvates can be

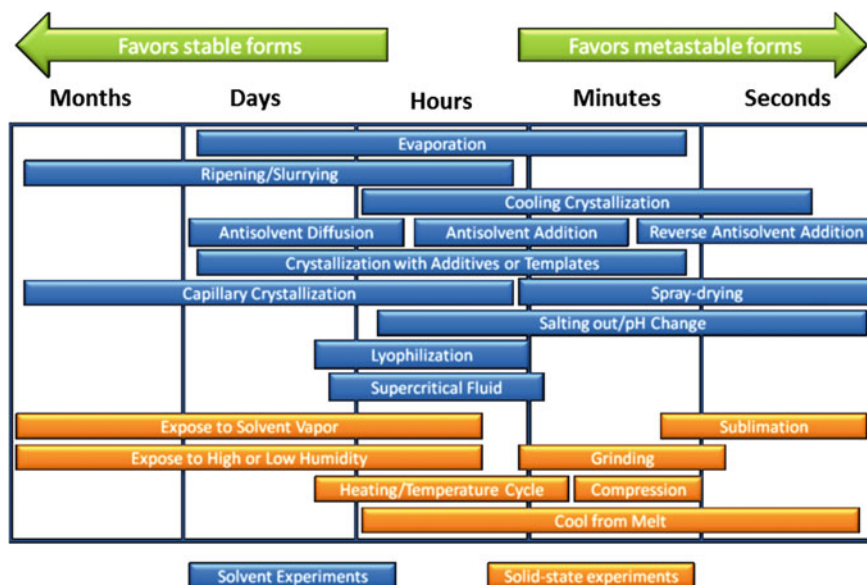


Fig. 1.6 Timescale of various crystallisation techniques, which is also highlighting the techniques which can be used to obtain stable and metastable crystal forms. Adapted from reference (Anderton 2007; Llinàs and Goodman 2008)

obtained just by changing the solvent system. Secondly, the information about propensity of solvate/hydrate formation of an API is required to develop an effective manufacturing process as API is exposed to various solvents during manufacturing and secondary processing (Aaltonen et al. 2009). Finally, in case of solvates/hydrates obtained from solution crystallisation, desolvation provides an alternative route to discover polymorphs (Nicolai et al. 2007) and was used to obtain polymorphic forms of one of the pharmaceutical molecules studied here (see Sect. 6.4.4).

Solution crystallisation also remains the most widely employed method for high-throughput crystallisation (HTC). HTC is a more efficient approach than the traditional manual approach and provides clues on the extent of solid-state diversity of the compound under study in a shorter period of time by utilising minimal resources. Using the HTC technique for physical form screening of a compound MK-996, over a 120 fold increase in efficiency in terms of number of experiments and time required to carry out those experiments over manual crystallisation approaches method has been achieved (Jahansouz et al. 1999; Almarsson et al. 2003). HTC is discussed in more detail in Chap. 4.

1.8 Control of Solid Form

For the pharmaceutical industry, control of solid form in crystallisation process is of paramount importance due to the probabilities of striking differences in physico-chemical properties of different polymorphs and to develop robust manufacturing process (Reutzel-Edens 2006). Control of the solid form is also critical because of the detailed scrutiny of the functional properties of the solid forms by the regulatory agencies. The appearance and disappearance of polymorphs are still largely empirical as there are no reliable methods to assess the potential extent of polymorphism in a given molecule, particularly for the typical pharmaceutical compounds with continuously increasing structural complexity (Chen et al. 2005; Lu et al. 2007). Some authors says that “perhaps there is a little of the black arts involved as findings like latent polymorphism, universal seeding and disappearing polymorphs cannot be fully explained by science of polymorphism” (Findlay and Bugay 1998).

The interest and understanding in the area of polymorph control is growing rapidly. Over the last two decades, there has been a significant progress in the development of various methods for controlling polymorphism and a plethora of new polymorphs have been characterised which is partly due to the advancements of the methods used for characterisation of solid forms (Llinàs and Goodman 2008). The desired crystal form can be obtained by an understanding of the structural relationship between polymorphs, the interplay between thermodynamic and kinetic factors, and by tuning the fundamental crystallisation block (Blagden and Davey 2003; Rodríguez-Spong et al. 2004).

The knowledge of the key controlling factors is essential for a selective solid form outcome in the crystallisation process. Factors controlling crystallisation outcome can be broadly divided into two categories; primary and secondary factors (Fig. 1.7) (Kitamura 2003). Supersaturation and temperature are the two most vital primary parameters affecting solid form outcome in crystallisation process. Three polymorphs of carbamazepine were successfully obtained from one solvent by targeting various degrees of supersaturation and multiple crystallization temperatures (Getsoian et al. 2008).

Supersaturation is the driving force for crystallisation and influences the kinetics of nucleation and crystal growth. The crystallisation outcome depends on the degree of supersaturation. According to the Ostwald's rule, at higher supersaturation, the metastable form may preferentially precipitate and at low supersaturation, the stable form may tend to precipitate. Various innovative methods have been developed to control polymorphic form by changing the degree of supersaturation. Some of them are (a) crystallisation using microporous membrane (Di Profio et al. 2007), (b) contact line crystallisation (Capes and Cameron 2006), (c) capillary crystallisation (Capes and Cameron 2006), (d) crystal nucleation in nanoscopic confinement (Ha et al. 2004; Hamilton et al. 2011), and (e) pH control using potentiometric cycling (Llinas et al. 2007). Majority of these methods are more suitable on a small scale, although these can generate seeds of the desirable form which can be used for further scale-up.

Temperature is the second most important factor in controlling the crystallisation outcome. Practically, crystallisation at different temperatures may produce different polymorphs (Kitamura and Nakamura 2002). For example, during crystallisation of L-glutamic acid at 25 °C the metastable α -polymorph nucleated and rapidly caused

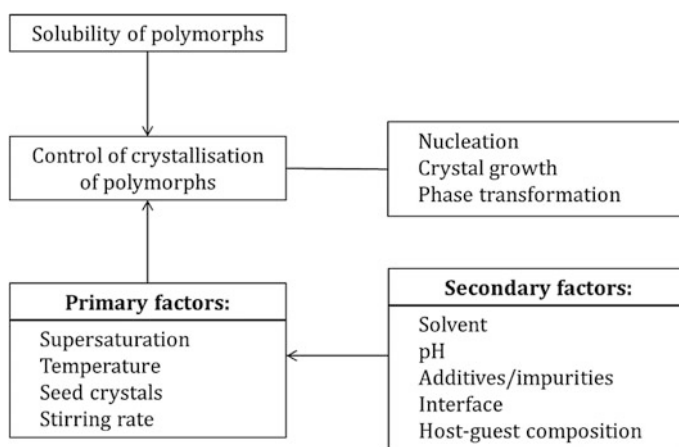


Fig. 1.7 Schematic illustration of factors controlling the polymorphic outcome in crystallisation processes. Reproduced from reference (Kitamura 2003)

the growth of the α -polymorph. When the crystallisation was carried out at 45 °C, though the α -polymorph still nucleated, it exhibited slow transformation and resulted in the growth of the more stable β -polymorph (Kitamura 1989). In the case of solvates, different stoichiometry of solvates can be obtained by changing the harvesting temperature and in particular low temperatures favour the formation of solvates with higher stoichiometry (Byrn et al. 1999). Therefore, during physical form screening, crystallisation at various temperatures is usually recommended to explore all solid forms and relationship amongst them.

Secondary factors such as pH, interface and host-guest composition affect the crystallisation outcome primarily through their effect on the degree of supersaturation. Seeding, where solid particles of desired form are added into the crystallisation medium, is the most common and well established method used by pharmaceutical industry to control solid form and particle size distribution (Beckmann 2000). Seeding strategy relies on the heterogeneous nucleation (promoted by crystal surfaces) and crystal growth in a controlled manner (Beckmann 2000), while avoiding heterogeneous nucleation mediated by unknown impurities (Mullin 2001). In general, seeding is very effective; however, in cases where the one solid form nucleates another solid form, then seeding becomes ineffective and will not produce the aimed outcome. For example, seeding of a system with metastable α form of L-glutamic acid induces the nucleation of more stable β form as surface of the α form acts as a template for its nucleation (Ferrari and Davey 2004).

Solid form control can also be achieved by heterogeneous nucleation mediated by employing additives (Davey et al. 1997), templates (Stoica et al. 2005), self-assembled monolayers (Hiremath et al. 2004; Yang et al. 2012) and polymers (Price et al. 2005). These approaches can sometimes lead to discovery of unknown more stable polymorph(s) as seen with form IV of CBZ obtained by polymer heteronucleation approach (Price et al. 2005) and can reveal the extent of polymorphism as in 8 polymorphs of flufenamic acid (López-Mejías et al. 2012).

Crystallisation processes under thermodynamic control are least affected by the nature of the solvent (Threlfall 2000); however it can have great effect on the polymorph appearance (Reutzel-Edens 2006). In some cases, solvent or solvent mixture can be used to promote or inhibit certain polymorphs. The mechanism of getting desired polymorphic forms by using different solvent is similar to the additives except that the solvent is in excess. Solvents can play a key role in directing nucleation at molecular level and both nucleation and crystal growth can be manoeuvred at the molecular level by exploring the solvent solute interactions for controlling competing crystallisation pathways (Davey et al. 2002; Blagden and Davey 2003). These studies suggest a link between the early stages of molecular recognition and aggregation and final crystal structure.

The polymorphic outcome can also be influenced by the experimental control of crystallisation conditions e.g. by laser induced nucleation (Sun et al. 2008), ultra-sound assisted crystallisation (Gracin et al. 2005), micronisation of antisolvent (Murnane et al. 2008) or crystallisation under high pressure (Fabbiani et al. 2005).

In spite of the progress made in the methods for controlling polymorphism, the fundamental mechanisms involved in crystallisation and the molecular properties that lead to physical form diversity are poorly understood. As a result, the appearance and disappearance of polymorphs is considered only partially explicable and prediction of the extent of potential polymorphism for a given compound still remains a formidable challenge.

1.9 Computational Methods

1.9.1 Crystal Structure Prediction

Crystal structure prediction (CSP) refers to the prediction of thermodynamically feasible crystal structures of a molecule using molecular structure alone by applying *ab initio* methods. Computational solid-state chemistry has progressed significantly in the last decade where the development was partly inspired by the promise of useful applications in the field of industrial development of pharmaceuticals (Price 2004; Verwer and Leusen 2007; Braga et al. 2010; Day 2011). However, the discovery and analysis of solid forms is still dependant on systematic experimental screening to explore and understand the complete picture of potential solid form diversity of today's structurally complex pharmaceutical molecules.

Due to potential applications of CSP, a range of free or commercial software packages have been developed and are now available to explore the different ways in which organic molecules may pack in the solid-state. Work is on-going in further improvements of these programs. Most commonly used software packages include, GRACE and VASP (Neumann and Perrin 2005; Neumann et al. 2008; Neumann 2011), Crystal Predictor, DMACRYS, Crystal Optimiser (Karamertzanis and Pantelides 2007; Price et al. 2010; Kazantsev et al. 2011b), Polymorph Predictor (Materials Studio; Accelrys Inc.) and CRYSTALG (Pillardry et al. 2001).

CSP is based on the assumption that molecule will crystallise in the most thermodynamic stable structure, although other crystal structures that are close in energy may also be obtained as polymorphs (Price 2009). It also assumes that the crystallisation is controlled by thermodynamic factors and all the temperature effects can be ignored. Thus, the method looks for static 0 K crystal structure (global minimum in lattice energy) with the most energetically favourable packing (Price 2004). CSP results are a set of the most stable computer generated structures/predicted lattice energy minima. These results are represented in a scatterplot of lattice energy versus density or lattice energy versus packing coefficient. These scatterplots are called crystal energy landscapes. The crystal energy landscapes can be broadly divided into four types. Schematic diagrams of the crystal energy landscapes are shown in Fig. 1.8 and a brief summary is described in the following sections.

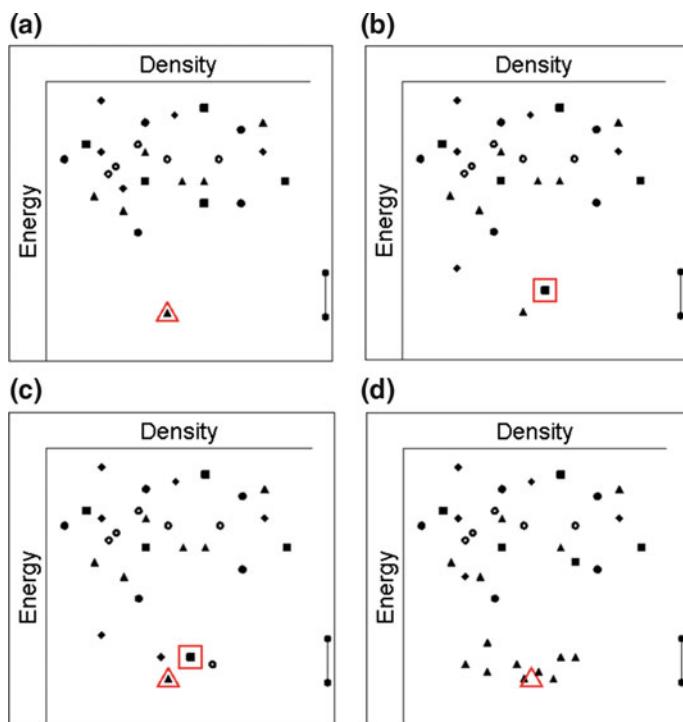


Fig. 1.8 Schematic examples of the crystal energy landscapes; **a**, **b**, **c** and **d** denote monomorphic, predictive, complex and interchangeable crystal energy landscapes respectively. Each point denotes a crystal structure that is a local energy minimum, with the symbols representing significantly different type of packing such as different hydrogen bonding motifs. The experimentally known structures are denoted by empty *red* symbols. Reproduced from reference (Price 2009)

1.9.1.1 Monomorphic Crystal Energy Landscape

Monomorphic crystal energy landscape is the one where one structure is thermodynamically most stable and hence the most preferred structure in the lattice energy (Fig. 1.8a). The energy difference between this and any other structure on the landscape is higher than the plausible energy difference between polymorphs. As suggested by the current literature, monomorphic crystal energy landscapes are rare for organic molecules. Pigment yellow 74 is a notable example where experimental crystal structure is 12 kJ mol^{-1} more stable than the next lowest energy structure and experimental screening also has not found any other structure.

1.9.1.2 Predictive Crystal Energy Landscape

A predictive crystal energy landscape is the one where the known most stable polymorph is not at the global minimum and an unknown structure is predicted to be more stable than this known polymorph (Fig. 1.8b). This kind of result provides strong motivation for design of crystallisation methods to find the predicted structure or rule out the possibility of any route of its nucleation. Crystallisation experiments were successfully designed to obtain predicted catemer based polymorph of CBZ which was predicted to be energetically competitive with the known $R_2^2(8)$ dimer motifs containing polymorphs (Arlin et al. 2011).

1.9.1.3 Complex Crystal Energy Landscape

A complex crystal energy landscape (Fig. 1.8c) is obtained when there are various distinct crystal structures within the low energy range and there are various competitive ways of packing of the molecule. In these cases, the structures that can be actually obtained experimentally would depend upon the kinetic factors that influence the nucleation and growth of structure provided that these will not transform into another more stable structure.

This type of landscape indicates that there is a probability of multiple solid forms and there is a packing problem with the molecule, which may result in polymorphism or may be solved by formation of multi-component system e.g. hydrate, solvate or co-crystal. Hydrochlorthiazide (HCT) exhibits complex crystal energy landscape, where a wide range of bimolecular hydrogen bonding motifs is present in the low energy region. The problem of packing these bimolecular hydrogen bonding motifs results in various distinct motifs and many of them were found in two polymorphs and seven solvates (Johnston et al. 2007).

1.9.1.4 Interchangeable Crystal Energy Landscape and Disorder

This is a particular type of complex crystal energy landscape (Fig. 1.8d), where the low energy crystal structures are associated in an interchangeable manner. This type of landscape arises when there are multiple ways of stacking the same motif (e.g. sheets/ribbons) within effectively the same energy range. This implies that multiple structures based on various arrangements of the motif, would be very close in energy. Therefore, depending on the energy barrier between different arrangements and to correct growth mistakes, this type of energy landscape may lead to disorder, polytypism, multiple stacking faults or incommensurate structures. The example of this type of crystal energy landscape is aspirin, in which the two alternate predicted equi-energetic modes of stacking of the same sheet justify the later finding of form II (Vishweshwar et al. 2005; Price 2009) and the presence of the intergrowth of polymorphic domains within the same single crystal (Bond et al. 2007).

Contrasting the crystal energy landscape of a molecule with the experimental screening results on a thermodynamic side can be the first step towards better understanding of the factors which control crystallisation and can result in polymorphism (Davey et al. 2002; Price 2004; Verwer and Leusen 2007; Price 2008b; Braga et al. 2010; Day 2011). The calculation of relative energies of polymorphs provides a major challenge to computational chemistry because energy differences between polymorphs are quite small compared to covalent bond energies. Therefore, calculating the crystal energy landscape with a worthwhile relative accuracy in thermodynamic stability of the crystal structures is restricted to the small pharmaceutical molecules with limited flexibility. However even after accurate calculations of the relative energies of the various polymorphs, the crystal energy landscape does not reflect the kinetic factors such as nucleation dynamics, solvent effects, temperature, pressure etc. (Price 2008a) and inclusion of kinetic factors in the CSP remains elusive.

Despite its limitations, many studies show that CSP is a valuable complement to the physical form screening and helps in discovering new structures as well as rationalising the solid forms that are found in experimental searches (Johnston et al. 2007; Arlin et al. 2011; Price 2013). Nowadays, one sees efforts towards simultaneous experimental and computational search for all possible polymorphs for a given organic compound (Florence et al. 2006; Braun et al. 2012).

The encouraging CSP results of 5th blind test on the flexible large molecule with 8 torsion angles and on multi-component systems i.e. salt and hydrate suggest that CSP can migrate to more complex systems from small molecules with limited flexibility, while highlighting the shortcomings where key improvements are still required (Bardwell et al. 2011). Still, it is desirable to push the limits of theoretical predictions for better understanding of the solid-state behaviour of the structurally complex pharmaceutical compounds.

1.9.2 Energetics of Non-bonded Interactions: The PIXEL/Semi-classical Density Sums Methods

An equilibrium crystal structure is formed when the attractive forces and the repulsive forces are balanced within a specific packing arrangement (Callear 2008). The total intermolecular interaction energy of a crystal and relative contribution of different forces towards the total intermolecular interaction energy can be calculated using semi-empirical PIXEL or semi-classical density sums (SCDS) method, which enables comparison of the governing forces in related solid-state structures.

PIXEL calculations also provide subdivision of lattice energy into molecule-molecule energies and information about the interaction(s)/structural determinants which dictate packing arrangement in the crystal lattice. All this information can help in a better understanding of the relationship between molecular constituents and intermolecular interactions, which is the key to the prediction and control of solid forms (Gavezzotti 2003a).

The PIXEL method provides a more realistic and comprehensive way of examining intermolecular interactions. It takes account of the entire electron density of a molecule rather than just a few nuclei or point charges and thus provides more rational and comprehensive way of describing interactions. Some significant contributions can be missed due to simplicity associated with the classical atom-atom method. For example, description of an OH...OH interaction using a simple attractive coulombic term i.e. $H(\delta^+)...O(\delta^-)$ would miss on repulsive $H(\delta^+)...H(\delta^+)$ and $O(\delta^-)...O(\delta^-)$ terms, which also contribute to the interaction (Dunitz and Gavezzotti 2005).

Four different types of forces calculated by PIXEL methods are summarised in Table 1.1 and the sum of these four terms provides the total intermolecular interaction energy. The stabilising forces are comprised of Coulombic, dispersion (London-type) and linear polarisation terms. Repulsion energy is estimated from the overlap of undeformed electron densities. As mentioned earlier, PIXEL calculations provide a list of molecule-molecule interactions (molecular pairs) in the crystal lattice, which are pairs of a reference molecules related by a symmetry operator, distance between their centre of mass and an intermolecular energy. This allows identification of the most stabilising molecule-molecule interactions.

First step during calculations of intermolecular energies using PIXEL method is to calculate the electron density of the individual molecule(s) using standard quantum mechanical programs, e.g. Gaussian[®]. Typical grid step size of 0.08–0.10 Å is used to calculate the electron density within a grid. The resultant grid containing electron density produced by Gaussian usually contains about 10^6 points (the original pixels), which is too large for routine calculations. Therefore, the grid containing pixels is then condensed into $n \times n \times n$ super-pixels using a typical condensation level n , of 3, 4 or 5. Super-pixels with negligible electron density (less than 10^{-6} electrons) are then removed and the overall molecular electron density is usually described by 10,000–20,000 pixels. Space-group symmetry operations are then applied to obtain the electron density of the molecular cluster (Dunitz and Gavezzotti 2005).

PIXEL mimics the results of computational expensive high-level quantum mechanical calculations within a very small fraction of the computational cost

Table 1.1 Different types of Intermolecular interactions involved in PIXEL calculations, their origin and their dependence on the intermolecular distance, r

Force	Origin	Varies as
Coulombic	Charge-charge interaction	$1/r$
Polarisation	Permanent dipole-dipole interaction	$1/r^3$
Dispersion or London	Inductive dipole-dipole/fluctuating multipoles	$1/r^6$
Repulsion (or exchange)	Repulsion between spins	$1/r^{12}$ overlap of electron cloud

(Gavezzotti 2003b). On a standard desktop computer, PIXEL calculations take few minutes to one hour for crystals while it takes just a few seconds for calculations on a dimer extracted from a crystal structure. Other advantages of PIXEL include decomposition of total intermolecular energy into four individual components, few parameters, delocalisation of the electrical description of the molecule and many body description of polarisation.

The main disadvantage of PIXEL is the rigid treatment of electron densities, which neglects any rearrangement of electrons that could happen upon molecular contacts. It is especially an issue for strongly H-bonded systems where covalence or charge transfer can happen. However, careful parameterisation has allowed the theory to be effective in the treatment of weak and medium strength H-bonds (Gavezzotti 2005). PIXEL calculations are sensitive to intermolecular bond geometries especially in the positions of hydrogen atoms and minor differences in geometries of structures can lead to differences in energies. Care should be taken while comparing the stability using PIXEL energy differences calculated on the experimental structures. An alternative would be to optimise all geometries of all the structures using standard procedure before PIXEL calculations. However, this would neglect all the conformational changes that can occur during crystal packing. Despite the caveats, PIXEL calculations have been proved to be as successful as high-level quantum chemical calculations for gas-phase dimers (Gavezzotti 2003a). It has also proved to perform comparably or sometimes better than atom-atom force field methods in ranking crystal energies for polymorphs of organic molecules (Gavezzotti 2003b).

PIXEL calculations have been successfully implemented for many diverse applications such as examining the effect of pressure on intermolecular interactions in crystal lattice (Wood et al. 2008), studying the effect of fluorine substitution on intermolecular energies of hydrocarbons and fluorocarbons (Dunitz et al. 2003), rationalisation of packing motifs observed in the crystal lattice of cyclohexane (Ibberson et al. 2007), identifying the stabilising factors in the crystal lattice of energetic materials (Eckhardt and Gavezzotti 2007), and investigating the polymorphic preference under certain conditions in structurally related analogues (Cruz Cabeza et al. 2006).

1.10 Experimental and Computational Studies on Structurally Related Compounds

The number of new approved pharmaceuticals is decreasing whilst costs are increasing creating additional pressures on physical form screening to deliver comprehensive information more quickly and at a lower cost whilst minimising the risk that any practically relevant forms have been missed. Also molecules that do reach the later phases of drug development are becoming more structurally complex which creates further challenges for physical form screening, e.g. large numbers of solvates or disordered structures may take longer to characterise.

There is no standard approach for physical form screening given that every compound possesses unique properties and can display very different crystallisation behaviour. Small differences in substituents can affect the molecular conformation, shape, H-bonding potential and can have significant effects on packing forces and hence the adopted crystal structures and resultant physical properties. Both structure and properties, particularly of large complex molecules, remains challenging to predict. Some examples of studies which illustrate the challenges in predicting structure of chemically related analogues are described below.

The structurally related analogues hydrochlorothiazide (HCT) and chlorothiazide (CT) (Fig. 1.9) exhibit varied solid form diversity and demonstrate the effect of subtle changes on hydrogen bonding potential, molecular shape and overall solid form diversity (Johnston et al. 2007, 2011). For example HCT has two polymorphs whilst CT is monomorphic under ambient conditions with both compounds forming a range of solvates. The differences in molecular structures showed an impact on the opportunities for favourable H-bonding interactions in the crystal structures of these molecules. Whilst the molecules have similar size and shape and display some similarity in local intermolecular packing, the experimental and predicted crystal structures showed no overlap. Similar shape and dominant dispersion interactions within the lattices suggest that both molecules could adopt similar structures. But the isostructures of these molecules on their respective crystal energy landscapes were found to be unfavourable i.e. very high up in energy from global minimum and have also not been observed experimentally.

Similarly, no crystal packing similarity was observed in polymorphs of the antipsychotic drug aripiprazole and its structurally related metabolite dehydro-aripiprazole (Zeidan et al. 2013). Changing the anion type in a pharmaceutical salt system can also dramatically affect the observed solid form diversity and crystal packing. The hydrochloride salt of sertraline is highly polymorphic with 8 known polymorphs (Casimir and Andrew 1997; Almarsson et al. 2003), while its hydrobromide salt has only been shown to have one form (Remenar et al. 2003). This is more predictable perhaps due to the significant change in size of the anion i.e. chlorine vs. bromine. Similarly, changing the cation type e.g. from sodium to potassium in the salts of same active pharmaceutical ingredient has been shown to be responsible for large changes in crystal packing. This might also be due to the higher tendency of sodium salts to form hydrates (see Sect. 1.3) (Wood et al. 2012).

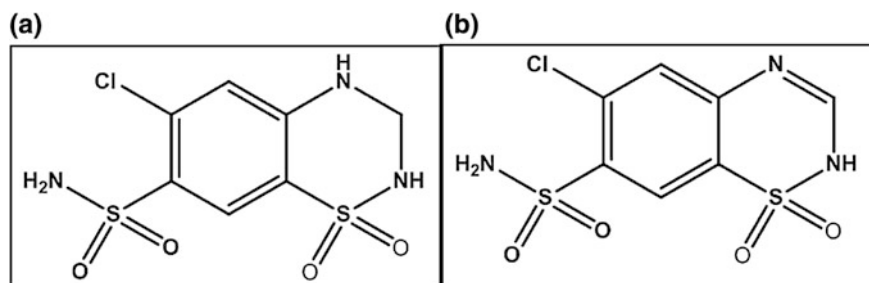


Fig. 1.9 Chemical Structures of (a) hydrochlorothiazide and (b) chlorothiazide

Thus from these and other examples it is clear that whilst it is often possible to propose reasons retrospectively as to why differences in molecular structure impact on differences in crystal structure, we cannot simulate *ab initio* what these specific effects will be. Thus crystal structure prediction provides a powerful tool to assist in developing a comprehensive knowledge of solid-state behaviour of organic molecules. The next section outlines some specific examples where predictive tools and structure modelling can inform the experimental investigation of solid-state diversity.

The family of CBZ analogues i.e. CBZ, dihydrocarbamazepine (DHC), oxycarbamazepine (OCBZ) and epoxycarbamazepine (ECBZ) serves as a good example to demonstrate the effect of small changes in molecular structure on solid-state diversity and packing motifs preferences in the crystal lattice (Fig. 1.10). CBZ, DHC and OCBZ have 5, 4 and 3 reported polymorphs, respectively in addition to forming solvates. However, ECBZ is monomorphic suggesting that the epoxy substituent is responsible for favouring certain structures or destabilising

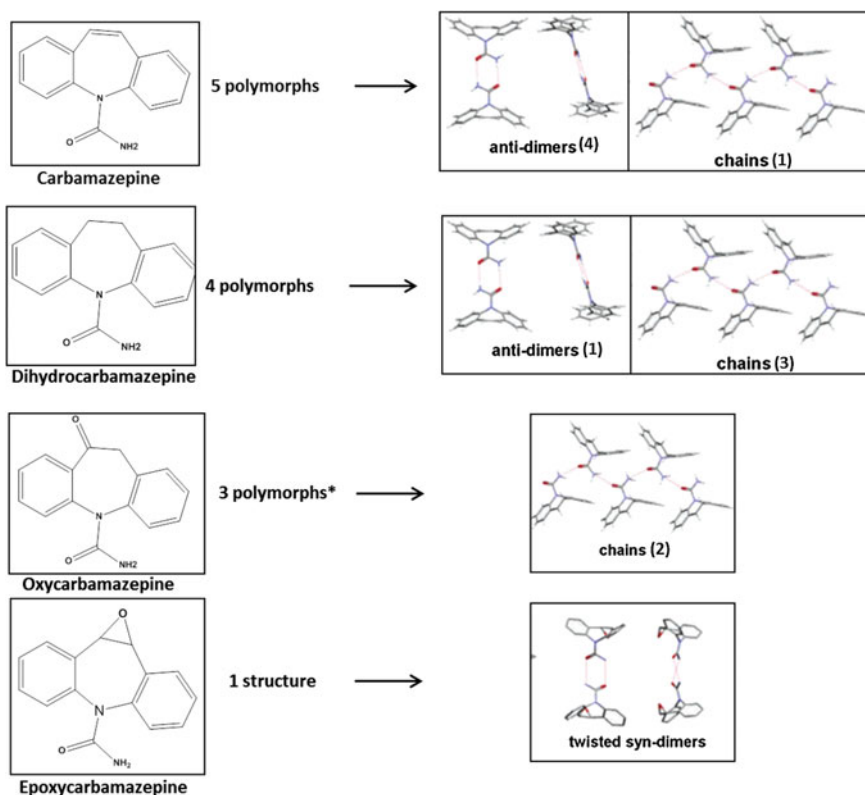


Fig. 1.10 Polymorphs and hydrogen bonding motifs observed in carbamazepine and its analogues. The number of polymorphs having particular motif are shown in parentheses. *For oxycarbamazepine, only crystal structures of two polymorphs are known

alternative ones and reducing the accessible forms. However, it must also be borne in mind that the current view of the extent of diversity in this molecule could also be due to insufficient or incomplete screening for the compound i.e. not all feasible forms have actually been discovered yet.

Lutker et al. concluded that the dibenzazepine backbone and urea moiety of CBZ constitute a “polymorphophore” (Lutker and Matzger 2010). A polymorphophore can be defined as “a structural element that, when incorporated into a molecule, favours the formation of polymorphic crystal forms” (Lutker et al. 2007).

Computational studies have shown the preference of chain motifs in the case of DHC and OCBZ due to the azepine ring distortion due to the different bonding compared to CBZ which prefers to adopt dimer motifs in the solid-state (Cruz Cabeza et al. 2006). This was also suggested by experimental studies in which comprehensive screening was carried out. However, more recently, the predicted and thermodynamically feasible dimer based polymorph of DHC was obtained from vapour phase crystallisation (Arlin et al. 2010). Similarly, the predicted chain motif based polymorph of CBZ was obtained by using DHC form II as a template (Arlin et al. 2011) exploiting the 3-D similarity between the predicted chain based form of CBZ and the experimental DHC form II. This emphasises the need for care when interpreting the outputs of computational studies. Also the relative difficulty in obtaining form V CBZ despite the predictions suggesting that they are energetically competitive with dimer based structures, highlights that current methods cannot provide kinetic favourability of individual structure formation.

Recently, CSP studies have been used to investigate the concept of polymorphophore using monomorphous fenamic acid and its analogue; tolfenamic acid for which 5 polymorphs have been reported (Fig. 1.11) (Uzoh et al. 2012).

CSP studies on fenamic acid and tolfenamic acid revealed that all the crystal structures present on the crystal energy landscape consist of $R_2^2(8)$ hydrogen bonded dimer (Etter 1990) and differ in the packing of conformationally flexible phenyl rings linked by secondary amine. In the crystal energy landscape of fenamic acid, only the known experimental crystal structure and a closely related crystal structure are thermodynamically favoured over all the other calculated crystal structures, thus limiting the extent of potential polymorphism.

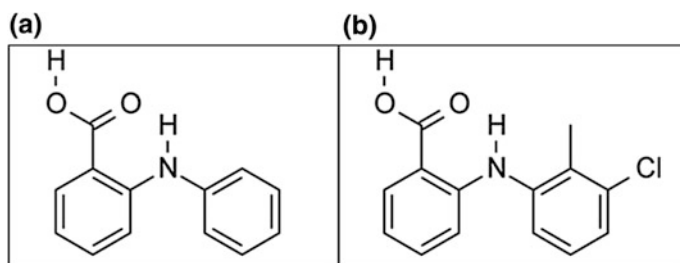


Fig. 1.11 Chemical structures of (a) fenamic acid (monomorphous) and (b) tolfenamic acid (5 polymorphs)

In case of tolfenamic acid, the introduction of methyl and chlorine substituents change the crystal energy landscape and produce a range of additional energetically competitive structures, including the experimentally observed polymorphs. This study suggests that the fenamate fragment constitutes a polymorphophore and can potentially form a large number of structures due to associated conformational flexibility. However, the substituents on the fenamate fragment determine whether the specific fenamate will be polymorphic or not (Uzoh et al. 2012). This suggests that a polymorphophore may promote but does not necessarily guarantee polymorphism.

Figure 1.12 shows examples of other polymorphic fenamic acid analogues with different substituents at various positions of phenyl ring or pyridine ring instead of phenyl ring (López-Mejías et al. 2012). However there is no available information about their crystal energy landscapes.

The above mentioned examples demonstrate that small changes in substituents can affect the molecular conformation, shape, H-bonding potential and can have significant effect on the packing forces and hence the adopted crystal structures and overall solid-state diversity. However, it is still not possible to predict the magnitude of changes and the resultant physicochemical and mechanical properties. Given the associated challenges and subtleties, it is therefore of continued interest to carry out more experimental and CSP studies to explore the basic science underpinning the structural diversity in structurally related pharmaceutical compounds.

This thesis is concerned with the methodology development for discovery of physical forms, prediction of crystallisability and demonstrates the use of combined experimental and computational studies to explore the solid-state diversity of structurally related molecules in two groups. Rigorous experimental screening utilising multiple crystallisation techniques is presented to achieve the maximum coverage of experimental crystallisation space and to maximise the probability of encountering all relevant forms by sampling nucleation/crystallisation outcome from a broad range of conditions. CSP studies were used as a complement to experimental screening. Thus each molecule has been subjected to CSP and

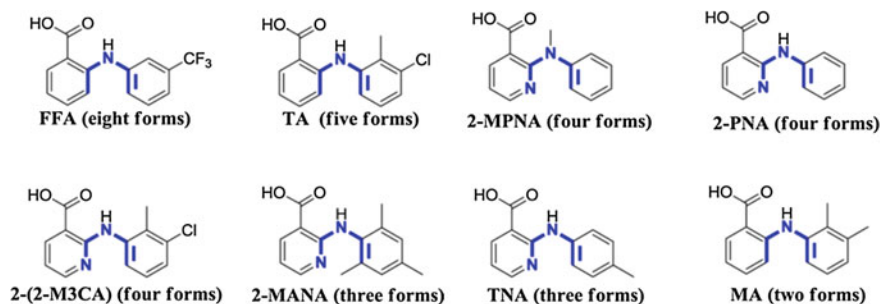


Fig. 1.12 Molecular structures of fenamic acid analogues. The number of structurally characterised polymorphs for each compound is written in parentheses. Reproduced from reference (López-Mejías et al. 2012)

experimental searches to explore and understand the range of structural forms obtained and/or that may be possible.

In addition to CSP studies, PIXEL calculations were used to provide a better understanding of the stabilising factors and most important interaction(s) in the crystal lattice using a step-wise approach to obtain a holistic understanding of the structural and energetic factors involved in stabilising the different crystal structures. These calculations can help in understanding the stability of one structure over others and non-observance of hypothetical/predicted structures during experimentation. Better understanding of the role of specific interactions in stabilising the structure can, in principle, help in achieving a better control over the solid-state form of pharmaceuticals and other molecular solids.

Structural analysis using XPac and Mercury has enabled the identification of structural relationships and characterisation of the key structural motifs that underpin the formation of the experimental structures. The applications of statistical modelling techniques in diverse solvent selection and identifying the underlying relationship between crystallisation conditions and its outcome have also been demonstrated.

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Chapter 2

Aims and Objectives

2.1 Aims

Control of crystal structure by crystallisation to deliver chemically and physically pure substances is of significant importance in the manufacture of safe, effective and high quality pharmaceutical products. The overall aim of this work is to investigate a range of experimental and computational approaches for the discovery and better understanding of the key factors underpinning solid-state structure and diversity of pharmaceuticals. A range of crystallisation techniques and analytical tools has been applied in combination with statistical modelling approaches, CSP, and a number of semi-empirical and quantum-mechanical approaches to study the molecular and crystal structures.

The work reported in this thesis has focussed on discovery of physical forms and exploration of the relationship between molecular structure and crystallisability. It has also concentrated on two groups each comprising of two structurally related molecules to investigate the influence of changes in the molecular structures and substituents on the conformation, intermolecular interactions, packing motifs in the crystal lattice, and overall extent of solid form diversity and to probe how predictions can aid in the interpretation of the experimental crystal energy landscape. The compounds studied are: olanzapine (OZPN) and clozapine (CZPN) in group 1, and loxapine (LXPN) and amoxapine (AXPN) in group 2 (Fig. 2.1).

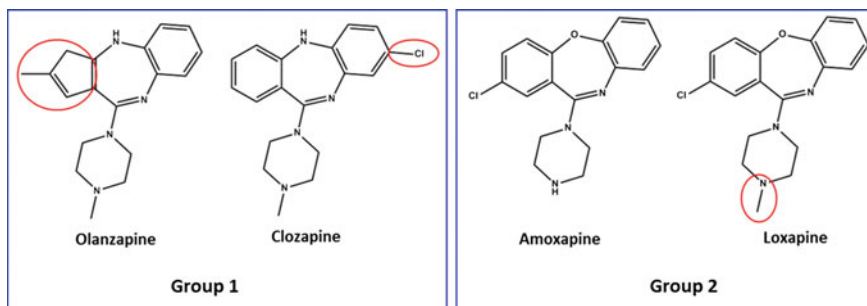


Fig. 2.1 The four compounds studied in this thesis. The differences in the chemical structures within a group are highlighted in red

2.2 Objectives

- Development and validation of high throughput crystallisation and analysis (HTCAA) methodology for physical form screening using quartz 96/48-well plates with an automated system for collecting high quality Raman spectra.
- Development of a statistical model for prediction of the crystallisability of a set of organic molecules based on calculated physicochemical descriptors.
- Comprehensive experimental physical form screening of molecules in group 1 (OZPN and CZPN) as well as in group 2 (AXPN and LXPN) by employing multiple crystallisation techniques to identify novel physical forms and determine their crystal structures using X-ray powder diffraction (XRPD) or single crystal X-ray diffraction (SXD).
- Exploitation of predicted crystal energy landscapes to aid the accurate interpretation of the experimental physical form screening results.
- Application of molecular packing analysis tools to the crystal structures of target molecules to identify key packing motifs and structural relationship amongst them.
- Use of computational techniques such as statistical modelling approaches and PIXEL calculations to develop a comprehensive understanding of the structural and thermodynamic factors directing crystal packing in different physical forms.
- Application of geometry optimisation calculations using CASTEP to obtain accurate H-atoms position and verification of the accuracy of the crystal structures solved by XRPD.

Chapter 3

Materials and Methods

3.1 Material

Olanzapine (OZPN) was obtained from Molekula Ltd, UK and Eli Lilly, USA. Clozapine (CZPN), amoxapine (AXPN) and Loxapine (LXPN) were purchased from Molekula Ltd, UK. LXPN was also procured from Eurolab Ltd, UK. All four compounds are listed in Table 3.1. X-ray powder diffraction (XRPD) was used to confirm the identity and phase purity of all the compounds. For all crystallisations, analytical/reagent grade solvents were purchased from Sigma-Aldrich or Fluka (UK).

3.2 Methods

3.2.1 Crystallisation Techniques

Various crystallisation techniques were adopted during the experimental screens of selected molecules to maximise the coverage of the experimental crystallisation space. The experimental screen was based largely on solution crystallisation using a variety of solvents selected to cover a wide range of physicochemical properties. Details of crystallisation techniques adopted in this study are mentioned in the following sections.

3.2.1.1 Slow and Fast Solvent Evaporation

Saturated solutions of the compound were prepared by introducing an excess of compound into 4–7 ml of the chosen solvent under agitation. After equilibration, samples were filtered to remove seeds and left to slowly evaporate at RT and at

Table 3.1 Compounds studied in this work

Compound	Molecular weight (g mol ⁻¹)	Melting point (K)
Olanzapine (OZPN)	312.44	468
Clozapine (CZPN)	326.82	456
Amoxapine (AXPN)	313.78	448–449
Loxapine (LXPN)	327.81	382–383

277 K. For faster solvent evaporation, samples were left to evaporate on a watch glass at RT.

3.2.1.2 Semiautomatic Cooling Crystallisation on React Array Platform

Saturated solutions were prepared at a temperature, T_{sat} , equivalent to the solvent boiling point minus 10 K with a heating rate of 40 K min⁻¹. Saturated solutions were then cooled to RT at the rate of 25 K min⁻¹.

3.2.1.3 Mechanical Grinding

Mechanical grinding was carried out in pestle mortar or in a Retsch MM400 mixer mill or in a Retsch Cryomill. Approximately 150 mg of the compound was placed in a stainless steel grinding jar containing 2 mm stainless steel ball (with or without a drop of a chosen solvent) and ground at RT (MM400 mixer mill) or at 77 K (Cryomill) using liquid nitrogen.

3.2.1.4 Crystallisation from Vapour Phase

Approximately 30 mg of the compound was placed at the bottom of the 3/5/10 ml glass vial. A glass fibre was suspended in the selected vial on a Cu wire placed ~1 cm above the sample. The glass vial was then sealed and kept on a hot plate at 353 K and the crystals were retrieved from the glass fibre or the walls.

3.2.1.5 Melt Quenching

The compound was melted using a hot plate at *ca.* 453 K on glass microscope slides. The slides were then either quenched in liquid nitrogen or left at RT to cool. Solidified compound was then scraped from the glass slide and analysed using XRPD and thermal techniques.

3.2.1.6 Freeze Drying

Freeze drying was carried out using bench top freeze-drier (Epsilon 2–4, Martin Christ). A saturated solution of the compound in t-butanol was prepared at RT and freeze drying was carried out using slow or fast freeze drying cycles. During slow freeze drying, the sample was transferred to the freeze drying chamber from RT, whilst during fast freeze drying, the sample was cooled to 193 K and then shifted to the freeze drying chamber. The temperature was maintained at 253 K for 48 h. The vacuum applied during the primary and secondary drying phases was equivalent to a pressure of 1 and 0.015 mBar, respectively. The resulting samples were analysed using XRPD and thermal techniques and Raman spectroscopy.

3.2.2 X-Ray Crystallography

3.2.2.1 X-Ray Powder Diffraction

Polycrystalline samples were analysed by XRPD for fingerprinting, structure solution and refinement. Also XRPD was used for in situ desolvation and amorphous recrystallisation studies as part of variable temperature (VT)-XRPD studies.

For sample fingerprinting, 10–50 mg of sample was placed on 28 well plate supported on a polyimide (Kapton, 7.5 μm thickness) film. Data were collected on a Bruker AXS D8-Advance transmission diffractometer equipped with θ/θ geometry, primary monochromated radiation (Cu $K\alpha_1$, $\lambda = 1.54056 \text{ \AA}$), a Vantec 1-D position sensitive detector (PSD) and an automated multi-position x - y sample stage. Data were collected in the range $4\text{--}35^\circ 2\theta$ with a $0.015^\circ 2\theta$ step size and 1 s step^{-1} count time (Florence et al. 2003). Samples were oscillated $\pm 0.5 \text{ mm}$ in the x - y plane at a speed of 0.3 mm s^{-1} throughout data collection to maximise particle sampling and minimise preferred orientation effects.

Capillary XRPD data were used for indexing attempts, phase identification using Pawley-type fits (Pawley 1981) and structural analysis using Rietveld refinement (Rietveld 1969). Samples were lightly ground in an agate pestle mortar and loaded into a 0.7 mm internal diameter borosilicate capillary. The data were collected on the Bruker AXS D8 Advance powder diffractometer equipped with transmission capillary geometry, primary monochromated radiation (Cu $K\alpha_1$, $\lambda = 1.54056 \text{ \AA}$) and a Bruker Lynxeye PSD. The capillary was rotated through data collection to avoid preferred orientation effects as far as possible. Data were collected in the range of $2\text{--}40^\circ 2\theta$ with a $0.015^\circ 2\theta$ step size and using a 1 or 3 or 8 s step^{-1} count time. Variable Count Time (VCT) data, typically in the range of $2\text{--}70^\circ 2\theta$ with step times ranging from 2–24 s were collected for Rietveld refinement to ensure more accurate intensity estimates at high angles as required by structural analyses.

For VT experiments, sample temperature was controlled using an Oxford Cryosystem 700 Plus series device to enable in situ sample transformation. All XRPD patterns were visualised using DIFFRAC^{plus} EVA (version 2.0) program (BRUKER-AXS).

Data analysis was carried out using DASH (version 3.2/3.3) (David et al. 2006) or TOPAS Academic (version 4.1) (Coelho 2007) software. For structure determination, the powder pattern was indexed using first 20 peaks using DICVOL04 (Boultif and Louer 1991) or singular valued decomposition (SVD)-Index algorithm (Coelho 2003a) in TOPAS (version 3.1). The space group was determined from volume and statistical assessment of the systematic absences as implemented in DASH structure solution package. Pawley refinement (Pawley 1981) was used to extract the intensities and their correlations by refining lattice parameters along with background, zero-point, reflection intensities and peak shape parameters. For structure solution (David et al. 1998), an internal coordinate (z-matrix) description of the molecules was derived from the crystal structures reported in the Cambridge Structural Database (CSD) (version 5.33 and 5.34) (Frank 2002), after a geometry check within the MOGUL program (version 1.4 and 1.5) (Bruno et al. 2004). The O–H, N–H and C–H distances in an internal model were normalised to 0.90, 0.90 and 0.95 Å respectively. The structure was solved using 800 simulated annealing (SA) runs distributed on multi-core processor using MDASH (version 1.0) (Griffin et al. 2009). The SA solution with lowest profile χ^2 was used as a starting point for a rigid body/restrained Rietveld refinement in TOPAS Academic (version 4.1). In some cases, the SA solution was also taken for geometry optimisation in CASTEP (Cambridge Sequential Total Energy Package) (Clark et al. 2005) to verify atomic positions.

3.2.2.2 Single Crystal X-Ray Diffraction Analysis

SXD data were collected on a Bruker Apex II diffractometer with charge coupled device (CCD) detector and graphite monochromated Mo $K\alpha_1$ radiation ($\lambda = 0.71073$ Å) with temperature control from an Oxford Cryosystems Cryostream device operating at 123 K. Diffraction data were processed (cell refinement and data reduction) using Bruker SAINT and APEX2 software (APEX2 2005). Structure solution was carried out using direct methods in SHELXS-97 (Sheldrick 2008) within the WinGX suit (Farrugia 1999). The hydrogen atoms positions were placed from the difference maps or from calculated positions using a riding model. Atomic coordinates and thermal parameters were refined using full-matrix least square methods on $|F^2|$ using all the unique data using SHELXL-97 (Sheldrick 2008) within the WinGX suite (Farrugia 1999, 2012). The refined structures were inspected using ORTEP-3 (version 2.02) (Farrugia 2012) and Platon (version 1.15) (Spek 2003) within the WinGX suite.

3.2.3 Thermal Analysis

Thermal behaviour, mass loss and melting points of all samples were monitored using simultaneous thermal analyses (STA), comprising differential scanning calorimetry (DSC) and thermal gravimetric analysis (TGA). This was carried out on a Netzsch STA 449 C thermocouple, equipped with a Netzsch CC 200 liquid nitrogen supply system and a Netzsch CC 200 C control unit. Samples were placed in 10 μL aluminium pans (lid with a pinhole) and a heating ramp was set in the range of 273–483 K at a rate of 2–20 K min^{-1} . A thermal heat-cool-heat/melt-recry stallisation-melt cycle for AXPN (see Sect. 7.3.2) comprises of heating of the sample to 457 K from RT at the rate of 10 K min^{-1} , followed by cooling to 263 K at the rate of 40 K min^{-1} and then again heating to 480 K at the rate of 10 K min^{-1} . All analyses were performed using the Netzsch Proteus thermal analysis program[®] (version 4.3.1) (NETZSCH-Gerätebau GmbH).

3.2.4 Raman and Infrared Spectroscopy

Raman spectra were collected using DXR Raman instrument (Thermo Scientific) equipped with a high precision x, y, z motorised stage. A 780 nm (frequency-stabilised single mode diode laser) or 532 nm (diode-pumped, solid state) laser with maximum laser power of 10 mW was used as an excitation source, coupled with air cooled CCD for collecting the Raman spectra in the shift region of 50–3400 cm^{-1} . Spectra were collected using a long working distance 10/20 \times objective with 50 μm aperture, with 1–10 s exposure and a spectral resolution of 5 cm^{-1} . All the spectra were visualised and analysed with OMNIC[™] software (version 8.2) (Thermo Scientific).

Fourier Transform Infrared (FT-IR) spectra were collected using Smart iTR NICOLET iS10 (Thermo Scientific). The spectra were recorded in the range of 4000–525 cm^{-1} at an instrument spectral resolution of 4 cm^{-1} (64 scans per spectrum). The spectra were visualised and analysed with OMNIC[™] software (version 8.1) (Thermo Scientific).

3.2.5 PIXEL Calculations

PIXEL (Gavezzotti 2002, 2003a, b) calculations were carried out to estimate the total lattice energy, contribution of polarisation (E_p), dispersion (E_d), Coulombic (E_c) and repulsive (E_r) interactions towards the total lattice energy (E_{tot}) and identify the most significant intermolecular contacts within the crystal structures. The molecular conformation was taken from each crystal structure, with hydrogen bond lengths adjusted to standard neutron values for the experimentally determined

structures (1.08 and 1.00 Å for C-H and N-H respectively). The electron density of the structures was calculated using GAUSSIAN[®] program (version 6.1) (GAUSSIAN03W 1995) at the MP2/6-31G** level of theory. A cube representing the electron density was generated using medium cube settings and a step size of 0.08 Å. Pixels were then condensed into superpixels with a condensation level $n = 4$. Lattice energy calculations were carried out on a cluster of molecules within a maximum distance of 18 Å from a central molecule and a maximum radius for the search of 35 Å. In case of OZPN, the effect of thermal expansion on the calculated energy contributions was also investigated by carrying out the PIXEL calculations on the experimental structures (123 and 298 K) and predicted structures (0 K).

3.2.6 Crystal Packing Analysis

XPac (version 2.0.1 and 2.0.2) (Gelbrich and Hursthouse 2005) and Mercury (version 3.0 and 3.1) (Macrae et al. 2006) were used to analyse the experimental and predicted crystal structures. For the XPac analysis, routine medium cut-off parameters ($\delta_{\text{ang}} = 10^\circ$, δ_{tor} and $\delta_{\text{dhd}} = 14^\circ$) and a van der Waals search radius of 1.5 Å were used. The similarity of pairs of the crystal structures and the molecular conformations in them were measured by calculating the root mean square deviation (RMSD_n) of the n molecule overlay using the Crystal Packing Similarity tool within Mercury. Packing coefficients were calculated using academic version of Mercury available at University College London.

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Chapter 4

Development and Validation of High-Throughput Crystallisation and Analysis (HTCAA) Methodology for Physical Form Screening

4.1 Introduction

Physical form screening, i.e. generating and analysing various physical forms of an API has become an essential part of drug development and product lifecycle management (Gardner et al. 2004; Aaltonen et al. 2009). Physical form screening is not only of concern at the preformulation stage during drug development, but is monitored continuously during scale-up and manufacturing to detect late appearing polymorphs and possible API-excipient interactions. The aim of comprehensive physical form screening is to achieve the maximum coverage of experimental crystallisation space or to achieve the greatest possible knowledge within the constraints of available time, material and resources (Florence 2009).

It is generally believed that a large number of crystallisation trials increase the likelihood of finding the most suitable physical form for drug development (Aaltonen et al. 2009). HTC studies rely on carrying out a large number of small-scale (mg of solute with μl of solvent) parallel crystallisations commonly using a multi-well plate (MWP) or multi-rack format. These approaches rely on extensive use of automation to carry out a large number of crystallisations using robotics and computer control to execute some or all steps involved in crystallisation (Florence 2009) and in situ analysis using fingerprinting techniques such as Raman spectroscopy or XRPD. Data mining tools are then applied to identify the new solid-state forms and the HTC results are stored in databases for future use (Aaltonen et al. 2009).

A number of approaches with a range of capabilities and benefits have been applied for HTC in search of physical forms of the pharmaceuticals. Some examples of physical form screening using automated methods, conditions and their results are summarised in Table 4.1.

HTC offers the advantage of exploring a large property space of a molecule requiring less material and time compared with traditional manual approaches. It is worth noting that in spite of the large number of crystallisation trials, the associated

Table 4.1 Examples of high-throughput crystallisation carried out for physical form screening of pharmaceuticals

API	Platform/Company	No. of crystallisations/ no. of solvents	HT crystallisation method	HT analytical method	No. of physical forms found	References
Carbamazepine	ChemSpeed Accelerator SLT100	594 crystallisations/ 66 solvents	Cooling, evaporation, cooling and evaporation	XRPD	3 polymorphs (forms I, II and III), 9 solvates	Florence et al. (2006)
Cimetidine	Symyx technologies, Inc.	288 crystallisations/ 20 solvents, 84 solvent mixtures	Cooling, evaporation, precipitation	Raman, XRPD, polarising light microscopy	3 polymorphs	Desrosiers (2004)
Carbamazepine	Solvias AG	Number not available/ 43 solvents and mixtures	Evaporation, suspension, desolvation	Raman	4 known polymorphs, 2 known solvates (dihydrate and acetone), 5 suggested new forms (incl. 2 solvates)	Hilfiker et al. (2003)
Angiotensin II receptor antagonist MK-996	CrystalMax™/ TransForm Pharmaceuticals, Inc.	1440 crystallisations/ 21 solvents and mixtures	Cooling (3 nominal concentration levels), separate hydrate screen	Raman, XRPD	18 crystalline forms	Almarsson et al. (2003)
Sertraline HCl	CrystalMax™/ TransForm Pharmaceuticals, Inc.	3072 crystallisations/ 24 solvents and mixtures	Cooling (2 nominal concentration levels)	Raman, XRPD	10 forms (4 additional forms by follow up studies)	Almarsson et al. (2003)

(continued)

Table 4.1 (continued)

API	Platform/Company	No. of crystallisations/ no. of solvents	HT crystallisation method	HT analytical method	No. of physical forms found	References
Ritonavir	CrystalMax™/ TransForm Pharmaceuticals, Inc.	2000 + crystallisations/ 24 solvents (single and binary mixtures)	Cooling (4 nominal concentration levels)	Raman	3 polymorphs (I, II, IV), 1 solvate (III). Follow up studies revealed a trihydrate (Form V)	Morissette et al. (2003)
Acetaminophen	CrystalMax™/ TransForm Pharmaceuticals, Inc.	7776 crystallisations (first iteration)/ 16 solvents (single and binary mixtures)	Cooling (3 nominal concentration levels)	Raman	2 polymorphs (I and II). Form III was found in subsequent studies	Peterson et al. (2002)

Reproduced from Ref. (Aaltonen et al. 2009)

hit rate (number of experiments where API crystallise) with HTC can be very low e.g. between 2.5 and 13.0 % (Peterson et al. 2002; Almarsson et al. 2003; Morissette et al. 2003). The ultimate advantage of HTC lies in carrying out a large number of experiments, utilising mg of API, μ l of solvent with little or no manual intervention (Aaltonen et al. 2009).

The need for HTC is driven by the requirement to take the most favourable physical form (polymorph, solvate or salt) to the market in the minimum amount of time. HTC can help not only in eliminating the risk associated with the development compound quickly, but also in finding ways to mitigate the risk of failures during later stage of drug development (Balbach and Korn 2004). Comprehensive information about various physical forms from HTC also provides an opportunity for maximum coverage of intellectual property space and helps in addressing the key regulatory questions e.g. number of physical forms of an API and the relationships amongst them (Morissette et al. 2004).

This chapter reports the development and validation of a High-Throughput Crystallisation and Analysis (HTCAA) methodology using 96/48 quartz well plates combined with automated data collection using Raman spectroscopy for physical form screening. This methodology is complementary to larger scale (3–8 ml) parallel approaches and enables studies where only small quantities (1–2 mg per crystallisation) of a compound are available. A schematic illustration of the experimental workflow for the HTCAA approach is shown in Fig. 4.1. Development and validation of steps 1–3 in Fig. 4.1 were included in this investigation. Novel physical

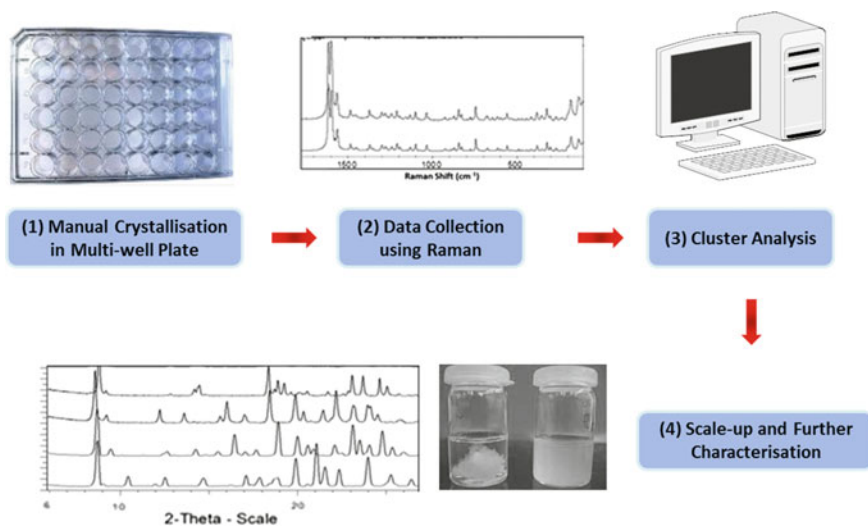


Fig. 4.1 Illustration of experimental workflow for high-throughput crystallisation and analysis methodology

forms identified during cluster analysis (step 3 in Fig. 4.1) were then prepared on a scale of ~ 150 – 200 mg. This was followed by the characterisation of the novel physical forms using thermal analysis, XRPD and/or SXD.

The HTCAA methodology developed here is not intended for comparison with highly automated and sophisticated systems (e.g. Crystal MaxTM and Symyx) summarised in Table 4.1 or with other larger scale systems e.g. fully automated parallel solution crystallisation platform which requires 150 mg of solute with 3–8 ml of solvent per crystallisation (Florence et al. 2006). The target was development of a complementary, low-cost, and efficient integrated methodology for small scale (1–2 mg) crystallisations and analysis to provide information on solid-state behaviour of a compound from a range of solvents when only limited amount of material is available. This would involve establishing and testing a robust workflow combining small scale crystallisation, Raman microscopy and chemometrics for fast and cost-effective physical form screening.

Raman spectroscopy was chosen as an analytical method as it is an efficient tool in differentiating between different physical forms like polymorphs, solvates, co-crystals and salts (Findlay and Bugay 1998). Raman spectroscopy is based on inelastic scattering of monochromatic excitation source (usually a laser source) upon contact with a sample. The change in the frequencies of the absorbed and remitted photons of the monochromatic excitation source by the sample is measured. This shift provides information about the vibrational, rotational and other low-frequency modes in molecules. Raman spectroscopy offers various advantages (e.g. no specific sample preparation, less material requirement and faster data collection) over other analytical techniques (Bugay 2001). It also provides physical and chemical information about a compound (Peterson et al. 2002; Kojima et al. 2006; Al-Dulaimi et al. 2010).

There are a few literature reports of semi-automated salts screening (Balbach and Korn 2004; Kojima et al. 2006) and co-crystals screening (Kojima et al. 2010) in MWP using Raman spectroscopy, however no chemometric analysis was carried out on the Raman spectra to aid application in a HTC context. Another report using Raman and optical microscopy has demonstrated the discovery and selection of polymorphs of CBZ, acetaminophen, sulfamethoxazole, and a pharmaceutical intermediate 5-methyl-2-[(2-nitrophenyl)amino]-3-thiophenecarbonitrile (ROY) using polymer heteronuclei (Balbach and Korn 2004; Price et al. 2005).

The volume of the data generated from MWP approaches can be overwhelming for individual spectral analysis and hence require effective data analysis tools. In this work a non-supervised chemometric tool called group analysis was used to identify novel physical forms from the Raman spectra collected. Whilst using adequate data pre-treatment to remove baseline effects and appropriate grouping (Lowry et al. 2006), useful information was extracted from the spectral data generated from MWP, which was subsequently utilised to guide larger scale (~ 150 – 200 mg) crystallisation efforts. Specifically, the application of HTCAA

methodology has been developed and assessed using salt screening of AXPB and polymorph/solvate screening of OZPB and CZPB (see Sect. 4.2).

Salt screening for an API is a common process in pharmaceutical industry. The increased number of poorly soluble compounds emerging from modern drug discovery approaches leads to increased utilisation of salt forms to increase aqueous solubility and hence bioavailability where the compound contains ionisable functional groups. Salts formation may also be employed to increase chemical stability or to reduce the solubility of an API in sustained released dosage forms (Ashby and Wang 1996). Furthermore, salts and other crystal forms (solvates, hydrates, and co-crystals) of a given molecular entity can enhance the intellectual property estate enabling extended protection of valuable market shares through patents (Clark et al. 2005). For a comprehensive understanding of physical form diversity, it is advisable to combine salt selection studies with simultaneous polymorph screening (Remenar et al. 2003).

AXPB is a basic drug with calculated pKa values of 9.0, 8.2 and 4.6 for the secondary amine, tertiary amine and imine nitrogen atoms respectively (Fig. 4.2) estimated using Pipeline Pilot Professional Client interface (Accelrys 2010). In addition to salt screening of AXPB using HTCAA, solvent incorporation in salts and polymorphic nature of salts was also assessed.

The HTCAA method was also applied to physical form (polymorph/solvate) screening of OZPB and CZPB (Fig. 4.3) to obtain a preliminary view of their solid-state behaviour in a selected solvent system. Although hydrates are sometimes utilised, solvates are not generally suitable for drug development, although may be used as precursors to the final form. Hence a robust knowledge of solvate formation, particularly in process relevant solvents, and their identification is essential to understand the solid-state behaviour of the compound (Anderton 2007).

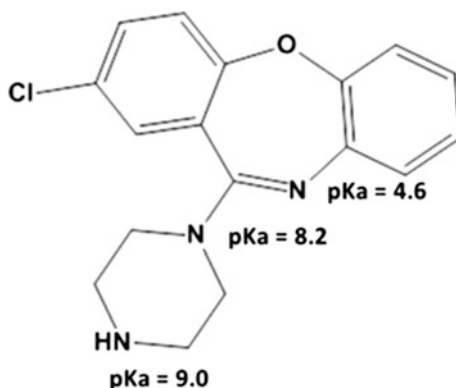


Fig. 4.2 Calculated pKa of nitrogen atoms in amoxapine

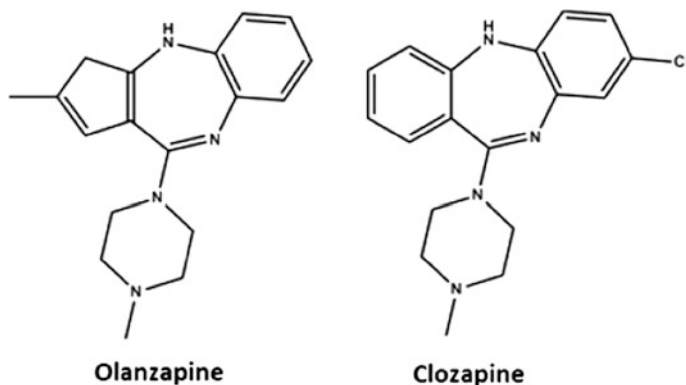


Fig. 4.3 Chemical structures of olanzapine and clozapine

4.2 Sample Preparation and Methodology Development

4.2.1 96/48 Quartz Multi-well Plate

There are many MWP available in terms of size, number of wells and material of construction. MWP selection was based on the following criteria: solvent/chemical compatibility, low/no fluorescence, reusable, and high temperature tolerance ($\sim 800^\circ\text{C}$). Quartz 96 and 48-well plates customised for use with the DXR Raman microscope (Thermoscientific, Madison, USA) were procured from Hellma, Germany. The layout of both 96 and 48-well plates showing typical configurations for salt screening and anti-solvent screening respectively are shown in Fig. 4.4.

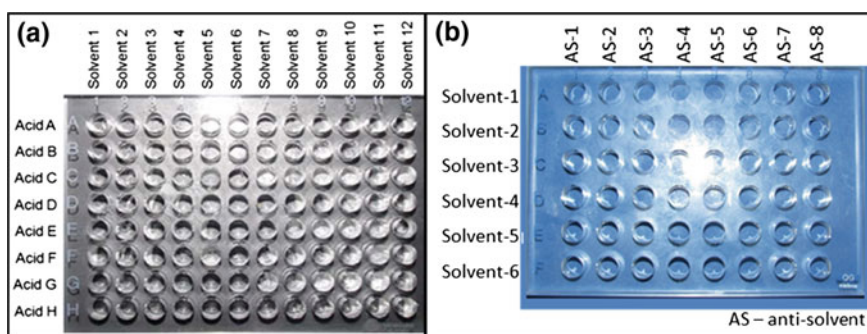


Fig. 4.4 Layout of **a** salt screening in the 96-well plate, and **b** anti-solvent screening in the 48-well plate. A polymorph screen could be carried out using a different solvent in each well for example

4.2.2 Preparation of 96-Well Plate for Salt Screening of Amoxapine

Salt screening of AXPN was carried out in 96-well plate using four different acids and two concentrations of AXPN in 12 solvents. A set of 4 pharmacologically safe mono and dibasic acids (Table 4.2) were selected for salt screening purpose and purchased from Sigma-Aldrich, UK. These acids were expected to form stable salts with AXPN as the pKa difference between ionisable group on AXPN and counter acid is more than 3 units (Bastin et al. 2000).

All the crystallisations were set up manually. The solutions (75 mM) of AXPN and the acids were prepared in ethyl acetate prior to use. The solution of AXPN was placed in each well of rows A, C, E, G and H (60 μ l per well) and B, D and F (120 μ l per well) of the 96-well plate (Fig. 4.4). To each well in the first seven rows, 60 μ l of ethyl acetate solution of succinic acid (row A–B) or maleic acid (row C–D) or PTSA (row E–F) or acetic acid (row G) was added. This resulted in a binary mixture of AXPN and acid in the molar ratio of 1:1 in rows A, C, E, G and 2:1 in rows B, D, F. Row H contained only AXPN in ethyl acetate as a control. The plate was then left in a fume hood at RT to allow solvent evaporation. After complete evaporation of solvent, 200 μ l of crystallisation solvent [one solvent per column from methanol, ethanol, acetonitrile, acetone, ethyl acetate, isobutyl acetate, nitromethane, cyclohexane, toluene, diisopropyl ether, tetrahydrofuran (THF) and water] was added to each column of the plate. The MWP was then sealed using transparent sealing films (ThermaSeal RTS™) and shaken using an orbital shaker at RT for 4 h to allow dissolution of solid. Following dissolution, the seal was removed and the MWP was left in the fume hood to allow slow solvent evaporation at RT. The MWP was then checked for crystals using polarised light microscopy and analysed using the Raman microscope.

Table 4.2 Counter ions used for salt screening of amoxapine

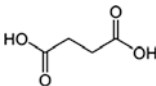
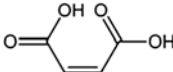
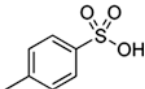

Name	Structure	pKa	Melting point (K)
Succinic acid		4.2, 5.6	457
Maleic acid		1.9, 6.1	408
Para-toluene sulfonic acid (PTSA)		-2.8	311
Acetic acid		4.8	289

Table 4.3 Solvents used for physical form screening of clozapine in experiment 1 (PS-1) using 48-well plate

S. No	Solvent	S. No	Solvent	S. No	Solvent
1	Methanol	9	Pentyl acetate	17	Acetonitrile
2	Ethanol	10	Butyl acetate	18	1,4-dioxane
3	1-propanol	11	Acetone	19	Pyridine
4	2-propanol	12	Methyl-ethyl ketone	20	Nitro methane
5	1-butanol	13	Diethyl ether	21	Tetrahydrofuran
6	2-butanol	14	Tertiary-butyl methyl ether	22	Dichloro methane
7	Methyl acetate	15	Toluene	23	Water
8	Ethyl acetate	16	1,1-dichloroethane	24	Acetic acid

4.2.3 Preparation of 48-Well Plate for Physical Form Screening of Clozapine

Two physical form screening experiments (PS-1 and PS-2) were carried out using a single concentration of solute and a 96-solvents system at RT in a 48-well plate. A solution of CZPN (75 mM) was prepared in ethyl acetate prior to use and 100 μ l was placed in each well of the 48-well quartz plate. The MWP was kept in the fume hood at RT for evaporation of the ethyl acetate to leave approximately 2.4 mg of solid after drying. 250 μ l of the crystallisation solvent (one per well chosen from 24 solvents in the same sequence as listed in Table 4.3) was added into the first 24 wells (A1–C8). 125 μ l of the same crystallisation solvent (one per well, in the same sequence as in wells A1–C8) was placed in the next 24 wells (D1–F8). In these wells (D1–F8), a further 125 μ l of water was added to make a 1:1 v/v mixture of water and each solvent. The MWP was sealed using transparent sealing films (ThermaSeal RTS™) and placed on an orbital shaker for 2 h to redissolve the CZPN. The plate was visually inspected to check dissolution of CZPN. Following dissolution of CZPN in the majority of wells, the seal was removed and the MWP was left in a fume hood at RT to allow slow evaporation of the solvents. The plate was inspected regularly for evidence of crystallisation. Following appearance of crystals, data were collected using the Raman microscope (see Sect. 4.2.5). A similar procedure was repeated for PS-2 with solvents listed in Table 4.4.

4.2.4 Preparation of 96-Well Plate for Physical Form Screening of Olanzapine

Physical form screening of OZPN was carried out using two concentrations of solute and 48 solvents at RT in a 96-well plate. A solution of OZPN (50 mM) in ethyl acetate was prepared prior to use. 70 and 140 μ l of OZPN solution were

Table 4.4 Solvents used for physical form screening of clozapine in experiment 2 (PS-2) using 48-well plate

S. No	Solvent	S. No	Solvent	S. No	Solvent
1	1-pentanol	9	Pentyl acetate	17	4-methyl-2-pentanone
2	2-pentanol	10	Trichloroethylene	18	2-ethoxy ethanol
3	1-hexanol	11	Chloroform	19	2,2,2-trifluoro ethanol
4	Cyclohexanol	12	Carbon tetrachloride	20	2-methoxy ethanol
5	Isoamyl alcohol	13	Fluoro toluene	21	1,2-dimethoxyethane
6	2-methyl-1-propanol	14	Cyclohexane	22	N,N-dimethyl formamide
7	Isopropyl acetate	15	Diethyl carbonate	23	N,N-dimethyl acetamide
8	Isobutyl acetate	16	Diisopropyl ether	24	Dimethyl sulfoxide

Table 4.5 Solvents used for physical form screening of olanzapine using 96-well plate

S. No	Solvent	S. No	Solvent	S. No	Solvent
1	Methanol	17	Tetrahydrofuran	33	2,2,2-trifluoroethanol
2	Ethanol	18	Pyridine	34	N,N,N-triethyl amine
3	1-propanol	19	Diethyl carbonate	35	Aniline
4	2-propanol	20	Diethyl ether	36	Hexane
5	1-butanol	21	Tertiary-butyl methyl ether	37	N,N-dimethyl formamide
6	2-butanol	22	Acetone	38	N,N-dimethyl acetamide
7	1-pentanol	23	Methyl-ethyl ketone	39	2-butoxy ethanol
8	2-pentanol	24	Toluene	40	2-methoxy ethanol
9	Methyl acetate	25	Fluoro toluene	41	Dimethyl sulfoxide
10	Ethyl acetate	26	Isoamyl alcohol	42	N-methyl pyrrolidone
11	Butyl acetate	27	Carbon tetrachloride	43	2-phenyl ethanol
12	Isobutyl acetate	28	Dichloromethane	44	1-methyl naphthalene
13	Pentyl acetate	29	1,2-dichloroethane	45	1,2-dimethoxyethane
14	1,4-dioxane	30	Tetrachloro ethylene	46	Formic acid
15	Acetonitrile	31	1-chlorobutane	47	Acetic acid
16	Nitro methane	32	1-bromobutane	48	Water

placed in wells 1–48 (A1–D12) and 49–96 (E1–H12) respectively. The MWP was then left in the fume hood at RT for evaporation of the ethyl acetate to leave approximately 1.1 and 2.2 mg of solid in wells 1–48 (A1–D12) and 49–96 (E1–H12) respectively after drying. 200 µl of each of the crystallisation solvent was added into the first 48 wells (A1–D12) in the same sequence as listed in Table 4.5.

The solvent addition step was repeated for wells E1–H12. The MWP was then sealed using transparent sealing film (ThermaSeal RTS™) and placed on an orbital shaker for 2 h to redissolve the OZPN. The plate was visually inspected to check for complete dissolution of OZPN. Next, the seal was removed and the MWP was left in the fume hood at RT to allow slow evaporation of the solvents. The plate was inspected regularly for evidence of crystallisation. Following appearance of the crystals, data were collected using the Raman microscope (see Sect. 4.2.5).

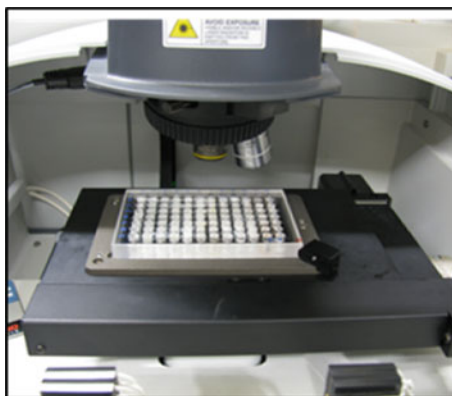
4.2.5 Raman Microscopy

Raman spectra were collected using a DXR Raman microscope (ThermoScientific, Madison, USA) equipped with a high precision x, y, z motorised stage with a holder for MWP (Fig. 4.5). The instrument employs a diode-pumped laser (532 nm) or frequency-stabilised single mode diode laser (780 nm) as an excitation source and an air cooled CCD detector. The maximum power of laser (10 mW) was used for data collection.

There are various data collection modes available, including (a) an average of multiple spectra collected from the well, (b) a spectrum collected from the centre of the well, (c) multiple spectra collected from a grid of defined area and step size across the well, (d) manual assignment of individual data collection locations, and (e) an automated search for the strongest Raman signal within the well available for data acquisition. Optical images are also automatically acquired for each data collection location to allow confirmation that spectra were collected from representative material.

Spectra were collected using a long working distance 10× objective with 50 μm aperture, 1 s exposure and a spectral resolution of 5 cm⁻¹. An autofocus option was employed for collecting spectra to optimise the signal to noise ratio from the sample and fluorescence correction was applied during data collection. The OMNIC™ Array Automation program (version 8.2.1) (Thermo Scientific) within OMNIC™

Fig. 4.5 DXR Raman microscope with motorised x, y, z stage and multi-well plate reader



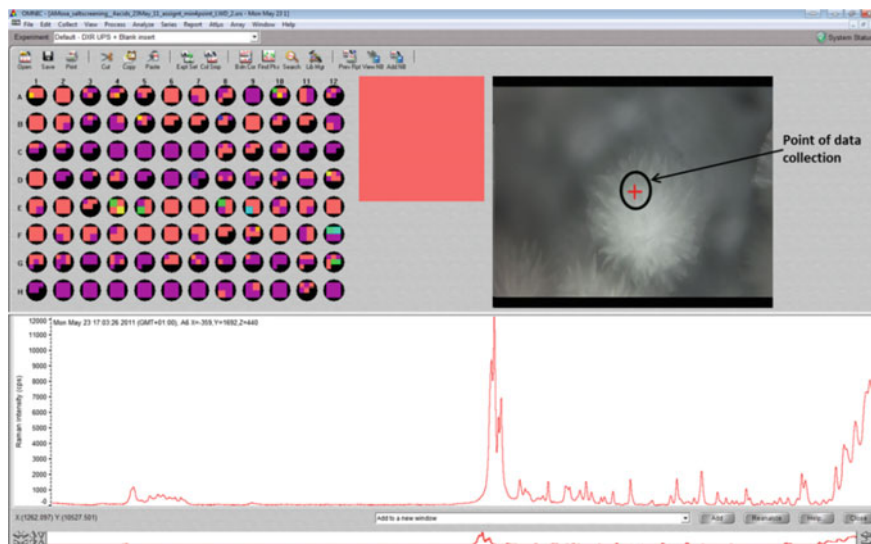


Fig. 4.6 A screenshot of the data acquisition interface set-up for use with the bespoke 96-well quartz plate. Each *circle* in the 8×12 grid (*top left*) represents a well on the plate and each *square* within a well represents a point of data collection (i.e. a Raman spectrum). The point (spot size- $1 \mu\text{m}$) from where the spectrum is being collected is shown by a plus sign on the image (*top right*) with the respective Raman spectrum shown (*bottom*). Spectra in the grid are coloured based on the magnitude of the measured Raman intensity. *Red* and *violet* colours indicate the highest and lowest intensity respectively

software (version 8.2) (Thermo Scientific) was used to define the data collection strategy. A minimum of 4 positions per well were assigned manually for analysis by inspecting each well for various crystal habits. A manual approach was used for selecting points for data collection due to the non-uniform distribution of crystals at the bottom of the wells. This ensured that Raman spectra from different morphologies would be analysed maximising data quality albeit at the expense of time required to select individual data collection locations. By collecting multiple spectra from each well the likelihood of detecting a mixture of forms where the minor component is only a low percentage of the bulk is increased. An example of the real time data collection interface is shown in Fig. 4.6. Once data were acquired chemometric analysis was applied using statistical techniques (see Sect. 4.2.6).

4.2.6 Chemometric Analysis

Pre-processing of each spectrum was done by using a Norris derivative (Norris and Williams 1984) for baseline correction which smooths and performs the derivatation in a single step within the Array Automation program (version 8.2.1) of the

Table 4.6 Raman bands within the region of 1400–1700 cm^{-1} of Raman shift

Functional Group/Vibration	Region (cm^{-1})	Raman
$\nu(\text{C}=\text{N})$	1610–680	Strong
$\delta(\text{CH}_2)$ $\delta(\text{CH}_3)$ asym	1410–1470	Medium
$\nu(\text{C}=\text{C})$ aromatic ring chain vibration	1580–1600 1450–1500	Strong Medium

OMNICTM software package (version 8.2). This treatment removes artefacts, variation in the spectra due to the presentation of crystals in each well (orientation effect) and baseline variations arising due to fluorescence or residual laser scatter (O’Connell et al. 2005). After preprocessing, spectra were clustered using the unsupervised group analysis technique in the region of $\sim 1400\text{--}1700\text{ cm}^{-1}$ of Raman shift, with a similarity cut off value of 90 % within array program. This region of Raman shift was used because of the presence of bands with high signal to noise ratio for these compounds. Various characteristic Raman bands for organic compounds within the Raman shift region of $1400\text{--}1700\text{ cm}^{-1}$ are listed in Table 4.6.

Being an unsupervised technique, group analysis makes no assumption about the number of classes or class assignment before the analysis (Kastanos et al. 2012). It compares all the spectra in the data set and sorts the spectra into groups or clusters based on their “similarity”. The similarity value for a group of spectra is a function of the cross-correlation coefficient between all the spectra in the set. After group analysis, the colour assigned to each well within MWP corresponds to the groups assigned as the result of the spectral data analysis enabling easy detection of different single or multiple forms (Lowry et al. 2006).

4.2.7 Scale-up and Characterisation of Novel Forms

Novel forms identified during each HTCAA study were scaled-up to a 100–200 mg scale by evaporative solution crystallisation in a 3–5 ml vial to allow further characterisation of each new solid form.

Novel salts forms of AXPN were prepared using the same conditions (solvent and molar ratio of AXPN and counter acid) as identified from the MWP screen. For OZPN and CZPN (only PS-1), evaporative crystallisations in vials (see Sect. 3.2.1.1) were carried out with all the solvents used during HTCAA to compare with the results obtained at smaller scale. In some cases, liquid-assisted grinding using Retsch MM400 mixer mill (see Sect. 3.2.1.3) and cooling crystallisations (see Sect. 3.2.1.2) were also used to confirm the results of evaporative solution crystallisation or obtain the pure form. All the novel forms were characterised using Raman microscopy (see Sects. 3.2.4 and 4.2.5), XRPD, SXD where suitable samples could be obtained (see Sect. 3.2.2) and thermal analysis using simultaneous DSC and TGA (see Sect. 3.2.3).

4.3 Results and Discussion

4.3.1 Salt Screening of Amoxapine

Out of the 96 recrystallisation experiments on the 96-well plate ($\sim 1.4\text{--}3.6$ mg solid per well), crystals were observed in 91 wells (hit rate of 94.8 %) as indicated by polarised light microscopy. In other cases, a sticky/oily material was formed which could not be analysed further.

Spectra obtained from the 96-well plate were grouped using the group analysis tool in the region of $1470\text{--}1700\text{ cm}^{-1}$ of Raman shift with a cut off value of 90 % for similarity. 466 spectra were grouped into a total of 11 groups (Fig. 4.7, Table 4.7) and the remaining 171 spectra were outliers and did not fall into any of the groups. These ungrouped spectra were analysed individually (Fig. 4.7).

Out of the 11 groups, groups 1–6 represent novel salts and group 7 represents poor quality spectra with no peak information. The spectra from groups 8–10 were similar to one of the novel salts identified in groups 1–6 but were different enough (i.e. poor Raman scattering band resolution) for the group analysis to classify accurately. In addition to sample presentation effects highlighted above

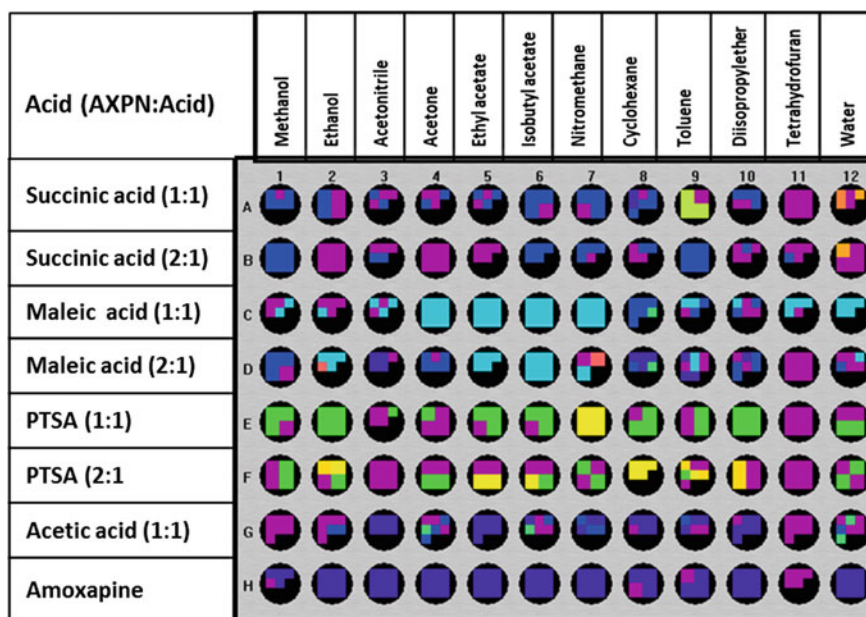


Fig. 4.7 Salt screening results of amoxapine after group analysis on a 96-well plate. Each *square* (spectrum) from the wells is colour coded according to classification group. Group 1 to 11 are shown by blue, fluorescent green, dark orange, cyan, green, yellow, orange, dark yellow, light green, pink-red and violet colour respectively. All other spectra shown by violet colour are outliers

Table 4.7 Details of 11 groups observed on the 96-well plate and their respective colour shown in Fig. 4.6

Group	Counter anion	Colour in Fig. 4.6
1	Succinic acid, maleic acid and acetic acid	Blue
2	Succinic acid	Fluorescent green
3	Succinic acid	Dark orange
4	Maleic acid	Cyan
5	PTSA	Green
6	PTSA	Yellow
7	Maleic acid	Orange
8	PTSA	Dark yellow
9	Maleic acid	Light green
10	Maleic acid and acetic acid	Pink-red
11	NA-only AXP	Violet

(see Sect. 4.2.6), minor changes in Raman spectra can also arise from differences in particle size, purity and residual solvent (Remenar et al. 2003).

The spectra in group 11 match that of the AXP starting material indicating that no polymorphs or solvates are obtained with the studied solvents. Two novel salts of AXP with acetic acid were obtained after analysing the spectra which could not be grouped in any of the 11 groups. The remainder of the ungrouped spectra were confirmed as belonging to one of the above groups (1–11) but were misclassified due to the variations in peak resolution or poor signal to noise ratio. The Raman spectra in the region of 1520–1640 cm^{-1} of Raman shift for all 10 novel salts are shown in Fig. 4.8.

Some maleic, succinic and acetic acid counter ion spectra were grouped together (group 1, shown by blue colour in Fig. 4.7) as these structures display similar peak positions in the 1400–1700 cm^{-1} region. On comparing the full spectra of these different salts, the differences were clearly evident from other regions of Raman spectra. Thus, a narrow wavelength region is sufficient to allow rapid and effective cluster analysis. A full range spectrum contains more spectral information but can lead to less effective clustering due to the increased information content.

The total number of AXP salts identified with each counter acid is reported in Table 4.8. Salts in the binary mixtures of AXP and counter acid exhibiting different spectra are labelled according to the initials of the counter acid (Tables 4.8 and 4.9).

Details of the crystallisation conditions (counter acid, stoichiometry and solvent) under which the individual salt was obtained are given in Table 4.9. A mixture of AXP with its succinate (S1), maleate (M1 or M2) and acetate (AA1, AA2 and AA3) salts was detected in 1, 4 and 4 wells respectively. A mixture of maleate (M1 and M2) salts was observed in 4 wells. Similarly, a mixture of tosylate (E1 and E2) salts was detected in 6 wells (Table 4.9).

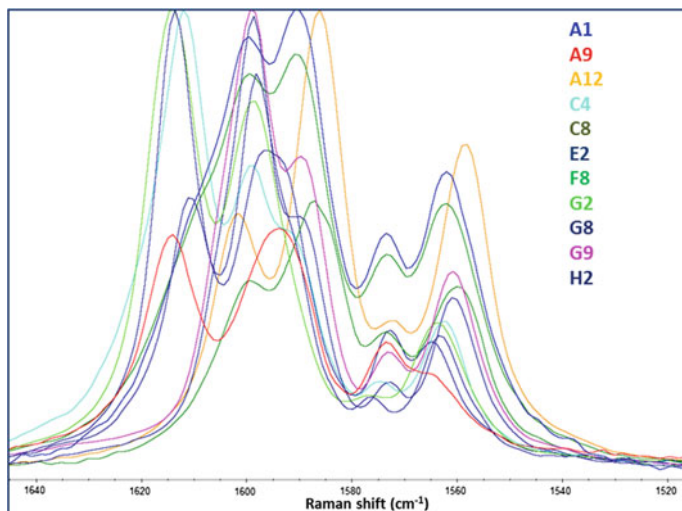


Fig. 4.8 Characteristic Raman spectra for 10 novel salts observed during salt screening of amoxapine. Each spectrum is labelled according to the well number from which they have been obtained on the 96-well plate

Table 4.8 Total number amoxapine salts identified from each counter acid during HTCAA

Group	Counter acid	Number of crystalline forms	Label
1	Succinic acid	3	S1, S2 and S3
2	Maleic acid	2	M1 and M2
3	PTSA	2	E1 and E2
4	Acetic acid	3	AA1, AA2 and AA3

In total, 10 novel salts were observed using the 4 acids in molar ratios (AXPN:counter acid) of 1:1 and 2:1 utilising a minimum amount of material i.e. ~ 187 mg of AXPN, ~ 50 mg of the 4 counter acids and ~ 20 ml of the 12 solvents. With appropriate data treatment and grouping techniques, a variety of chemical information was obtained. For example, two potential solid-state forms were observed for maleate as well as tosylate salts. Similarly three potential solid-state forms were detected for both succinate and acetate salts. However, it is not clear if the salts were hydrates, solvates or a combination. In addition, the same crystalline forms were observed in the wells with 1:1 and 2:1 molar ratio of AXPN and counter acid.

The presence of both M1 and M2 in wells with 1:1 and 2:1 molar ratio of AXPN and maleic acid and AXPN free base in some wells with 2:1 molar ratio of AXPN and maleic acid suggest that the AXPN tends to form salts with maleic acid in a molar ratio of 1:1. The identity of the novel salts was confirmed using SXD/XRPD and STA analyses during scale-up experiments (see Sect. 4.3.1.1).

Table 4.9 Amoxapine salts classified by Raman spectra using group analysis on the results obtained in the screening experiment on the 96 well plate

		Solvents																
CA	AXPN:CA	1	2	3	4	5	6	7	8	9	10	11	12					
		MeOH	EtOH	MeCN	Acetone	EtOAc	IBA	NM	cHex	Toluene	DIPE	THF	Water					
Succinic acid	1:1	S1	S1	S1	S1	S1	S1	S1	S1	S1	S1	---	S3					
Succinic acid	2:1	S1	S1	---	S1	S1	S1	S1	S1	S1	S1	S1	S3					
Maleic acid	1:1	M1	M1	M2	M1	M1	M1	M1	M1	M2	M2	M1	M1					
Maleic acid	2:1	M2	M2	M2	AXPN	M2	M1	M1	M1	M2	AXPN	AXPN	M1	M2	AXPN	M2	M2	M1
PTSA	1:1	E1	E1	E1	E1	E1	E1	E1	E2	E1	E1	E1	E1					
PTSA	2:1	E1	E1	E2	E1	E1	E2	E1	E2	E1	E2	E1	E2	---	E1			
Acetic acid	1:1	AA1	AA1	AXPN	AA1	AXPN	AXPN	AA1	AXPN	AA1	AA2	AXPN	AA3	AXPN	AXPN	---	AA1	
AXPN		AXPN	AXPN	AXPN	AXPN	AXPN	AXPN	AXPN	AXPN	AXPN	AXPN	AXPN	---	AXPN				

Raman spectra of salts from AXPN and succinic acid (1:1, 2:1) are classified as S1 or S2 or S3
Raman spectra of salts from AXPN and Maleic acid (1:1, 2:1) are denoted as M1 or M2

Raman spectra of salts from AXPN and PTSA (1:1, 2:1) are represented as E1 or E2

Raman spectra of salts from AXPN and acetic acid (1:1) are classified as AA1 or AA2 or AA3
CA counter acid, AXPN amoxapine, MeOH methanol, EtOH ethanol, MeCN acetonitrile, EtOAc ethyl acetate, IBA Isobutyl acetate, NM nitromethane, cHex cyclohexane, DIPE diisopropyl ether, THF Tetrahydrofuran

4.3.1.1 Scale-up and Characterisation of Novel Salts of Amoxapine

Succinate and Acetate Salt Forms of Amoxapine

All the succinate (S1, S2 and S3) and acetate (AA1, AA2 and AA3) salt forms could be obtained by solvent evaporation from the respective solvents as identified during the screen. An overlay of Raman spectra of the succinate and acetate salt forms observed from the 96 well plate and after scale-up is shown in Fig. 4.9.

An overlay of XRPD patterns of the novel salts including the three different succinate and acetate salt forms obtained after scale-up is shown in Fig. 4.10.

S1, AA1, AA2 and AA3 form a part of a group of six salts, for which single crystal data were also collected and lattice parameters are reported in Table 4.10. Structural analysis was not the key goal of this study; however a brief overview of key structural features of these 6 salts is presented in Table 4.11.

Maleate Salts of Amoxapine

M1 is a non-solvated 1:1 maleate salt (as indicated by SXD data and Thermal analysis) of AXPN and was obtained from solvent evaporation from methanol at RT. The stoichiometry information obtained here corroborates the inference of salt screening on the 96-well plate. M2 was observed concurrently with M1 from

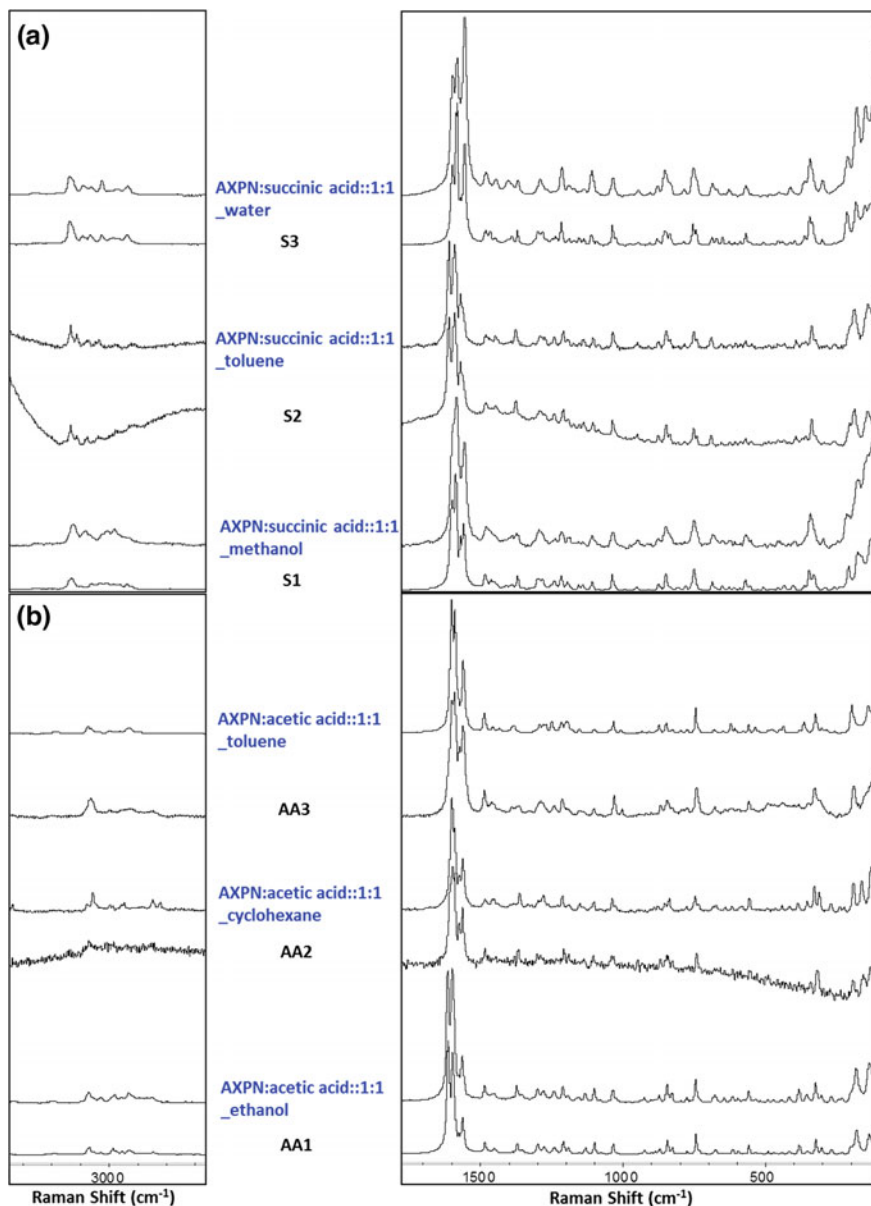


Fig. 4.9 Stack plots of Raman spectra collected from samples of salts of **a** amoxapine and succinic acid, **b** amoxapine and acetic acid, at 96-well plate and on 150 mg scales. The Raman spectra of salts obtained from 96-well plate and on 150 mg scales are labelled in *black* and *blue* colour respectively

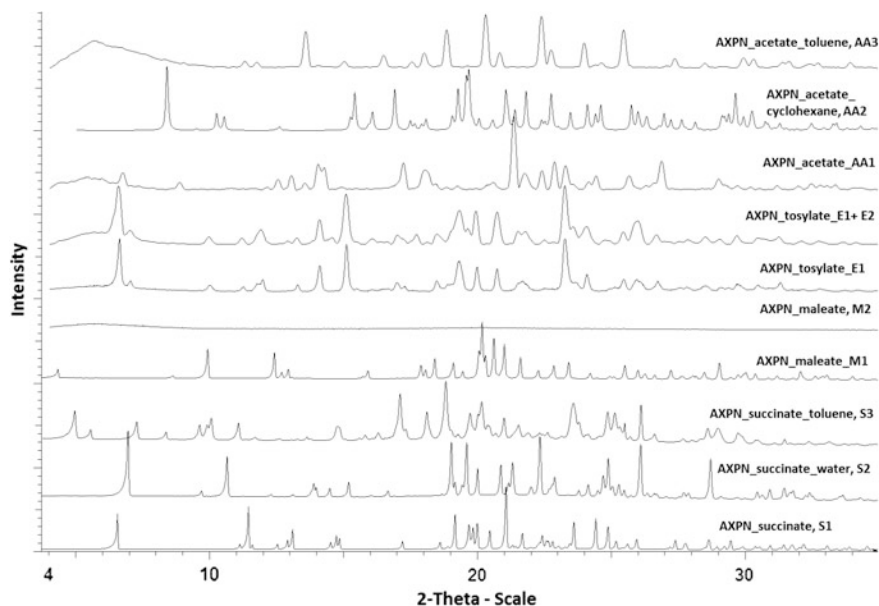


Fig. 4.10 Stack plot of XRPD patterns of the 10 novel amoxapine salts obtained on 150 mg scales in the range of 4–35° 2 θ

Table 4.10 Lattice parameters of the amoxapine salts identified from the salt screen

Structure ID	Identifier	Space Group	<i>a</i> (Å)	<i>b</i> (Å)	<i>c</i> (Å)	β (°)	Volume (Å ³)
1	AXPN_succinate, S1	<i>Pbcn</i>	24.2941 (11)	21.0763 (11)	8.5064 (4)	90.00	4355.5(4)
2	AXPN_maleate, M1	<i>P2₁/c</i>	20.6004 (9)	9.8341 (4)	9.7939 (4)	96.779 (1)	1970.2(1)
3	AXPN_PTSA, E1	<i>C2/c</i>	31.5462 (13)	5.8832 (3)	27.6448 (12)	119.299 (2)	4474.3(4)
4	AXPN_acetate, AA1	<i>P2₁/n</i>	14.5022 (13)	7.8015 (7)	19.0516 (17)	105.906 (4)	2072.9(3)
5	AXPN_acetate_cyclohexane, AA2	<i>P2₁/c</i>	21.0726 (12)	6.0393 (3)	18.6087 (10)	92.096 (2)	2366.6(2)
6	AXPN_acetate_toluene, AA3	<i>P2₁/c</i>	13.5397 (5)	7.8076 (2)	19.5838 (7)	97.089 (2)	2054.4(1)

All parameters were determined from single-crystal diffraction data collected at 123(2) K (see Sect. 3.2.2)

solvent evaporation of AXPN and maleic acid in a molar ratio of 2:1 from methanol or ethanol. The XRPD pattern of M2 however revealed that it is non-crystalline or diffraction amorphous (Fig. 4.10). To confirm this, cooling crystallisations and liquid-assisted grinding using ethanol and methanol were carried out. XRPD data from these samples were consistent with samples comprising M1 and AXPN. No evidence of diffraction amorphous samples was found from these methods. The

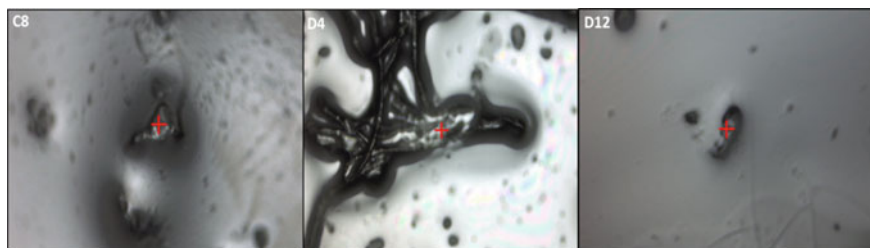


Fig. 4.11 Microscope images (20 \times) of the M2 crystals observed in wells C8, D4 and D12 of 96-well plate

appearance of M2 could be due to rapid onset of supersaturation, resulting in oiling out or rapid precipitation of an amorphous solid of AXPN maleate salt (Morissette et al. 2004). This is supported by the morphology analysis of M2 during HTCAA as visual inspection of the morphology indicates that M2 consists of poor quality crystals (Fig. 4.11).

Tosylate Salts of Amoxapine

E1 and E2 were obtained in the initial screen as a mixture from solvent evaporation of a 1:1 molar ratio of AXPN and PTSA in cyclohexane at RT. E1, E2 and AXPN were obtained from solvent evaporation from a 2:1 molar ratio of AXPN and PTSA in cyclohexane. SXD analysis revealed that E1 is a 1:1 non-solvated tosylate salt of AXPN. Only pure E2 was obtained on 96-well plate from nitromethane and cyclohexane with 1:1 and 2:1 molar ratios of AXPN and PTSA. But in vials, E2 was always found in the presence of E1 or AXPN. This suggests that E1 or AXPN might have been missed by the Raman analysis in these wells during data collection. Alternatively, this change (i.e. obtaining a mixed phase) is due to the effect of the change in solvent volume (Aaltonen et al. 2009). Another reason might be the lack of control over the nucleation and growth process in the small scale evaporation trials resulting in varying rates of supersaturation, hence increasing the possibility of formation of a mixed phase sample. E1 and E2 were obtained as a mixture from 1:1 molar ratios of AXPN and PTSA, however, when a 2:1 molar ratio of AXPN and PTSA was used, excess AXPN was observed suggesting these two forms are polymorphic rather than different stoichiometric salts. Overlays of the Raman spectra of the maleate and tosylate salts are shown in Fig. 4.12.

To summarise, 10 novel AXPN salts were observed from the novel HTCAA method developed and were successfully scaled-up to mg quantities. The crystal structures of 6 salts were determined using SXD (Tables 4.10 and 4.11) and the remaining 4 salts were characterised using XRPD, Raman and thermal analysis. Further work would be required to obtain suitable samples to enable structure determination of these four salts. SDPD was not attempted for these 4 salts though has been used in Chap. 7 in this work.

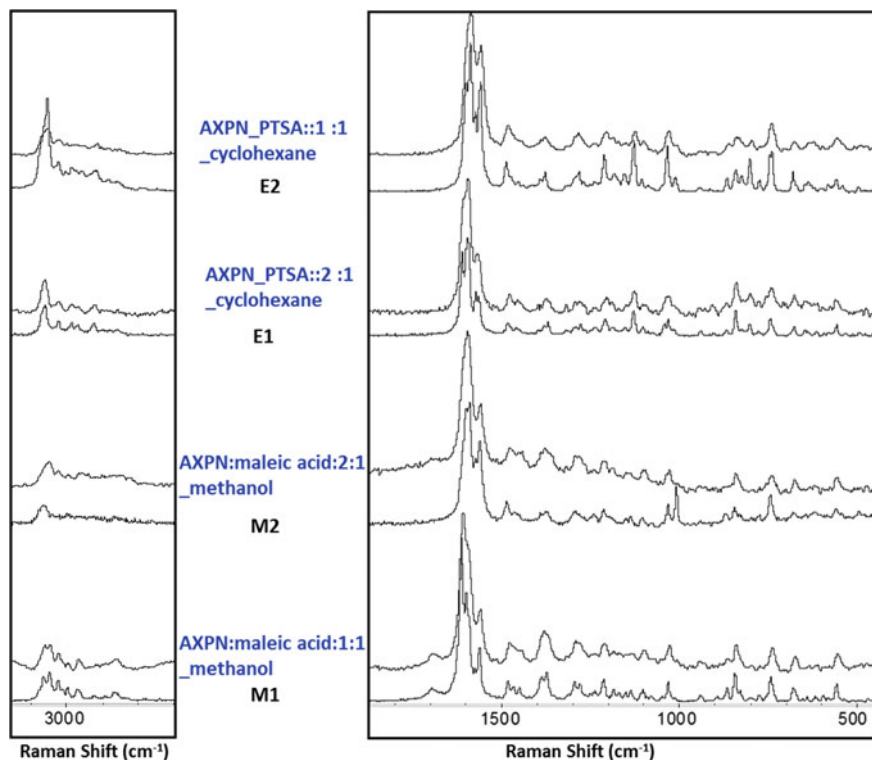


Fig. 4.12 Stack plots of Raman spectra collected from samples of salts of **a** amoxapine and maleic acid and **b** amoxapine and para-toluene sulfonic acid at 96-well plate and on 150 mg scales. The Raman spectra of salts obtained from 96-well plate and on 150 mg scales are labelled in *black* and *blue* respectively

Table 4.11 Content of asymmetric unit of six novel salts of amoxapine reported in Table 4.10

Identifier		Asymmetric unit
S1	AXPN_succinate	$[\text{H-AXPN}]_2^+ [\text{succinate}]^{2-} [\text{succinic acid}]_2 [\text{H}_2\text{O}]_2$
AA1	AXPN_acetate	$[\text{H-AXPN}]^+ [\text{acetate}]^- [\text{acetic acid}]$
AA2	AXPN_acetate_cyclohexane	$[\text{H-AXPN}]_2^+ [\text{acetate}]_2^- [\text{acetic acid}]_2 [\text{cyclohexane}]$
AA3	AXPN_acetate_toluene	$[\text{H-AXPN}]^+ [\text{acetate}]^- [\text{toluene}]$
M1	AXPN_maleate	$[\text{H-AXPN}]^+ [\text{H-maleate}]^-$
E1	AXPN_PTSA	$[\text{H-AXPN}]^+ [\text{tosylate}]^-$

Table 4.12 Solvent systems used in physical form screening, PS-1 of clozapine using a 48-well plate

	1	2	3	4	5	6	7	8
A	MT	ET	PP	PP-2	BT	2-butanol	MA	EA
B	PA	BA	Acetone	MEK	DEE	TBMe	Toluene	DCE
C	CH ₃ CN	DXN	Pyridine	NM	THF	DCM	Water	AA
D	MT + water	ET+ water	PP + water	PP-2 + water	BT + water	2-butanol + water	MA + water	EA + water
E	PA + water	BA + water	Acetone + water	MEK+ water	DEE + water	TBMe + water	Toluene + water	DCE + water
F	CH ₃ CN + water	DXN + water	Pyridine + water	NM + water	THF + water	DCM + water	Water + water	AA + water

Wells where no crystals were observed are coloured green. Group analysis of all the Raman spectra is shown in Fig. 4.13

MT methanol, *ET* ethanol, *PP* 1-propanol, *PP-2* 2-propanol, *BT* 1-butanol, *MA* methyl acetate, *EA* ethyl acetate, *PA* propyl acetate, *BA* butyl acetate, *MEK* methyl ethyl ketone, *DEE* diethyl ether, *TBMe* t-butyl methyl ether, *DCE* 1,1-dichloroethane, *CH₃CN* acetonitrile, *DXN* 1,4-dioxane, *NM* nitromethane, *THF* tetrahydrofuran, *DCM* 1,2-dichloroethane, *AA* acetic acid

4.3.2 Physical Form Screening of Clozapine

4.3.2.1 Experiment 1, PS-1

Following the method outlined in Sect. 4.2.3, crystalline solid was obtained in 38 out of 48 wells (hit rate = 79.2 %) as indicated by polarised light microscopy (Table 4.12). Raman spectra obtained from all the samples on the plate were grouped by employing group analysis tool (see Sect. 4.2.6) using data in the region of 1495–1678 cm⁻¹. 229 spectra were grouped into 5 groups (Fig. 4.13) and the remaining 66 spectra were outliers and did not fall into any of the groups (Fig. 4.13). These ungrouped spectra were analysed individually. Spectra from group 1 (Fig. 4.13) were present in 34 wells and represent the starting form of CZPN (Petcher and Weber 1976), designated as form A. Spectra in groups 2 and 3 were present in 11 and 18 wells respectively. Spectra from group 4 were only found in single well. The physical forms representing group 2–4 have been designated as form B, C and D respectively. Visual inspection of the recrystallised material in all the wells in group 3 suggested that it was oily or poorly crystalline. Spectra from group 5 (well C3 and E8) did not produce any spectral information. A mixture of physical forms was observed in 14 wells. Ungrouped spectra either do not have any spectral information or fall into one of the groups (1–5) but were misclassified due to variations in peak resolution or poor signal to noise ratio in the experimental spectra.

An overlay of the Raman spectra representative of physical forms A, B, C and D in the region of 1480–1680 cm⁻¹ is shown in Fig. 4.14.

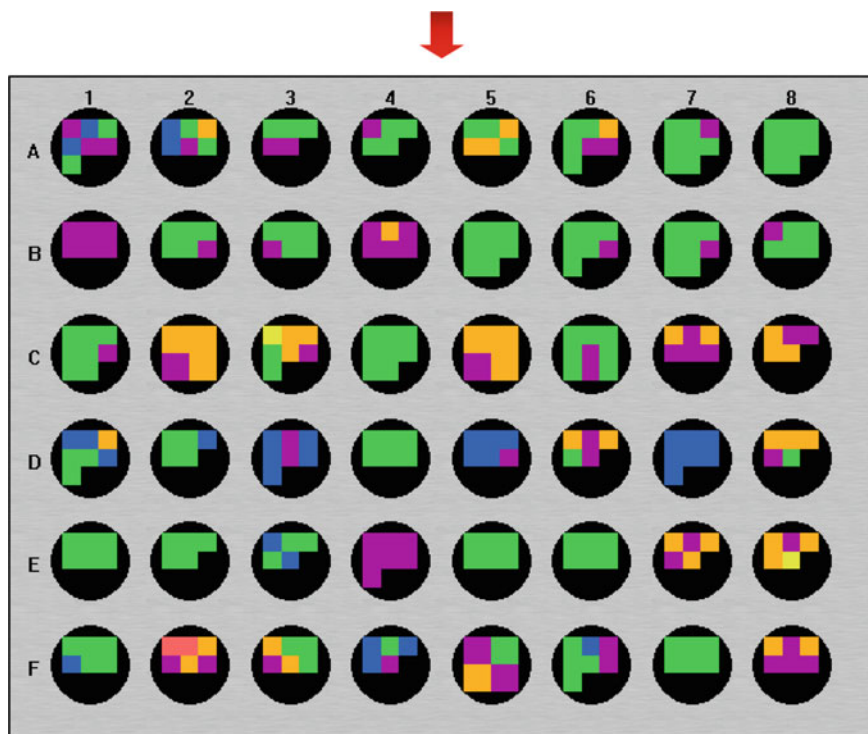


Fig. 4.13 Physical form screening (PS-1) results of clozapine after group analysis on the 48-well plate using the conditions shown in Table 4.12. The wells are *colour* coded according to classification group. Group 1, 2, 3, 4 and 5 are shown by *green*, *blue*, *orange*, *red* and *yellow* colour, respectively. All other spectra shown by *magenta* colour are outliers

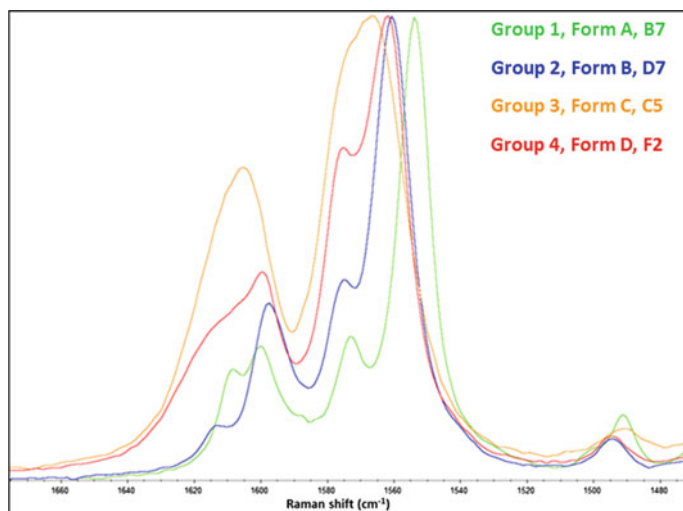


Fig. 4.14 Overlay of Raman spectra in the region of 1450–1700 cm⁻¹ of Raman shift for four physical forms (A, B, C and D) observed during physical form screening of clozapine

4.3.2.2 Experiment 2, PS-2

A second plate for physical form screening (PS-2) was prepared following the method outlined in Sect. 4.2.3, crystalline solid was obtained in 42 wells on the 48-well plate (hit rate = 87.5 %) as indicated by polarised light microscopy (PS-2; Table 4.13). Raman spectra obtained from all the samples on the plate were grouped using the group analysis tool in the region of 1495–1678 cm^{-1} .

270 spectra were grouped into 4 groups and the remaining 120 spectra were outliers and did not fall into any of the four groups (Fig. 4.15). These ungrouped spectra were analysed individually to confirm their identity. Samples exhibiting spectra that belong to group 1 were present in 37 wells (Fig. 4.15) and relate to the CZPN starting material. Spectra from group 2 and 3 were obtained from samples in 4 and 10 wells respectively (Fig. 4.15) and represent form B and C of CZPN, as observed from PS-1. Group 4 represents samples that returned no spectral information. PS-2 also yielded the same physical forms (form A, B, and C) as were observed in PS-1.

To summarise, two HTCAA experiments encompassing 96 crystallisations, utilising a minimum amount of material i.e. ~ 235 mg of solute and ~ 24 ml of 96 solvent systems yielded 3 physical forms of CZPN. On the basis of these results, CZPN appears to have a more limited range of solid-state diversity as compared to OZPN (studied in Sect. 4.3.3).

Table 4.13 Solvent systems used in physical form screening, PS-2 of clozapine using a 48-well plate

	1	2	3	4	5	6	7	8
A	PNT	PNT-2	HN	CH	IAA	MPN	IPA	IBA
B	PA	TCE	CHCl_3	CCl_4	FT	CH	DEC	DIPE
C	MP	EXE	TFE	MXE	DME	DMF	DMA	DMSO
D	PNT + water	PNT-2 + water	HN + water	CH + water	IAA + water	MPN + water	IPA + water	IBA + water
E	PA + water	TCE + water	CHCl_3 + water	CCl_4 + water	FT + water	CH + water	DEC + water	DIPE + water
F	MP + water	EXE + water	TFE + water	MXE + water	DME + water	DMF + water	DMA + water	DMSO + water

Wells where no crystals were observed (based on visual inspection) are coloured pink. Group analysis of all the Raman spectra is shown in Fig. 4.15

PNT 1-pentanol, *PNT-2* 2-pentanol, *HN* 1-hexanol, *CH* cyclohexanol, *IAA* isoamyl alcohol, *MPN* 2-methyl-1-propanol, *IPA* isopropyl acetate, *IBA* isobutyl acetate, *PA* pentyl acetate, *TCE* trichloroethylene, *CHCl_3* chloroform, *CCl_4* carbon tetrachloride, *FT* 4-fluorotoluene, *CH* cyclohexane, *DEC* diethyl carbonate, *DIPE* diisopropyl ether, *MP* 4-methyl-2-pentanone, *EXE* 2-ethoxyethanol, *TFE* 2,2,2-trifluoroethanol, *MXE* 2-methoxyethanol, *DME* 1,2-dimethoxyethane, *DMF* N,N-dimethylformamide, *DMA* N,N-dimethylacetamide, *DMSO* dimethylsulfoxide

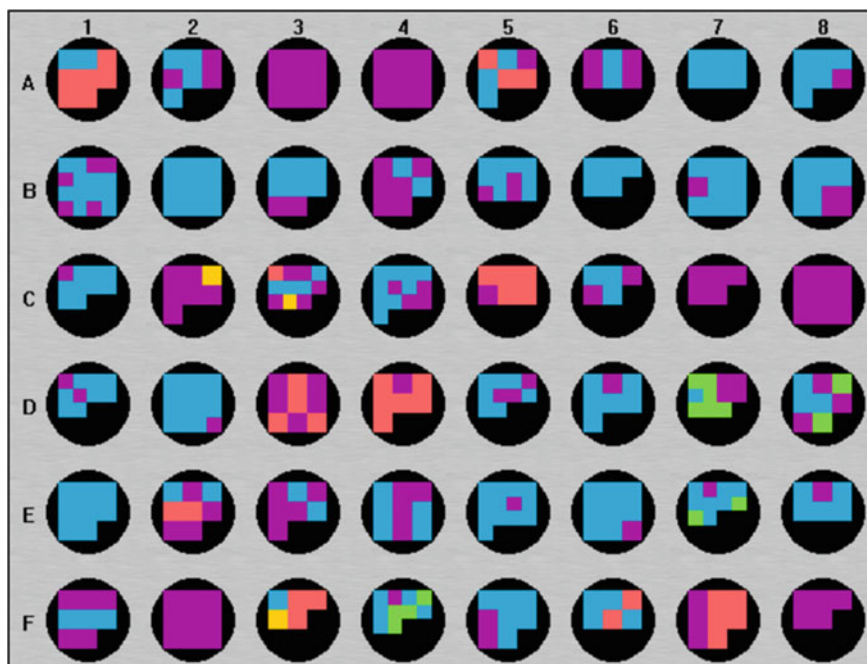


Fig. 4.15 Physical form screening (PS-2) results of clozapine after group analysis on the 48-well plate using the conditions shown in Table 4.13. The wells are colour coded according to classification group. Group 1, 2, 3 and 4 are shown by blue, green, orange and yellow colour, respectively. All other spectra shown by magenta colour are outliers

4.3.2.3 Characterisation of Novel Forms of Clozapine After Scale-up, PS-1

Each of the three forms were successfully scaled up and fully characterised. Form A and B were obtained from the solvent systems as identified during the HTCAA screen. Crystal structure determination of form B revealed that it is a monohydrate of CZPN (Siva Lakshmi et al. 2011).

Form C that was present in 18 wells was an oily or poorly crystalline material. On scale-up, it was obtained from acetic acid, 1,4-dioxane, methyl ethyl ketone and 1,4-dioxane:water (1:1) and is characterised as an amorphous phase based on the lack of diffraction observed from XRPD. Other solvent systems which yielded form C on a 48-well plate provided either form A or B or mixture of both on scale-up.

A stack plot of the characteristic Raman spectra of forms B, C, and D obtained from the screen and scale-up experiments are shown in Fig. 4.16. XRPD patterns of the anhydrous, monohydrate and non-crystalline phases of CZPN are shown in Fig. 4.17.

The Raman spectrum of form D (obtained from well F2 during PS-1 from 1:1 mixture of 1,4-dioxane and water) appeared very similar to that of form B. This was

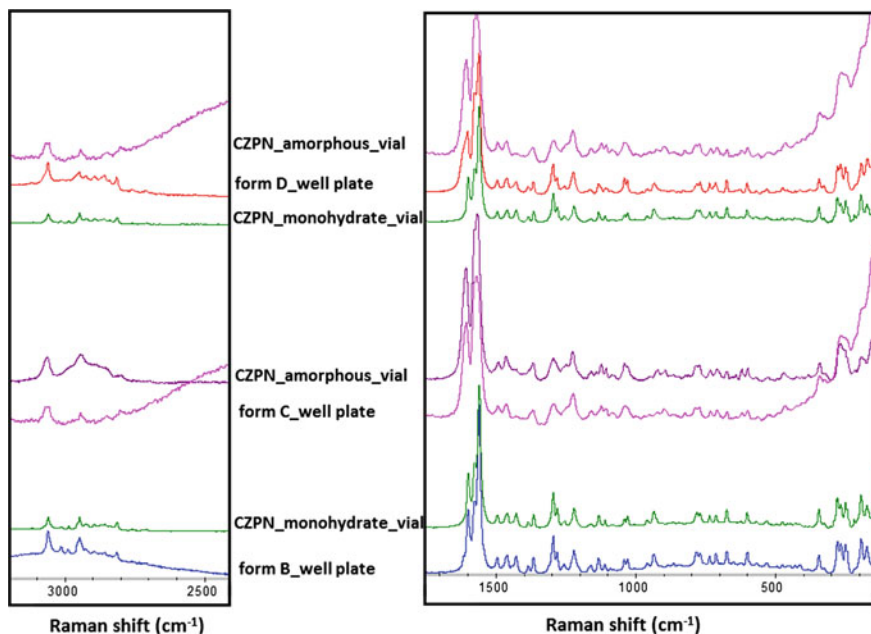


Fig. 4.16 Stack plot of the Raman spectra collected from samples of physical forms of clozapine observed on the 48-well plate and on 150 mg scales. The Raman spectra are labelled according to the source of their origin

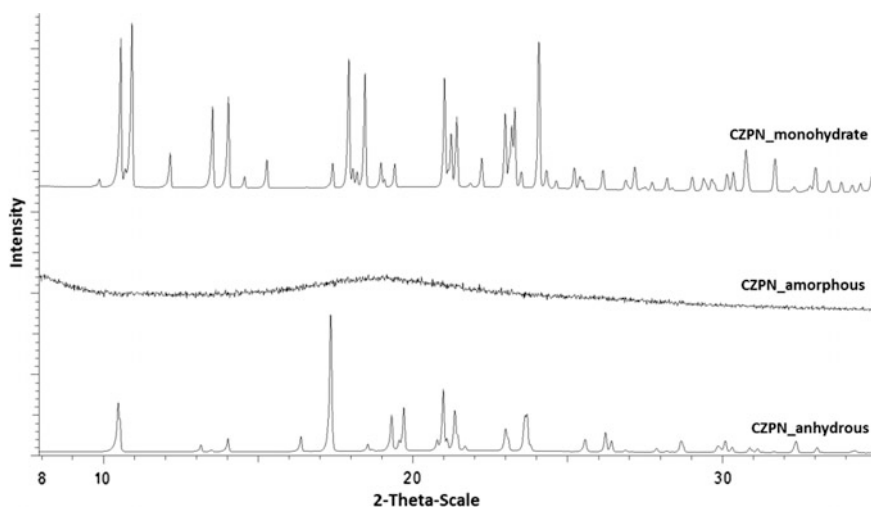


Fig. 4.17 Stack plot of the characteristic XRPD patterns of the 3 physical forms of clozapine obtained on 150 mg scales in the range of 4–35° 2 θ . CZPN_anhydrous, CZPN_amorphous and CZPN_monohydrate represent form A, C, and B observed on the 48-well plate

confirmed by merger of groups 2 and 4 into one group by decreasing the cut-off of similarity to 85 % in subsequent group analysis of all spectra obtained from PS-1 and manual inspection. Evaporative crystallisations in 1:1 mixture of 1,4-dioxane and water yielded either a monohydrate or a non-crystalline phase. Closer inspection of the full Raman spectrum of form D revealed that it has Raman bands of both form B (CZPN monohydrate) and form C (non-crystalline phase) and is therefore a mixture of both. During group analysis of all the spectra obtained from MWP, form D spectra were classified as a separate group due to presence of peaks from both form B and C in the region of 1448–1680 cm^{-1} which was used in the analysis.

To summarise, 3 physical forms were identified from the HTCAA screen and successfully obtained after scale-up. Detailed analysis of all the physical forms has been described in Chap. 7.

4.3.3 Physical Form Screening of Olanzapine

Following the method outlined in Sect. 4.2.4, crystalline solid was obtained in 68 out of 96 wells (hit rate = 70.8 %) as indicated by polarised light microscopy. Group analysis (see Sect. 4.2.6) of the Raman spectra obtained from all the wells in the region of 1400–1650 cm^{-1} of Raman shift yielded 8 groups (Table 4.14). Spectra belonging to group 1 represent the starting material of OZPN and were observed in 19 and 18 wells from rows A-D and E-H respectively (Table 4.14). Spectra that belong to the remaining seven groups denote the novel physical forms of OZPN (Table 4.14). A mixture of form I and a novel form was detected in 5 wells.

Significant differences were found in the region of 1650–1400 cm^{-1} of the Raman spectra for all the novel physical forms of OZPN (Fig. 4.18). The same physical forms were typically observed irrespective of the solute concentration suggesting the robustness of the crystallisation of each form in the presence of the selected solvent. Exception includes wells A10 and E10 with ethyl acetate. In the case of F10 and H3 with acetone and 2-butoxyethanol respectively, novel physical forms were observed with concentration of 2.2 mg/well, while no crystals were observed in respective wells with 1.1 mg/well.

To summarise, 96 crystallisations utilising a total of ~ 158 mg of solute with ~ 20 ml of 48 solvents yielded 7 novel forms of OZPN.

4.3.3.1 Scale-up of Novel Physical Forms of Olanzapine

All 7 novel physical forms were obtained from the respective solvents as per plate samples. A stack plot of the characteristic Raman spectra of all 7 physical forms obtained from the screen and on scale-up experiments is shown in Fig. 4.19. Six physical forms were characterised as OZPN solvates i.e. acetic acid, ethanol, 2,2,2-trifluoroethanol, 2-butoxyethanol, isoamylalcohol hydrate and 1-butanol hydrate. Crystal structure determination of the 7th physical form (detected on

Table 4.14 Physical form screening results of olanzapine using 96-well plate after group analysis based on Raman spectra

	conc	1	2	3	4	5	6	7	8	9	10	11	12
A	1mg	Methanol new	Ethanol new	1-propanol new	2-propanol new	1-butanol form I	2-butanol	1-pentanol form I	2-pentanol form I	MA new	EA form I	BA form I	IBA form I
B	1mg	PA form I	DX new	CH ₃ CN new	NM new	THF new	Pyridine	DEC form I	DEE form I	TBMe	Acetone	MEK	Toluene form I
C	1mg	FT form I	IAA New	CCl ₄ form I	DCM form I	DCE form I	TCE form I	CB form I	BB	TFE new	TEA	Aniline	Hexane form I
D	1mg	DMF form I	DMA form I	BXE	MXE new form I	DMSO new form I	NMP	PE	MNP	DME	FA	AA new	Water
E	2mg	Methanol new form I	Ethanol new	1-propanol new	2-propanol new form I	1-butanol new	2-butanol form I	1-pentanol form I	2-pentanol form I	MA new form I	EA new form I	BA new form I	IBA new form I
F	2mg	PA form I	DX new	CH ₃ CN new	NM new form I	THF new	Pyridine	DEC form I	DEE form I	TBMe form I	Acetone new	MEK	Toluene form I
G	2mg	FT form I	IAA New	CCl ₄ form I	DCM form I	DCE form I	TCE form I	CB form I	BB	TFE new	TEA form I	Aniline	Hexane form I
H	2mg	DMF form I	DMA	BXE new	MXE new form I	DMSO new form I	NMP	PE	MNP	DME	FA	AA new	Water

The wells are colour coded according to the classification group. Wells with no fill represent cases where no crystals were observed

Conc concentration, *MA* methyl acetate, *EA* ethyl acetate, *BA* butyl acetate, *IBA* isobutyl acetate, *PA* pentyl acetate, *DX* 1,4-dioxane, *CH₃CN* acetonitrile, *NM* nitromethane, *THF* tetrahydrofuran, *DEC* diethyl carbonate, *DEE* diethyl ether, *FT* 4-fluorotoluene, *TBMe* tertiary butyl methyl ether, *MEK* methyl ethyl ketone, *IAA* isoamyl alcohol, *CCl₄* carbon tetrachloride, *DCM* dichloromethane, *DCE* 1,2-dichloro ethane, *TCE* tetrachloro ethylene, *CB* 1-chloro butane, *BB* 1-bromo butane, *TFE* 2,2,2-trifluoroethanol, *TEA* N,N,N-triethylamine, *DMF* N,N-dimethylformamide, *DMA* N,N-dimethylacetamide, *BXE* 2-butoxyethanol, *MXE* 2-methoxyethanol, *DMSO* dimethylsulfoxide, *NMP* N-methylpyrrolidone, *PE* 2-phenylethanol, *MNP* 1-methylnaphthalene, *DME* 1,2-dimethoxyethane, *FA* formic acid, *AA* acetic acid

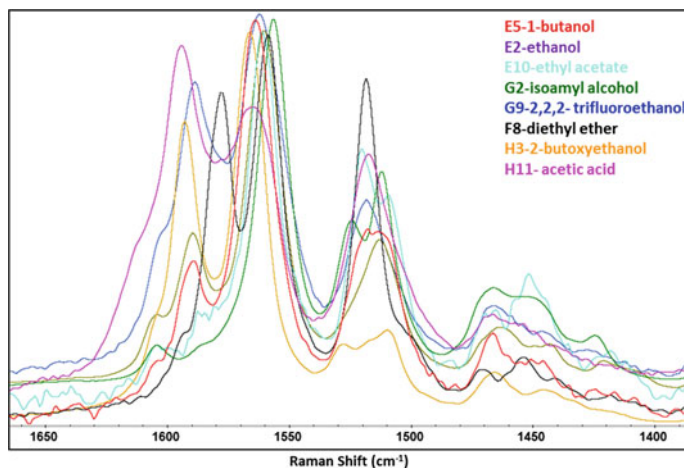


Fig. 4.18 Characteristic Raman spectra in the 1480–1650 cm⁻¹ region for 7 novel physical forms and form I of olanzapine identified during HTCAA. Spectra are coloured and labelled according to the well from which they have been detected

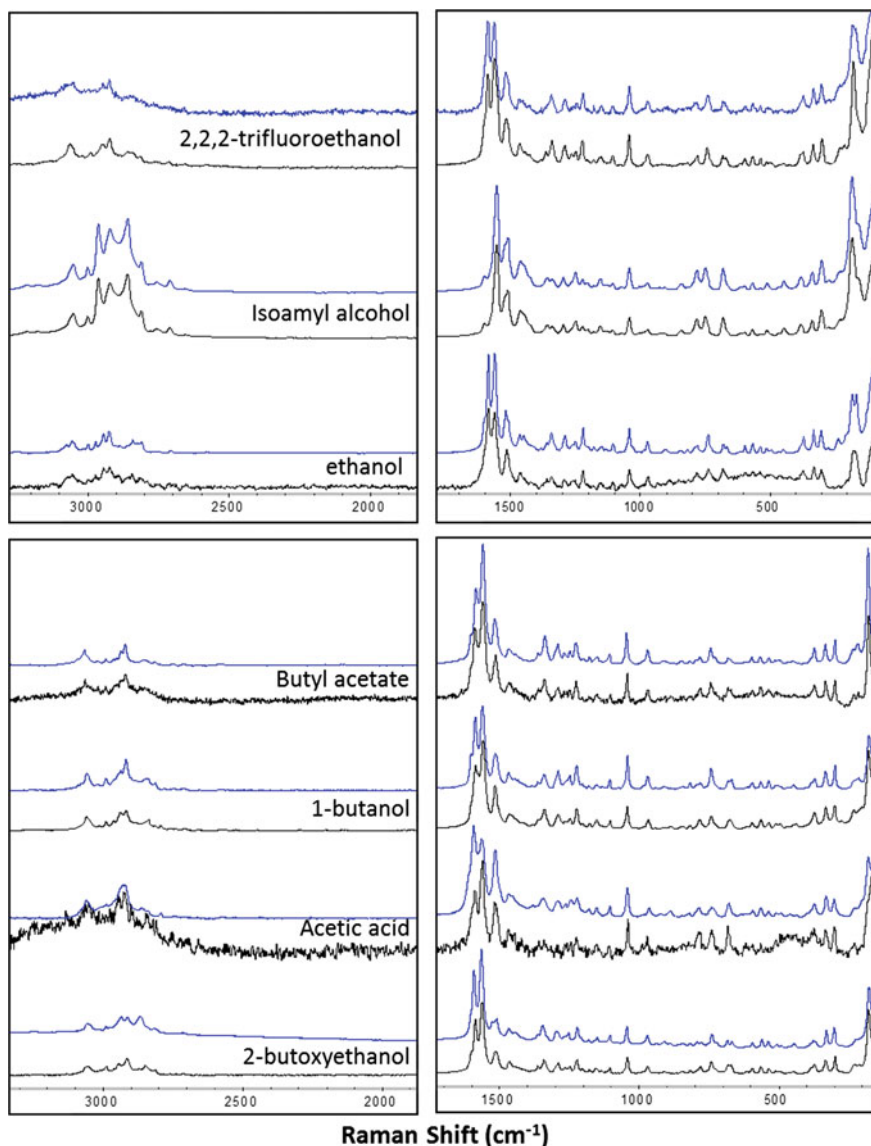


Fig. 4.19 Stack plot of Raman spectra collected from samples of physical forms of olanzapine at 96-well plate (black colour) and 150 mg scales (blue colour)

wells E10, E11 and E12) revealed that it is a dihydrate B of OZPN (further details on various dihydrates of OZPN are provided in Chap. 6).

Whilst group analysis of Raman spectra in selected range of the Raman shift spectra yielded only 8 distinct groups, SXD/XRPD and thermal analysis revealed that the

methanol, ethanol, 1-propanol, 1,4-dioxane, acetonitrile, nitromethane, 2-methoxyethanol, acetone, DMSO, methyl acetate and 1-butanol form different solvates with OZPN. Whilst during group analysis of Raman spectra, novel physical forms from methanol and ethanol were grouped together, the other techniques revealed differences in their characteristic data. Novel physical forms obtained from 1-propanol, 1-butanol, methyl acetate, 1,4-dioxane, acetonitrile, nitromethane, THF, acetone, 2-methoxyethanol and DMSO were also combined in one group from the Raman analysis. SXD analysis revealed that these groups consist of isostructural solvates which have the same long range packing but differ in the solvent and solvent mediated interactions in crystal lattice (discussed in Sect. 6.4.2 of Chap. 6). Due to the presence of similar Raman peaks in the region of $1400\text{--}1650\text{ cm}^{-1}$, these isostructural solvates have been grouped together using a 90 % cut off similarity. This emphasises the need for caution in relying in automated data analysis. The use of multiple techniques is always recommended to maximise the certainty of correctly identifying discrete forms.

By closer inspection of the Raman spectra of methanol and ethanol solvates, small differences were observed in the higher frequency and phonon regions which could be due to the different alkyl groups in the solvent moiety and changes in the lattice vibrations respectively (Fig. 4.20).

Subtle differences were observed in another group of isostructural solvates (hydrated OZPN solvates of 1-propanol, 1-butanol, methyl acetate, 1,4-dioxane, acetonitrile, nitromethane, THF, acetone, 2-methoxyethanol and DMSO) in the regions of Raman shift other than the one used for group analysis ($1400\text{--}1650\text{ cm}^{-1}$, Fig. 4.21). These differences are due to the different functional groups present in the solvent molecules, i.e. vibration due to cyanide group at 2255 cm^{-1} in acetonitrile hydrate; C-O-C band at 835 cm^{-1} in 1,4-dioxane hydrate; variations in higher Raman shift region ($3100\text{--}3650\text{ cm}^{-1}$) due to hydroxyl group in hydrate solvates of 1-propanol, 1-butanol and due to methyl groups in hydrate solvates of acetonitrile, nitromethane, acetone and methyl acetate (Smith and Dent 2005a).

16 novel OZPN solvates were observed from the HTCAA method and successfully scaled up to mg quantities. A stack plot of XRPD patterns of form I and 16 novel solvates of OZPN is shown in Fig. 4.22.

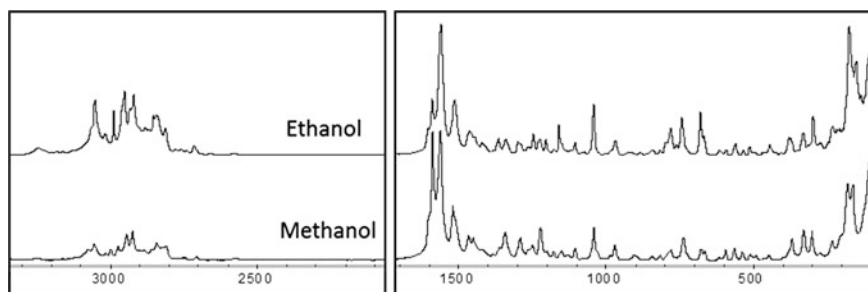


Fig. 4.20 Raman spectra of isostructural methanol and ethanol solvates of olanzapine

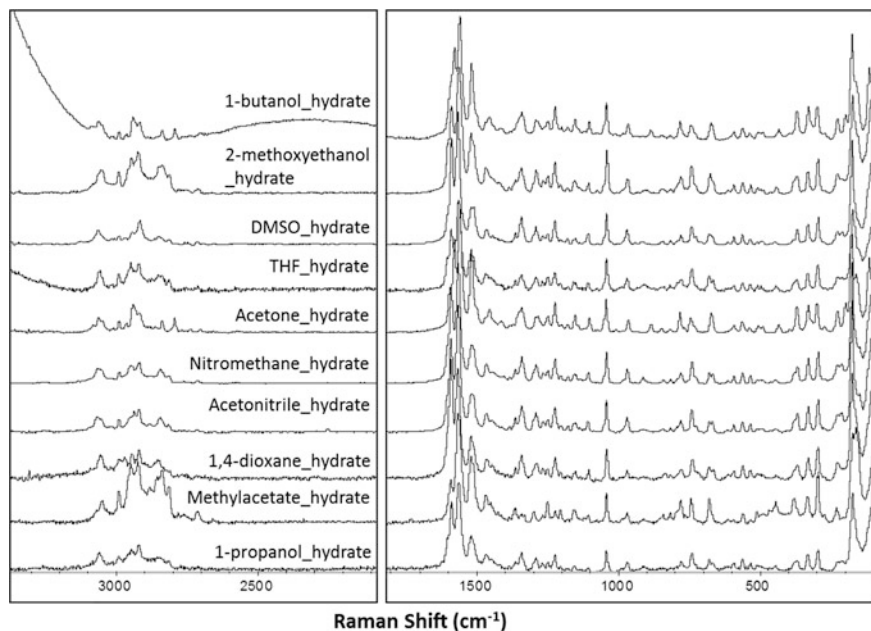


Fig. 4.21 Raman spectra of isostructural hydrated solvates of olanzapine

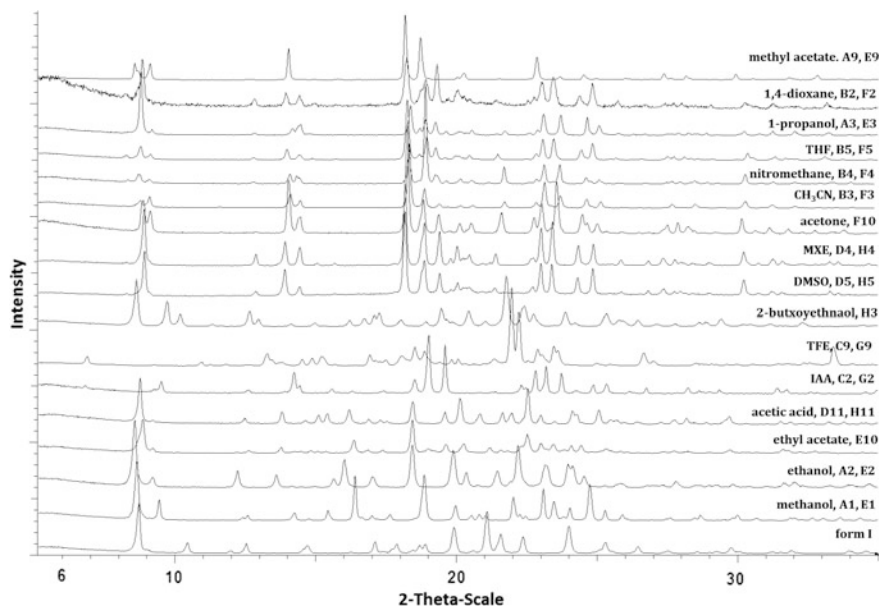


Fig. 4.22 Stack plot of XRPD patterns of the 16 novel solvates and form I of olanzapine obtained on 150 mg scales. Abbreviations used in the figure are: THF-tetrahydrofuran, CH₃CN-acetonitrile, MXE-2-methoxyethanol, DMSO-dimethylsulfoxide, TFE-2,2,2-trifluoroethanol and IAA-isoamyl alcohol

In addition to this, another 7 novel OZPN solvates from DMF, 2-butanol, 2-pentanol, pyridine, TBMe, 1,2-dimethoxyethane and formic acid were also obtained on 150 mg scales. Either form I (4 cases, might be due to desolvation of solvates) or no crystals (3 cases) were observed from these solvents on the 96-well plate. No polymorph of OZPN was observed on 96-well plate or 150 mg scales. Further details of all novel OZPN solvates are provided in Chap. 6.

4.4 Key Findings of the Developed HTCAA Methodology

The methodology developed in this work has been shown to be useful in finding the initial scope of physical form diversity for a compound using minimal material. This includes salts, polymorphs, solvates and non-crystalline solid forms. Clearly given the ability of Raman to distinguish different lattices and chemical compositions the approach could also have potential applications for co-crystal screening studies.

Typical studies took 2–3 days from set-up to data analysis highlighting the relative speed of the HTCAA approach. By comparison the vial recrystallisations took 6–7 days. The results from the multi-well plate approaches are complementary to larger scale automated methods and can be used to guide large-scale crystallisation efforts (up to 500 mg).

Many HTC approaches have been described in the literature using sophisticated, complex technologies (summarised in Sect. 4.1). In contrast, this approach represents a simple, fast and cost-effective method, well-suited for initial evaluation of solid-state behaviour of compounds available in mg quantities in the laboratory. Potential advantages and disadvantages for this approach are summarised in Table 4.15.

Table 4.15 Potential advantages and disadvantages of HTCAA methodology

Advantages	Disadvantages
Low initial setup cost and low maintenance cost	Prone to human error during manual dispensing
Low material requirement and cost-effective	Only one temperature zone for whole plate
Robust and flexible	Poor control during solvent evaporation
Can be implemented to variety of other diverse crystallisation conditions	No stirring and filtration at RT or under temperature control, thus poor control on compound dissolution
Fast data acquisition and analysis	Limitations of chemometric technique e.g. grouping of isostructural crystal forms
Sensitive analytical technique	Difficult to handle compound exhibiting fluorescence
Quick initial overview of a compound's solid-state behaviour	Potential of cross contamination
	False positives/false negatives

This methodology is capable of exploring various crystallisation techniques specifically here, cooling crystallisations and solvent evaporation at various temperatures. Also, this approach and equipment would be well suited for other crystallisation techniques e.g. slurry methods, crystallisation from melt, co-crystal screening and crystallisation involving heterogeneous nucleation. It can inform candidate form selection by providing additional information (e.g. polymorphic and stoichiometric information of the salt, solvent incorporation in lattice, crystal habit) and to gain a comprehensive understanding of the propensity and extent of solid form diversity. Incorporation of solvents in the crystal lattice is crucial information especially during process development. These solvents can be avoided during manufacturing or during optimisation of crystallisation processes (Morissette et al. 2004).

The use of multi-well plates in this manual approach also has limitations in the range of conditions that can be controlled. It is not always possible to obtain all the physical forms on a multi-well plate. As has been stated elsewhere (Morissette et al. 2004), an effective and rigorous solid-form screen benefits from multiple crystallisation techniques. This approach can support several of them but is complementary to a few techniques e.g. reverse sublimation, grinding and spray drying. For example, in a study for OZPN, HTCAA found 19 solvates but a further 7 were discovered during further scale-up experiments (using 100–200 mg of OZPN with 3–5 ml of solvent in vials). Other novel solvates of OZPN were also observed using different crystallisation techniques as a part of larger crystallisation screen (see Chap. 6). No polymorphs of OZPN were observed from this methodology, whilst 2 additional polymorphs were observed using other crystallisation methods (see Chap. 6). This highlights the fact that a single method cannot guarantee all physical forms of an API. It is advisable to complement the HTC methodology with various in-depth experiments using multiple crystallisation techniques e.g. grinding, desolvation of solvates, recrystallisation from melt and reverse sublimation, in order to explore the complete experimental crystal energy landscape of an API.

Some of the limitations encountered during development and validation of this methodology relate to the sole reliance on Raman spectroscopy. Raman spectra acquired from isostructural solvates were very similar and sometimes difficult to classify as separate spectra types. New physical forms that are structurally closely related could therefore be missed if no further investigation is done using other analytical techniques including XRPD, SXD and thermal analysis. For example, 9 solvates of OZPN which were grouped in the same cluster during HTCAA were successfully identified by further investigation with other analytical techniques. Raman spectra with small changes due to particle size, orientation and residual solvent can be mistaken as discrete physical forms and characterisation using other analytical techniques is advisable to avoid false positives. Whilst Raman allows the presence of a new form to be established it was not always possible to determine whether this new form was a polymorph, hydrate or solvate.

Other frequently encountered challenges associated with Raman microscopy of molecular solids are fluorescence and sample charring. Fluorescence is the “process of emission of electromagnetic radiation in the form of light as a result of

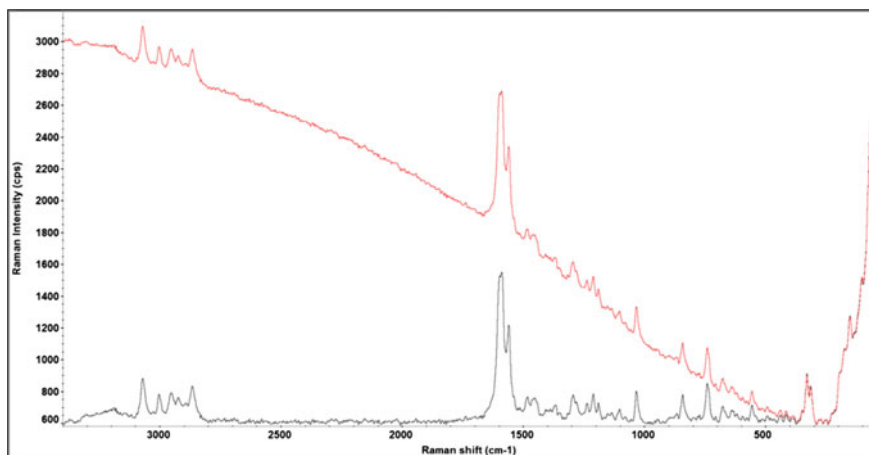


Fig. 4.23 Raman spectra of the sample exhibiting fluorescence (*red*) and after applying fluorescence correction (*black*)

absorption of light from another source” (Smith and Dent 2005b). This emission appears as a strong background in the Raman spectrum when the sample is illuminated by the excitation laser. Fluorescence is usually appears as a very broad curve extending across hundreds of wavenumbers. An example of a Raman spectrum exhibiting fluorescence is shown in Fig. 4.23.

Fluorescence may be an inherent property of the compound under study though it can also occur due to the presence of an impurity or residual solvent or from the well plate material itself (hence quartz well plates were used in this work which exhibit minimal fluorescence). As a result, a relatively large fluorescence background may be encountered that can dominate the emission spectrum resulting in degradation or complete loss of the Raman signal (Matousek et al. 2002; Pommier et al. 2005; Lowry et al. 2006; Romero-Torres et al. 2009).

Fluorescence can be minimised using a number of approaches. Lasers with longer wavelengths e.g. in near Infra-red region (NIR; 800–2500 nm) can be used to minimise the fluorescence as the fluorescence intensity usually increases at shorter wavelength (Matousek et al. 2002). In the case of pharmaceutical compounds studied here, the intensity of Raman bands was low with 780 nm laser. In comparison, the intensity from the 532 nm laser was suitable for data analysis and hence was used in majority of this work. Where fluorescence is an inherent property of the compound under investigation and sharp Raman peaks are visible on the back of broad background, baseline correction can be applied to subtract it from the background. In some cases, derivation of the spectrum is required to remove majority of the broadband background. However, by doing this, the noise of the spectrum can also get amplified. Therefore, smoothing is often applied in conjunction with derivatives to remove high frequency noise from the spectrum. Care must be taken when selecting the smoothing function as it can affect the spectral

resolution and ability to differentiate between physical forms with subtle changes in spectra. Ideally a smoothing function is preferred which would provide the highest signal to noise ratio with the least amount of smoothing (Pommier et al. 2005; Lowry et al. 2006).

For impure samples, recrystallisation of the material to remove the impurities responsible for the fluorescence is another approach to remove/minimise it (Pommier et al. 2005), although impractical in the current context as it may have impact on polymorphism. In one of the test compounds used in this study, raw material of CZPN showed high fluorescence. However, no fluorescence was observed in the sample obtained from vapour phase crystallisation. This suggests that fluorescence in the raw material might be due to the presence of a fluorescent impurity.

Sometimes the laser can cause thermal decomposition due to sample heating by high excitation energies of the laser. This was observed with OZPN and few samples of AXP. This was avoided by using lower laser power or selecting a 780 nm laser, however this also impacts signal to noise ratio or results in longer data collection times.

4.5 Summary

In this chapter, the development and validation of HTCAA methodology for physical form screening using Raman microscopy and a quartz multi-well plate has been demonstrated. This methodology is complementary to the existing large scale parallel approaches and offers various advantages including reduced sample requirement (~ 1 mg per crystallisation), no sample preparation prior to data collection, rapid data acquisition using a non-destructive analytical technique and rapid analysis of the spectral data using chemometric techniques. It has been shown to be an effective tool for preliminary investigation of polymorphism, solvate formation and salt formation providing data to guide further efforts in the most productive direction. HTCAA provides knowledge of suitable crystallisation conditions that give specific forms and provides a basis for subsequent scale-up.

A variety of physical as well as chemical information was obtained using Raman microscopy during salt screening of AXP. Chemical information suggests salt formation, stoichiometry with polyprotic counter acid and (in some cases) solvent incorporation into the crystal lattice. Physical information includes possible polymorphism and crystallinity of the salts.

As a relatively low-cost screening tool, HTCAA provided a useful overview and an initial scope of the solid-state diversity of OZPN and CZPN with the given set of solvents in a shorter period of time. One HTCAA experiment involving 96 crystallisations on a 96-well plate indicated a complex crystal structure landscape for OZPN. Approximately 158 mg of OZPN with ~ 20 ml of 48 solvents yielded 16 physical forms. In contrast, only 3 physical forms were detected for CZPN with the same number of crystallisations carried out in two experiments on a 48 well plate by

utilising ~235 mg of CZPN and ~24 ml of 96 solvent systems. Both compounds have similar solubility profile in selected solvent systems so the experiments are comparable. It took 2–3 days for experiments on OZPN and CZPN whereas screening carried out using traditional methods for the same compounds using same solvent systems took 1–2 weeks.

Following the initial discovery, the majority of the forms were successfully obtained on 150 mg scale in 3–8 ml vials. However, 7 new solvates of OZPN were obtained during scale-up that had not been identified by the initial MWP experiments. This demonstrates that solvent volume and the inexact control of conditions during small scale crystallisation can play a role in deciding crystallisation outcome.

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Chapter 5

Predicting Crystallisability of Organic Molecules Using Statistical Modelling Techniques

5.1 Statistical Modelling Techniques

5.1.1 Introduction

Statistical modelling and analysis used for data mining, machine learning and prediction involves careful selection and appropriate application of statistical analysis techniques. This requires certain underlying assumptions to be fulfilled, data analysis, correlation, hypothesis and testing of hypothesis to validate conclusions. During analysis of data, there are generally two goals; prediction and inference. Prediction involves analysis of the existing data and drawing of conclusions which can be used to predict the hypothetical or future data. Inference involves investigation of the nature of correlation between various components of complicated processes (Mytkolli and Calitoiu 2009). Various stages involved in a typical modelling process are shown in Fig. 5.1.

Various statistical modelling techniques are used in the pharmaceutical industry at different stages of drug discovery and development. These include principal component analysis (PCA) (Wold et al. 1987), artificial neural networks (ANN) (Kauffman and Jurs 2001; Doniger et al. 2004), multiple linear regression (MLR) (Kauffman and Jurs 2001), partial least squares (PLS) (Sheridan et al. 1994), hierarchical clustering (HC) (Makretsov et al. 2004), Random Forest (RF) (Breiman 2001) and support vector machine (SVM) (Doniger et al. 2004). All these approaches have their associated advantages and disadvantages due to their varying complexities. Two methods; PCA and RF programs, which have been used for this work, are described in the sections below.

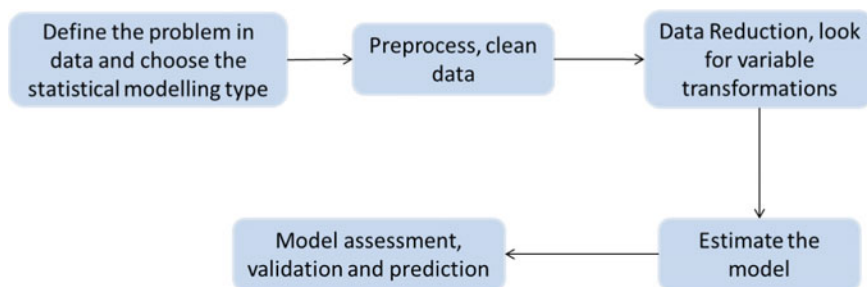


Fig. 5.1 Schematic workflow of various stages of a typical statistical modelling process

5.1.2 Principal Component Analysis

PCA is a powerful tool for reducing the number of observed variables to a smaller number of artificial variables known as principal components (PC) (Fig. 5.2). The first PC accounts for maximum possible variance in the dataset and each subsequent PC accounts for the remaining variance to the fullest extent (Wiklund 2008; Suh et al. 2009). Typically, the first two PCs will describe 60–70 % of the overall variance in the dataset.

PCA effectively removes redundancy (i.e. correlated variables which measure the same response) which is important as highly correlated variables can exert a disproportionate influence and bias results (Eder et al. 1994). PCA is helpful in identifying patterns in the data and highlighting the similarities and differences within the data. It is also a useful tool for classification and of particular use when a data reduction procedure is required which makes no assumptions of an underlying causal structure that is responsible for co-variation in the data.

Two interpretable plots are obtained from PCA namely; score plots and loading plots (Fig. 5.3). The score plot provides information about the relationship amongst objects whereas the loading plot depicts the relationship amongst variables. The following guidelines can be used to interpret the score and loading plots.

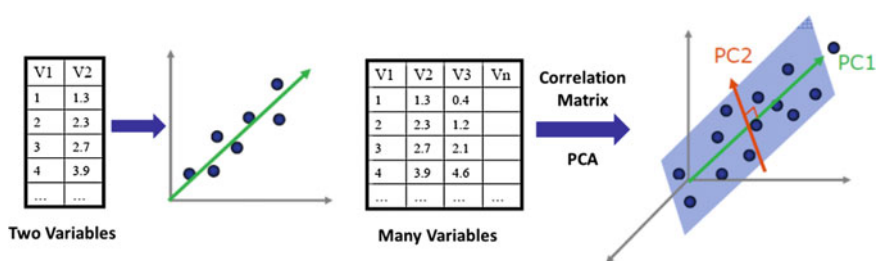


Fig. 5.2 Principal component analysis. Reproduced from reference (Wiklund 2008)

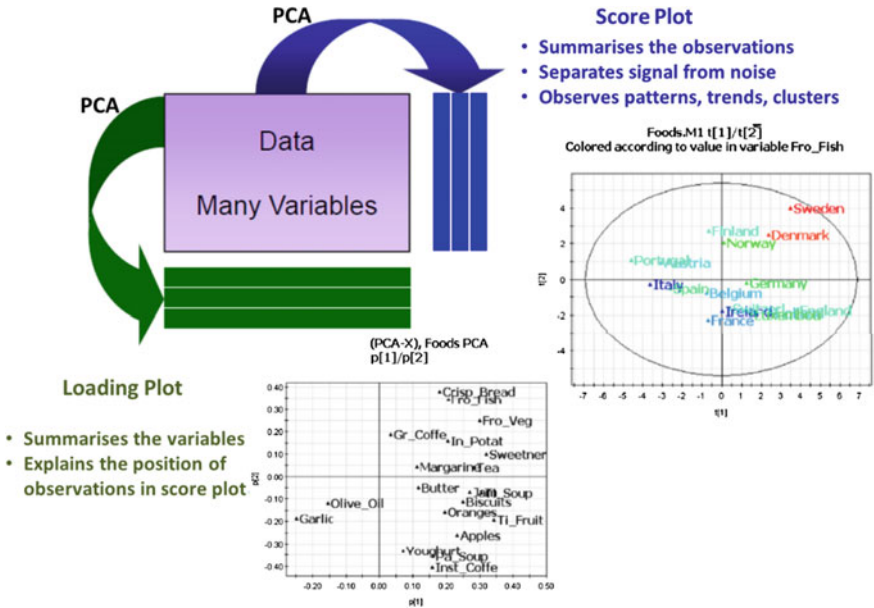


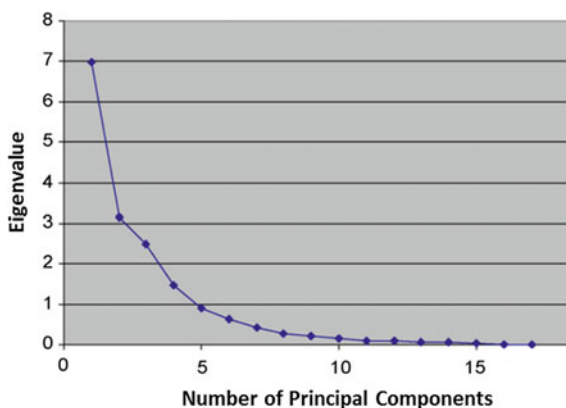
Fig. 5.3 Example of score and loading plots obtained from principal component analysis while investigating the patterns of food consumption of 20 food products in 16 countries. Score and loading plots relate to observations (countries in this case) and variables (food products in this case) respectively. Reproduced from reference (Wiklund 2008)

- Similar objects are close to each other on score plot.
- Variables with high correlation are close to each other on loading plot.
- Variables on opposite side of origin are negatively correlated.
- Objects on the right of score plot are dominated by variables on the right of loading plot and same applies for the objects on left of the score plot (Wiklund 2008; Suh et al. 2009).

5.1.3 Criteria for Deciding the Number of Principal Components

In general, only the first few PCs account for meaningful variance in the data, and the higher PCs will tend to account for only trivial variance. Four criteria are used while deciding the number of components during PCA analysis. The 1st criterion is known as “Eigenvalue-one criterion/Kaiser criterion” which means that any PC with an eigenvalue greater than 1.00 is retained (Kaiser 1960). Eigenvalues provide information on the content of individual PCs. According to the 2nd criterion, “The Cattell Scree test”, the eigenvalues associated with each component are plotted and

Fig. 5.4 Scree plot of the number of principal components versus eigenvalues. Adapted from reference (Xu and Redman-Furey 2007)



the plot is then assessed to identify a break between the components with relatively large eigenvalues and those with small eigenvalues. The components that appear before the break are assumed to be meaningful and are retained; those appearing after the break are assumed to be unimportant and are discarded (Cattell 1966). The other way is to find a place in the plot, where the smooth decrease of eigenvalues appears to level off to the right of the plot. There is no set criterion for deciding this level. For example, a scree plot for a dataset (Fig. 5.4) may suggest as many as 8 PCs but in this case 5 PCs were used based on combined results of both Eigenvalue-one and Cattell Scree test criteria (Xu and Redman-Furey 2007).

The 3rd criterion is based on the “percentage of the variance explained by the component in the data set”. This can be calculated by dividing the eigenvalue for the component of interest by total eigenvalues of the correlation matrix. Components which explain 5–10 % of variance can be retained. A cumulative percentage of variance can also be used as a criterion for selecting components. For example, how many components are required to explain at least 70 % of variance of data set. The 4th criterion is known as “Interpretability criteria” which includes the interpretation or substantive meaning of the retained components using any of the above mentioned three criteria and verifying that this interpretation makes sense in terms of what is known about the system under investigation (Wold et al. 1987; Ferré 1995).

5.1.4 *Random Forests Classification Method*

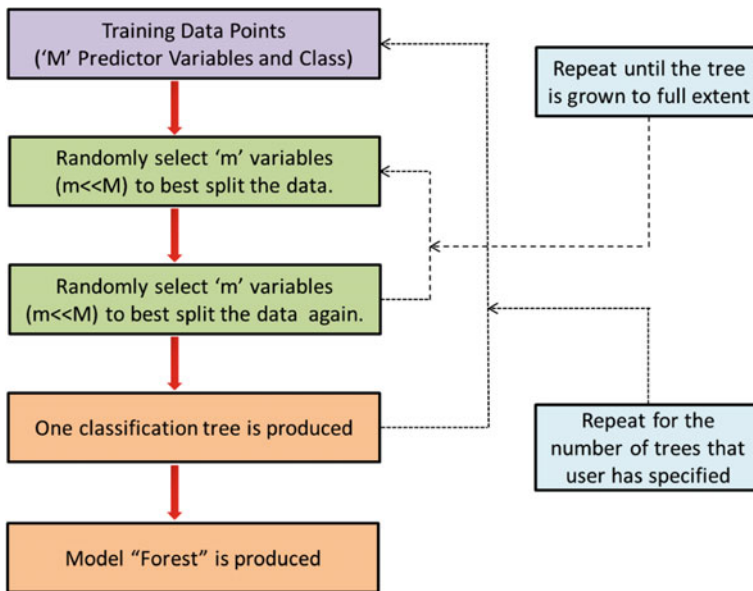
Random forests (RF) is a method for classification and regression (Breiman 2001; Liaw and Wiener 2002; Svetnik et al. 2003). RF is an ensemble classifier that consists of many decision trees. Prediction of a continuous variable is provided as

an average of the predictions of all trees. RF offers various advantages over other methods which are stated below;

- No over-fitting of the data, as the generalisation error almost converges with increase in number of trees.
- Provides an estimate of internal error, strength and correlation.
- Can handle large number of descriptors and employs a good method to estimate the missing value.
- Provides a measure of descriptor’s importance.
- Can handle multiple outcomes.
- High predictive accuracy and is applicable even in high-dimensional problems with highly correlated variables.
- Relatively robust to outliers and noise.

A schematic diagram of an RF workflow is shown in Fig. 5.5. Bootstrap sampling and random selection of input descriptors are used to induce randomness in the input data used to develop the RF model. This ensures that the classification trees grown in the forest are dissimilar and not correlated to each other.

Using bootstrap sampling, classification trees are grown using 2/3rd of the dataset and remaining 1/3rd of the dataset [Out Of Bag (OOB) data] is employed to obtain unbiased estimates of correct classification rates (internal estimates of error). Compared to a single classification tree, this algorithm yields better prediction rates



Random Forest ---- Building the Model Forest

Fig. 5.5 Schematic workflow of building of random forests model

and is more robust in dealing with noise in the data set because the forest of trees are grown to the full extent. The generalisation error of a forest of trees classifiers depends on the strength of the individual tree in the forest and the correlation between them. As part of a forest construction, RF computes proximities (overall similarities and dissimilarities) between the objects and provides a proximity matrix which can be used for clustering and detecting outliers (Breiman 2001; Liaw and Wiener 2002; Svetnik et al. 2003). The proximity matrix from the RF is generally analysed using multi-dimensional scaling (MDS) in 2-D/3-D plot. The closer the two observations in the MDS plot, the larger the proximity between them (Steyvers 2006).

The RF algorithm also assesses the importance of descriptors used in building of the classification model. It is assessed by replacing each descriptor in turn by random noise and the resulting deterioration in the model quality is a measure of descriptor importance. The deterioration in the RF model quality is assessed by mean decrease in accuracy (based on OOB data) and/or mean decrease in Gini (Gini index used in splitting) (Li et al. 2005; Palmer et al. 2006).

RF is widely used in many scientific areas, e.g. for measuring aqueous solubility (Palmer et al. 2006), predicting mutagenicity, (Zhang and Aires-de-Sousa 2006), QSAR studies (Debeljak et al. 2007), for building of drug likeness classification models (Good and Hermsmeier 2006), and selecting relevant predictor variables in the analysis of microarray data, in DNA sequencing and other applications in life sciences (Lunetta et al. 2004; Bureau et al. 2005; Huang et al. 2005; Li et al. 2005; Qi et al. 2006). There is only one report of RF application in the area of crystallisation of small molecules (Johnston et al. 2008).

5.1.5 Applications of Statistical Modelling Techniques in Pharmaceutical Industry

Statistical modelling techniques are widely used at various stages of drug discovery and development in the pharmaceutical industry (Tye 2004; Alsenz and Kansy 2007). Due to advances in high throughput instrumentation and robotics being applied in drug discovery and development activities, large volumes of data are routinely generated. Statistical modelling techniques can be used in experimental design and optimisation (Rose 2002). They can also be used for analysis of complex multivariate datasets in an efficient and robust way which then allows the user to sift through the information and reveal trends between factors and responses within the data. Statistical models can be applied to yield quantitative structure property relationships (QSPR) for predicting physicochemical properties (water solubility, lipophilicity etc.) during hit identification and lead optimisation stages of drug discovery (Taskinen and Yliruusi 2003; Alsenz and Kansy 2007). This area has benefited from advances in computing power enabling rapid calculation of 2-D and 3-D molecular descriptors and generation of fast outputs from the range of

commercial and freely available analysis programs. This capability leads to accelerated validation of QSPR models (Hughes et al. 2008).

Statistical techniques have also been used in various aspects of solid form selection and during the development of robust crystallisation processes. Statistical modelling techniques are also of relevance in the context of Quality by Design (QbD) approaches in pharmaceutical manufacturing (Kourti 2009). Some of the examples of applications of statistical modelling techniques in crystallisation area are briefly described.

5.1.5.1 Solvent Classification/Selection

The aim of physical form screening is to cover the maximum area of crystallisation space efficiently. For solution crystallisations this can be aided by judicious choice of solvents with diverse physicochemical properties. Solvent variation is a straightforward means of designing diversity in the experimental crystallisation screen and manipulating the crystallisation outcome. Using statistical approach, an attempt is made for grouping of solvents by quantifying the similarities and dissimilarities of the solvents in a given library based on various experimental and calculated physicochemical descriptors of solvent molecules, thus providing a basis for rational solvent selection. Ideally these physicochemical descriptors are directly relevant to the solvent's potential influence over the nucleation and growth of the solute. The selection of suitable solvent physicochemical descriptors for grouping is a persistent challenge because of the poorly defined relationship between solvent, nucleation and crystal growth. Furthermore, crystallisation is influenced by many experimental parameters other than solvent identity (Florence 2009).

Gu. et al. clustered 96 solvents into 15 solvent groups using a HC method (Gu et al. 2004). A total of 8 physicochemical descriptors for each solvent were employed for this clustering. In another case, 57 solvents were clustered into 20 groups based on 17 physicochemical descriptors using cluster analysis (Xu and Redman-Furey 2007). These approaches classify different solvents in specific groups allowing the selection of diverse conditions using one solvent for each cluster initially. Similarly, in an in-house study, 24 solvent clusters were obtained using ClusterSim approach on 94 solvents. Using this ClusterSim approach, both polymorphs of HCT were obtained by using 24 representative solvents from the entire library, one selected from each cluster as well as identifying likely solvate formers. A similar approach was employed for polymorph screening of OZPN and no polymorph was observed from any of the 24 solvents used for screening. This is believed to be due to OZPN's prolific tendency of solvate formation. To date only the thermodynamically stable form has been obtained directly from solution crystallisation and all other polymorphs can be obtained from alternative crystallisation methods (see Chap. 6).

Although the grouping and related approaches for assessing solvent diversity cannot guarantee that the multiple solid forms of the solute will be obtained from solution, they still add considerable value while selecting solvent libraries. Analysis

of the property space of the solvent library can help in identifying the under-represented regions that would benefit from the addition of new solvents or identifying solvents with largely similar properties which may be considered for exclusion (Florence 2009).

5.1.5.2 Design of Experiment

It is well known that the chances of obtaining all physical forms increase with the number of properly designed experiments. Therefore, Design of Experiment (DOE) approaches can be employed for selecting the optimum number of experiments required to maximise the coverage of experimental crystallisation space within the constraints of available material, equipment and time. It can also be implemented in optimising the outcome of the crystallisation experiment e.g. maximising the chances of getting the desired form (McCabe 2010). Application of DOE for polymorph screening of CBZ has showed that not only new forms can be found, but also analysis of input variables against outcome response allows prediction of the crystallisation outcome (i.e. polymorphic form) of crystallisation experiments (McCabe 2010).

5.1.5.3 Assessment of Completeness of Experimental Screens

Statistical modelling techniques can be used to assess the completeness of an experimental screen. An attempt can also be made to identify the correlation between the conditions tested and the outcomes. Retrospective inspection of the crystallisation outcomes of a comprehensive physical form screen for CBZ against the crystallisation conditions using RF led to three novel crystalline solvates of CBZ obtained from solvents predicted to lead to solvates (Johnston et al. 2008).

5.1.5.4 Revealing Trends in Larger Datasets

Statistical analyses are quite useful in revealing trends in large and complex datasets, e.g. statistical analysis of a database of 34,770 organic crystal structures from the CSD has revealed that the hydrate formation is not affected by the donor/acceptor ratio or the molecular weight of a compound, but that the probability of hydrate formation increases with an increase in the polar surface area (Infantes et al. 2007). A statistical analysis of 974 co-crystal structures from the CSD showed that shape and polarity of constituent molecules of the co-crystals tend to be similar. Interestingly the complementarity of the number of hydrogen bond donor/acceptors in the constituent molecules of the co-crystals was not found to be a dominant factor (Fabian 2009).

5.1.5.5 Predicting Crystallisation of Small Molecules from the Melt

Taylor and co-workers have reported a classification model using PCA to evaluate the crystallisation tendency of organic molecules from undercooled melts. A relationship between molecular and physical properties of organic molecules with glass forming ability (GFA) and glass stability (GS) tendency was observed. This model has applications in assessing the glass forming ability and the stability of new chemical entities, allowing the evaluation of the viability of amorphous formulation during early stages of drug development (Baird et al. 2010). The same group also reported that viscosity is an important parameter in determining the crystallisation tendency of organic compounds from undercooled melts (Baird et al. 2012).

5.1.5.6 Predicting Crystallisability of Proteins

Structural characterisation of proteins has been hindered because of the inherent difficulty in obtaining good quality crystals suitable for diffraction due to their highly dynamic conformations. To overcome this, various crystallisability predictor models have been developed using the data available in Structural Genomic consortia (Sanchez-Puig et al. 2012). These predictive models require only the protein sequence as input to predict crystallisability. They are based on various input parameters including energy and hydrophobicity indices, composition of certain amino acid types, secondary structure, solvent accessibility, predicted disorder and content of certain buried and exposed residues.

Various crystallisation propensity prediction models include PPCpred (Mizianty and Kurgan 2011), OBScore (Overton and Barton 2006), XtalPred (Slabinski et al. 2007), ParCrys (Overton et al. 2008), CRYSTALP2 (Kurgan et al. 2009), MetaPPCP (Mizianty and Kurgan 2009) and SVMCrys (Kandaswamy et al. 2010). Depending on the program, the output can be simple categorical descriptors e.g. “crystallisable” or “non-crystallisable” or a category 1–5, where the highest value corresponds to proteins that are “very difficult” to crystallise and the lowest value corresponds to proteins that are “optimal” to crystallise. Only PPCpred can be used to predict the propensity of each of four steps in a full chain which includes (i) production of diffraction quality crystals, (ii) production of crystals, (iii) purification and (iv) production of the protein material and inform about the step responsible for crystallisation failure.

Comparative analysis has suggested that these predictive models have a prediction accuracy of ~70–80 %. These predictive models take into account only the intra-molecular factors encoded within protein chains. Therefore, these crystallisation propensity predictor models may fail to provide dependable predictions when the inter-molecular factors such as the protein–protein and/or protein–precipitant interactions, characteristics of the expression systems, buffer composition, precipitant diffusion method, etc., must be considered (Mizianty and Kurgan 2011).

There are no reports of crystallisability prediction of small molecules from solution; therefore, it was of interest to use the applications of statistical modelling techniques in prediction of crystallisation propensities for small molecules. Organic compounds exhibit different crystallisation propensities. Some organic molecules crystallise well or quickly, while others do so badly or slowly. Poor crystallisation behaviour can include a collection of outcomes including nano/micro crystals formation, oiling out, no significant improvement in purity, and/or agglomeration. Despite great efforts towards better theoretical understanding of crystal nucleation and growth, it is still not possible to understand how to improve difficult and troublesome crystallisations. Hence in most practical situations, experience, trial-and-error and empirical knowledge are largely relied upon to achieve a desirable outcome (Hursthouse et al. 2009).

In this chapter, PCA and RF were applied to predict the crystallisation propensities (“crystallisability”) of a published dataset of small organic molecules (Hursthouse et al. 2009). Here, crystallisability means that the molecule is crystallising to give single crystals suitable for SXD. An RF model was built using calculated 2-D and 3-D molecular descriptors of organic molecules and was used to model the property space responsible for the different observed crystallisation outcomes. The developed model was also used to find important calculated molecular descriptors governing the varied crystallisation outcomes. A comparison of these descriptors with experimentally known factors responsible for reduced crystallisation tendency was also performed.

5.2 Descriptor Calculations, Model Building and Validation

5.2.1 *Training Dataset and 2- and 3-Dimensional Descriptors Calculations*

There are very few examples of schematic crystallisation studies on a series of organic molecules, however, Hursthouse, et al. published a dataset (Hursthouse et al. 2009) which was suitable for predicting the crystallisation propensities. In the reported study, crystallisation was attempted from ethanol in the first instance. Other solvents used for crystallisation were water, toluene, benzene, aqueous ethanol, cyclohexane-benzene mixtures, dimethyl sulfoxide, N,N-dimethyl formamide and pyridine. However, no detailed information is provided in the report and it is also not known whether every solvent was used for crystallisation for each molecule. While selecting this dataset, it was assumed that crystallisation was well controlled.

This dataset reported, consists of 382 molecules with a common acylanilide skeleton (Fig. 5.6). The skeleton was modified to create 382 analogues by alteration

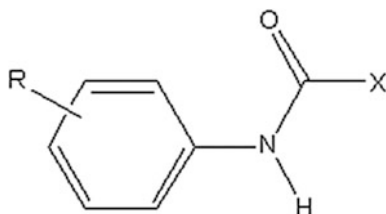


Fig. 5.6 Basic skeleton of acylanilide molecules, R and X represent the two points of modifications. X includes H, CH₃, C₂H₅, C₃H₇, C(CH₃)₃, CF₃, OCH₃, OC₂H₅NH₂ and Cl. R includes H, CH₃, C₂H₅, C(CH₃)₃, OCH₃, OC₂H₅, OCF₃, F, Cl, Br, I, CF₃, OH, NH₂ and COOH

of substituents of the R and X groups. This created a diverse library of molecules that share a common molecular nucleus.

All the molecules were drawn using Chemdraw Ultra (version 11.0) and reliable 3-D conformations generated in Discovery Studio using the Pipeline Pilot interface (Accelrys 2010). 2-D (185) and internal 3-D (i3-D) (123) molecular descriptors were calculated using MOE (MOE 2002). 2-D molecular descriptors are defined to be numerical properties and calculated from the atoms and connection table of the molecule. 2-D molecular descriptors included physical properties descriptors (e.g. molecular weight, sum of the atomic polarisabilities), atom and bond count descriptors (number of atoms, number of rotatable bonds), connectivity and shape indices descriptors (atomic connectivity index, first kappa shape index), adjacency and distance matrix descriptors (largest value in the distance matrix, balaban's connectivity topological index), pharmacophore features descriptors (e.g. number of hydrogen bond donors and acceptors) and partial charge descriptors (atomic partial charges calculated using Partial Equalisation of Orbital Electronegativities (PEOE) method). i3-D molecular descriptors are calculated using 3-D coordinate information of the molecules. The i3-D molecular descriptors included potential energy descriptors (e.g. total potential energy and torsion potential energy), volume, surface area and shape descriptors (e.g. van der Waals volume and water accessible surface area) and conformation dependant charge descriptors (e.g. dipole moment calculated from the partial charges of the molecule).

A correlation matrix was prepared using a Pearson correlation coefficient by using a Pipeline Pilot interface. Molecular descriptors which showed zero variance and covariance (threshold of Pearson correlation coefficient >90 %) were removed from the dataset. The resultant training dataset comprised of 151 calculated molecular descriptors. The two known crystallisation outcomes from the original report (Hursthouse et al. 2009) were put into the training set and described as: class 1, where single crystal suitable for SXD was observed and class 2, where no single crystal suitable for SXD was observed.

5.2.2 Training the Statistical Model

A PCA of crystallisability was carried out using the SIMCA program (version 12.0 and 13.0) (Umetrics) (SIMCA 2012) by inputting 2-D and 3-D calculated physicochemical descriptors for molecules. PCA was carried out with varying number of PCs to explore the effectiveness of procedure in describing the data variability.

RF analysis was carried out using the 'RandomForests' package available in the statistical computing and graphics environment 'R' (version 2.10.1) (R Development Core Team 2006) denoted as RF/R and a commercially available RandomForests[®] package (Salford Systems) represented as RF/Salford. The optimal values of parameters; seed, mtry, ntree, nodesize and jclasswt were selected until no further improvement was seen in the classification model.

Here, 'ntree' refers to the number of trees grown during model building and was increased incrementally until no further improvement was observed in the model. 'mtry' is the number of different molecular descriptors tried at each split and the default value is the square root of the total number of input descriptors. 'jclasswt' allows weightings to adjust error rates between classes that have very different number of observations. 'nodesize' refers to the minimum nodesize below which leaves are not further subdivided and the default value is 1. 'Seed' refers to any non-zero integer number which controls the random number generator. It was arbitrarily set to 45 to provide reproducibility in the random numbers required by the RF. OOB error of estimate was used as a guide during model training process.

The RF model was trained using all 151 calculated descriptors and 2 crystallisation outcomes using the following parameters: ntree = 20000, mtry = 12, jclasswt = 1 (for class 1) and 1950000 (for class 2), nodesize = 1, seed = 45.

The RF model reports the crystallisation prediction as probabilities, which correspond to the percentage votes across all trees for a molecule as each crystallisation outcome (class 1 vs. class 2). For each molecule, RF prediction provides a distribution of percentage votes for each defined outcome, totalling 100 %. The mean decrease in accuracy method (see Sect. 5.1.4) was used to assess the relative importance of molecular descriptors responsible for the final classification model.

5.3 Results and Discussion

5.3.1 Principal Component Analysis

PCA revealed that only 51 % variance was explained using two PCs. Thirteen PCs were required to explain only 81 % variance suggesting that PCA is not able to define a simplistic trend in a complex dataset. No significant clustering of two classes (crystals vs. no crystals) was observed from the PCA (Fig. 5.7). Due to inability of the PCA to provide a useful model of the relationship in the dataset, no further investigation was done and a decision was taken to use RF technique.

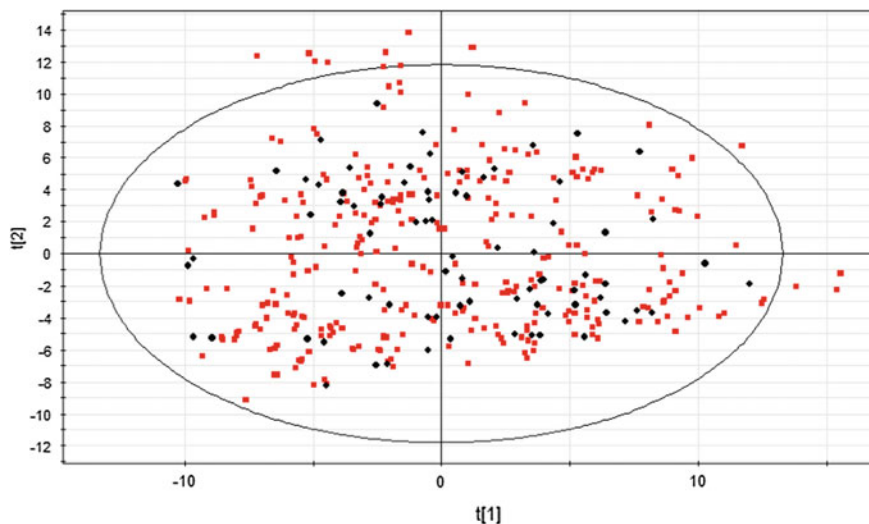


Fig. 5.7 Scatter plot of properties of molecules, shown with an ellipse that represents the Hotelling T2 with 95 % confidence. Each of the 382 points on the plot represents a molecule from the dataset. Molecules are coloured according to the crystallisation outcome: class 1 (crystals, red) and class 2 (no crystals, black)

5.3.2 Random Forests Classification Model

During RF classification model building, the overall error rate was converged with an increase in the number of trees. The final RF model has classified the molecules in two classes with an overall OOB error of prediction of 32.6 % and prediction accuracy of 67.4 % (Fig. 5.8). In procedure, this translates to a 67 % chance of accurately predicting the current outcome of a molecule based on the RF model. This model is better than the random accuracy of 50 % expected in a system with

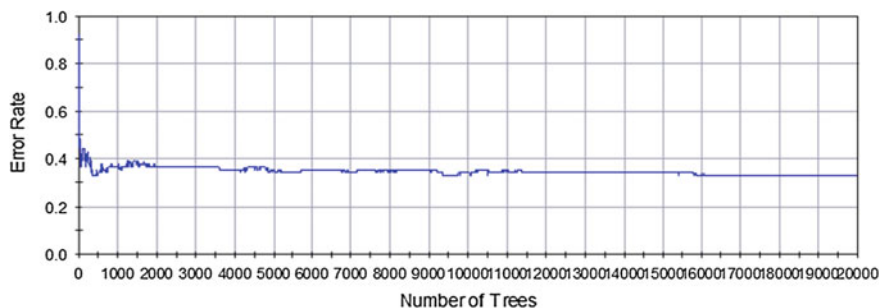


Fig. 5.8 Error plot for the random forests classification model trained using 2-D and 3-D molecular descriptors of the molecules present in the dataset. Blue line shows the evolvement of overall OOB error of prediction with the addition of number of trees

binary outcome. Similar results were obtained from both the programs; RF/R and RF/Salford.

The error plot in Fig. 5.8 provides an overall OOB error of prediction and prediction accuracy for the classification model and a confusion matrix in Table 5.1 provides information on the prediction accuracy and OOB error rate associated with each class. Data in Table 5.1 confirm that the RF model has predicted the number of molecules in each class with similar percentage accuracy.

The RF program computed the proximities between pairs of molecules which were then scaled down into two dimensions using MDS. In contrast to PCA, the MDS shows some distinct clustering. The MDS plot of scaling coordinates 1 versus 2 (Fig. 5.9), obtained from the proximity matrix generated by RF/Salford showed two distinct zones belonging to two classes and an overlapped zone which

Table 5.1 Confusion matrix generated by random forests for classification of dataset of 382 molecules

Actual class	Total cases	% Correct	1, N = 231	2, N = 151	Class error
1	303	67.7	205	98	32.34
2	79	67.1	26	53	32.91

Class 1 represents the molecules which crystallised and class 2 represents the molecules which did not crystallise

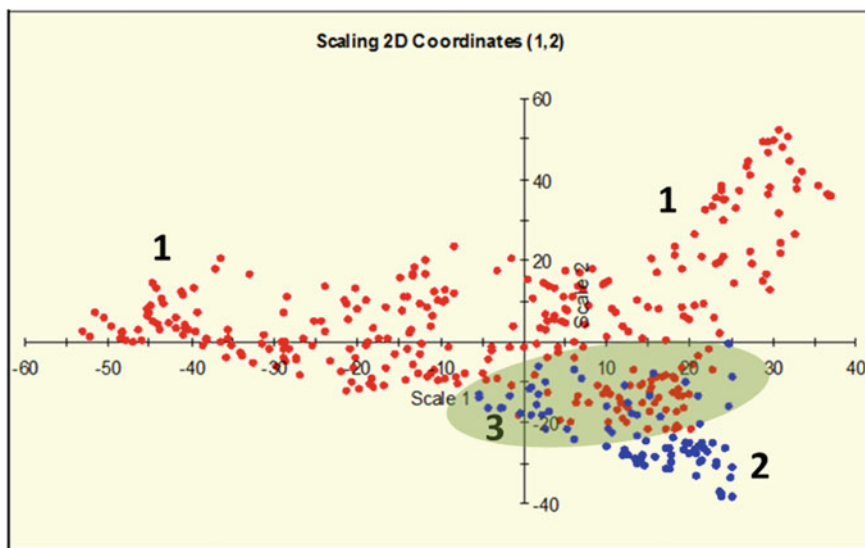


Fig. 5.9 The multidimensional scaling plot of the scaling coordinates (1, 2) obtained from the random forests classification proximity matrix. Each of the 382 points on the multidimensional scaling *plot* represents a molecule from the dataset and is coloured according to crystallisation outcome: class 1 (*red*) and class 2 (*blue*). 1 and 2 denote the two separate zones correspond to molecules from class 1 and class 2. 3 (*encircled in green*) denotes the overlapped zone with molecules from both classes

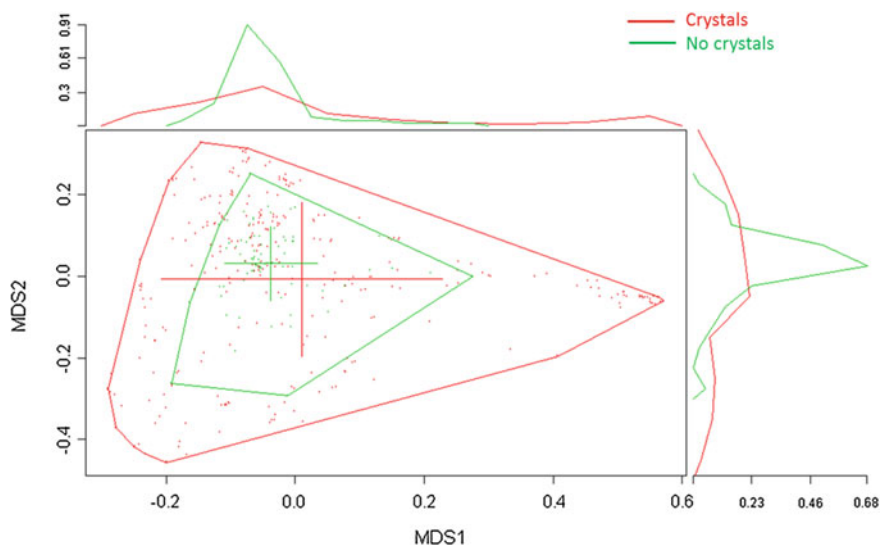


Fig. 5.10 Convex hull plot of scaling coordinates obtained from random forests classification proximity matrix. Molecules in class 1 and 2 are represented by *red* and *green* points respectively. The *cross sign* is the mean of MDS1 and MDS2 for each group

comprises molecules from both the classes (Fig. 5.9). This model can be further used to predict the crystallisability of molecules from the same series for which no crystallisation attempts have been made. The chances of accurate crystallisability prediction for these molecules would be $\sim 70\%$.

The MDS plot (Fig. 5.9) highlights the overlapped region, where molecules from both the classes coexist. Therefore, a convex hull plot which is an alternative to the MDS plot and offers a useful representation of large datasets with a considerable overlap of points between them (Vidmar and Pohar 2005) was generated. The convex hull plot shows that the molecules in class 2 were confined in a limited space of the plot indicating a common set of features that is consistent with poor crystallisability while molecules in class 1 were present across a larger area (Fig. 5.10).

The top 10 most important molecular descriptors responsible for this classification model include the descriptors that describe the relative energies of the molecules, their atoms connectivity, molecular conformations and number of rotatable bonds in the molecules (Table 5.2).

5.3.3 Model Optimisation Attempts

The RF model was retrained after removing the least important descriptors and was evaluated for prediction accuracy using OOB error of estimate. This process was

Table 5.2 Ten most important descriptors selected by random forests for classification model

Descriptor	Rank	Descriptor definition	Further details of descriptors
E_TOR	1	Torsion (proper and improper) potential energy	The energy descriptors use the MOE potential energy model to calculate energetic quantities from stored 3D conformations
E_VDW	2	van der Waals component of the potential energy	
GCUT_SMR_0	3	Atomic contribution to molar refractivity	The GCUT descriptors using atomic contribution to molar refractivity instead of partial charge
AM1_EELE	4	Electronic energy calculated using the AM1 Hamiltonian	Can be calculated from the connection table (with no dependence on conformation) of a molecule
BCUT_PEOE_3	5	Calculated from adjacency matrix of a chemical structure	It is calculated from the eigenvalues of a modified adjacency matrix
B_1ROTR	6	Fraction of rotatable single bonds: b_1rotN divided by b_count	The atom count and bond count descriptors are functions of the counts of atoms and bonds
VSURF_CW2	7	Capacity factor	Depend on the structure connectivity and conformation
E	8	Value of the potential energy	Same description as for descriptors ranked from 1–2
B_ROTTR	9	Fraction of rotatable bonds: b_rotN divided by b_count	Same description as for descriptors ranked at 6
GCUT_SLOGP_1	10	Atomic contribution to logP	The GCUT descriptors using atomic contribution to logP instead of partial charge

Reproduced from web reference <http://www.juit.ac.in/attachments/podophyllotoxin/introduction.htm>

iteratively repeated and from every training model the least important descriptors were removed. However, no significant improvement in the overall/class-wise prediction accuracy was observed. RF model trained using only 33 descriptors (1/5th of the total number of descriptors) gave an overall OOB error rate of estimate of 32.3 % (for class 1–31.7 % and for class 2–32.9 %). The predictive accuracy of this model is very close to the starting model developed using 151 descriptors. This suggests that only 33 descriptors are required to develop the classification model.

To further improve the predictive accuracy of this model, it was subjected to a backward elimination algorithm. During this, only one descriptor was removed at a time and the model was trained using the remaining descriptors. However, no further improvement was observed in the classification model.

5.3.4 Important Descriptors Assessment

Achieving a $\sim 70\%$ accuracy in the predictive model provides a useful indication based on its ability to identify problematic systems with reasonable confidence thereby flagging problematic compounds and identifying early targets for more detailed efforts to improve. The most important descriptors listed by RF showed that the torsion energy, van der Waals/steric energy, structure connectivity, conformation and numbers of rotatable bonds in the molecules are contributing towards different crystallisation behaviour.

Some of these descriptors represent the conformational flexibility in the molecule and it is known that conformational flexibility plays an important role in reducing the crystallisation tendency of the molecules (Yu et al. 2000). For molecules containing long alkyl chains, multiple conformations would be present in crystallising media and only one would fit into the crystal lattice (Yu et al. 2000). In the original report (Hursthouse et al. 2009), similar trends were observed for molecules i.e. crystallisation tendency was reduced on increasing the length of the alkyl chain. Propionanilide and butylanilide derivatives (Fig. 5.11) had poorer crystallisation tendencies as compared to acetanilide and trimethylacetanilide derivatives.

For some of the acylanilide derivatives, it was also observed that para-substituted derivatives were easier to crystallise than the ortho-substituted derivatives, which in turn were crystallised more easily than meta-substituted derivatives. The possible explanation for this is that the para-substituted derivatives have only one major conformation as compared to two conformations for meta-substituted derivatives in the crystallising media (Fig. 5.12) which in turn decreases the crystallisation tendency presumably due to the requirements of orientation of the molecules to fit into the growing lattice.

Ortho-substituted acylanilide derivatives have a higher tendency of crystallisation compared to meta-substituted acylanilide derivatives. This is due to the steric effects of substituents at ortho position which tend to favour a particular conformation in

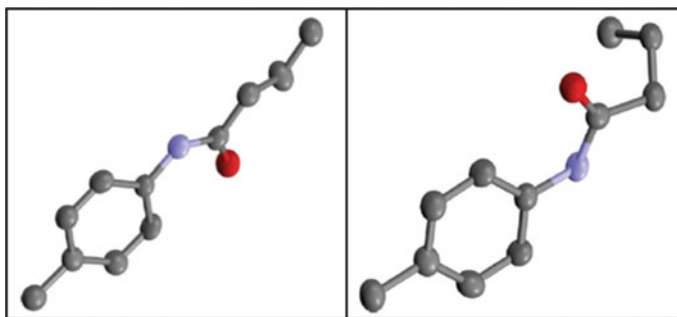


Fig. 5.11 Two different conformation of propyl chains in 4-methylbutylanilide. Reproduced from reference (Hursthouse et al. 2009)

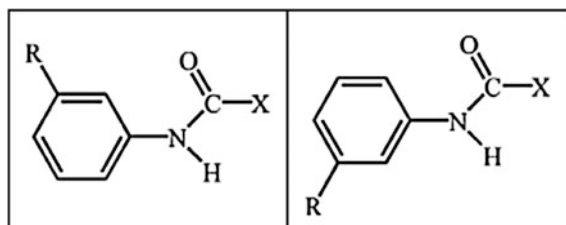


Fig. 5.12 Alternate conformations of meta-substituted acylanilides. The rotation is around aromatic carbon to N bond. Reproduced from reference (Hursthouse et al. 2009)

solution and in the solid-state (Hursthouse et al. 2009). It is pleasing that the molecular descriptors identified by the RF methods are consistent with chemical and structural expectations and/or knowledge leading to confidence in this method.

5.3.5 Limitations of Random Forests Classification Model

This model is based on 2-D and 3-D molecular descriptors of the organic molecules and completely ignores the effect of impurities (Hursthouse et al. 2009), solvents and crystallisation conditions (RH, rate of solvent evaporation etc.). Unfortunately, the information about crystallisation conditions has not been provided in the original report and therefore, cannot be incorporated in the RF model in an attempt to improve its predictive ability.

The solubility of the compound in different solvents can vary significantly and affects the appearance of crystals. Very high solubility may lead to increased viscosity and possibly gums/oils whilst inadequate solubility may lead to extreme dilute solutions which rarely give large crystals. A limited range of solvents and crystallisation conditions have been used for the crystallisations of these molecules in the original report. The experimental results may vary after attempting the crystallisation in a wider range of solvents and crystallisation conditions.

This dataset is taken from the literature and given the aim of the original study was a structural systematics investigation, the systematic effort towards crystallisation may have been limited. The experiments were done under similar conditions but may not have been tightly controlled leading to changes in concentration, supersaturation due to temperature or evaporation rate fluctuations. All these factors might have an effect on the crystallisation outcome.

Impurities often play a role in inhibiting crystal growth and phase transformation (Blagden et al. 1998). The crystallisation behaviour may be different under different sets of conditions used for synthesis and crystallisation. These molecules are likely to have major/minor impurities and no information has been provided in the original report about the nature and amount of impurities and therefore is not considered in the RF classification model.

5.4 Summary

Statistical tools were applied to predict the crystallisability of a set of organic molecules. RF classification method has provided better results than PCA and a RF model with prediction accuracy of $\sim 70\%$ has been built. This kind of model can potentially identify the problematic systems with reasonable confidence, allowing early efforts towards improvement. This RF predictive model takes into account only the molecular descriptors of the organic molecules. Therefore, crystallisability prediction may fail when the other factors such as solvent, supersaturation, RH etc. are responsible for the crystallisation outcome.

Identification of physicochemical descriptors suitable for any statistical analysis is a persistent challenge. Crystallisation is known to be influenced by shape, surface and ease of conformational change. In this study, RF has correctly identified the descriptors responsible for varied crystallisation propensities, leading to confidence in the predictive model. Identification and selection of critical descriptors responsible for varied crystallisation outcome by RF model is a potentially useful tool.

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Chapter 6

Exploring the Crystal Structure Landscape of Olanzapine

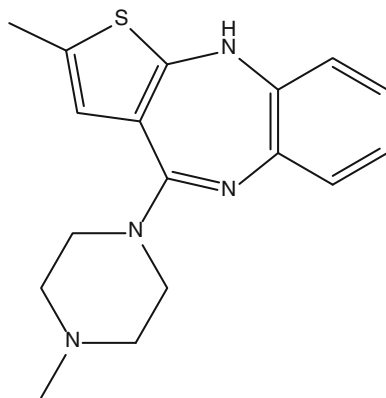
6.1 Introduction

Physical form screening of olanzapine (OZPN, $C_{17}H_{22}N_4S_1$, Fig. 6.1) which belongs to group I (see Sect. 2.1) using HTCAA methodology has been described in Chap. 4. This chapter describes a comprehensive physical form screening of OZPN using various crystallisation techniques. In addition to a rigorous experimental search for solid-forms of OZPN, a CSP study was used as a complement to experimental screening and to interrogate the experimental results.

OZPN, is a benzodiazepine derivative with demonstrated efficacy in the treatment of schizophrenia and related psychoses (Fulton and Goa 1997; Tollefson et al. 1997; Sanger et al. 2001). OZPN has been reported to display a number of solid-state forms including three polymorphic non-solvated forms; form I—CSD (Frank 2002) refcode: UNOGIN01 (Reutzel-Edens et al. 2003; Wawrzycka-Gorczyca et al. 2004a); form II [form II in this work has been referred to as form IV (CSD refcode: UNOGIN02) previously by (Thakuria and Nangia 2011)]; and form III whose crystal structure has not been determined to date.

The crystal structure of form II was determined from a single crystal grown from the vapour phase as part of a larger crystallisation screen described in two published reports (Miglani et al. 2011; Bhardwaj et al. 2013) and in this thesis. This structure is consistent with the characteristic powder data for form II reported by Reutzel-Edens and co-workers (Reutzel-Edens et al. 2003) as evidenced by a Pawley type refinement ($R_{wp} = 3.9$), confirming the assignment of this form as form II. During the course of our study, we were made aware of the structure report of form IV of OZPN obtained from a failed co-crystallisation attempt of OZPN with nicotinamide. This structure is isostructural with the form II structure here and a Pawley type refinement of the reported form IV unit cell against the form II powder data reported in research article by Reutzel-Edens and co-workers yielded an $R_{wp} = 2.461$. On this basis we conclude the reported form IV structure is actually

Fig. 6.1 Molecular structure of olanzapine



form II, following the nomenclature of the published research article by Reutzel-Edens and co-workers.

Across the various reports to date on the polymorphism of OZPN, inconsistent nomenclature for the polymorphs of OZPN has been used (Wawrzycka-Gorczyca et al. 2004a; Polla et al. 2005; Tiwari et al. 2007). In this thesis, we are following the nomenclature of Reutzel-Edens and co-workers, specifically forms I, II and III are defined as per the characteristic data shown in Table 6.1.

Other reported solid forms of OZPN include three polymorphic dihydrates referred to as D (AQOMAU), E (AQOMAU02), and B (AQOMAU01) (Reutzel-Edens et al. 2003), later being equivalent to disordered hydrate, AQOMEY01 (Wawrzycka-Gorczyca et al. 2007), a 'higher hydrate' (AQOMEY) (Reutzel-Edens et al. 2003), 6 single and mixed organic solvates [Dimethylsulfoxide (DMSO) hydrate: CAYTUS (Polla et al. 2005), methanol hydrate: ELEVOG (Capuano et al. 2003), methanol: UNOGOT (Wawrzycka-Gorczyca et al. 2004b), 2-butanol hydrate: WEXPUL, ethanol hydrate: WEXQEW and DCM solvate: WEXQAS (Wawrzycka-Gorczyca et al. 2007)] and 3 co-crystals (Clarke et al. 2012). To date, anhydrous form III has only been obtained as a mixture with polymorphs I and II which has precluded structure determination attempts and the structure of this form remains unknown (Reutzel-Edens et al. 2003; Bhardwaj et al. 2013). The key aim of this work was to investigate the factors controlling the solid-state diversity of this important drug.

Calculating the crystal energy landscape has been used as a complement to experimental polymorph screening for small molecules, directing the search for specific new forms (Cross et al. 2002; Arlin et al. 2011), and providing complementary atomic-level insights and more confidence in the interpretation of the experimental data (Price 2008; Braun et al. 2010), including placing of protons in structures solved from XRPD data (Braun et al. 2012). The 2010 CCDC blind test of crystal structure prediction (Bardwell et al. 2011) included a highly flexible and drug-like molecule benzyl-(4-(4-methyl-5-(p-tolylsulfonyl)-1,3-thiazol-2-yl)phenyl)carbamate; $C_{25}S_2N_2H_{22}O_4$ with 8 exocyclic torsion angles and forced the

Table 6.1 Nomenclature for non-solvated polymorphs of olanzapine and their characteristic data [this work and from reference (Reutzel-Edens et al. 2003)]

Form	Unit cell parameters ^a	XRPD peaks ^b	DSC ^c	Raman bands (cm ⁻¹) ^d	Solid state ¹³ C NMR chemical shifts ^e (Reutzel-Edens et al. 2003)
I	a = 10.328(3), b = 14.524(3), c = 10.500(3), β = 100.606(14) vol = 1548.2(7)	8.639, 12.463, 17.050, 19.834, 21.507, 22.302	Melt at 468 K	375.5, 1521, 1561, 1579, 1594,	16.7(C16), 46.0(C17), 48.4(C12, C15), 121.8 (C11), 142.7(C9), 155.5(C3)
II	a = 9.8544(14), b = 16.314(2), c = 9.9754(12), β = 98.304(8), vol = 1586.9(4)	9.002, 12.928, 13.975, 15.914,	Transforms to form I on heating at <i>ca.</i> 454 K prior to finally melting at 468 K	369.9, 391.8, doublet at 1510 and 1524, 1560, 1586	17.01(C16), 45.5 (C17), 47.7, 50.1 (C12, C15), 118.1 (C11), 140.9(C9), 157.2(C3)
III	–	8.890, 14.306, 15.017, 19.269, 20.842, 22.117	–	–	14.9(C16), 45.2(C17), 47.6, 50.1,(C12, C15), 117.1(C11), 142.7(C9), 157.2(C3)

^aSingle crystal collected during this study at 123 K

^bCharacteristic low angle peaks identified using high resolution capillary powder diffraction data

^cDSC measurements of pure samples of form I and II

^dRaman data collected from single crystal samples of form I and II

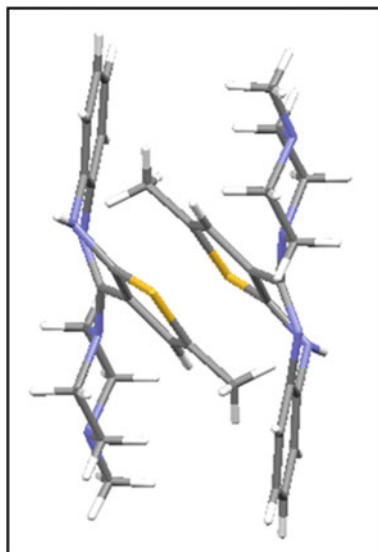
^eChemical shifts are presented as ppm

development of computational methodologies capable of successfully tackling such molecules (Kazantsev et al. 2011b). Hence, it is now timely to see how the crystal energy landscapes of pharmaceutical drugs can aid experimental solid form screening.

Larger molecules, with the conformational flexibility to adopt a range of nearly isoenergetic molecular shapes, introduce new questions in interpreting crystal energy landscapes, as well as being more challenging to calculate accurately. In particular, the ability to rearrange both the conformation and the packing in condensed phases is likely to be significantly more difficult than for small molecules which can have many densely-packed structures with small barriers to rearrangement in condensed phases (Hulme et al. 2007). CSP study of the flexible OZPN molecule was aimed at providing a theoretical basis for physical form diversity in this important pharmaceutical compound and how the crystal energy landscapes of flexible pharmaceuticals can complement experimental approaches.

Molecular packing analysis of known structures in the CSD belonging to the OZPN family using XPac (Gelbrich and Hursthouse 2005) and Mercury (Macrae et al. 2006) revealed that they all contain a common non-hydrogen bonded dimeric unit, with enantiomer pairs sitting on a symmetry centre (Fig. 6.2).

Fig. 6.2 Centrosymmetric dimer observed in all the experimental crystal structures of olanzapine



The centrosymmetric dimer is stabilised by the van der Waals interaction between thiophene of one OZPN molecule with piperazine ring of second OZPN molecule (Wawrzycka-Gorczyca et al. 2007). This motif is present in all the reported OZPN structures and is believed to be the structural building block for OZPN crystal structures. Thus it is of interest to develop a better understanding of the factors controlling the solid-state packing of OZPN and to find out whether any alternative packing motifs are possible in other experimental forms found in this study or in the computed structures from CSP. Another aim of the study of this compound was to compare its overall extent of solid-state diversity with that of clozapine (CZPN), which is another structurally related compound in group 1, and the factors governing those findings (see Chap. 7).

6.2 Experimental Procedures

6.2.1 Crystallisation

The experimental screen was based on solution crystallisations using 71 solvents selected to cover a wide range of physicochemical properties. These were supplemented by a further extensive range of crystallisation techniques to maximise the range of conditions under which crystallisation of OZPN was affected (see Table 6.2). A total of 417 individual crystallisations were carried out. General crystallisation techniques have been described in Chap. 3; other additional techniques which have been used specifically for OZPN are mentioned here.

Table 6.2 Summary of manual crystallisation conditions used in the experimental search

Crystallisation techniques	Crystallisation method	Number of crystallisations
Solution crystallisation $T_{\text{sat}} = \text{RT}$	Evaporation in vials, on watch glass at RT and at 277 K	128
Solution crystallisation $T_{\text{sat}} = 343 \text{ K}/323 \text{ K}$	Cooling to 323/298 K with agitation 850 rpm	75
	Antisolvent crystallisation	60
	Neat/liquid-assisted grinding	35
	Crystallisation as function of pH	18
	Crystallisation from vapour phase	10
Desolvation of solvates	Crystallisation on functionalised surfaces	12
	Isothermal and in-situ desolvation at 333 and 318 K Desolvation under vacuum at RT	66
Melt quenching		1
Recrystallisation from amorphous		5
Spray drying		3
Freeze drying		4

T_{sat} = temperature at which the saturated solutions were prepared

Following recrystallisation, each sample was analysed using XRPD/SXD, Raman and thermal analysis to confirm sample identity as described in the Chap. 3.

6.2.1.1 Cooling Crystallisation of Olanzapine Using Automated Platform

These crystallisations were carried out on Chemspeed Accelerator SLT100 Platform. Solutions were prepared by adding excess solid to each solvent to ensure that solutions were saturated at the appropriate temperature prior to being filtered automatically into a clean crystallisation vessel. T_{sat} , the temperature at which solutions were prepared was 343/323/298 K and the solutions were cooled to 323/298 K at a cooling rate of approximately 5 K min^{-1} . Crystallisation in filtered solutions was induced by either controlled cooling or evaporation. All the experiments were done in duplicate.

6.2.1.2 Antisolvent Crystallisation of Olanzapine

Saturated solutions of OZPN were prepared by dissolving the starting material in the chosen solvent under agitation. After equilibration, solutions were filtered to remove seeds and three volume equivalents of the respective antisolvent (cyclohexane, heptane, diisopropyl ether) was added.

6.2.1.3 Crystallisation of Olanzapine as Function of pH

Various salts were synthesised by grinding the compound with the respective base in molar ratio of 1:1 together with a drop of isobutyl acetate in a Retsch MM400 mixer mill (20 min at 20 Hz). Crystallisation of compound by disproportionation of each salt was carried out in acetone/water adjusted to pH 8–12 using ammonium hydroxide or aqueous or methanolic sodium hydroxide.

6.2.1.4 Crystallisation of Olanzapine on Functionalised Surfaces

Saturated solution of OZPN was prepared in ethyl acetate at RT and the derivatised glass slides were kept in the vials at 45° angle completely submerged in the saturated OZPN solution.

Derivatised glass slides were prepared by following procedure: Glass slides were kept in Pyrana solution (H₂SO₄ and H₂O₂) for 45 min and washed using distilled water and dried under nitrogen air. These slides were then placed in 5, 10, 20 and 20 % v/v solution of APTES ((3-Aminopropyl)triethoxysilane), MPTMS ((3-Mercaptopropyl)trimethoxysilane), TPS (trimethoxy(propyl)silane) and GPTMS ((3-glycidoxypropyl) trimethoxysilane) respectively in toluene for 12 h. The slides were sonicated in toluene, dimethylformamide and distilled water for 20 min each. After sonication, these slides were dried under nitrogen. The uniformity of self-assembled monolayer was assessed by contact angle measurement of small drops (2–3 μL) of water (Millipore, 18.2 M Ω cm) using Krüss DSA30B goniometer (Krüss, GmbH, Germany).

6.2.1.5 Spray Drying of Olanzapine

Preliminary investigation using spray drying techniques was carried out for physical form screen of OZPN. Spray-dried samples of OZPN were prepared at various concentrations (0.25, 0.5 and 1 %) in different solvents (dichloromethane (DCM) and methanol). Solutions were spray dried under nitrogen atmosphere, 600 psi/4 kbar using a Buchi Mini Spray Dryer B-290 (BUCHI Labortechnik AG, Flawil, Switzerland). Resulting samples were analysed using XRPD within 1 h of their preparation.

6.2.1.6 Recrystallisation from Amorphous Olanzapine

Amorphous sample obtained from melt quenching was left as it is (on the same slide which was used for melt quenching) or was scratched gently from the slide and slightly triturated before filling into a 0.7 mm borosilicate capillary or in vials. These capillaries were then analysed using XRPD at constant temperature or VT.

6.2.2 Variable Temperature-X-Ray Powder Diffraction

Temperature was controlled using an Oxford Cryosystem 700 Plus series device, with a cryostream cold head with a nozzle suspended at the top of, and parallel to, the capillary. Gas at the required temperature flows through the isothermal nozzle out to the capillary. In some cases, the capillary was shifted directly to the required temperature, while in other cases, especially in situ desolvation, temperature was increased at a rate of 5 K min^{-1} following each data collection.

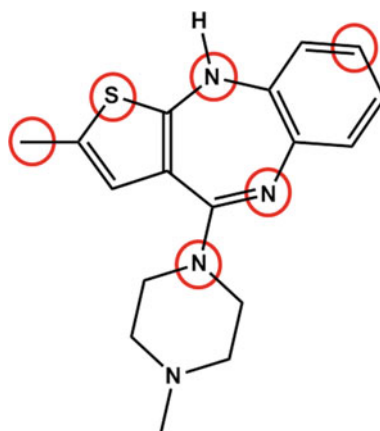
6.2.2.1 Desolvation of Olanzapine Solvates

Isothermal desolvation of various OZPN solvates was carried out at 333 K and 318 K in a convection oven. Selected solvates were subjected to desolvation in vacuum at RT and in situ desolvation at 313 K using XRPD.

6.2.3 XPac Analysis of Crystal Structures of Olanzapine

The molecular shape of the OZPN was parameterised using six common ordered sets of points (COSPs) shown in Fig. 6.3. The calculations were performed using standard cut-off parameters. The use of additional COSPs, including the selection of the whole molecule, was also tried but did not result in an appreciable improvement in the comparison. The base vectors correspond to a 1-D arrangement of molecules and are defined by their direction relative to the three crystallographic axes along with the repeat distance. Supramolecular construct (SC) can be defined as a recurring periodic or discrete arrangement of molecules with unique spatial characteristics.

Fig. 6.3 Common ordered sets of points selected for XPac analysis



6.2.4 *Random Forests Classification Model of Olanzapine Solvates*

Random Forests (RF) (see Sect. 5.1.4) classification was performed using the ‘RandomForest library package’ available in statistical computing and graphics environment R (version 2.11.1) (R Development Core Team 2006) denoted as RF/R and a commercially available RandomForests[®] package (Salford Systems) represented as RF/Salford. The training data comprised of 250 numerical physicochemical solvent descriptors calculated using MOE (MOE 2002). Three known experimental outcomes (three packing types) were defined as 1, 2 and 3 corresponding to SC₃₁, SC₃₂ and SC₃₃ (described later in Sect. 6.7). The RF model was trained using all the 250 numerical descriptors and the molecular packing type outcome using the following parameters: ntree = 15,000, mtry = 15, nodesize = 1, seed = 45. 24 out of 28 solvates were taken for random forest classification as there were no calculated descriptors for 3 solvents (1,4-butanediol, t-butanol and ethylene glycol (EG)) and OZPN hydrate was considered only once in the molecular packing type SC₃₂.

6.3 Calculation and Analysis of the Crystal Energy Landscape (Crystal Structure Prediction) of Olanzapine

The crystal energy landscape was generated using CSP methods (Day 2011) based on quantum mechanical calculations on the single molecule, to provide conformational energy differences ΔE_{intra} , and the molecular charge distribution. This molecular charge distribution is analysed to give the model for the intermolecular electrostatic forces, which in combination with an empirical exp-6 repulsion-dispersion model is used (Price et al. 2010) to evaluate the intermolecular lattice energy U_{inter} . The relative stability of the different crystal structures is estimated from the lattice energy, $E_{\text{latt}} = U_{\text{inter}} + \Delta E_{\text{intra}}$, which is the energy of the static crystal relative to a gas of the molecules in their lowest energy conformation.

The search for possible crystal structures has to consider the entire range of conformations which the molecule could adopt to give a favourable crystal structure, balancing specific intermolecular interactions such as hydrogen bonding with the dispersion stabilisation from a densely packed crystal structure. Ab initio calculations on OZPN showed that the accessible conformational space naturally separated into two low energy regions as defined in Fig. 6.4.

Conformations outside these two regions (Fig. 6.5) are too high in energy to be compensated for by favourable intermolecular interactions in the crystal and so need not be considered in the search. Whether solvent molecules could lower the conformational energy barrier so that the molecules could pass between regions A and B in solution, is a different question (Abraham et al. 1974).

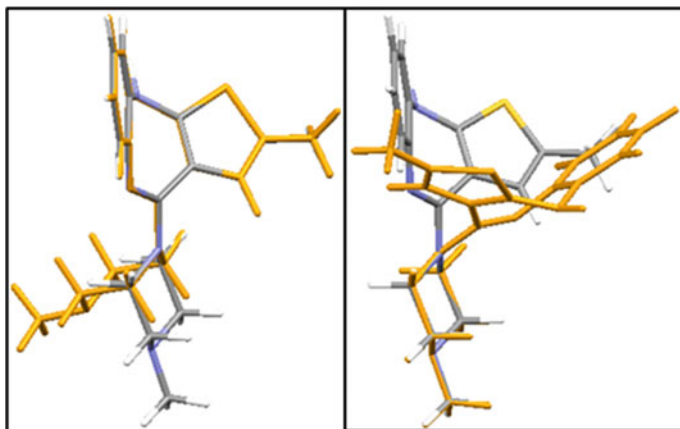


Fig. 6.4 The difference between the observed conformation (region A, coloured by element) and the alternative low energy conformation (region B, coloured by *orange*) depicted by overlaying (*left*) the benzodiazepine or (*right*) the piperazine rings, of the gas phase optimised conformations

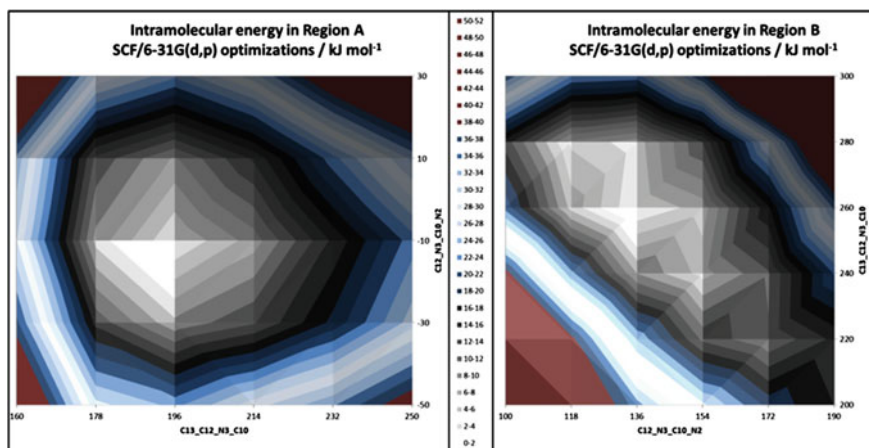


Fig. 6.5 The CrystalPredictor grid of intramolecular energies ΔE_{intra} , in kJ mol^{-1} relative to the lowest energy point in each region shown in Fig. 6.4

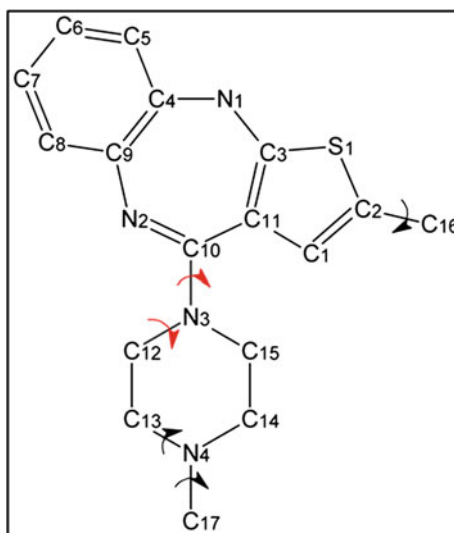
Two separate grid calculations were carried out with the angle ranges described in Table 6.3. These were done with full optimisation at the SCF 6-31G(d, p) level, with a single point charge calculation at the MP2 6-31G(d, p) level.

Approximately a million crystal structures in each conformational region were generated using CrystalPredictor (Karamertzanis and Pantelides 2007) in the space groups $P1$, $P-1$, $P2_1$, $P2_1/c$, $P2_12_12$, $P2_12_12_1$, $Pna2_1$, $Pca2_1$, $Pbca$, $C2/c$, Cc and $C2$, the 12 most common space groups (observed for molecules of this size (Kazantsev et al. 2011b) in the CSD). This includes chiral as well as

Table 6.3 The angles considered in the CrystalPredictor grid generation

Angle	Range in A region	Range in B region
C12_N3_C10_N2	-50° to +30° (5 points/20° steps)	+100° to +190° (6 points/18° steps)
C13_C12_N3_C10	+160° to +250° (6 points/18° steps)	+200° to +300° (6 points/20° steps)

Fig. 6.6 The molecular structure of olanzapine, showing all degrees of flexibility considered in final CrystalOptimizer refinements (C₁₁-C₁₀-N₃-C₁₂, C₁₀-N₃-C₁₂-C₁₃, H-C₁₇-N₄-C₁₃, C₁₇-N₄-C₁₃-C₁₂ and H-C₁₆-C₂-C₁)



centrosymmetric space groups, as although OZPN does not have a chiral centre and is observed in both mirror images, we do not wish to assume that the molecule could not invert in solution or gas phase to crystallise in just one hand. The relative energies of the resulting *ca.* 13,000 unique structures were improved by using a distributed multipole model for the electrostatic interactions. The lowest 1150 unique low energy structures, within 30 kJ mol⁻¹ of the global minimum for each region, were optimised to minimise their lattice energy, E_{latt} , with CrystalOptimizer allowing all the torsion angles shown in Fig. 6.6 to change along with the crystal cell parameters and relative positions and orientations of the molecules. The intramolecular conformational energy was calculated at the PBE0/6-31G(d, p) (Kazantsev et al. 2011a, 2011c) level, and these charge densities provided the electrostatic model for U_{inter} .

All other terms in the intermolecular energy were estimated by empirically fitted isotropic exp-6 atom-atom potential with the FIT parameters (Price et al. 2010) choosing the sulphur parameters fitted to thioether and thiocarbonyl groups. As a final refinement of the lattice energy, the effect of an average organic crystalline environment (Cooper et al. 2008) was approximated by using a Polarizable Continuum Model (PCM) (Cossi et al. 2002) with $\epsilon = 3$, to calculate the molecular charge density and conformational energy ΔE_{intra} .

6.4 Results and Discussion

Across all crystallisation conditions, three non-solvated polymorphs, 56 solvates and an amorphous form were obtained (Table 6.4). No evidence for non-solvated polymorphs other than forms I, II and III was observed.

6.4.1 Forms I, II and III of Olanzapine

Form I was most frequently observed under all conditions and the only non-solvated form which could be obtained directly from solution recrystallisation as a pure phase. Form II single crystals were obtained through vapour phase via sublimation of OZPN and XRPD analysis of the experimental samples revealed a mixture of form II and III. No suitable single crystals of form III were obtained. Form II, in presence of small amount of form III, was also obtained by neat grinding of form I in a Retsch mixer mill MM400. Form III was also observed, albeit as a mixture with form II, from desolvation of Dichloromethane (DCM), ethanol and 2,2,2-trifluoroethanol solvates, and the 1-butanol solvate hydrate.

An overlay of the XRPD data for form I, II (simulated from RT single crystal structure) and a mixed phase sample of III and II (obtained by desolvation of the DCM solvate) in which form II is a minor component is shown in Fig. 6.7. All three polymorphs can be readily distinguished by the low-angle reflection positions in

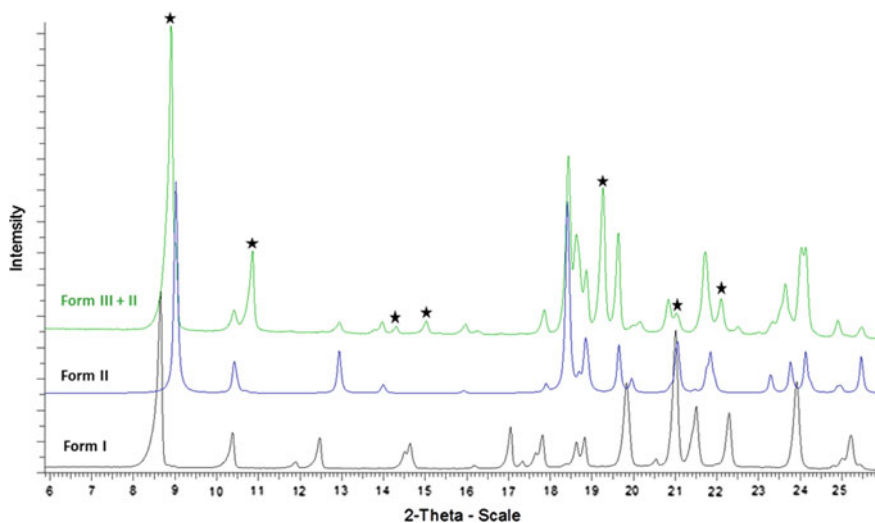


Fig. 6.7 Overlay of XRPD patterns of form I (experimental, *black*), form II (simulated from room temperature single crystal structure, *blue*) and III + II (experimental, *green*) of olanzapine. Characteristic peaks of form III are marked

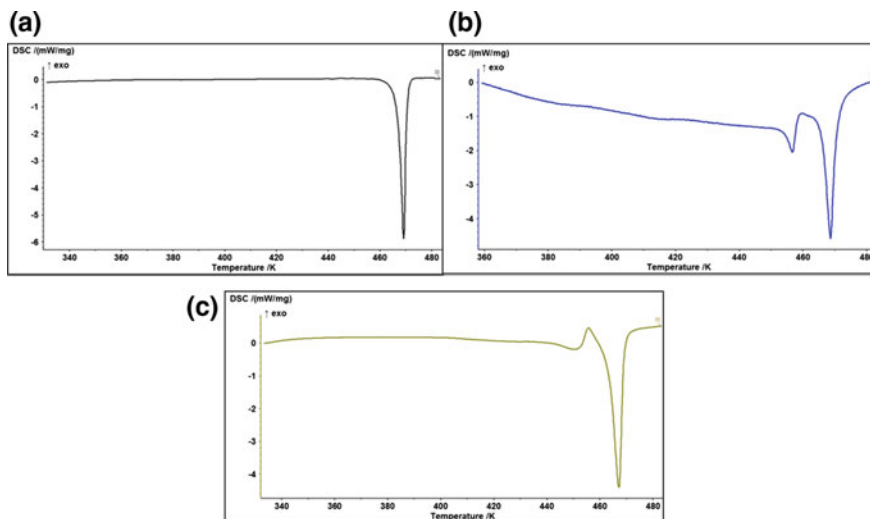


Fig. 6.8 DSC thermograms from samples of olanzapine **a** form I, **b** form II, sample comprising of several single crystals, **c** form III + II

their XRPD patterns, however detailed comparison of forms II and III is complicated by the lack of a pure form III sample. Since the low angle peak at $10.84^\circ 2\theta$ appears in XRPD data previously reported (Polla et al. 2005; Tiwari et al. 2007) for form II, Fig. 6.7 suggests that the samples used were actually mixtures of form II and III.

DSC data collected at 10 K min^{-1} shows that form I melts at 468 K and form II exhibits a transformation to form I via melt/recrystallisation with an onset temperature of 454 K prior to melting at 468 K (Fig. 6.8). The mixed phase form III produces a similar DSC trace except that the endotherm corresponding to the transformation of the sample to form I has a lower onset at *ca.* 443 K. Due to the presence of form II in the form III sample, it was not possible to accurately estimate the transition temperature for form III to form I based on this measurement alone.

Whilst metastable to form I, forms II and III are relatively stable in the solid-state at room temperature, with no evidence of transforming after 10 months. At 313 K and above, forms II and III transform rapidly to form I, typically within 48 h. Slurries of mixed phase samples of II and III in non-solvate forming solvents transform completely to form I within 2 h at RT.

Raman spectroscopy allows unambiguous identification of phase pure form I and form II. Differences were observed between C-H bands in high frequency zone ($2700\text{--}3100\text{ cm}^{-1}$), C-C (aromatic) band in medium frequency zone ($1500\text{--}1700\text{ cm}^{-1}$, peak splitting at 1525 cm^{-1}), C-S band ($1080\text{--}1100\text{ cm}^{-1}$), C-C alicyclic bands in $600\text{--}1300\text{ cm}^{-1}$ region and in the low wavenumber region, below 400 cm^{-1} , which are due to the differences in crystal packing and lattice vibrations

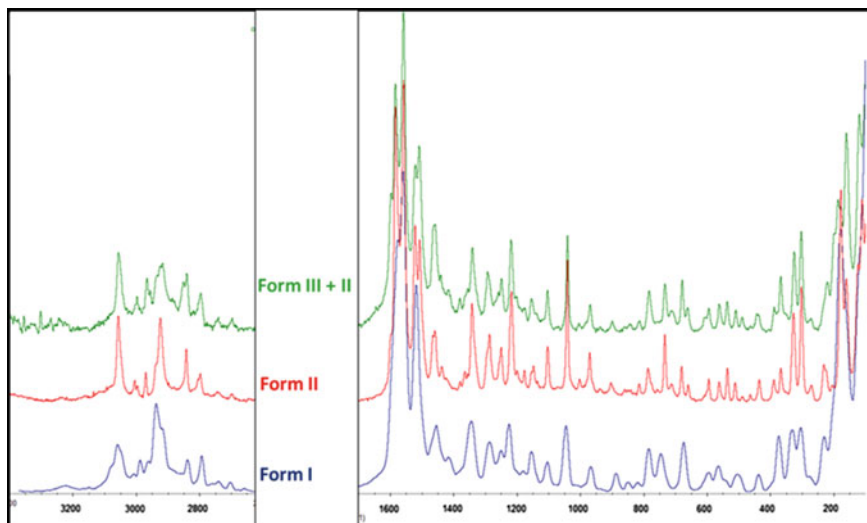


Fig. 6.9 Raman spectra of form I (blue), form II (red) and form III + II (green)

(Fig. 6.9), whereas the spectra collected from a mixture of forms III (major) and II show subtle differences compared with pure form II.

FT-IR spectra of form I vs. form II (major) + III or form III (major) + II show significant differences whereas form II (major) + III or form III (major) + II show subtle differences (Fig. 6.10). Raman and FT-IR data suggest that the structures of

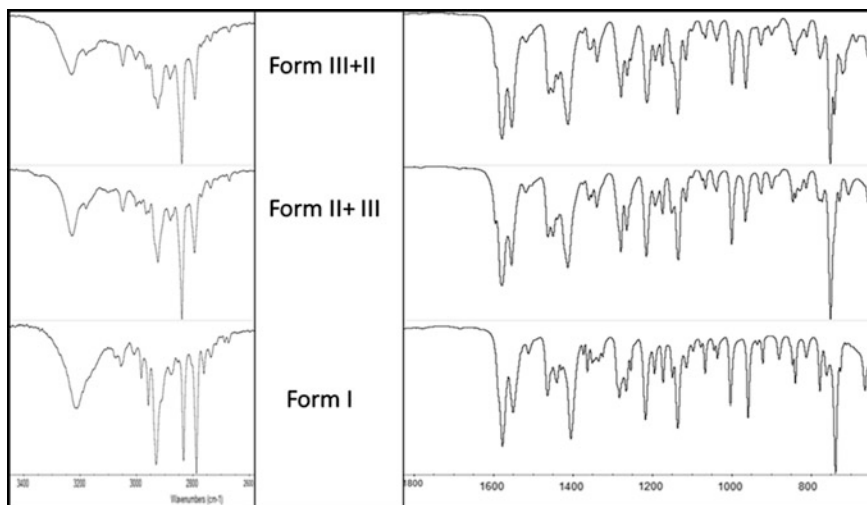


Fig. 6.10 FT-IR spectra of form I, II (major) + III (minor), III (major) + II (minor) and amorphous phase of olanzapine

forms II and III are closely related which was also observed using SS-NMR (Reutzel-Edens et al. 2003).

6.4.2 Solution Crystallisation of Olanzapine

The solvent screen includes slow evaporation in vials at RT and 277 K, faster solvent evaporation, cooling crystallisation on automated platform, antisolvent crystallisation, and crystallisation on various surfaces and as a function of pH using 71 diverse solvents (see Sect. 6.2.1 and Appendix Tables A.1–A.6). The results of various solution crystallisations are reported in Table 6.4.

Of the 293 solution crystallisations carried out, 30 (10.2 %) yielded either no sample or insufficient solid for XRPD analysis due to poor solubility and/or chemical decomposition. Of the 263 samples giving measurable diffraction, 180 were identified as crystalline solvates and 31 were identified as mixtures comprising form I and the respective solvate. The remaining 52 single phase samples obtained from solution crystallisation were form I (starting material). Crystallisation carried out at higher temperature (323 K) to avoid solvate formation on automatic platform yielded form I. No solution crystallisations yielded forms II or III. In all salt disproportionation experiments the OZPN dihydrate B (CSD refcode: AQOMAU01) (Reutzel-Edens et al. 2003) was obtained regardless of pH used. This reflects the rapid formation of dihydrate B in the presence of water.

In total, 56 different solvates were identified from solution crystallisation. Overall, whilst OZPN shows a prolific capacity to form solvates with a wide range of solvent molecules, under the conditions tested it did not form solvates with several esters (ethyl acetate, isopropyl acetate, butyl acetate, and isobutyl acetate), diethyl ether, diisopropyl ether, toluene or fluorotoluene. In some cases, dihydrate B/D was obtained from esters (Appendix Tables A.1–A.6).

Of the 56 organic solvates and hydrates identified in this work, 10 crystal structures were available in the literature. Twenty four previously unreported solvate crystal structures were determined by SXD and the crystal structures of the remaining 22 solvates were not determined but were identified on the basis of XRPD and/or DSC/TGA analyses. Lattice parameters of 30 crystal structures (24 novel solvates, form I, form II and crystal structure redeterminations of 4 solvates) are tabulated in Table 6.5. From the solvate crystal structures, there are three groups of similar unit cell parameters (Table 6.5) highlighting the essentially isostructural relationships within each group with OZPN forming a common network in which different solvent molecules can be accommodated. Apart from the higher hydrate, all the 11 other structures that crystallise in space group $C2/c$ have the organic solvent molecule residing on a special position and are highly disordered. In this group of solvates, OPZN molecules play as host, where variety of guest molecules can be accommodated. Crystal data, data collection and refinement details are provided in Table A.7 of the Appendix.

Table 6.4 Summary of crystallisation techniques used and summary of solid forms produced in the experimental search for physical forms of olanzapine

Crystallisation techniques	Crystallisation method	Number of solid form(s) (See further details for identity)			Further details	
		Non-solvated polymorph(s)	Solvate(s)	Amorphous		
Solution crystallisation	$T_{\text{sat}} = \text{RT}$, Evaporation at RT, on watch glass and at 277 K (Appendix Tables A.1–A.2)	1	56 (see further details for identity)		Crystal Structure Determined in This Work see Table 6.5	
	$T_{\text{sat}} = 343 \text{ K}$, Cooling to 298 K with agitation 850 rpm (Appendix Table A.3)	1			Crystal Structure Known from Literature dihydrate D, dihydrate E, DMSO hydrate, methanol hydrate, 2-butanol hydrate, ethanol hydrate	
	Antisolvent crystallisation (Appendix Table A.4)	1			No Crystal Structure Determined^a Sect. 6.4.2	
	Crystallisation on functionalised surfaces (Appendix Table A.5)	1			Form I	
Neat/liquid-assisted grinding (Appendix Table A.8)	Crystallisation by pH swing (Appendix Table A.6)		1		Dihydrate B	
		1	20		form II and solvates as obtained for solution crystallisation except ethanol, water, DCM and DCM: acetonitrile:water (1:1:1)	
Desolvation of solvates (Appendix Table A.9)	Isothermal and in-situ desolvation at 333 and 318 K Desolvation under vacuum at RT)	3			Form I, or II and III ^b	

(continued)

Table 6.4 (continued)

Crystallisation techniques	Crystallisation method	Number of solid form(s) (See further details for identity)			Further details
		Non-solvated polymorph(s)	Solvate(s)	Amorphous	
Crystallisation from vapour phase		3			Single crystals of form I and II, II, only concomitant with polycrystalline form III
Melt quenching				I	
Recrystallisation from amorphous form (Appendix Table A.10)		3			Form I, or II and III ^b
Spray drying		3			Form I, or II and III ^b
Freeze drying		3			Form I, or II and III ^b

^aHydrated solvates of 1-methylnaphthalene, 2-butanone, 2-methoxyethyl ether, 1,1,2-trichloroethylene, N,N,N-triethylamine, 2,2,2-trifluoroethanol, benzene, bromoform, butyl ether, cyclohexane, carbon tetrachloride, chloroform, DCM, dodecane, furfural, N,N-dimethylacetamide, N-methyl pyrrolidone, pentyl acetate, tetrachloroethylene and solvates of formic acid, 1-bromo-2-chloro ethane, 1-octanol

^bMixture of forms I, II and III in varying ratios

Table 6.5 Lattice parameters for olanzapine crystal structures found in the experimental search (standard uncertainties in parentheses)

Structure ID	Form (OZPN:solvate)	Space group	Stoichiometry ^a	<i>a</i> (Å)	<i>b</i> (Å)	<i>c</i> (Å)	α (°)	β (°)	γ (°)	Cell Volume (Å ³)
1	Form I ^b	<i>P</i> ₂ ₁ / <i>c</i>		10.3411 (13)	14.521 (2)	10.5314 (14)	90	100.291 (4)	90	1555.9(4)
2	Form II	<i>P</i> ₂ ₁ / <i>c</i>		9.8544 (14)	16.314 (2)	9.9754 (12)	90	98.304 (8)	90	1586.9(4)
3	2-butoxyethanol	<i>P</i> ₂ ₁ / <i>c</i>	1:1	10.4420 (10)	17.7328 (15)	12.5720 (12)	90	95.755 (5)	90	2316.17(12)
4	2,2,2-trifluoroethanol	<i>P</i> ₂ ₁ / <i>c</i>	1:2	12.72 44(9)	11.7538 (8)	16.006 7 (11)	90	94.782 (2)	90	2385.63(5)
5	Acetic acid	<i>P</i> ₂ ₁ / <i>c</i>	1:1	10.0427 (11)	12.7430 (13)	14.3886 (15)	90	92.436 (4)	90	1839.70(5)
6	Ethylene glycol	<i>P</i> ₂ ₁ / <i>c</i>	1:1	9.839(2)	13.278 (2)	14.588 (2)	90	96.328 (7)	90	1894.37(16)
7	Ethanol	<i>P</i> ₂ ₁ / <i>c</i>	1:1	10.349 (2)	13.003 (2)	13.870 (2)	90	92.469 (6)	90	1864.66(7)
8	Tertiary butyl methyl ether (TBM _e) ₂ hydrate	<i>P</i> ₂ ₁ / <i>c</i>	1:1:2	14.2070 (1)	12.2210 (9)	14.5500 (1)	90	109.239 (3)	90	2385.2(2)
9	2-pentanol ₂ hydrate	<i>P</i> ₂ ₁ / <i>c</i>	1:1:1	13.4466 (10)	12.3833 (9)	14.5522 (9)	90	104.839 (2)	90	2342.3(3)
10	2,2,2-triethylamine ₂ hydrate	<i>P</i> ₂ ₁ / <i>c</i>	1:0.5:2	14.817 (1)	12.623 (1)	14.461 (1)	90	113.359 (2)	90	2483.1(2)
11	t-butanol ₂ hydrate	<i>P</i> ₂ ₁ / <i>c</i>	2:2:5	14.2491 (9)	12.3838 (8)	27.1418 (17)	90	99.052 (2)	90	4729.7(5)
12	3-methyl-1-butanol ₂ hydrate	<i>P</i> -1	1:1:1	12.34(2)	13.55(2)	14.63(2)	105.88 (6)	90.29 (6)	92.00 (6)	2317.9(4)

(continued)

Table 6.5 (continued)

Structure ID	Form (OZPN:solvate)	Space group	Stoichiometry ^a	a (Å)	b (Å)	c (Å)	α (°)	β (°)	γ (°)	Cell Volume (Å ³)
13	1,4-butanediol_hydrate	P-1	2:1:2	12.2634 (1)	14.115 (1)	14.178 (1)	63.98 (3)	65.65 (4)	65.44 (4)	1924.9(4)
14	Dimethylformamide (DMF)_hydrate	P2 ₁ /c	2:1:2	14.9885 (9)	12.7558 (7)	19.8567 (12)	90	93.348 (2)	90	3789.93(6)
15	Pyridine_hydrate	P2 ₁ /c	1:0.5:1	14.8824 (7)	12.7289 (7)	20.3218 (11)	90	93.465 (2)	90	3842.65(6)
16	Tetrahydrofuran (THF)_hydrate	C2/c	1:0.5:1	24.2355 (10)	12.5913 (5)	15.0767 (6)	90	124.999 (1)	90	3768.76(3)
17	1,4-dioxane_hydrate	C2/c	1:0.5:1	24.447 (3)	12.566 (2)	14.959 (2)	90	125.42 (5)	90	3744.9(16)
18	Acetone_hydrate	C2/c	1:0.5:1	24.226 (2)	12.527 (12)	15.0737 (15)	90	124.98 (4)	90	3748.3(12)
19	1-butanol_hydrate	C2/c	1:0.5:1	24.575 (6)	12.429 (3)	15.007 (3)	90	125.26 (7)	90	3743.1(3)
20	Acetonitrile_hydrate	C2/c	1:0.7:1	24.307 (1)	12.350 (1)	15.031 (1)	90	125.31 (5)	90	3682.7(16)
21	Nitromethane_hydrate	C2/c	1:0.5:1	24.352 (3)	12.371 (1)	15.018 (1)	90	125.531 (5)	90	3681.9(16)
22	1,2-dimethoxyethane_hydrate	C2/c	n.d.	24.467 (13)	12.229 (8)	15.107 (8)	90	125.67 (2)	90	3672.2(7)
23	2-methoxyethanol_hydrate	C2/c	1:0.5:1	25.0869 (8)	12.3821 (4)	15.1983 (5)	90	126.872 (1)	90	3776.7(3)
24	Methyl acetate_hydrate	C2/c	1:0.5:1	24.899 (4)	12.532 (2)	15.243 (2)	90	126.99 (5)	90	3798.9(18)

(continued)

Table 6.5 (continued)

Structure ID	Form (OZPN:solvate)	Space group	Stoichiometry ^a	a (Å)	b (Å)	c (Å)	α (°)	β (°)	γ (°)	Cell Volume (Å ³)
25	1,2-propanediol_hydrate	C2/c	1:0.5:1	24.704 (2)	12.188 (1)	15.124 (1)	90	125.20 (3)	90	3721.0(5)
26	1-propanol_hydrate	C2/c	1:0.5:1	24.475 (1)	12.351 (6)	15.111 (8)	90	125.65 (1)	90	3712.0(3)
27	Higher hydrate ^b	C2/c	1:2.5	24.940 (6)	12.156 (3)	14.867 (3)	90	124.928 (6)	90	3695.2(14)
28	Methanol ^b	P2 ₁ /c	1:1	10.1493 (9)	12.2895 (10)	14.0944 (13)	90	91.905 (5)	90	1757.0(3)
29	Dihydrate B ^b	P2 ₁ /c	1: 2	9.846(2)	12.672 (3)	14.384 (3)	90	92.724 (9)	90	1792.7(7)
30	Dichloromethane (DCM) ^b	P-1	2:1	9.6671 (15)	11.5070 (17)	16.697 (2)	103.991 (6)	96.989 (6)	99.825 (6)	1749.8(4)

All parameters were determined from single-crystal diffraction collected at 123(2) K

n,d not determined

^aStoichiometry of OZPN:solvent:water, determined using crystal structure and/or mass loss in TGA curve

^bCrystal structure redetermined in this study at 123(2) K

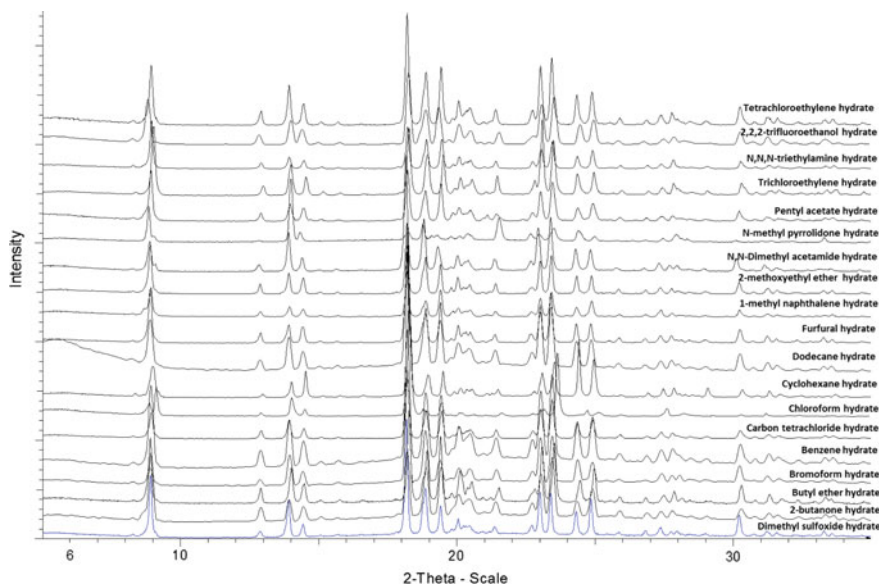


Fig. 6.11 XRPD patterns of the 18 novel isostructural solvates (belong to crystal structures in space group $C2/c$) observed during experimental screen and a reference pattern of the known olanzapine DMSO hydrate

Twenty two solvates, for which crystal structures were not determined, were obtained during cooling crystallisation on automated platform (Appendix Table A.3) except formic acid solvate/salt which was obtained from liquid-assisted grinding (Appendix Table A.8). As mentioned earlier, these solvates were identified on the basis of XRPD and/or DSC/TGA analyses. 18 out of 22 solvates were found to be isostructural with the group of OZPN solvates which crystallise in space group $C2/c$ (Table 6.5) based on solvent loss in TGA and similarity in XRPD data (Fig. 6.11). The XRPD data of remaining 4 solvates did not match with any of the known solvate structures and are shown in Fig. 6.12. The majority of solvate crystal structures (38/56) were mixed solvates containing the organic solvent of recrystallisation and at least one water molecule in the asymmetric unit in addition to OZPN. Water was not deliberately used during crystallisation but instead was either absorbed from the atmosphere or introduced in the organic solvent used for crystallisation.

6.4.3 Neat and Liquid-Assisted Grinding of Olanzapine

Neat grinding in a Retsch MM400 mixer mill (see Sect. 3.2.1.3) of form I produced form II with traces of form III. During the experiment, XRPD peaks of form II

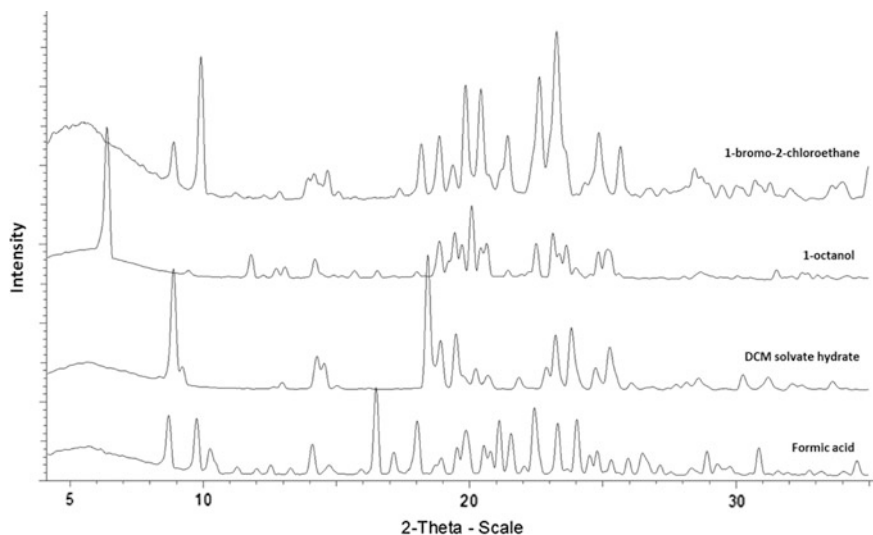


Fig. 6.12 XRPD patterns of the four novel olanzapine solvates obtained from crystallisation on the automated platform

started appearing after 10 min of grinding at a frequency of 30 Hz with increased background, peak broadening and poor signal to noise ratio. Form II with traces of form III was obtained after 60 min of grinding at 30 Hz. Further grinding was not found to change the results. A Pawley fit of the single crystal unit cell and space group of form II against the XRPD data for the sample obtained by grinding is shown in Fig. 6.13. The good agreement confirms that the single crystal structure is

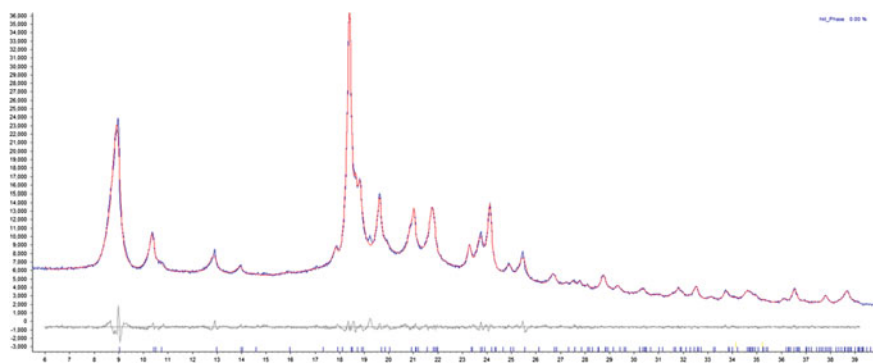


Fig. 6.13 Pawley fit in TOPAS Academic (version 4.1), observed profile (*blue*), calculated profile (*red*) and difference plot (*black*) of the Pawley fit for form II in the range of 6–39° 2 θ . $R_{wp} = 2.461$

representative of the bulk sample, although some unfitted peaks of form III e.g. $19.3^\circ 2\theta$ are present.

Solvent assisted grinding (see Sect. 3.2.1.3) of form I OZPN was carried out using 33 solvents at 25 Hz for 30 min. Form I was observed with 13 solvents tested, and the remaining 20 samples returned a solvate, either as a pure sample (18 samples) or as a mixture with form I (2 cases; Appendix Table A.8). In the majority of cases (16/20), grinding produced the same solvated form as solution recrystallisation. For the remaining four solvent-assisted grinding experiments using ethanol, water, DCM, and DCM:acetonitrile:water (1:1:1), different solvated forms were obtained. These were mixed ethanol hydrate, higher hydrate which transforms to mixture of dihydrate E and B, DCM solvate and DCM solvate hydrate respectively (Appendix Table A.8).

6.4.4 Desolvation of Olanzapine Solvates

With the exceptionally large number of OZPN crystalline solvates produced, desolvation was assessed as a potential route to obtain new polymorphic forms. The majority of the solvates for which crystal structures were determined in this study were desolvated isothermally at 333 and 318 K. After over 24 h at 333 K, most samples transformed to form I, while desolvation at 318 K yielded mixtures of varying composition of forms I, II and III (in case of ethanol, 2-butoxyethanol, 2,2,2-trifluoroethanol, 1-butanol, dichloromethane, dihydrate B and chloroform) (Appendix Table A.9).

In an attempt to obtain form III, those solvates that showed evidence of forms II and III upon desolvation were also subjected to vacuum at RT as well as in situ desolvation at 313 K monitored using XRPD. The lower temperatures were used in an attempt to isolate forms II and/or III and minimise the transformation to form I, which occurs rapidly at temperatures over 333 K. However, no conditions were identified that yielded a pure sample of form III suitable for structure determination from powder diffraction data or further characterisation. Desolvation of the DCM solvate either under vacuum or at 318 K (Fig. 6.14) gave the best yield of form III from any of the experimental conditions tested as part of the screen and samples prepared from this method were used in subsequent characterisations of this form. Desolvation of methanol and dihydrate B yielded form II as the major product.

6.4.5 Melt Quenching and Recrystallisation of Amorphous Olanzapine

XRPD data of an amorphous form of OZPN showed the characteristic broad halo and absence of Bragg diffraction peaks (Fig. 6.15). STA data show a glass

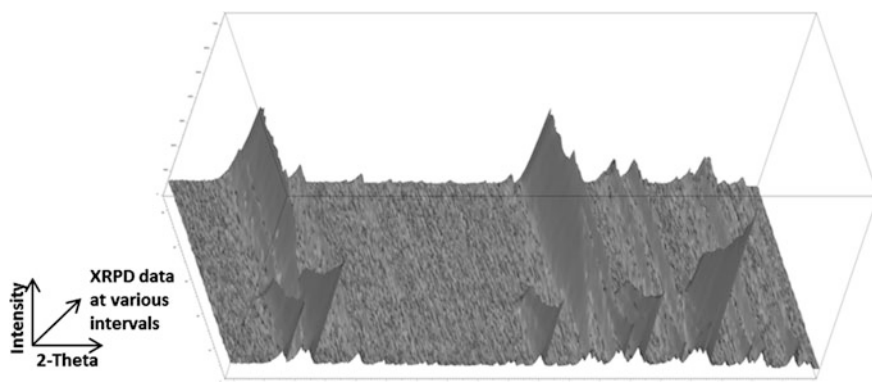


Fig. 6.14 3-D overlay of the XRPD patterns during in-situ desolvation of olanzapine DCM solvate at 318 K, showing appearance of peaks of form III and II and disappearance of peaks of DCM solvate

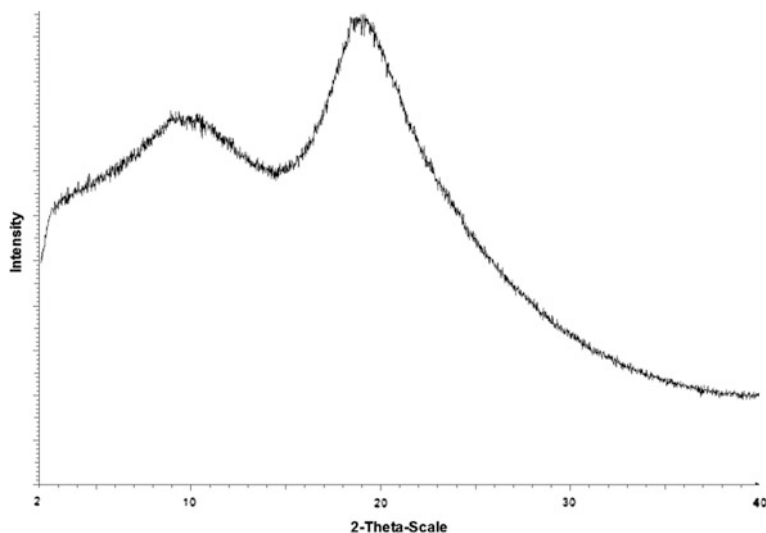


Fig. 6.15 XRPD data of amorphous olanzapine in the region of 2–40° 2 θ

transition ~ 343 K after which the material crystallises with an onset temperature of 381 K to form II, III or a mixture thereof. On heating, form II/III transform to form I at a temperature ca. 453 K, prior to finally melting at ca. 468 K (Fig. 6.16).

Further experiments to study the recrystallisation of OZPN from amorphous samples held under different conditions (for a minimum of 24 h) show a range of outcomes (Appendix Table A.10). A melt-quenched amorphous phase prepared on a glass slide, if left undisturbed, was stable for weeks. The amorphous form reproducibly crystallised to mixtures of form II and form III (in varying ratios)

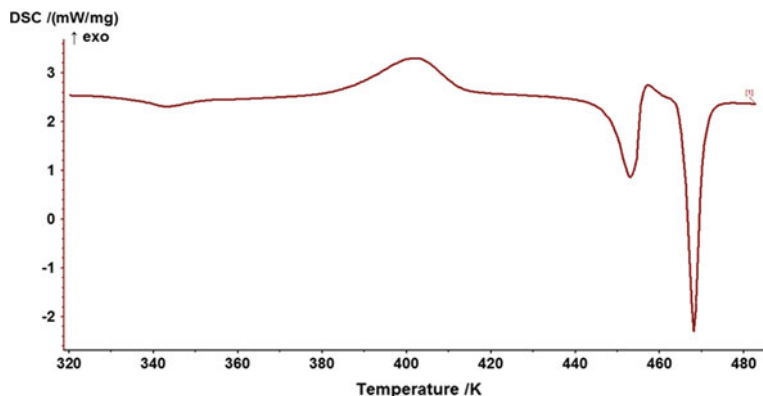


Fig. 6.16 DSC data of amorphous olanzapine. Data was collected from 263 to 483 K at a heating rate of 20 K min^{-1}

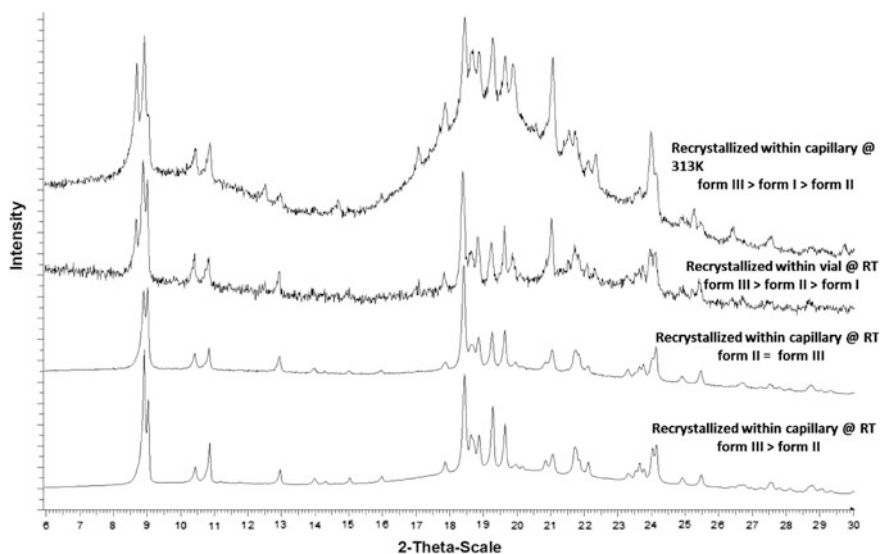


Fig. 6.17 XRPD data in the range $6\text{--}30^\circ 2\theta$ collected from melt-quenched sample of olanzapine recrystallised within borosilicate capillary or in a vial held at RT or at 313 K

within a 0.7 mm borosilicate glass capillary within 24 h (Fig. 6.17). Also a mixture of form I, II and III was obtained from an amorphous sample left in a vial under ambient conditions (Fig. 6.17). When the amorphous sample was heated at 313 K, the ratio of form I was increased in the recrystallised product (Fig. 6.17). No phase transformation was observed when sample was stored below 283 K.

Based on the DSC, OZPN is present as form II or III after recrystallisation of amorphous phase at 393 K. As guided by DSC, to get pure form II/III, the

Table 6.6 Results of spray drying experiments for olanzapine

S. No	OZPN Solution	PXRD	DSC
1	1 % DCM	Form I (major) + form III (minor) + form II (traces)	Melting endotherm corresponds to form I
2	0.5 % DCM	Form III (major) + form I (minor) + form II (traces)	Melting endotherm corresponds to form I
3	0.25 % CH ₃ OH	Form II + form I + methanol solvates (traces) Observed halo of amorphous, but material crystallised within minutes	Mass loss and Melting endotherm corresponds to form I

amorphous sample was directly heated at 393 K, but the thermodynamically stable form I was observed within 5 min. No traces of form II or III were observed when heated above 353 K. Phase pure sample of form II or III could not be obtained in a capillary under the conditions tried for recrystallisation of amorphous form.

6.4.6 Spray Drying and Freeze Drying of Olanzapine

Spray drying (see Sect. 6.2.1.5) can produce different polymorphs, particle morphologies and particle sizes (Yu and Ng 2002; Vehring 2008). All three known polymorphs were obtained from preliminary assessment of spray drying (Table 6.6) and the polymorphic form(s) produced vary according to the experimental conditions used. A further systematic study is required to explore the possibility of obtaining pure form III in particular. Limited freeze drying experiments (see Sect. 3.2.1.6) provided mixture of form I and form II. XRPD data revealed some amount of amorphous content in the sample and were confirmed by STA.

6.5 Molecular Packing Analysis of Olanzapine Crystal Structures Using XPac

Packing arrangements of all 35 known OZPN crystal structures (30 crystal structures from this work as per Table 6.5 and 5 solvate crystal structures from the CSD) were compared using XPac to identify the common packing features that underpin the large number of crystal structures. In all the structures, in the solid-state, the diazepine ring of OZPN exists in a puckered conformation between the planes of the thiophene and benzene rings and the piperazine ring adopts a chair conformation with the methyl group in an equatorial position. All structures show packing motifs involving the centrosymmetric dimer, hereafter referred to as SC₀. This uniform appearance of SC₀ in all crystal structures confirms SC₀ as the key

Table 6.7 Highest-dimensionality SCs observed in the 35 olanzapine structures and forms obtained after desolvation

SC	Dimensionality	Structures	Desolvation Product
SC ₀	0D	2-butoxyethanol[3], 2,2,2-trifluoroethanol[4]	Form II and III
SC ₁₁	1D	Form II[2], DCM [30]	Form II and III
SC ₁₂	1D	2-butanol hydrate[35] ^a	
SC ₂₂	2D	Form II[1], dihydrate D[34] ^a	
SC ₃₁	3D	1,4-butanediol hydrate[13], DMF hydrate[14], pyridine hydrate[15], THF hydrate[16], 1,4-dioxane hydrate[17], acetone hydrate[18], 1-butanol hydrate[19], acetonitrile hydrate[20], nitromethane hydrate [21], 1,2-dimethoxyethane hydrate [21], methoxy ethanol hydrate[23], methyl acetate hydrate[24], 1,2-propanediol hydrate[25], 1-propanol hydrate[26], higher hydrate[27], DMSO hydrate[31] ^a , methanol hydrate[32], ethanol hydrate[33] ^a	Form I except 1-butanol hydrate which provides form II and III
SC ₃₂	3D	Acetic acid[5], ethylene glycol[6], ethanol[7], methanol solvate[28], dihydrate B[29],	Form II + III except acetic acid solvate which provides form I
SC ₃₃	3D	TBMe hydrate[8], 2-pentanol hydrate [9], N,N,N-triethylamine hydrate [10] ^a , isoamylalcohol hydrate[12] t-butanol hydrate[11]	Form I

The number in square brackets corresponds to each structure in Fig. 6.18

^aNo desolvation data

structural building block from which crystalline structures of OZPN are assembled (Reutzel-Edens et al. 2003). The head-to-tail arrangement of OZPN molecules in the dimer affords the opportunity for the single hydrogen-bond donor, N1 and the two hydrogen-bond acceptors (imine N2 and piperazine N4) to form hydrogen bonds with adjacent dimers or solvent molecules, resulting in a variety of extended arrangements. The XPac analysis also identified a range of 1-D, 2-D and 3-D similarities across the OZPN structures that illustrate repeated occurrences of common packing arrangements in the series. The supramolecular constructs (SC) (Gelbrich and Hursthouse 2006) identified are summarised in Table 6.7 and the associated structural inter-relationships are illustrated in Figs. 6.18 and 6.19.

SC₁₁ is the most frequently observed 1-D OZPN SC (10/35 structures) and is of particular relevance given that it is a shared feature of OZPN form I and II as well as a number of solvates. It comprises a 1-D stack of SC₀ dimers and can pack in a

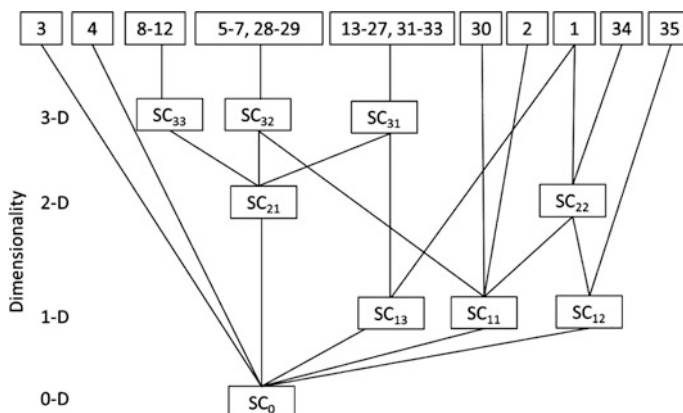


Fig. 6.18 Diagram showing the similarity relationship between 35 structures of olanzapine with structures identified by the crystal structure numbers used in Table 6.7

variety of ways. The form I and II crystal structures differ in the relative orientations of the SC_{11} stacks about their t_4 translation vector (defined in Fig. 6.19) such that in form I they are approximately parallel whilst in form II they adopt an offset “corrugated” arrangement (Fig. 6.20).

The DCM solvate (‘30’, Fig. 6.20) shows a significantly different arrangement, in which alternating layers of SC_{11} pack along a second axis with alternate layers lying perpendicular to those of its neighbours. This solvate shares 1-D similarity with only one other polymorph structure, form II, via SC_{11} .

In 28 structures, the dimer SC_0 , adopts a common arrangement along two axes to form the SC_{21} layer, the most frequently occurring 2-D SC. The high frequency of occurrence (80 % of all OZPN structures) highlights the very robust nature of SC_{21} . SC_{21} sheets can also stack with different inter-layer spacing and translations to produce three distinct 3-D SCs, namely SC_{31} , SC_{32} and SC_{33} (Fig. 6.18). SC_{22} is present in only 2 structures, form I and dihydrate D (‘1’ and ‘34’, Fig. 6.18) with the major difference between the structures resulting from the relative orientations of neighbouring SC_{22} sheets due to the incorporation of water molecules in dihydrate D (Fig. 6.20).

Of the 3-D SCs, the most common, SC_{31} , is observed in 18 structures which are all solvates (Fig. 6.18). This high dimensionality SC comprises SC_{21} plus the 1-D SC_{13} which is also shared with OZPN form I. This structural relationship may contribute to the facile nature of the transformation for the 18 solvates that contain SC_{13} to form I upon desolvation (Table 6.7). SC_{32} , is observed in five structures in which the arrangement of SC_{21} is defined by the 1-D SC_{11} . The corrugated arrangement of SC_{11} is preserved in the SC_{32} arrays but the inclusion of solvent molecules, illustrated in Fig. 6.20 for the acetic acid solvate, leads to an increase in

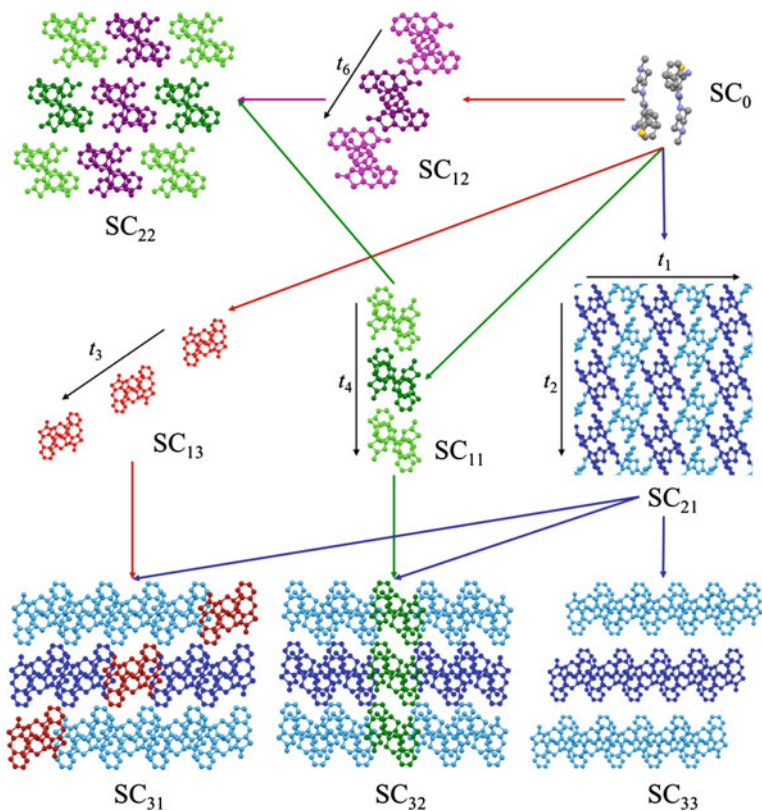


Fig. 6.19 Packing diagrams highlighting the supramolecular constructs (SCs) and their relationships highlighted in Fig. 6.18. The directions of the primary vectors are indicated by arrows and in the SC₂₁ layer the SC₀ pairs are differentiated by *light* or *dark blue shading*. As the three-dimensional arrays correspond to three distinct packing modes of the SC₂₁ layers these are all viewed along the direction of the t_2 vector with the constituent SC₂₁ layers differentiated by *dark* and *light blue shading*. The three one-dimensional SCs are coloured *green* (SC₁₁), *purple* (SC₁₂) and *red* (SC₁₃) respectively and are viewed perpendicular to the axis of their translation vectors. In SC₃₁ and SC₃₂, the SC₂₁ layers are related by the SC₁₃ and SC₁₁ constructs respectively and a single occurrence of each, viewed perpendicular to its translation vector, is highlighted with the corresponding colour. A single SC₂₂ layer is shown with the SC₁₂ component running approximately vertical, highlighted in purple, with three SC₁₁ constructs running horizontally and differentiated by *dark* and *light green shading*

the separation between SC₁₁ columns and breaks the 3-D similarity between form II and this group of solvates. Given the shared SC₁₁ link between the SC₃₂ solvates and form II it is interesting to note that three of the four solvates in this group produced mixtures of forms II and III upon desolvation. SC₃₃ is shared by 5 solvates in which the arrangement of molecules along the third axis shows a larger inter-layer spacing in order to accommodate the bulky solvent molecules in this group (2-pentanol, TBMe, isoamyl alcohol, N,N,N-triethylamine and t-butanol).

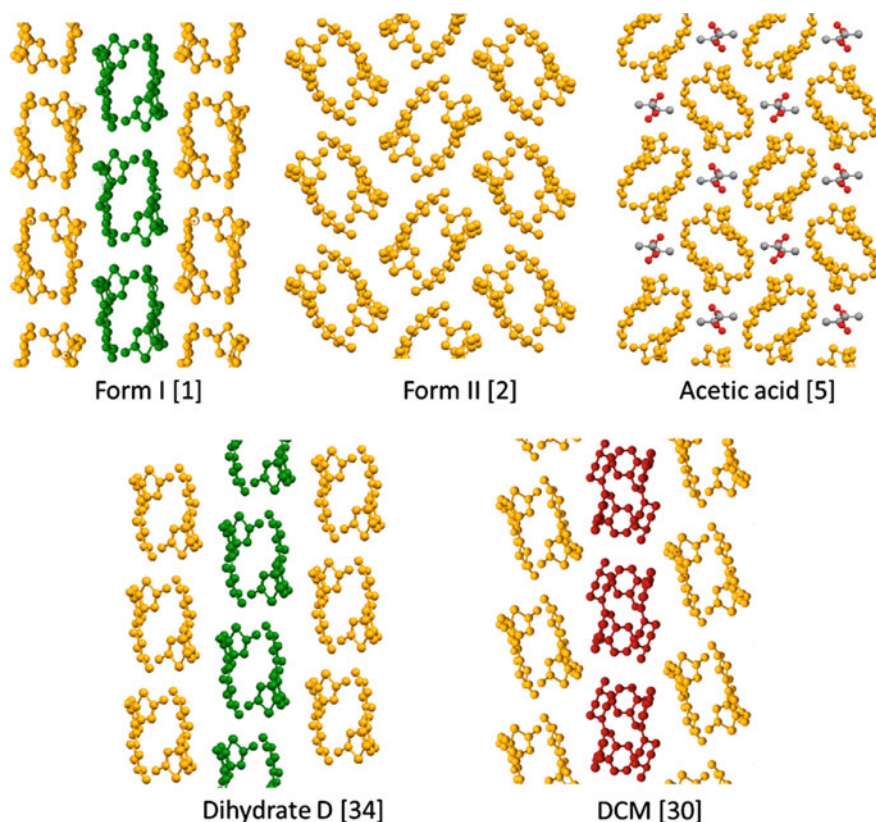


Fig. 6.20 The five different packing arrangements adopted by the SC_{11} stacks, these are viewed along the axis of the t_4 vector (which run perpendicular to page) with each pair of face-to-face molecules (coloured yellow) representing a single SC_{11} stack. In the dichloromethane solvate the dark red molecules represent SC_{11} columns in which the t_4 vector runs perpendicular to those in the neighbouring layers, in form I and dihydrate D, a SC_{22} layer is shown by the green molecules

6.6 Hydrogen-Bonding Analysis of Olanzapine Crystal Structures

In all the experimental structures, the arrangement of OZPN in SC_0 exposes the H-bond donor and acceptors to take advantage of available H-bonding sites. Both form I and II have the same hydrogen bonding i.e. N1-H of the azepine ring of every OZPN forms H-bond with N2 of the azepine ring of OZPN in adjacent centrosymmetric dimer, leaving behind two unsatisfied hydrogen bond acceptors (N3 and N4) on the piperazine ring (Fig. 6.21).

In majority of the solvate structures, hydrogen bonding is mediated by the solvent molecule(s) and, in some cases, the solvent molecule(s) fulfil(s) the hydrogen bonding sites of OZPN in place of other OZPN contacts. As a water

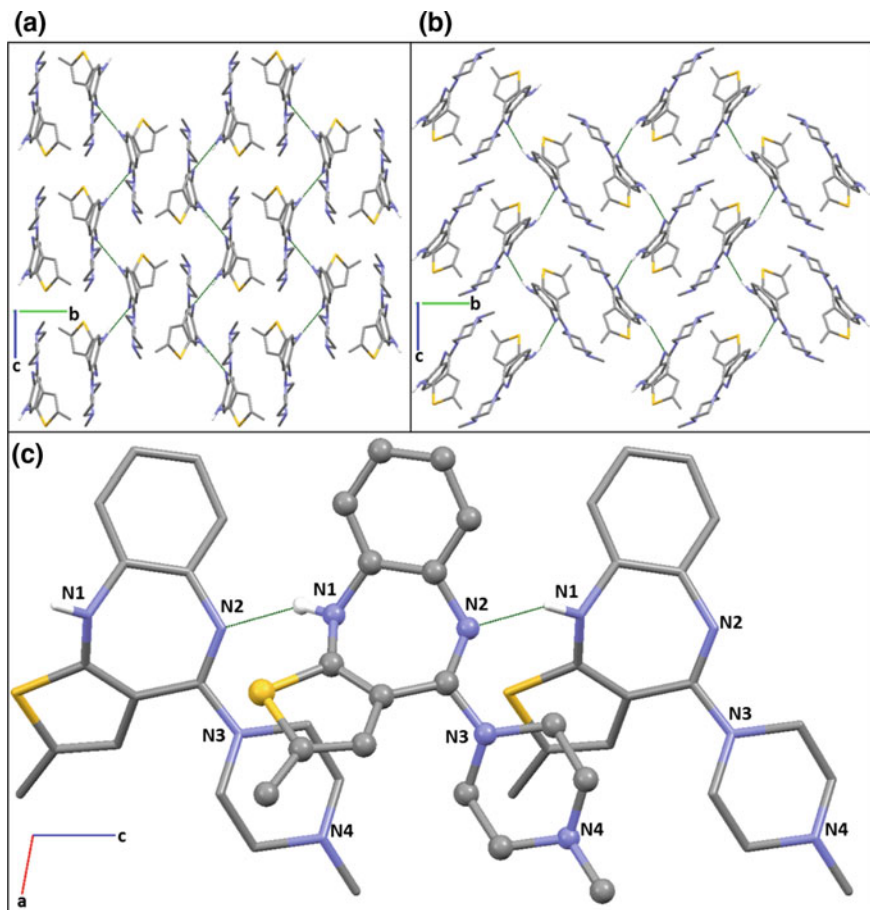


Fig. 6.21 Different arrangements of SC₁₁ in **a** form I and **b** II of olanzapine, which share the same H-bonding (shown by *green dotted line*). **c** A closer view at the olanzapine atoms involved in H-bonding. Other hydrogen atoms are omitted for clarity

molecule is present in 36 out of 56 solvates, special emphasis was given to find out the environments of water molecules in these structures. Water can be easily incorporated into crystal lattices because of its small size and multi-dimensional H-bonding capabilities (Gillon et al. 2003). As such, water molecules can stabilise crystal structures when there is an imbalance in the number of acceptors and donors (Desiraju 1991b). In OZPN solvates, three environments of water were observed (Fig. 6.22), **Type 1, DD**: where water molecule acts as donor for two H-bonds, **Type 2, DDA**: where water molecule acts as a donor for two H-bonds and acceptor for one H-bond [indeed this is the most common environment found for water molecules in organic crystal structures in the CSD (Gillon et al. 2003)], **Type 3, DDAA**: where water molecule acts as donor as well as acceptor for two H-bonds

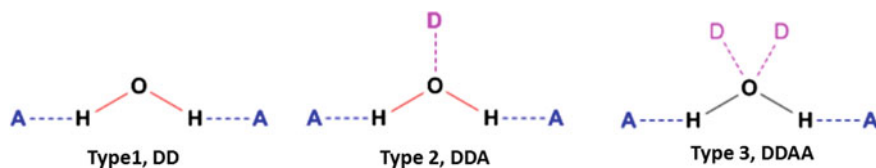


Fig. 6.22 Three water H-bonding environments observed in family of olanzapine solvate crystal structures, (D-Donor, A-acceptor). Weak interactions such as C-H...O were not included in the analysis. Reproduced from reference (Clarke et al. 2010)

each, thus forming four H-bonds. This is the 2nd most common environment for water molecule in organic crystal structures in the CSD (Gillon et al. 2003).

The packing analysis of solvates has been covered in Sect. 6.5. Here the specific hydrogen bonding interactions of OZPN dimers with water molecules and/or solvent in various packing types (based on SC₀, SC₁₁, SC₂₂, SC₃₁, SC₃₂ and SC₃₃, see Sect. 6.5) are described.

6.6.1 Hydrogen Bonding in Olanzapine Solvates Based on Packing Type SC₃₁

Mixed OZPN solvates that exist in group SC₃₁ have a minimum of one water molecule with the organic solvent in the asymmetric unit. OZPN dimers are connected by N1H-N4 hydrogen bond (instead of N1H-N2 in form I and II) mediated by water molecule present within the SC₂₁ sheets. Each OZPN molecule participates in two hydrogen bonds as in anhydrous forms but involving different acceptor site (N4) in H-bonding. Water molecules are present in type 2 and/or type 3 environments. OZPN 1,4-dioxane solvate hydrate is shown as an example of observed type 2 environment for water molecules in Fig. 6.23.

Each organic solvent molecule is surrounded by four pairs of centrosymmetric dimers of OZPN (four from two different SC₂₁ sheet), similar to a host-guest complex, where the solvent molecule acts as a guest. The solvent molecule is involved in hydrogen bonding and/or hydrophobic interactions with water and OZPN molecules (Fig. 6.23).

6.6.2 Hydrogen Bonding in Olanzapine Solvates Based on Packing Type SC₃₂

All OZPN solvates present in this group are anhydrous organic solvates. Methanol, ethanol and acetic acid solvates showed similar H-bond interactions (N1H...N4) to those of mixed solvates structures in SC₃₁ but mediated by a solvent molecule (Fig. 6.24).

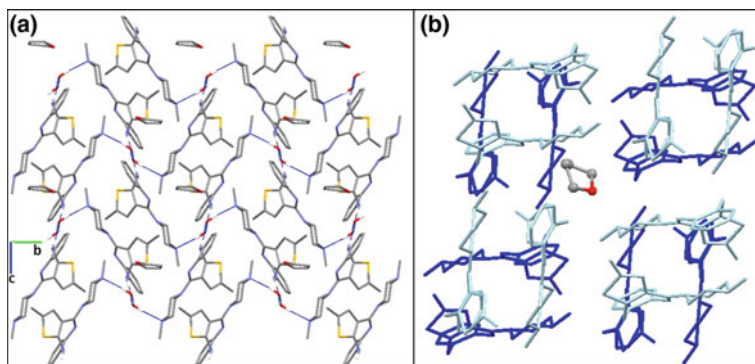


Fig. 6.23 **a** Hydrogen bonds (N1H...N4) between centrosymmetric dimers, conciliated by water molecules present within SC_{21} sheet of olanzapine 1,4-dioxane solvate hydrate. H-bonds are shown by *blue dotted lines* **b** organic solvent molecule surrounded by 4 pairs of centrosymmetric dimers from adjacent SC_{21} sheets (coloured by *blue* and *cyan*), arranged in a staggered manner. Other hydrogen atoms are omitted for clarity

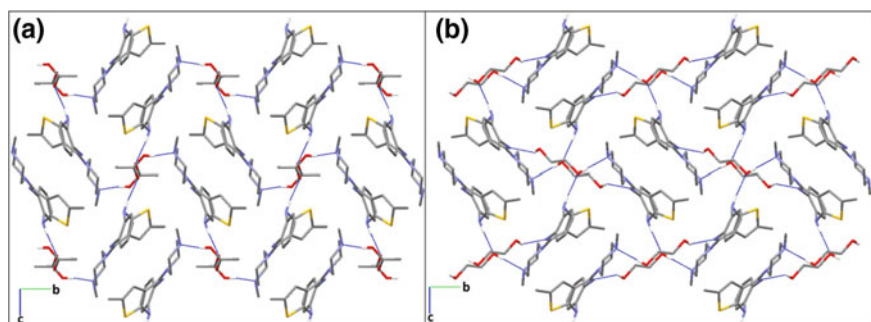


Fig. 6.24 **a** Olanzapine acetic acid solvate in which acetic acid links the centrosymmetric dimers through N1H...N4 H-bonds. **b** Olanzapine ethylene glycol solvate, where each olanzapine molecule is involved in three H-bonds (N1H, N2 and N4) with solvent molecules. H-bonds are shown by *blue dotted lines*. Other hydrogen atoms are omitted for clarity

In case of EG solvate and dihydrate B, each OZPN molecule takes advantage of one additional hydrogen bonding site (N1H, N2 and N4) (Fig. 6.24). In case of dihydrate B, water molecules are arranged as a catemer.

6.6.3 Hydrogen Bonding in Olanzapine Solvates Based on Packing Type, SC_{33}

All olanzapine solvates in this group are mixed solvates, i.e. organic solvent exists with at least one water molecule in the asymmetric unit. Water molecules were

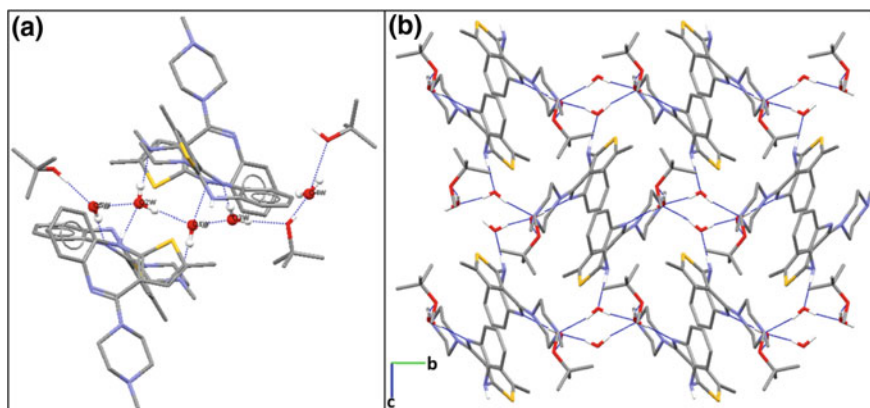


Fig. 6.25 **a** Catemer arrangement of water molecules in olanzapine t-butanol solvate hydrate. **b** Water molecules exist in type 2 environment in olanzapine TBMe solvate hydrate. H-bonds are shown by blue dotted lines. Other hydrogen atoms are omitted for clarity

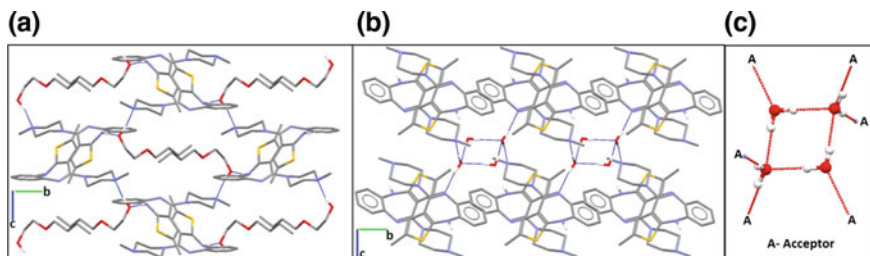


Fig. 6.26 H-bonding (N1H...N4) in **a** olanzapine 2-butoxyethanol solvate, **b** olanzapine dihydrate D, where water is present as cyclic tetramer, **c** cyclic tetramer, where water is present in type 2 and type 3 environments. H-bonds are shown by blue colour. Other hydrogen atoms are omitted for clarity

observed in a type 2 environment in all crystal structures except t-butanol solvate hydrate. In the t-butanol solvate hydrate, water molecules are arranged as catemer which shows all the three types of water environments (Fig. 6.25).

TBMe solvate hydrate is shown as an example of observed type 2 environment in Fig. 6.25. In each structure, OZPN molecule takes advantage of one additional hydrogen bonding site (N1H, N2 and N4) compared to anhydrous forms.

6.6.4 Hydrogen Bonding in Other Olanzapine Solvates Based on SC_0 , SC_{11} and SC_{22}

In 2-butoxyethanol solvate, the SC_0 dimers arrange themselves to accommodate the large 2-butoxyethanol molecules which connect OZPN dimers through N1H...N4

H-bonds (Fig. 6.26). In 2,2,2-trifluoroethanol solvate, in addition to the solvent mediated N1H...N4 hydrogen bond, each solvent molecule also forms H-bond with the N2 of OZPN molecule. In case of 2-butanol hydrate, water molecules are present in a type 2 environment and each OZPN participates in three H-bonds. In Dihydrate D, each OZPN forms three H-bonds (N1H, N2 and N4) with water molecules, which are arranged as a cyclic tetramer and are present in type 2 and 3 environments (Fig. 6.26).

6.7 Prediction of Olanzapine Solvate Formation Using Random Forests Classification Model

XPac analysis (see Sect. 6.5) revealed that the SC₂₁ sheets are present in 28 solvates out of 35 and gives rise to three 3-D molecular packings based on SC₃₁, SC₃₂ and SC₃₃ (Fig. 6.27). SC₃₂ and SC₃₃ differ in the separation distance between neighbouring SC₂₁ sheets. In the case of SC₃₁, the distance between SC₂₁ sheets is similar to that of SC₃₂, but the neighbouring SC₂₁ sheets are shifted by one molecule relative to each other along the t_1 axis. In other words, SC₂₁ sheets pack in either a staggered or an eclipsed manner in SC₃₁ and SC₃₂, respectively.

The solvent molecules occupy the void spaces between the SC₂₁ sheets in solvates based on SC₃₁ and SC₃₃ and within the SC₂₁ sheet in case of solvates based on SC₃₂ (Fig. 6.28). Therefore, it was of interest to explore the effect of the solvent molecules on the three observed 3-D molecular packing types in the 28 experimental crystal structures and to confirm if the solvent molecules are directing the crystal packings of the solvates. To achieve this, RF (see Sect. 5.1.4) technique was employed to develop a classification model to correlate calculated solvent physicochemical properties with the three 3-D molecular packing types observed in the crystal structures of OZPN solvates.

6.7.1 Random Forests Classification Model – Prediction Results

RF classification model (see Sects. 5.1.4 and 6.2.4) trained using all 250 physicochemical descriptors of solvents, showed an overall error rate of 25 with 100 %

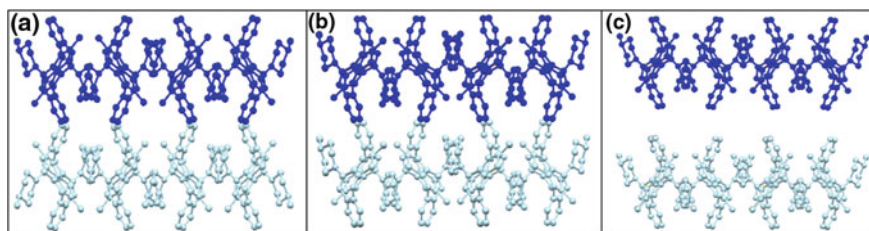


Fig. 6.27 Three 3-dimensional supramolecular constructs, **a** SC₃₁, **b** SC₃₂ and **c** SC₃₃, formed by SC₂₁ sheets (coloured by cyan and blue colour) in olanzapine solvates

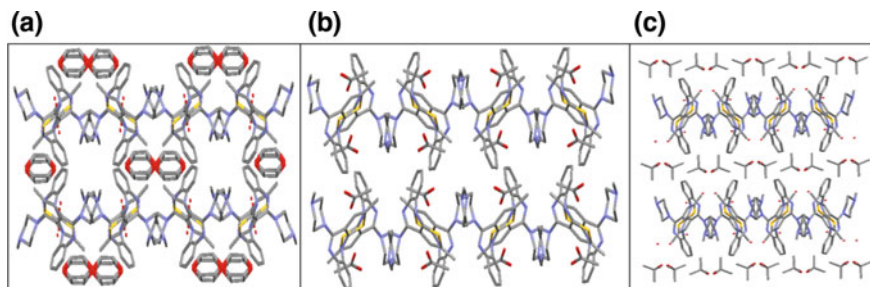


Fig. 6.28 Representative crystal structures of olanzapine solvates based on **a** SC_{31} -olanzapine-1,4-dioxane solvate hydrate; **b** SC_{32} -Olanzapine-acetic acid solvate and **c** SC_{33} -Olanzapine-TBMe hydrate; showing the position of solvent molecules within the crystal lattice

accurate prediction rates for OZPN solvates based on SC_{33} (Fig. 6.29). The confusion matrix summarising the prediction error associated with each 3-D molecular packing type (class) is shown in Table 6.8.

The MDS plot (see Sect. 5.1.4) (Fig. 6.30) obtained from the RF classification proximity matrix represents the molecular packing types as two orthogonal clusters. Points represented by red, green and blue colour correspond to OZPN solvates based on SC_{31} (class 1), SC_{32} (class 2) and SC_{33} (class 3), respectively.

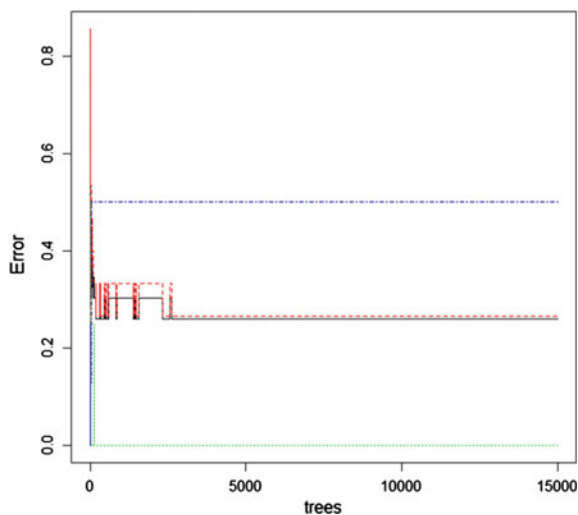
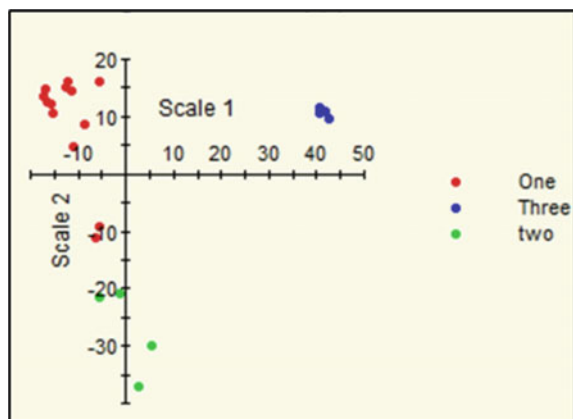


Fig. 6.29 Plot of Random Forest classification error for molecular packing types of olanzapine solvates. The *black line* represents the error associated with the overall model. *Red, blue and green lines* represent the error associated with the molecular packing type classes; SC_{31} , SC_{32} and SC_{33}

Table 6.8 Confusion matrix generated from Random Forest classification for the three molecular packing types of olanzapine solvates

Predicted →	Class 1 (SC ₃₁)	Class 2 (SC ₃₂)	Class 3 (SC ₃₃)	Class error (%)
Observed ↓				
Class 1(SC ₃₁)	12	4	0	25
Class 2 (SC ₃₂)	2	2	0	50
Class 3 (SC ₃₃)	0	0	4	0

**Fig. 6.30** The MDS plot obtained from the Random Forest classification proximity matrix. Each of the 24 points represents a olanzapine solvate and is coloured according to crystal packing type: class 1 (red), class 2 (green) and class 3 (blue)

These results indicate that the physicochemical properties of the solvents are directing the crystal packing in OZPN solvates. The OZPN solvates in class 3 have been classified with 100 % accuracy, although there is an overlap in the classification of solvates in class 1 and class 2. Four OZPN solvates present in class 1 (methanol solvate, dihydrate E, acetonitrile solvate hydrate and nitromethane solvate hydrate) are classified into class 2 and two OZPN solvates present in class 2 (acetic acid and ethanol solvates) are classified in class 1. It is worth considering why the model failed to predict accurate classes for 6 OZPN solvates.

All the data corresponding to these 6 solvents were removed from the training dataset and the model was trained using the remaining training dataset. Subsequent predictions of molecular packing type of OZPN solvates with these 6 solvents were carried out using the new RF model. Nitromethane and acetonitrile have been given

a prediction probability slightly in favour of class 2 (54.5 and 56.1 % for nitromethane and acetonitrile respectively) compared to class 1 (44.9 and 43.6 % for the nitromethane and acetonitrile, respectively). This model suggests that acetonitrile and nitromethane have a slightly higher probability of forming solvates with OZPN in class 2.

According to this model, methanol and water have been given prediction probabilities for solvate formation with OZPN in favour of class 2 as compared to class 1. Experimentally, methanol and water form solvates with OZPN in class 1 as well as in class 2 depending upon the crystallisation conditions (see Sect. 6.4.2). The developed RF classification model does not take account of crystallisation conditions and particularly, for methanol and water, crystallisation conditions e.g. residual water in the solvent of crystallisation, % RH, and temperature dictate the crystallisation outcome i.e. molecular packing type in resulting OZPN solvates.

The RF model suggests that ethanol and acetic acid have a higher tendency of forming solvates with OZPN in class 1 (with a prediction probability of 69.5 and 72.6 % for ethanol and acetic acid respectively) but still have some probability of forming solvates with OZPN in class 2 (with a prediction probability of 30.5 and 27.4 % for ethanol and acetic acid respectively). Experimentally, OZPN ethanol solvate exhibits both types of molecular packing (see Sect. 6.4.2).

This model was then further tested to predict the packing type for solvents next to ethanol in terms of alkyl chain length and branching. In experimental screening, 1-propanol, 1-butanol and 1,2-propanediol formed solvates with OZPN in the class 1 (see Sect. 6.4.2). Similar probability ratios as that of ethanol were obtained for 1-propanol and 1,2-propanediol for both the classes (1 and 2) which suggests that 1-propanol and 1,2-propanediol might also form solvates with OZPN based on SC₃₂. The prediction probability for 1-butanol was 90 % for class 1 which indicates that it has a higher probability of forming solvate in class 1 than in class 2.

Based on the results obtained so far, it can be hypothesised that because of the different interplanar spacing between SC₂₁ sheets of OZPN, solvent molecules bigger than 1,2-propanediol cannot be accommodated within the SC₂₁ sheets or between eclipsed SC₂₁ sheets to give rise to packing based on SC₃₂. Alternatively, the driving force would be towards forming packing based on SC₃₁, where alternate SC₂₁ sheets are arranged in a staggered manner. This packing arrangement leaves a bigger space to accommodate larger solvent molecules than the other two packings based on other SCs and is also stabilised by water molecules located within the SC₂₁ sheets. Solvent molecules smaller than 1,2-propanediol can adopt any of the two packing types (SC₃₁ and SC₃₂) depending on the crystallisation conditions.

Further experiments are desirable to confirm whether acetonitrile, nitromethane, 1-propanol and 1,2-propanediol would form solvates with OZPN based on SC₃₂ perhaps by crystallisation using anhydrous solvents. Similarly further investigations are required to confirm whether acetic acid can form a solvate with OZPN based on SC₃₁ perhaps by crystallisation in presence of water.

OZPN solvates based on SC₃₁ and SC₃₃ have water molecules in the asymmetric unit and so the effect of incorporation of water on the predictive capability of the RF classification model was also investigated. The same results were obtained after taking account of water as a categorical descriptor (present/not present) and even by taking it as a numerical descriptor whose value was equivalent to the number of water molecules in the asymmetric unit of the respective OZPN solvate.

6.7.2 Important Solvent Physicochemical Descriptors for Random Forests Classification Model of Olanzapine Solvates

With specific reference to molecular packing type, the RF classification also provided a rank dependence of OZPN solvate classification on solvent descriptors. The most important descriptors were found to be SMR (molecular refractivity which is a measure of the total polarisability of the molecule), apol (sum of the atomic polarisabilities), vdW_vol (van der Waals volume) and b_count (number of covalent bonds).

The variable dependency plots (Fig. 6.31, Table 6.9) indicate that the packing based on SC₃₃ is favoured by large solvent molecules and these can be easily distinguished from other solvent molecules forming solvates in other two classes (numerical values of descriptors are provided in Table 6.9). Smaller solvent molecules like water and methanol favour the packing based on SC₃₂. Although there is some overlap in values of descriptors of the solvents forming solvates based on SC₃₁ and SC₃₂ (Table 6.9). Depending on the crystallisation conditions (RH, residual water in crystallisation solvent, temperature and supersaturation) some solvents that form solvates based on SC₃₂ can form solvates based on SC₃₁ with OZPN.

To summarise, the developed RF classification model suggests that the crystal packing of OZPN solvates is dependent on the physicochemical properties of the solvent molecules incorporated in the crystal lattice. Largest solvent molecules tend to form solvates based on SC₃₃ and using this classification model, these can be predicted more accurately than the solvents which tend to form solvates based on SC₃₁ and SC₃₂. This model also suggests that the solvent molecules bigger than 1,2-propanediol have a higher tendency to exhibit packing based on SC₃₁. Solvent molecules smaller than 1,2-propanediol can exhibit packing based on both SC₃₁ and SC₃₂ depending on the crystallisation conditions. Further crystallisation experiments are required to confirm this.

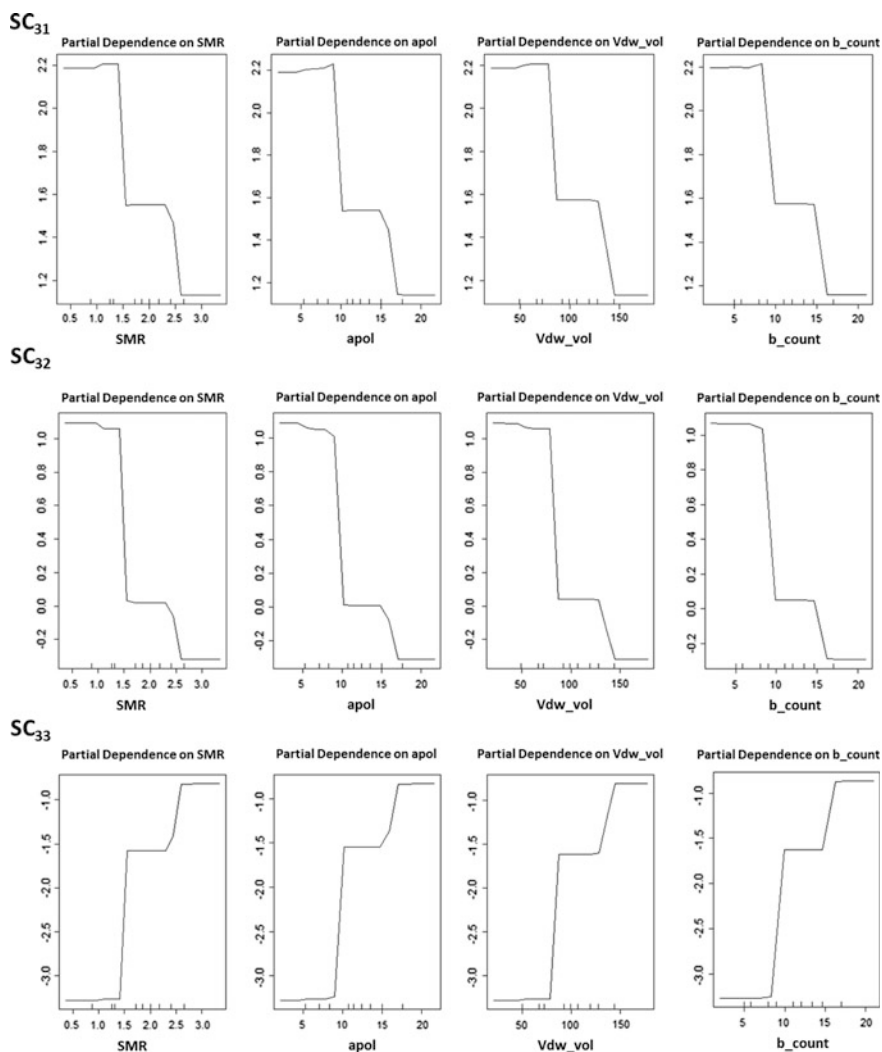


Fig. 6.31 Variable dependency plots (SMR, apol, VdW_vol and b_count) for molecular packing types, SC₃₁, SC₃₂ and SC₃₃. Numerical values for solvent descriptors are summarised in Table 6.9

Table 6.9 Numerical values of solvent descriptors obtained from variable dependency plots generated during Random Forests classification of olanzapine solvates

Packing type	SMR	apol	VdW_vol	b_count
SC ₃₁	0.8–2.4	5.2–14.5	59.0–132.9	5–15
SC ₃₂	0.3–1.3	<8.3	<72.5	<8
SC ₃₃	>2.6	>17.6	>144.6	>17

6.8 Crystal Energy Landscape of Olanzapine

The computational search (Fig. 6.32) found both the experimentally observed non-solvated polymorphs, reproducing the structures well (Fig. 6.33). Both are present in the low energy region below about -125 kJ mol^{-1} , in the crystal energy landscape.

Above this value there are a plethora of crystal structures whose relative lattice energies are sufficiently high to suggest that they are less likely to be viable experimental forms. Hence this crystal energy landscape is reasonably realistic, though there is some uncertainty in the relative energies.

The crystal energy landscape shows that there are other structures which are competitive in energy with the known forms and this is generally consistent with the observation of polymorphism and multiple solvates of this molecule. The global minimum corresponds to a structure with a different conformation (conformation B, Fig. 6.4) from the experimental structures, although low energy computed structures based on the A-conformer do tend to be more efficiently packed than those based on the alternative, B. The majority of the structures on the landscape do not contain the SC_0 motif that is found in all of the experimental polymorphs and

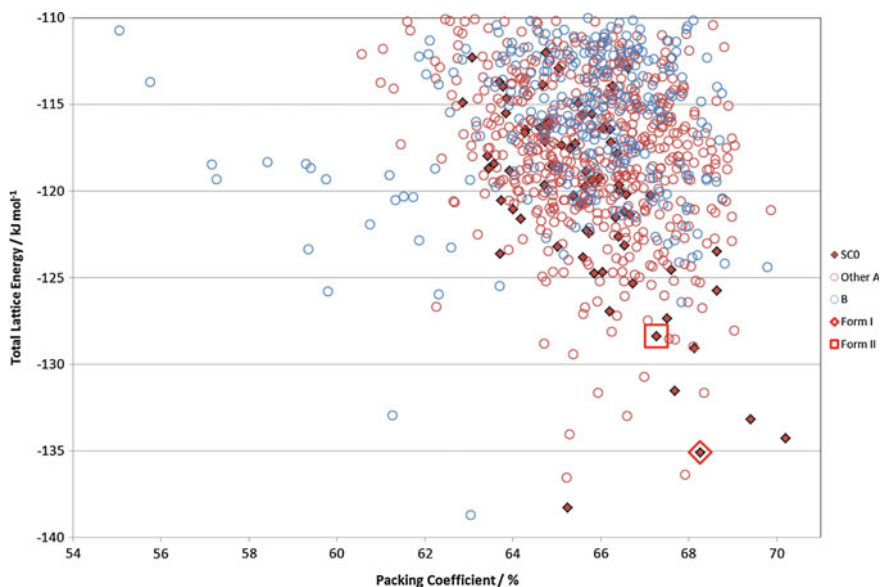


Fig. 6.32 Summary of crystal structure search for olanzapine. Each point represents a crystal structure classified by the conformational region, A or B, as defined in Fig. 6.4, and whether it contains the centrosymmetric dimer SC_0 . The open red diamond and square symbols denote lattice energy minima corresponding to experimental structures, forms I and II respectively. The crystal energy landscape is comprised of the structures below -125 kJ mol^{-1} . A11 and A45 are the computed structures corresponding to form I and II respectively

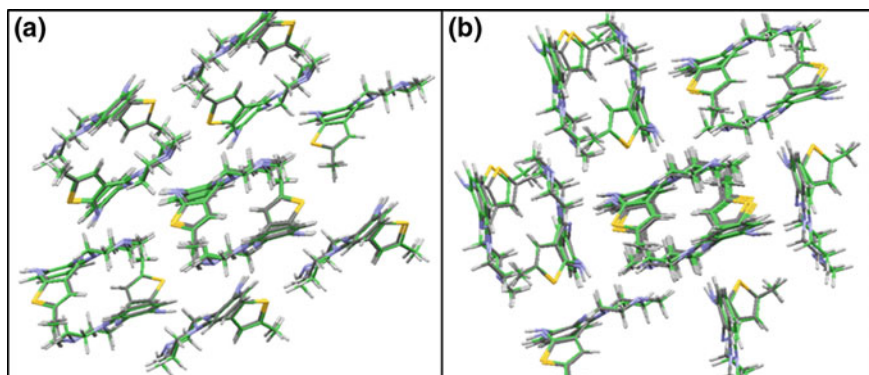


Fig. 6.33 Overlay of **a** experimental form I (colour by element) with A11 (green) and **b** experimental form II (colour by element) with A45 (green). The RMSD_{15} of these overlays are **a** 0.170 Å and **b** 0.225 Å

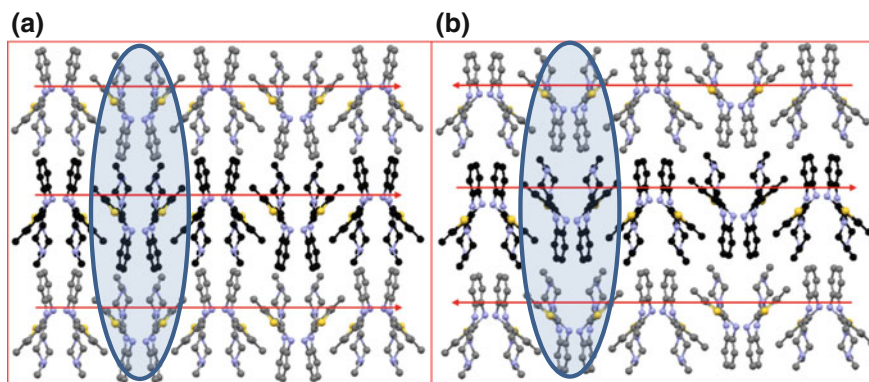


Fig. 6.34 Comparison of **a** form I (calculated structure A11) and **b** calculated structure A1392, showing the arrangements of the common 2-D SCs; SC_{23} (based on stacking of SC_{12}). The constructs are viewed along the axis of the t_6 vector with the t_8 axis (red arrows) running left-right across the page for the central layers, which are shown in black. In form I the upper and lower layers (grey) stack in parallel to the middle layer (black) while in A1392 they are rotated such that the top and bottom layers pack with opposite direction to that of the central layer. SC_{23} is not defined in Fig. 6.18, as it only occurs in one of the experimental structures, i.e. form I

solvates observed to date. The predictions therefore provide evidence that alternative packing arrangements are thermodynamically competitive. This suggests that kinetic effects are responsible for all the observed structures being based on the centrosymmetric dimer.

Another notable feature of the landscape is the occurrence of low energy structures that display 2-D similarity with the different layers found in form I and form II but with alternative stackings and consequent differences in interlayer

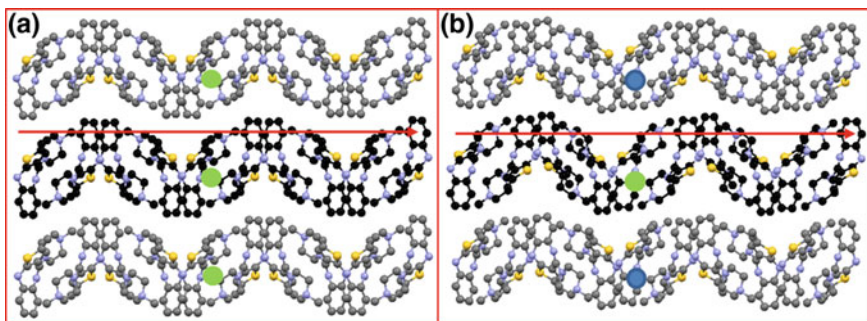


Fig. 6.35 Comparison of **a** form II and **b** A162, showing the arrangement of the common 2-D SC, SC_{24} . The central constructs (*black*) are viewed along the axis of the t_{11} vector (shown by the *green circles*) with the t_{10} axis running *left-right* across the page as indicated by the *red arrows*. The upper and lower layers in form II (*grey*) run parallel with t_{11} axis of the central construct while in A162 alternate layers pack in opposite directions ($-t_{11}$ indicated by the *blue circles*). SC_{24} , not shown in Fig. 6.18 as this 2-D construct was only observed in form II of the experimental structures included in the XPac analysis

hydrocarbon-hydrocarbon interactions. For example, the hypothetical structure A1392 shows 2-D similarity to form I (SC_{23}) and the different arrangement of layers in these two structures is shown in Fig. 6.34.

Similarly, A162 and form II share a 2-D SC, SC_{24} however; the structures differ in the relative orientations of this layer (Fig. 6.35). The lattice energy difference between form I and A1392 (3.56 kJ mol^{-1}) is relatively large, producing a significant thermodynamic driving force favouring growth based on the stacking of form I. In contrast, the small difference of 1 kJ mol^{-1} between form II and A162 suggests this change in stacking may be thermodynamically competitive.

The lack of availability of a suitable single-crystal or phase-pure polycrystalline samples of form III has precluded attempts to define in detail the structural relationship between forms II and III. In an alternative approach to identify a reliable structural model for form III, the unit cell and space group of each of the 50 lowest-energy predicted structures were used along with the form II unit cell in a series of two-phase Pawley-type refinements [using TOPAS version 3 in batch mode, (Coelho 2003)] against the best available mixed-phase form III pattern (desolvated DCM solvate; $\sim 20\%$ form II). The best visual and statistical fit was obtained with A162 ($R_{wp} = 6.152$, Fig. 6.36). The observed fit suggests a degree of similarity, however the refinement did not account for several observed peaks attributed to form III. Thus, A162 is not a reliable structural model for form III and either the unit cell or space group is incorrect. Thus, assuming that form III is a $Z' = 1$ ordered crystal structure, as indicated by the SS-NMR (Reutzel-Edens et al. 2003), it was either missed in the search, or was sufficiently similar to A162 for the clustering algorithms to have not considered the structures unique.

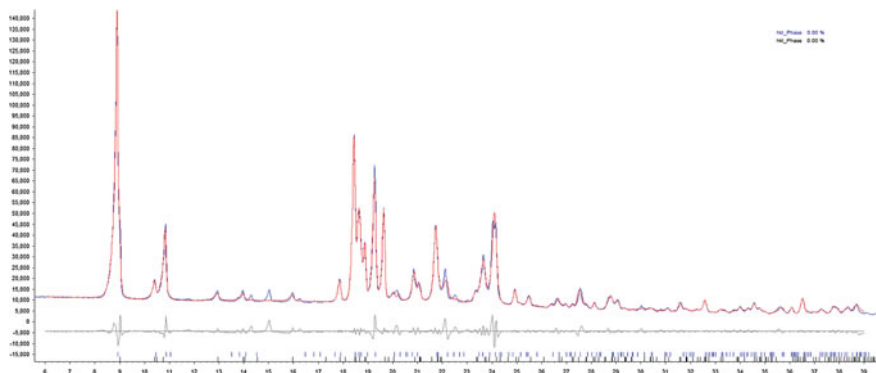


Fig. 6.36 Multi-phase Pawley fit of unit cell of A162 against XRPD data of mixture of form III (major) and II (minor), observed profile (*blue*), calculated profile (*red*) and difference plot (*black*) in the range of 6–39° 2 θ . $R_{wp} = 6.152$

6.9 PIXEL Calculations on Olanzapine

The PIXEL calculations provide an alternative method of estimating the intermolecular contributions to the lattice energy, based on the interactions between the electronic density in a model of its charge distribution. The intermolecular lattice energy difference between forms I and II varies from 0.7 to 5 kJ mol⁻¹ depending on whether 298 or 123 K experimental structures or the 0 K computational lattice energy minimum is used in the calculations (Table 6.10), emphasising the sensitivity of this energy to the precise geometry of the crystal. However, the PIXEL calculations clearly show that by far the largest contribution to crystal stabilisation comes from dispersion energy (E_d).

Table 6.10 Partitioned intermolecular interaction energies (kJ mol⁻¹) from the PIXEL calculations of form I and II structures at 298 K, 123 K and 0 K

Structure	Temperature (K)	E_c^a	E_p^b	E_d^c	E_r^d	E_t^e	Density g cc ⁻¹
Form I	298	-67.0	-32.3	-180.7	139.0	-141.0	1.296
	123	-75.5	-38.3	-200.3	170.3	-143.8	1.340
	0	-57.3	-27.6	-168.4	124.1	-129.2	1.263
Form II	298	-64.6	-40.6	-179.7	139.2	-145.7	1.279
	123	-74.9	-42.3	-194.1	168.1	-143.1	1.308
	0	-47.1	-25.4	-165.3	113.6	-124.2	1.241

^aElectrostatic (Coulombic) energy

^bPolarisation term

^cDispersion term

^dRepulsion term

^eTotal intermolecular interaction energy, $E_t = E_c + E_p + E_d + E_r$

Table 6.11 Intermolecular interaction energies (kJ mol^{-1}) for the top three ranked pair-wise interactions in experimental form I and II at 298 K, 123 K and in predicted form I and II at 0 K

Structure	Temperature (K)	Rank ^a	E_C	E_p	E_d	E_r	E_t	COM (\AA) ^b
Form I	298	1st	-19.9	-11.3	-93.5	63.7	-60.9	4.019
	123	1st	-26.4	-15.7	-104.3	81.7	-64.7	3.929
	0	1st	-19.0	-9.9	-87.5	57.4	-59.0	4.127
	298	2nd	-44.4	-20.1	-52.7	66.7	-50.5	6.440
	123	2nd	-45.7	-21.6	-57.1	75.9	-48.5	6.376
	0	2nd	-34.8	-15.5	-47.9	53.4	-44.7	6.552
	298	3rd	-3.2	-1.4	-18.8	9.3	-14.0	10.388
	123	3rd	-7.0	-3.7	-18.5	18.5	-10.8	9.739
	0	3rd	-2.0	-0.9	-14.9	5.6	-8.7	10.400
Form II	298	1st	-22.3	-13.7	-95.9	70.0	-61.9	4.042
	123	1st	-26.4	-17.2	-104.4	85.0	-62.9	3.977
	0	1st	-20.0	-10.2	-91.2	62.3	-59.0	4.145
	298	2nd	-35.1	-16.8	-50.0	56.3	-45.6	6.593
	123	2nd	-39.6	-19.4	-53.2	66.6	-45.6	6.553
	0	2nd	-21.5	-11.5	-45.5	43.8	-34.7	6.617
	298	3rd	-5.3	-2.9	-22.9	16.2	-14.8	9.913
	123	3rd	-6.7	-3.8	-24.2	20.1	-14.6	9.854
	0	3rd	-3.7	-1.7	-19.5	10.4	-14.5	10.000

^aRank contribution of a pair of molecules to the overall intermolecular interaction energy in the structure studied

^bDistance between the centres of mass of the two molecules (\AA)

The PIXEL calculations on form I, II identified several dimer arrangements within the 2.5 kJ mol^{-1} threshold. Analysis of the crystal packing in terms of the individual pairwise molecular interactions (Table 6.11, Fig. 6.37) shows that the overall intermolecular energy in each form is dominated by the contribution from SC_0 , which is predominantly stabilised by the E_d .

This centrosymmetric dimer, which is a top contributor towards stabilising energy may be regarded as one of the fundamental structure units directing the assembly of OZPN molecules in crystal lattice (Dunitz and Gavezzotti 2005). The 2nd ranked pairwise intermolecular interaction, which includes contributions from the N1H ... N4 hydrogen bond, is over 10 kJ mol^{-1} less favourable in forms I and II at all temperatures. These two molecule-molecule interactions are significantly more favourable than the others within the coordination shell.

Dispersion forces clearly have a key role in directing the pairwise assembly of OZPN molecules to form the SC_0 unit that underpins all of the experimental structures. PIXEL calculations on two non-dimer based low energy computed structures (A1 and A30) were carried out to explore the relative contributions of the pairwise intermolecular interactions in the absence of the dispersion stabilised SC_0 . As with forms I and II, the total interaction energy is dominated by the E_d (Table 6.12).

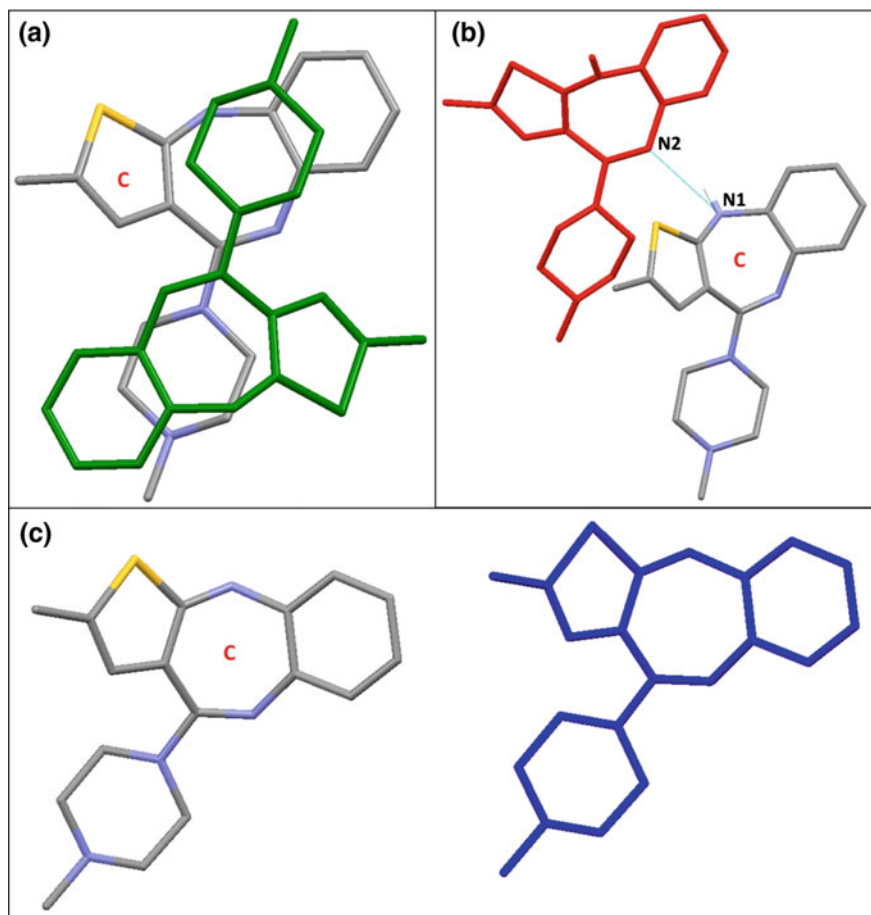


Fig. 6.37 Top three pairwise intermolecular interactions in form I and form II, quantified in Table 6.11. The central molecule (colour by atom type and labelled as 'C') interacts with neighbouring molecule to form a **(a)** centrosymmetric dimer, SC₀, **(b)** molecular pair involving hydrogen-bond (N1-H ... N2), and **(c)** molecular pair involving weaker molecule-molecule interaction

Table 6.12 Partitioned intermolecular interaction energies (kJ mol⁻¹) from the PIXEL calculations of hypothetical structures A1 and A30

Structure	E _C	E _p	E _d	E _r	E _t
A1	-57.8	-28.7	-167.7	121.2	-133.0
A30	-78.9	-40.0	-158.2	157.6	-119.4

Table 6.13 Intermolecular interaction energies (kJ mol^{-1}) for the top two ranked dimer interactions in computed structures, A1 and A30 at 0 K

Structure	Rank	E_C	E_p	E_d	E_r	E_t	COM (\AA)
A1	1st	-26.9	-13.9	-34.6	42.8	-32.6	8.594
A30	1st	-58.1	-31.5	-51.3	101.4	-39.5	7.184
A1	2nd	-11.4	-4.5	-34.4	19.1	-31.2	8.105
A30	2nd	-13.2	-4.8	-47.1	33.4	-31.7	6.536

However the largest interaction in the coordination sphere is significantly smaller than that in the SC_0 dimer in forms I and II (by a factor of 0.55 for A1 and 0.67 for A30) and is dominated by the contribution of electrostatic energy (E_C) contribution associated with alternative the N1-H...N4 hydrogen bonds (Table 6.13).

6.10 Concomitant Appearance of Form III with Other Polymorphs of Olanzapine

It seems highly likely that the crystal structure of form III is also based on SC_0 . SS-NMR (Reutzel-Edens et al. 2003), Raman and IR provides supporting evidence that the structures of forms II and III are closely related. Although the hypothetical structure A162 is not a reliable structural model for form III, the similarities observed from comparison with the powder data and the small energy and structural difference from form II, suggest that form III is based on an alternative packing of the layers in form II (Fig. 6.35). This type of structural similarity implies that it would be challenging to find conditions to nucleate them separately, which is supported by current and previous (Reutzel-Edens et al. 2003) experimental results. Indeed the small energy difference between the two ways of stacking the layers of form II implies that there could be a range of structures, differing in the sequence of the two types of stacking that would be competitive in energy; however, no evidence of such disorder in stacking is apparent in XRPD patterns. Although single-crystals of form II have been produced by growth from the vapour phase, form III has never been obtained in pure form and is always observed to co-exist with form II, though never with form I alone. There are several explanations for the concomitant occurrence of these two OZPN polymorphs that include the promotion of nucleation of one form by another through structural templating at the face of the seed form (Tao et al. 2007) or as a form of cross-nucleation at errors in the formation of the interlayer interactions, as seen for ROY (Chen et al. 2005) or via a nucleation mechanism that gives rise to polymorphic domains as observed for aspirin (Bond et al. 2007). In the experiments conducted in this study that produced form III (in situ desolvation, vapour phase crystallisation and grinding) it has not been possible to establish even a qualitative distinction between the growth kinetics of forms II and III, with both forms appearing simultaneously within the temporal resolution of the measurements.

6.11 Prolific Solvate Formation of Olanzapine

The experimental search has highlighted the extensive tendency of OZPN to form crystalline solvates and mixed solvates forming a total of 56 different solvated forms. In a study of solvate formation based on entries in the CSD, molecules with non-coplanar aromatic rings were found to be one of three categories of molecules with a higher than average tendency to form solvates (van de Streek 2007). Thus OZPN solvate formation appears to be related to the shape of the benzodiazepine moiety with the SC_0 dimers able to form a range of extended structures that can host a wide range of solvent molecules, stabilising the structure through filling void space and/or hydrogen bonding to surrounding OZPN molecules. The majority of solvates (38/56) are mixed solvates that include at least one water molecule as well as the organic solvent within the asymmetric unit. In four cases, methanol, ethanol, DCM and 2,2,2-trifluoroethanol, both solvate and solvate hydrate forms have been obtained depending on the crystallisation method used. In all the mixed solvate structures water is hydrogen bonded to adjacent OZPN molecules, presumably due to its ability to act as a small orientational flexible probe for favourable electrostatic interactions i.e. it can fill a void and fulfil H-bond interactions inaccessible to the larger and more constrained organic solvent.

The crystal energy landscape (Fig. 6.32) also highlights that OZPN molecules have no one good way of packing to give a dense structure, which is consistent with the prolific tendency to form solvates. A large number of the experimental solvates (28/35 structures available for analysis) are based on SC_{21} with the space between SC_{21} layers able to accommodate a broad range of solvent molecule sizes, shapes and physicochemical properties.

Computational desolvation calculations were used to investigate the role of solvent in structures based on SC_{31} (1-butanol hydrate), SC_{32} (dihydrate B; AQOMAU01) and SC_{33} (t-butanol hydrate) which all share 2-D similarity via SC_{21} . “In silico desolvation” involved removing all the atoms relating to the solvent and relaxing the structure with the CrystalOptimizer model described previously in Sect. 6.3 (in which the first step, with the molecule held rigid, will usually eliminate much of the void space formerly occupied by solvent) and subsequently refining within the Polarisable Continuum Model. This is not a simulation of desolvation, but more an analysis of the effect of the solvent on the OZPN-OZPN interactions in the solvates. The calculations minimised the structures obtained after removal of the solvent molecule and resulted in structures that are quite high up on the energy landscape confirming that the interactions between SC_{21} layers are relatively unfavourable in the absence of solvent. The solvent molecules are actively stabilising the solvate structures, by hydrogen bonding and other favourable interactions to OZPN molecules. This is reflected in the stability of the majority of the solvates to desolvation under ambient conditions.

The stabilisation of the solvates by solvent molecules is not just a density packing effect as observed in some published reports (Price et al. 2006; Roy et al.

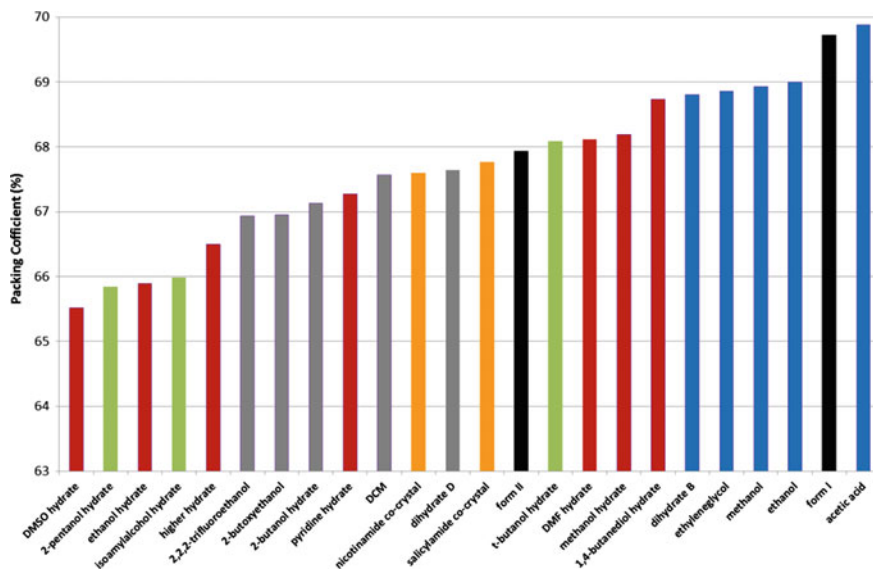


Fig. 6.38 Packing coefficient (%) for the non-solvated polymorphs (*black*), co-crystals (*orange*) and solvates of OZPN. Solvate structures are coloured according to structural relationships. Specifically, SC₃₁, SC₃₂ and SC₃₃ are shown by *red*, *blue* and *green bars*

2012), Inspection of the packing efficiency for the various known structures of OZPN (Fig. 6.38) shows that the solvates do not generally have a significantly better packing coefficient than the non-solvated forms.

6.12 Challenges with Crystal Structure Prediction of Olanzapine and Unobserved Calculated Structures

Considering the uncertainty in the relative energies of the structures on the crystal energy landscape (Fig. 6.32), the results are consistent with the experimental observations that form I is the thermodynamically most stable single component phase. PIXEL calculations show that the intermolecular lattice energy is dominated by the dispersion contribution. This universal attractive force is particularly challenging for computational methods to evaluate reliably, and its contribution to the lattice energy increases quite markedly with density (as shown by the PIXEL results in Table 6.10). The problem with evaluating the dispersion contribution between the different parts of the OZPN molecule, contributes in part to the uncertainty in the conformational energy penalty between type A and B structures. Whilst the CSP accurately predicts the structures of both experimental polymorphs amongst the most thermodynamically stable structures, specific alternative predicted structures remain unobserved despite extensive experimental screening. Thus, under the

experimental conditions tested, OZPN apparently favours only a subset of all the feasible packings (molecules in conformation A) arranged in the SCs (SC_0 dimer exclusively observed) and lattices identified in the predicted crystal energy landscape. This could be because this calculated crystal energy landscape underestimates the stabilising role of the SC_0 dimer in the formation of experimental structures. Alternatively, during crystallisation the barrier to rearranging to form the dimers in the form I, II or III packing is sufficiently small that the alternative structures cannot be kinetically trapped as metastable polymorphs. Many of the low energy structures have packing features in common with forms I and II, which may mean that there is no mechanism for nucleating and growing these hypothetical structures in competition with form I. Alternatively, the experimental searches to date may simply not have included conditions that can promote the formation of alternative structures. Another possibility is that solvate formation offers a highly competitive alternative to the formation of many non-solvated predicted structures.

6.13 Summary

In this chapter, systematic experimental screening in conjunction with the calculation of the crystal energy landscape using high level theoretical models has been applied to the antipsychotic drug OZPN. An extensive experimental search for solid forms of OZPN identified 60 distinct solid forms including three non-solvated polymorphs (thermodynamically stable form I and metastable forms II and III), 56 crystalline solvates and an amorphous phase. However, no conditions could be identified to produce phase pure samples of the metastable polymorph III and its crystal structure remains elusive. It seems that form III is based on SC_0 and SS-NMR, IR and Raman provide evidence that it is closely related to form II and further work is required to confirm this.

XPac analysis of the 35 experimental crystal structures (30 from this study and 5 from the CSD) containing OZPN showed that they all contain a specific, dispersion-bound, dimer structure, SC_0 , which can adopt various arrangements that accommodate diverse solvents to produce structures with a similar, moderate, packing efficiency to form I. PIXEL calculations showed that the overall intermolecular energy in OZPN polymorphs is dominated by the contribution from SC_0 . Thus, SC_0 can be regarded as the fundamental structural unit which directs the assembly of crystalline aggregates in OZPN crystal formation. Structural similarity analysis using XPac provides a rationale of desolvation products of various OZPN solvates by highlighting the close relationships between the forms and desolvated 'end product'. RF classification revealed that the calculated molecular refractivity, polarisabilities, number of covalent bonds and van der Waals volume of the solvent molecules are responsible for the molecular packing types in OZPN solvates based on SC_{21} . Solvents which tend to form molecular packing type SC_{33} can easily be distinguished from solvents which tend to form molecular packing types SC_{31} and SC_{32} .

The CSP studies found and reproduced both the experimentally observed non-solvated polymorphs on the crystal energy landscape. CSP studies identified a hypothetical structural type that offers an explanation for the inability to obtain the metastable forms II and III separately. It is plausible that form III contains the same SC₂₄ layers as form II, but stacked in the alternative manner similar to the hypothetical structure, A162, which is only slightly less stable than form II.

Crystal energy landscape shows that the prolific solvate formation of OZPN is due to the inability of OZPN to pack with an efficiency of more than 70 % and explains the role of solvent in stabilising solvate structures using computational desolvation studies. H-bonding analysis also revealed that the solvent molecules actively stabilise the crystal lattice of OZPN solvate via hydrogen bonding and other favourable interactions and solvate formation is not solely based on space filling, as shown by the packing efficiency calculations. Due to their small size and orientational freedom, water molecules play a specific role in stabilising the OZPN solvate structures and are present in various H-bonding environments.

The CSP calculations also found thermodynamically feasible structures that do not contain the SC₀. The inability to obtain these forms despite a diverse range of experimental studies suggests that the rapid kinetics of dimer formation in solution are responsible for all the observed structures based on the dimer. The experimental challenge remains to achieve sufficient control over molecular self-assembly to promote the formation of alternative growth units that lead to a specific, thermodynamically feasible structure. Whilst comprehensive screening has enhanced the ability to identify multiple forms more completely and in a shorter period of time, CSP methods showed that there may be an opportunity to move beyond physical form discovery based on ease of formation, to target the selection of specific crystal structures using the information that they appear thermodynamically feasible.

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Chapter 7

Exploring the Physical Form Landscape of Clozapine, Amoxapine and Loxapine

7.1 Introduction

A detailed investigation of solid form diversity of olanzapine (OZPN) which belongs to group 1 (see Sect. 2.1, Fig. 7.1) using various experimental and computational approaches has been described in Chap. 6. This chapter describes the results of physical form screening of clozapine (CZPN, group 1), loxapine (LXPN, group 2) and amoxapine (AXPN, group 2) (see Sect. 2.1, Fig. 7.1) using multiple crystallisation techniques. CSP studies were used as a complement to experimental screening for these three molecules. Investigation of the experimental crystal structures using PIXEL calculations has identified the dominant pairwise intermolecular interactions and provided a basis to investigate the effect of substituents and solvent incorporation on the dominant intermolecular interactions in the crystal structures of these molecules. In this context it is of particular interest to contrast the different solid-state landscapes and the respective crystal structures for molecules within each group to understand the structural factors that may influence similarities and differences in the packing of these closely related molecules (Fig. 7.1).

While it may be expected that small changes in substituents lead to changes in solid-state diversity or crystal packing, the magnitude of these changes and resultant physicochemical properties remains unpredictable (see Sect. 1.10). Hence it is of continued interest to study solid form diversity of structurally related pharmaceutical compounds. Each of the molecules mentioned above (Fig. 7.1) exhibit different reported levels of solid form diversity in terms of the reported numbers of polymorphs and solvates. Given the extent of previous crystallisation studies is not always apparent there is a need to carry out further investigations to confirm whether reported structures are representative of the actual solid-state properties of the molecule rather than any limitation in the scope of previous crystallisation searches.

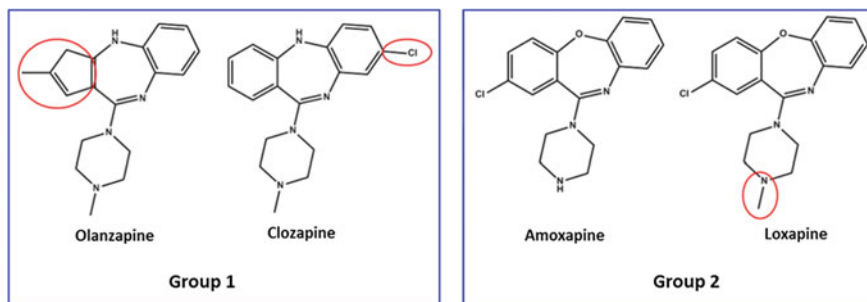


Fig. 7.1 The four compounds studied in this thesis. Differences in the chemical structures within a group are highlighted in red

7.1.1 Background of Molecule in Group 1-Clozapine

CZPN, [8-chloro-11-(4-methyl-1-piperazinyl)-3H-dibenzo(b,e)(1,4) diazepine], is a benzodiazepine derivative and an atypical antipsychotic drug used in the treatment of schizophrenia, which affects approximately 1 % of the world's population (Jablensky et al. 1987). It is effective against treatment-resistant schizophrenia (Ashby and Wang 1996). Crystal structures of CZPN [CSD refcode: NDNHCL01 (Petcher and Weber 1976) and NDNHCL10 (Fillers and Hawkinson 1982b)] have been reported. The crystal structure of CZPN monohydrate was independently determined as a part of this doctoral research at the same time as a published report (Siva Lakshmi et al. 2011). Crystal structures of four arylmethyl analogues of CZPN (Capuano et al. 2000, 2005, 2010), a monohydrate of 2-chloro isomer of CZPN (Petcher and Weber 1976) and a dihydrobromide salt (Fillers and Hawkinson 1982b) are also available in the CSD.

7.1.2 Background of Molecules in Group 2-Amoxapine and Loxapine

AXPN and LXPN are benzoxazepine derivatives, and differ structurally from one another by a methyl group at position 4 on the piperazine ring. AXPN [2-chloro-11-(1-piperazinyl)-dibenz(b,f)(1,4)oxazepine] has anti-depressant properties (Greenbla and Osterber 1968) with only one reported crystal structure (CSD refcode: AMOXAP) (Cosulich and Lovell 1977). LXPN [2-chloro-11-(4-methyl-1-piperazinyl)dibenz(b,f)-(1,4)oxazepine] acts as a tranquilising agent (Latimer 1969) and is used in the treatment of schizophrenia or bipolar disorder. It is reported to exist in two polymorphic forms (CSD refcode: NDOCLH10 and NDOCLH01 respectively) (Petcher and Weber 1976; Cosulich and Lovell 1977) with no reported hydrates/solvates. It is marketed as a succinate salt whose crystal structure has been determined (Fillers and Hawkinson 1982a).

The methyl group at 4th position of piperazine ring is responsible for the different spectrum of biological activity i.e. anti-schizophrenic versus anti-depressant for LXPN and AXPN respectively. Comparison of the crystal forms and their structures therefore also allows the effect of this methyl group on the solid-state diversity of these two molecules to be studied.

7.2 Experimental Details

7.2.1 *Principal Component Analysis of Solvent Properties*

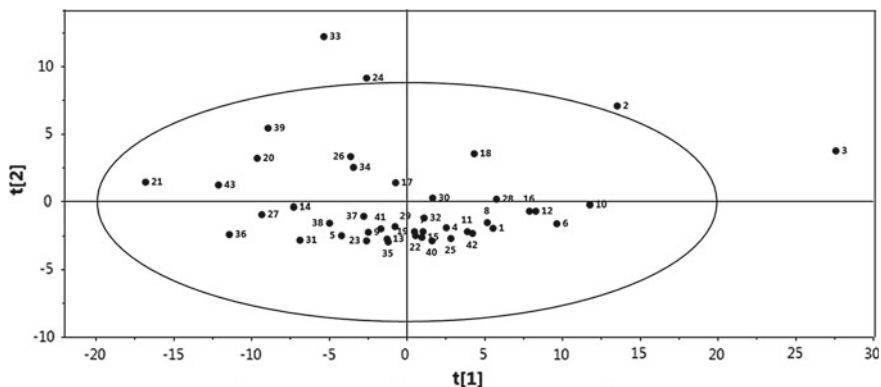
In order to select a diverse range of solvent properties for an efficient and effective crystallisation search a solvent classification approach was utilised. A PCA (see Sect. 5.1.2) of solvent property diversity was carried out using the SIMCA package (version 13.0) (Umetrics) (SIMCA 2012) by inputting calculated physicochemical properties of the solvents. 2-D and 3-D physicochemical descriptors for solvents were calculated using MOE (MOE 2002). Descriptors which showed zero variance and covariance (threshold of Pearson correlation coefficient >90 %) were removed. All the data were reduced to two principal components (t[1] and t[2]) that described 69.8 % of the total variance in solvent properties (observations, n = 43 and descriptors = 250) (Fig. 7.2). The 2-D scatter plot from PCA provides a convenient means of cluster identification and/or visualisation of the crystallisation results as a function of solvent identity (Florence et al. 2006).

7.2.2 *Crystallisation Experiments of Clozapine*

The experimental screen was based on solution crystallisations using 43 solvents selected from the PCA (see Sect. 7.2.1). In addition to solution crystallisation, other crystallisation techniques were also used (see Sect. 3.2). A total of 157 individual crystallisations were carried out (Table 7.1).

7.2.3 *Crystallisation Experiments of Amoxapine*

The experimental screen was based on solution crystallisations using 47 solvents selected from the PCA (see Sect. 7.2.1). Other crystallisation techniques (see Sect. 3.2) were also used to maximise the crystallisation search space. A total of 138 individual crystallisations were carried out (Table 7.2).



ID	Solvent	ID	Solvent	ID	Solvent
1	1,5-pentanediol	16	Isobutyl acetate	31	Ethanol
2	1-methyl naphthalene	17	Pyridine	32	Ethyl acetate
3	Dodecane	18	Toluene	33	Carbon tetrachloride
4	N-methyl-2-pyrrolidone	19	1,4-dioxane	34	2,2,2-trifluoro ethanol
5	Dimethyl sulphoxide	20	Nitromethane	35	Tetrahydrofuran
6	2-butoxy ethanol	21	Water	36	Methanol
7	N,N-dimethyl acetamide	22	2-butanol	37	Methyl acetate
8	Cyclohexanol	23	1-propanol	38	Acetone
9	N,N-dimethyl formamide	24	Trichloroethylene	39	Dichloromethane
10	Pentyl acetate	25	1,2-dimethoxyethane	40	Diethyl ether
11	3-methyl-1-butanol	26	1,2-dichloroethane	41	1,2-propanediol
12	Butyl acetate	27	Acetonitrile	42	2-methoxy-2-methylpropane
13	2-methoxy ethanol	28	Cyclohexane	43	Methanoic acid
14	Acetic acid	29	2-butanone		
15	1-butanol	30	1-chlorobutane		

Fig. 7.2 Principal component analysis score plot of solvent physicochemical properties, shown with an *ellipse* that represents the Hotelling T2 with 95 % confidence. 1-methylnaphthalene, dodecane, trichloroethylene and carbon tetrachloride were outliers from the 95 % confidence limit. Each *number* in the plot represents one solvent as mentioned below the *score plot*

7.2.4 Crystallisation Experiments of Loxapine

A limited experimental screening was carried out for LXPN due to material and time constraints. The experimental screen was based on solution crystallisations using 32 solvents selected from the PCA (see Sect. 7.2.1). A total of 96 individual crystallisations were carried out (Table 7.3).

Table 7.1 Summary of the manual crystallisation techniques used in the experimental search for physical forms of clozapine

Crystallisation technique	Crystallisation method	Number of crystallisations
Solution crystallisation, $T_{\text{sat}} = \text{RT}$	Solvent evaporation in vials and on watch glass at RT	73
Solution crystallisation, $T_{\text{sat}} = \text{B.P.} - 10 \text{ K}$	Cooling to 298 K	32
Neat/liquid-assisted grinding (using Retsch MM400 mixer mill or cryo mill)		36
Crystallisation from vapour phase		6
Melt quenching		4
Recrystallisation from amorphous		4
Freeze drying		2

T_{sat} = temperature at which the saturated solutions were prepared, B.P. = boiling point of the solvent

Table 7.2 Summary of the manual crystallisation techniques used in the experimental search for physical forms of amoxapine

Crystallisation technique	Crystallisation method	Number of crystallisations
Solution crystallisation $T_{\text{sat}} = \text{RT}$	Solvent evaporation in vials at RT and at 277 K	70
Solution crystallisation $T_{\text{sat}} = \text{B.P.} - 10 \text{ K}$	Cooling to 298 K	44
Neat/liquid-assisted grinding (using Retsch MM400 mixer mill)		10
Crystallisation from vapour phase		6
Melt quenching		4
Recrystallisation from the amorphous		4

T_{sat} = temperature at which the saturated solutions were prepared, B.P. = boiling point of the solvent

Table 7.3 Summary of the manual crystallisation conditions used in the experimental search for physical forms of loxapine

Crystallisation techniques	Crystallisation method	Number of crystallisations
Solution crystallisation $T_{\text{sat}} = \text{RT}$	Solvent evaporation in vials and on watch glass at RT	64
Solution crystallisation $T_{\text{sat}} = \text{B.P.} - 10 \text{ K}$	Cooling to 298 K	32

T_{sat} = temperature at which the saturated solutions were prepared, B.P. = boiling point of the solvent

7.2.5 Preliminary Crystal Structure Prediction Studies for Clozapine, Amoxapine and Loxapine

Preliminary CSP studies on CZPN, AXPN and LXPN were carried out to provide a view of thermodynamically feasible packing arrangements. A simple rigid molecule search using MOLPAK/DMACRYS (Holden et al. 1993; Price et al. 2010) with the molecular conformation optimised at the PBE0/6-31G(d,p) level (Fig. 7.3), with multipoles calculated from the charge density at the same level. Searches were carried out in space groups $P1$, $P-1$, $P2_1$, $P2_1/c$, $P2_12_12$, $P2_12_12_1$, $Pna2_1$, $Pca2_1$, $Pbca$, $C2/c$, Cc and $C2$, the 12 most common space groups observed for molecules of this size (Kazantsev et al. 2011a, b, c) in the CSD.

7.2.6 Solid-State Calculations Using CASTEP

Density Functional Theory (DFT) calculations were carried out using CASTEP (version 4.3 and 5.0) (Clark et al. 2005) on the LXPN hydrogen succinate crystal structure determined from XRPD data. The input files were prepared and results were visualised using Material Studio (MS) software suite (© Accelrys) (version 5.5) interface to CASTEP. Geometry optimisation calculations were carried out using the Broyden-Fletcher-Goldfarb-Shannon (BFGS) algorithm. The lattice parameters and space group symmetry were kept fixed during all the calculations. Exchange-correlation potential was described using a generalised gradient approximation (GGA-PBE). Medium convergence criteria (tolerances of energy per atom, maximum forces and maximum displacement were 0.00002 eV/atom, 0.05 eV/Å and 0.002 Å respectively) were used. Ultrasoft pseudopotentials were used for core electrons as they allow calculations to be performed at the lowest possible cut-off energy for the plane wave basis set. Depending on the size of the

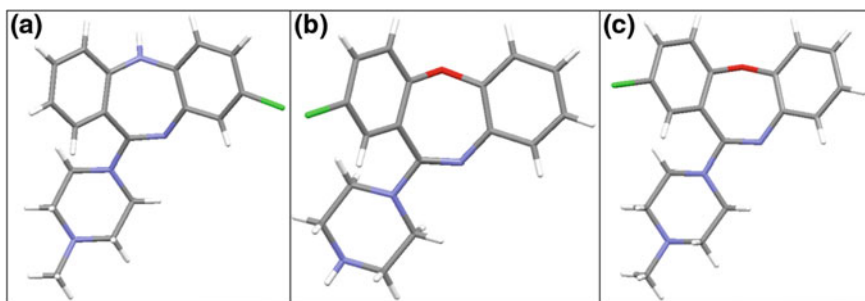


Fig. 7.3 Conformation 'A' of **a** clozapine, **b** amoxapine and **c** loxapine used for preliminary crystal structure prediction study and is also present in the experimental crystal structures (CSD refcodes: NDNHCL01, AMOXAP and NDOCLH01 for clozapine, amoxapine and loxapine respectively)

unit cell, the number of k-points employed for sampling was automatically calculated by the MS interface. CASTEP calculations were carried out by distributing on the National Grid Server (UK) facilities and results were analysed using the MS visualiser.

7.2.7 Structure Analysis

All the samples obtained from the crystallisation screens were analysed using XRPD/SXD, thermal analyses and Raman spectroscopy as described in Sects. 3.2.1–3.2.4 of Chap. 3. PIXEL calculations and molecular packing analyses were also carried out using the techniques outlined in Sects. 3.2.5–3.2.6 of Chap. 3.

7.3 Results and Discussion

7.3.1 Physical Form Screening of Clozapine

Across all crystallisation conditions (Sect. 7.2.1), the known anhydrous form (same as the starting material), one monohydrate, two solvates [N,N-dimethylacetamide (DMA) and ethylene glycol (EG)] and an amorphous form were obtained. No polymorphs of CZPN were observed.

Of the 105 solution crystallisations carried out, 5 (4.8 %) yielded no sample for XRPD analysis due to poor solubility. Of the remaining 100 samples giving measurable diffraction, 6 were identified as monohydrate, 6 were mixtures of anhydrous form and monohydrate, 3 were recognised as solvates, and 3 were non-crystalline (i.e. they gave no diffraction). All the remaining 82 single phase samples were the known anhydrous form.

After neat grinding of CZPN either at RT or at 77 K, no phase transformation was observed. Solvent assisted grinding of CZPN at RT was carried out using 32 solvents. CZPN monohydrate was obtained after grinding with water and the remaining 31 solvents returned the known anhydrous form. No change was observed after grinding at 77 K in the presence of methanol.

The outcomes of each crystallisation technique are represented by a series of scatter plots (Figs. 7.4 and 7.5). Each point in the plot is positioned according to the value of $t[1]$ and $t[2]$ from the solvent property PCA score plot (Fig. 7.2, see Sect. 7.2.1) and coloured according to the crystallisation outcome. A detailed listing of the form(s) identified from each recrystallised sample is provided in the Appendix (Tables A.11–A.14).

The novel solvated forms obtained comprise a monohydrate, DMA and EG solvates of CZPN. Crystal structures of all the four physical forms were determined by SXD and the lattice parameters are tabulated in Table 7.4. Crystal data, data collection and refinement details are provided in Table A.15 of the Appendix.

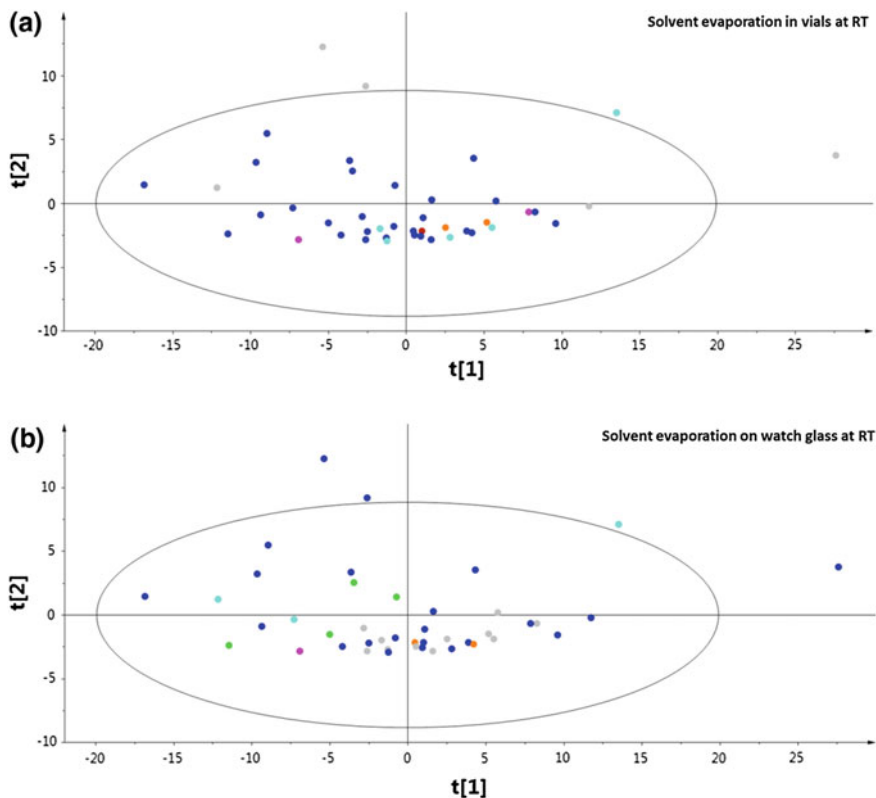


Fig. 7.4 Scatter plot of solvents with positions according to the value of $t[1]$ and $t[2]$ from Fig. 7.2 and coloured according to crystallisation outcome: clozapine anhydrous form (*blue*), clozapine monohydrate (*magenta*), mixture of clozapine anhydrous form and clozapine monohydrate (*green*), amorphous (*orange*), no sample obtained (*cyan*) and solvated form (*maroon*). Solvents not used in crystallisation condition are coloured *grey*. Plots shown for crystallisation conditions listed in Table 7.1: **a** solvent evaporation in vials at RT and **b** solvent evaporation on watch glass at RT

In contrast to OZPN (Chap. 6), no evidence of polymorphism was obtained for CZPN and it has a significantly lower propensity for solvate formation. The powder diffraction patterns of all novel forms are shown in Fig. 7.6. The XRPD patterns of these forms are unique and do not show signs of isostructurality as observed in OZPN solvates.

STA shows that CZPN melts at 457–458 K with no other thermal transition between RT and the melt (Fig. 7.7). The CZPN monohydrate and DMA solvate lose water and DMA with onset temperatures of ~ 340 and ~ 372 K, respectively, before melting at 458 K (Fig. 7.7). Due to insufficient quantity of the ethylene glycol solvate being available, STA could not be carried out.

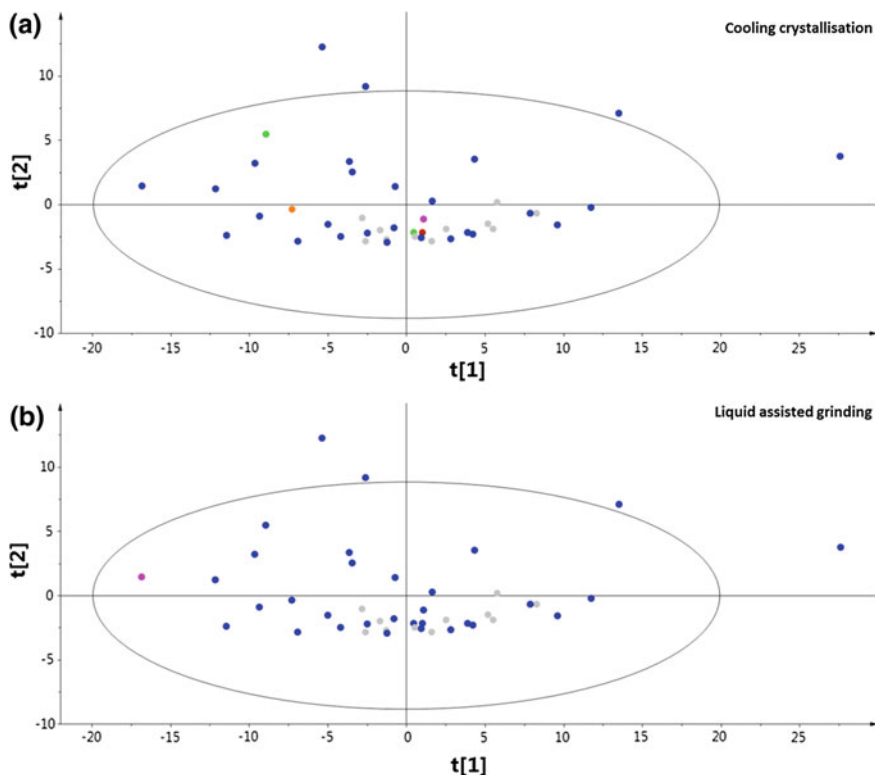


Fig. 7.5 Scatter plot of solvents with positions according to the value of $t[1]$ and $t[2]$ from Fig. 7.2 and coloured according to crystallisation outcome: clozapine anhydrous form (*blue*), clozapine monohydrate (*magenta*), mixture of clozapine anhydrous form and clozapine monohydrate (*green*), amorphous phase (*orange*), no sample obtained (*cyan*) and solvated form (*maroon*). Solvents not used during crystallisation condition are coloured *grey*. Plots shown for crystallisation conditions listed in Table 7.1: **a** cooling crystallisation and **b** liquid-assisted grinding

There is no evidence that solvate desolvation leads to the formation of further polymorphs. Small exotherms with an onset at ~ 411 and ~ 423 K in the case of DMA solvate and monohydrate could be due to recrystallisation of partial amorphous form created after desolvation. Further in-situ VT-XRPD experiments are required to confirm this.

7.3.1.1 Molecular Packing Analysis of Physical Forms of Clozapine

Molecular packing analyses of all the experimental and a few predicted crystal structures of OZPN have been described in Sect. 6.5 of Chap. 6. This section describes the molecular packing analysis using XPac and Mercury (see Sect. 3.2.6)

Table 7.4 Lattice parameters for clozapine crystal structures obtained in the experimental search (standard uncertainties in parentheses)

Structure ID	Form (CZPN: solvate)	Space group	Stoichiometry CZPN: solvent	<i>a</i> (Å)	<i>b</i> (Å)	<i>c</i> (Å)	β (°)	Cell volume (Å ³)
1	CZPN	<i>P</i> 2 ₁ 2 ₁ 2 ₁	NA	9.328(7)	9.632(7)	17.836 (13)	90.00	1603.0(2)
2	CZPN_monohydrate	<i>P</i> 2 ₁ / <i>c</i>	1:1	9.915(3)	16.365(4)	10.920(3)	102.23(1)	1731.6(1)
3	CZPN_N,N-dimethylacetamide (DMA)	<i>P</i> <i>bca</i>	1:1	8.866(4)	17.542(7)	28.124(1)	90.00	4374.0(3)
4	CZPN_ethylene glycol (EG)	<i>P</i> 2 ₁ / <i>c</i>	1:1	20.628(1)	10.849(1)	17.502 (1)	93.13(2)	3911.0(3)

All parameters were determined from single-crystal diffraction data collected at 123(2) K

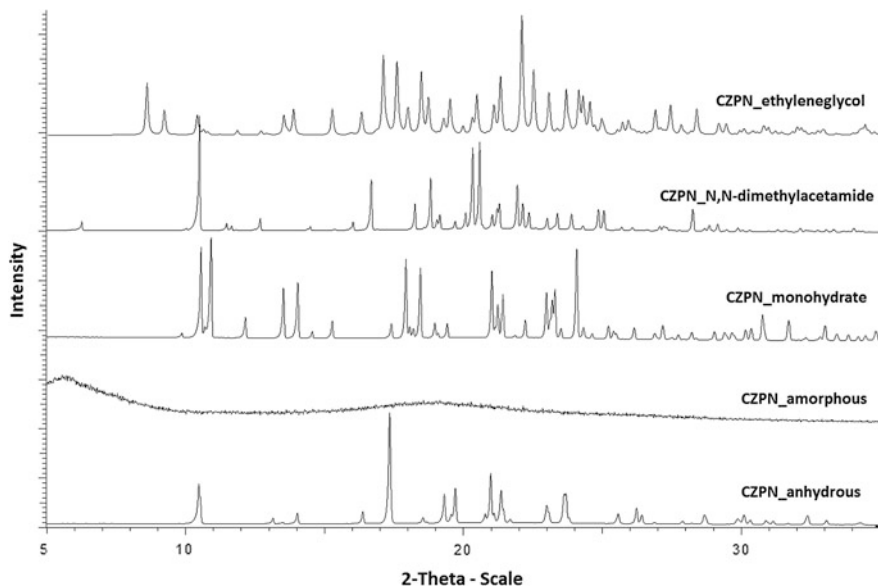


Fig. 7.6 Stack plot of XRPD patterns of physical forms of clozapine observed during experimental screening in the range of 5–35° 2θ

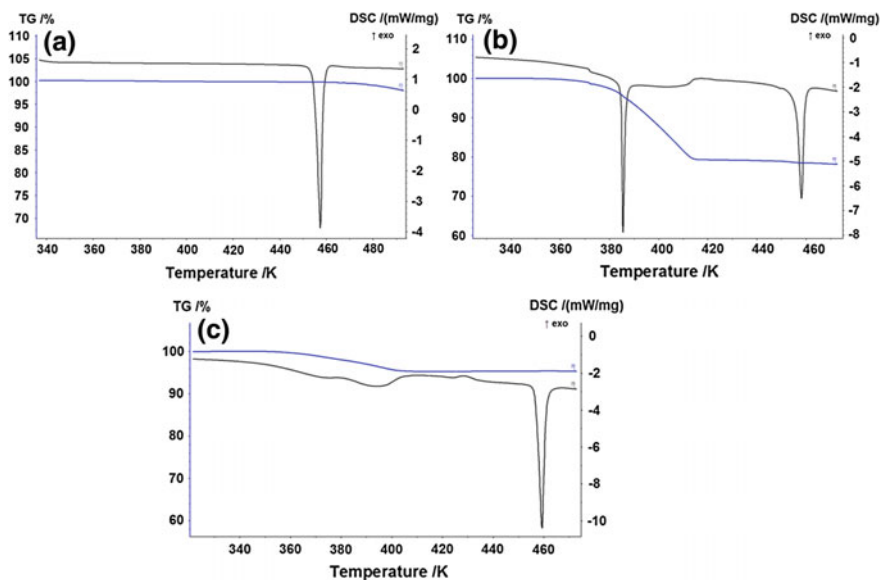
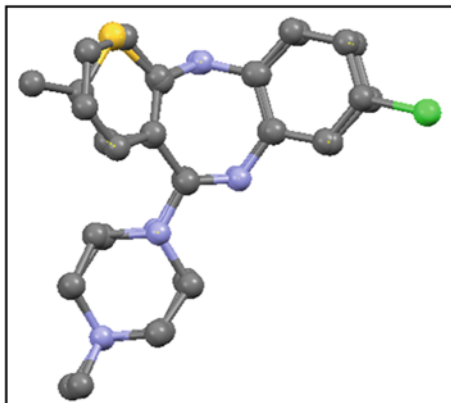


Fig. 7.7 STA thermograms of **a** clozapine anhydrous form, **b** clozapine N,N-dimethylacetamide and **c** clozapine monohydrate. DSC and TG curves are shown by *black* and *blue* colour, respectively

Fig. 7.8 Overlay of the molecular conformations of olanzapine and clozapine which are present in the experimental crystal structures (RMSD of non-hydrogen atoms = 0.21 Å)



carried out on the experimental crystal structures of CZPN to investigate the effect of the substituents and chemical modifications on the molecular conformation and packing motifs.

Both OZPN and CZPN exhibit similar molecular conformation in all the experimental crystal structures (Fig. 7.8). In this conformation the diazepine ring exists in a puckered conformation between the planes of the two phenyl rings, and the piperazine ring adopts a chair conformation with the methyl group in an equatorial position.

Molecular Packing in Anhydrous Form of Clozapine

In the anhydrous form of CZPN, only one enantiomer is present in the crystal lattice as compared to all the known OZPN crystal structures where both mirror related enantiomers are present in the crystal lattice. The CZPN molecules form side-ways dimers in which they are arranged in an edge to face arrangement (Fig. 7.9a, b) as compared to the SC_0 (face to face arrangement of OZPN molecules) observed in all OZPN known crystal structures (see Chap. 6) and in other physical forms of CZPN explained later in this section (e.g. monohydrate and EG solvate).

These side-ways dimers stack to form columns along the *a*-axis. These columns arrange themselves in a corrugated manner to make the 3-D structure. The CZPN dimers between the columns are connected via N1-H...N2 H-bond (Fig. 7.9c). Each CZPN molecule in the dimer is involved in two H-bonds with two other CZPN molecules from the adjacent dimers. A detailed PIXEL analysis of intermolecular interactions in the crystal lattice is presented in Sect. 7.3.1.3.

Molecular Packing Analysis of Clozapine Solvates

In the DMA solvate, each CZPN molecule forms a hydrogen bond with the DMA molecule (N1-H...O). The CZPN molecules form two types of chains (each

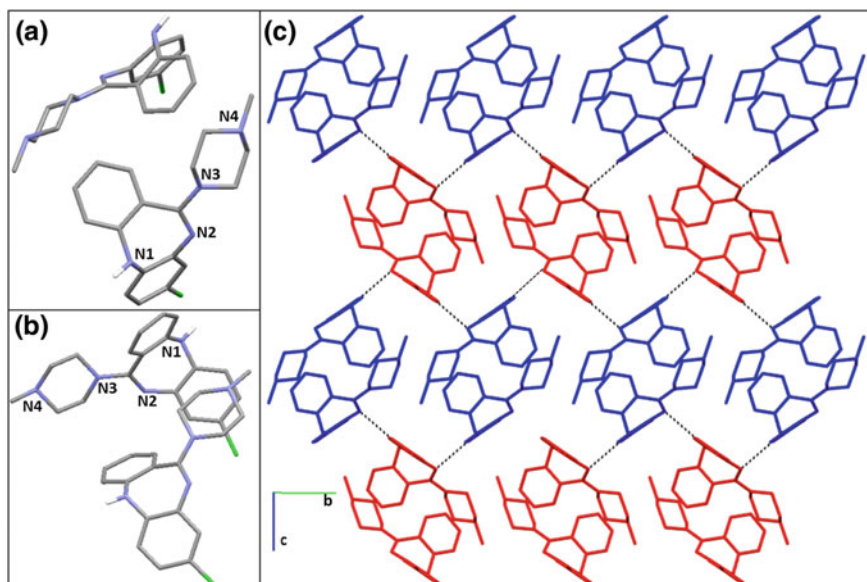


Fig. 7.9 **a, b** Two views of the dimer formed by clozapine molecules, **c** 3-D arrangement of columns of clozapine dimers. Active H-bonds between dimers are shown by *dotted black lines*. Other hydrogen atoms are omitted for clarity

consists of one enantiomer) along the *c*-direction (Fig. 7.10a). Two types of chains stack antiparallel to each other to form 2-D sheets which further stack in a staggered manner (Fig. 7.10b).

In both CZPN monohydrate and CZPN EG solvate, CZPN molecules form a centrosymmetric dimer which is similar to the SC_0 present in all crystal structures of OZPN (see Chap. 6). In the CZPN monohydrate structure, centrosymmetric dimers form columns along the *a*-axis. These columns stack in a zig-zag manner to create the 3-D structure (Fig. 7.11a). Water molecules are present between the columns and connect the centrosymmetric dimers of parallel columns. Each CZPN molecule is involved in three H-bonds with three water molecules (Fig. 7.11a).

The asymmetric unit of CZPN EG solvate consists of two CZPN and two EG molecules in which one of the EG molecules is disordered. The centrosymmetric dimers form columns along the *b*-axis (Fig. 7.11b). Each CZPN molecule is involved in three H-bonds with three EG molecules similar to the solvent interactions in CZPN monohydrate.

The CZPN monohydrate and CZPN EG solvate share 1-D similarity as revealed by the XPac analysis. The 2-D similarity between CPZN monohydrate and EG solvate is lost because of the larger size of EG molecules (molecular volume— 92 \AA^3) present between the columns compared to the smaller water molecules (molecular volume— 24 \AA^3). No other similarity at any level was observed amongst the four CZPN crystal structures and is therefore, not discussed further.

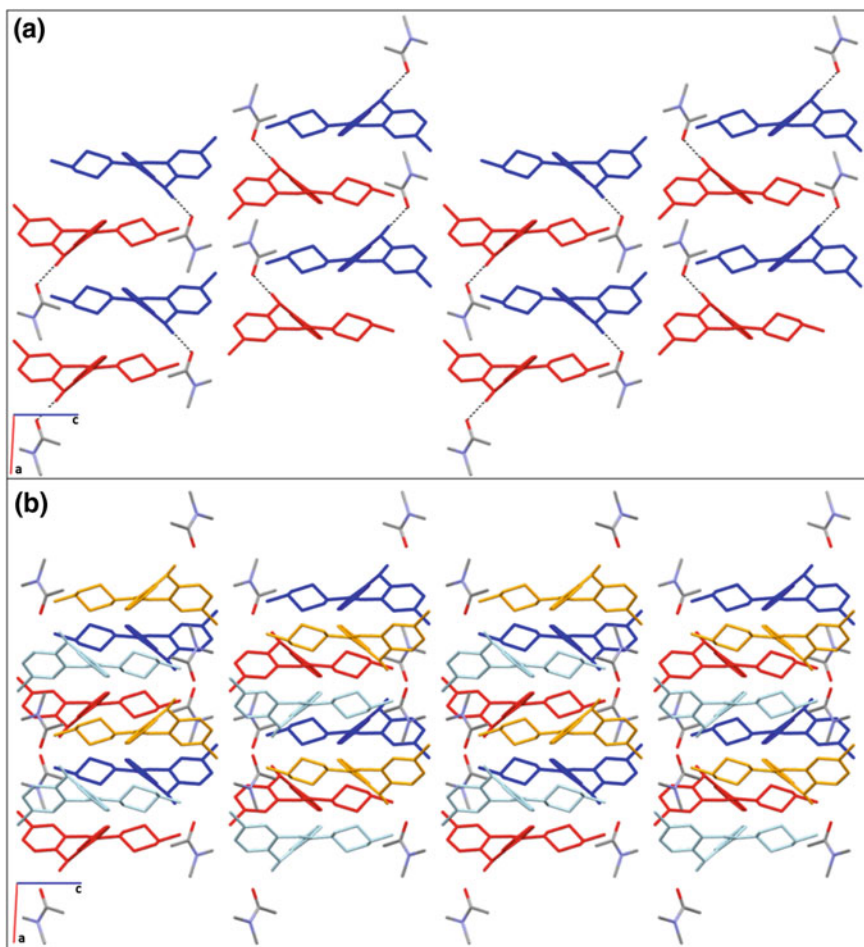


Fig. 7.10 **a** 2-D sheet structure formed by the two antiparallel chains of clozapine molecules (shown by red and blue colour) and N,N-dimethylacetamide molecules. H-bonds are shown by black dotted lines. **b** 3-D arrangement of sheets. All the hydrogen atoms are omitted for clarity

Comparison of Crystal Structures of Clozapine and Olanzapine

Two of the CZPN crystal structures (monohydrate and EG solvate) share only 0-D similarity (i.e. centrosymmetric dimer) with OZPN crystal structures but no packing similarity was observed amongst the anhydrous structures.

Packing efficiencies of form I of OZPN (packing coefficient = 69.7 %) and CZPN (packing coefficient = 69.3 %) are similar whereas form II of OZPN has a lower packing efficiency (packing coefficient = 67.9 %) (Fig. 7.12).

Inspection of the calculated packing efficiency for the known structures of CZPN shows that the stabilisation of the CZPN solvates by solvent molecules is not just a

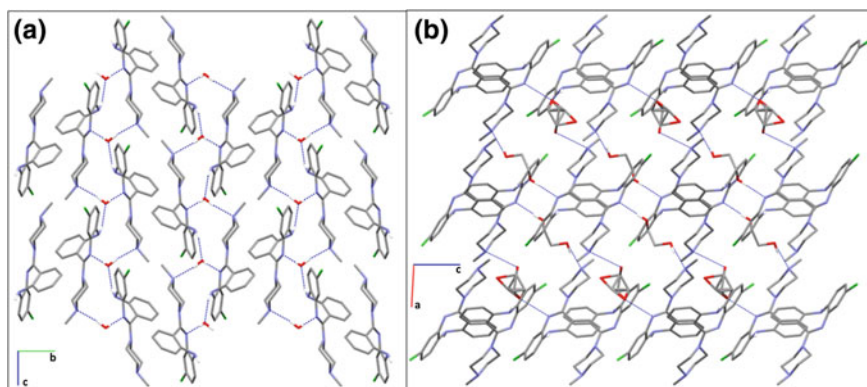


Fig. 7.11 3-D arrangement formed by the columns of the centrosymmetric dimers of clozapine in **a** clozapine monohydrate and **b** clozapine ethylene glycol solvate. H-bonds between clozapine and solvent molecules are shown by the *blue dotted line*. Other hydrogen atoms are omitted for clarity

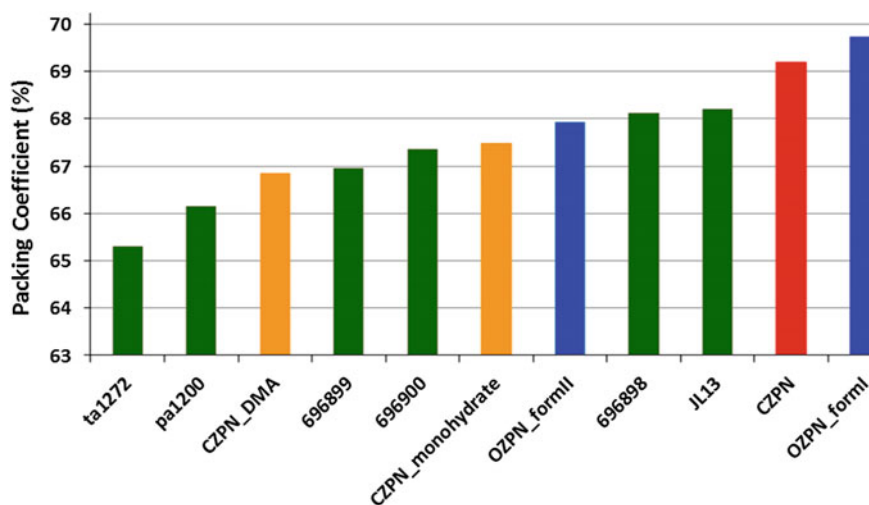


Fig. 7.12 Packing coefficient (%) for the anhydrous form (*red*), solvates (*orange*), analogues (*green*) of clozapine and anhydrous polymorphs (*blue*) of olanzapine

density packing effect similar to OZPN (Sect. 6.11), as the packing coefficient for the two CZPN solvates (monohydrate and DMA solvate) is not higher than the anhydrous form (Fig. 7.12). Similarly packing efficiency of the other reported CZPN analogues with or without large substituents at position 4 of piperazine ring (Fig. 7.13) (Dupont et al. 1996; Capuano et al. 2000; Dupont and Liegeois 2003; Capuano et al. 2010), have relatively lower packing efficiency than CZPN (Fig. 7.12). It is expected that large bulky substituents at N4 of piperazine ring would reduce the packing

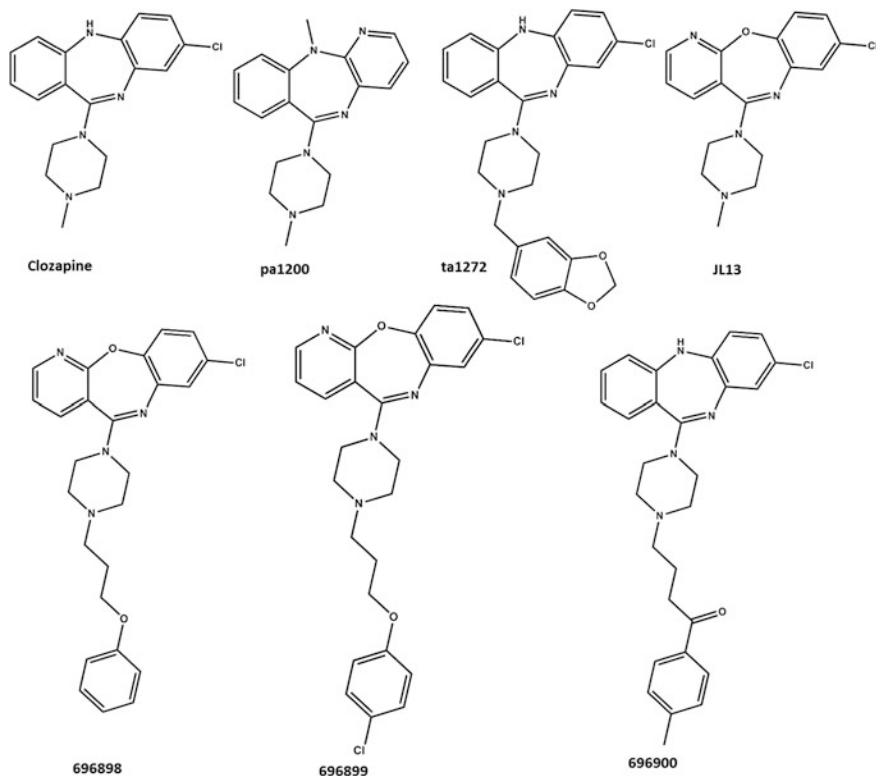


Fig. 7.13 Chemical structures of clozapine and its analogues

efficiency of the resulting crystal structure but the methyl substituent at N1 (pa1200) also reduces the packing efficiency considerably.

7.3.1.2 Preliminary Crystal Structure Prediction of Clozapine

Encouragingly the experimental structure was obtained as the global minimum in lattice energy in the search (Fig. 7.14). The next two lowest energy structures are very close to each other and are almost 4.6 and 5.1 kJ mol⁻¹ higher in energy from global minimum. Another close cluster of crystal structures is observed in the region of -144.4 to -141.1 kJ mol⁻¹ of lattice energy (Fig. 7.14).

In spite of being only a preliminary search, these results provide a valuable approximation of the crystal energy landscape. In contrast to CSP results of OZPN, these findings suggest that other polymorphic structures of CZPN are actually unlikely during standard crystallisation investigation due to the large lattice energy gap between the global minimum and other predicted crystal structures.

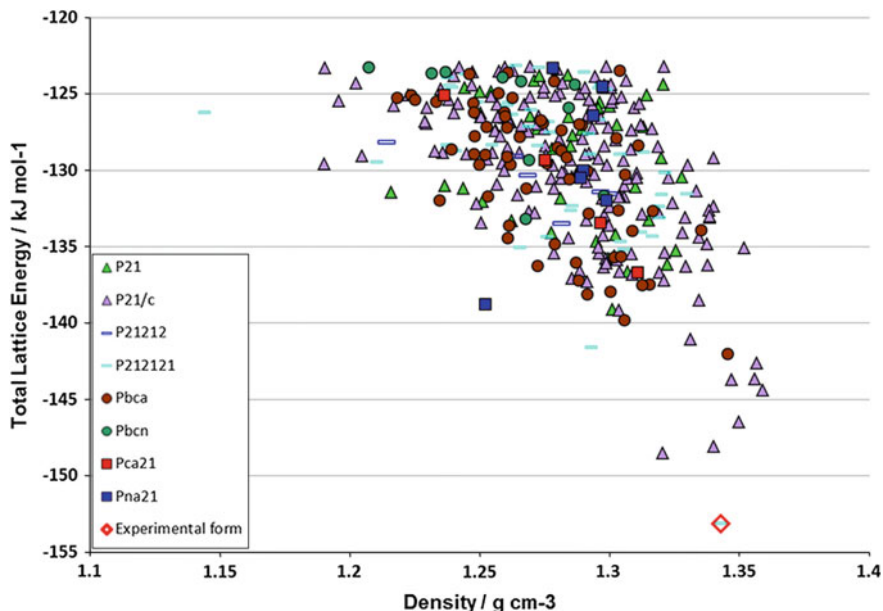


Fig. 7.14 Summary of the preliminary crystal structure search of clozapine. Each *point* represents a hypothetical crystal structure/lattice energy minimum. The *cyan rectangle with open red diamond* represents the global minimum in the lattice energy, which corresponds to the known experimental structure

Crystal structures with the centrosymmetric dimer were also commonly observed on the crystal energy landscape. The 2nd lowest energy structure contains the centrosymmetric dimer but is less densely packed than the global minimum. This suggests that in the two experimentally obtained CZPN solvates the solvent is stabilising the solvate structures by hydrogen bonding and other favourable interactions with the CZPN centrosymmetric dimers.

PIXEL calculations were further employed to develop a detailed picture of the interplay between molecular and crystal structures of OZPN and CZPN.

7.3.1.3 PIXEL Calculations on Clozapine

PIXEL calculations (see Sect. 3.2.5) were carried out on the CZPN anhydrous form, monohydrate and DMA solvate. Due to the disorder in the EG solvate crystal structure, PIXEL calculations could not be carried out. These structures (anhydrous form, monohydrate and DMA solvate) form an ideal set to study the relative contribution of the various packing motifs (centrosymmetric dimer vs. edge to face dimer vs. individual molecule) to the total lattice energy using PIXEL. The results of the crystal lattice calculations on these three structures are summarised in Table 7.5.

Table 7.5 Partitioned intermolecular interaction energies (kJ mol^{-1}) from the PIXEL calculations on clozapine anhydrous form, monohydrate and DMA solvate

Structure	E_c^a	E_p^b	E_d^c	E_{attrac}^d	E_r^e	E_t^f
CZPN	-66.9	-34.8	-201.2	-302.9	143.2	-159.8
% of E_{attrac}	22.1	11.5	66.4	–	–	–
CZPN monohydrate	-91.3	-41.5	-113.3	-246.1	132.4	-113.8
% of E_{attrac}	37.1	16.9	46.0	–	–	–
CZPN DMA	-50.3	-22.8	-121.4	-194.5	85.8	-108.8
% of E_{attrac}	25.9	11.7	62.4	–	–	–

^aElectrostatic (Coulombic) energy, ^bPolarisation term, ^cDispersion term, ^d $E_{\text{attrac}} = E_c + E_p + E_d$, ^eRepulsion term, ^fTotal intermolecular interaction energy, $E_t = E_c + E_p + E_d + E_r$

In all three CZPN structures, the attractive forces are dominated by the E_d . This is followed by the contribution from the E_c , and then the E_p . In the case of the monohydrate, the contribution of E_c towards the total attractive energy (E_{attrac}) is highest amongst the three structures. This might be due to the involvement of each CZPN molecule in three H-bonds with water molecules compared to two hydrogen bonds in the anhydrous form and one hydrogen bond in the DMA solvate.

Pair-Wise Molecular Interactions in Crystal Structure of Anhydrous Clozapine

The PIXEL calculations also identified several molecular pairs within the 2.5 kJ mol^{-1} threshold of intermolecular interaction energy in all the three structures. Analysis of the crystal packing in terms of the individual pairwise molecular interactions for anhydrous form shows that the overall intermolecular energy in each molecular pair is dominated by the contribution from the E_d (Table 7.6). Non-localised interactions between the diffuse electron clouds of CZPN molecules in dimers are most likely responsible for the higher dispersion energy contribution (Dunitz and Gavezzotti 2005).

Table 7.6 Intermolecular interaction energies (kJ mol^{-1}) for the top three ranked molecular pairs in the anhydrous form of clozapine

Rank ^a		E_c	E_p	E_d	E_{attrac}	E_r	E_t	COM (\AA) ^b
1st		-27.5	-12.3	-46.1	-85.9	40.4	-45.5	6.997
	% of E_{attrac}	32.0	14.3	53.7	–	–	–	–
2nd		-14.3	-8.1	-63.8	-86.2	45.5	-40.7	6.178
	% of E_{attrac}	16.6	9.4	74.0	–	–	–	–
3rd		-8.4	-3.8	-20.6	-32.8	17.4	-15.4	9.609
	% of E_{attrac}	25.6	11.6	62.8	–	–	–	–

These pairs are shown in Fig. 7.15

^aRank contribution of a pair of molecules to the overall intermolecular interaction energy in the structure studied, ^bDistance between the centres of mass of the two molecules (\AA)

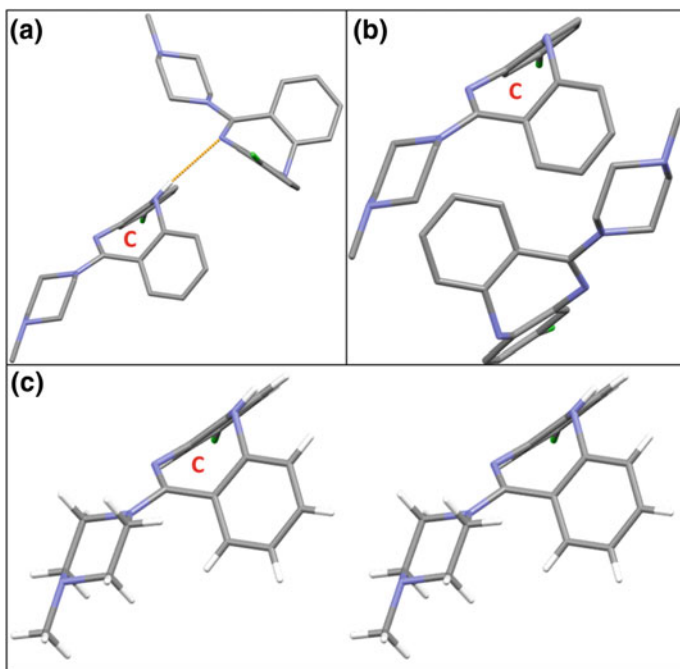


Fig. 7.15 The top three molecular pairs present in the crystal lattice of clozapine identified in Table 7.6. **a** Dimer involving hydrogen-bond between clozapine molecules (shown by *orange line*), **b** side-ways dimer, and **c** dimer involving weaker molecule-molecule interactions. The central molecule is labelled as ‘C’

The topmost molecular pair-wise interaction involves CZPN molecules connected via NH...N hydrogen bond (Table 7.6 and Fig. 7.15). The 2nd ranked molecular pairwise interaction includes contributions from CH₂... π interactions between the CZPN molecules which form a side-ways dimer (Table 7.6 and Fig. 7.15) and is over 4.8 kJ mol⁻¹ less favourable than the top ranked pair-wise molecular interaction.

The top two molecular pairs are significantly more favourable (>25 kJ mol⁻¹) than the others within the coordination shell. The 3rd ranked molecular pair includes van der Waals interactions between the CZPN molecules (Fig. 7.15) from adjacent dimers along the *b*-direction.

Pair-Wise Molecular Interactions in Crystal Structures of Clozapine Monohydrate and DMA Solvate

Unlike the CZPN anhydrous form, the top most molecular pair in the DMA solvate and monohydrate involves non-hydrogen bonding CZPN molecules (Table 7.7, Fig. 7.16) and E_d is not the key contributor towards E_t in all the molecular pairs.

Table 7.7 Intermolecular interaction energies (kJ mol^{-1}) for top three ranked dimer interactions in clozapine monohydrate and *N,N*-dimethylacetamide solvate

	Rank		E_C	E_p	E_d	E_{attrac}	E_r	E_t	COM (Å)
DMA solvate	1st		-18.0	-8.7	-68.4	-95.1	47.1	-48.0	5.861
		% of E_{attrac}	18.9	9.1	71.9	-	-	-	-
	2nd		-40.9	-15.5	-18.5	-74.9	34	-41.0	6.651
		% of E_{attrac}	54.6	20.7	24.7	-	-	-	-
	3rd		-7.2	-3.2	-25.2	-35.6	14.9	-20.8	5.461
	% of E_{attrac}	20.2	9.0	70.8	-	-	-	-	
Monohydrate	1st		-28.8	-10.8	-94.9	-134.5	70.9	-63.6	4.446
		% of E_{attrac}	21.4	8.0	70.6	-	-	-	-
	2nd		-46.3	-20.6	-18.8	-85.7	51.2	-34.6	4.003
		% of E_{attrac}	54.0	24.0	22.0	-	-	-	-
	3rd		-49.7	-23.0	-15.5	-88.2	58.5	-29.7	6.733
	% of E_{attrac}	56.3	26.1	17.6	-	-	-	-	

These pairs are shown in Fig. 7.16

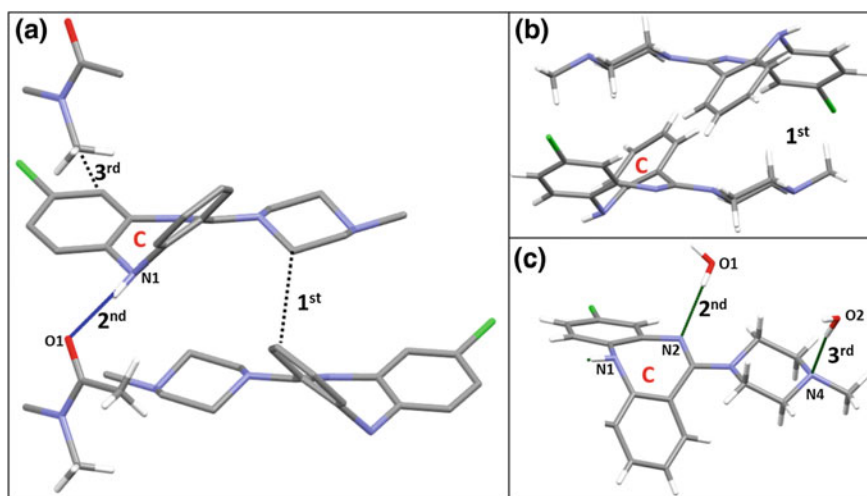


Fig. 7.16 Top three pair-wise intermolecular interactions in **a** clozapine *N,N*-dimethylacetamide solvate and **b, c** clozapine monohydrate, quantified and labelled as in Table 7.7. The central molecule is labelled as 'C'. Other hydrogen atoms are omitted for clarity

The most significant molecular pair in DMA solvate is a dispersion dominated dimer consisting of CZPN molecules from the adjacent chains and involves contribution from van der Waals interactions between CZPN molecules (Fig. 7.16a). The 2nd ranked molecular pair shows an association mode based on intermolecular hydrogen bonds, namely N1-H...O1 (Fig. 7.16) and E_{attrac} is dominated by the E_C . Similar to the anhydrous CZPN, the top two molecular pairs in the DMA solvate are

significantly more favourable ($>20 \text{ kJ mol}^{-1}$) than the others within the coordination shell. The 3rd ranked molecular pair includes contributions from van der Waals interactions between CZPN and the DMA molecule and the E_d is the main contributor towards E_{attrac} (Fig. 7.16 and Table 7.7).

The topmost molecular pair in terms of interaction energy in CZPN monohydrate is a centrosymmetric dimer formed by CZPN molecules (Fig. 7.16b) which is significantly more favourable than other molecular pairs within the coordination shell (Table 7.7). The 2nd and 3rd ranked molecular pairs involve contribution from H-bonds (O1-H...N2 and O2-H...N4 respectively) between CZPN and water molecules (Table 7.7 and Fig. 7.16c). As expected from the H-bonded motif, the attractive forces are dominated by the E_C , which represents over half of the total attractive forces in these two molecular pairs (Table 7.7 and Fig. 7.16c). Dispersion forces in these two H-bonded pair-wise molecular interactions are not as significant as those of the anhydrous form of CZPN ($\sim 22\%$ vs. $\sim 54\%$) due to the fact that this dimer involves one CZPN with a water molecule as compared to the dimer of two CZPN molecules in the anhydrous form.

To summarise, PIXEL calculations have revealed that, independent of the packing motif, E_d is a key contributor towards stabilisation of the crystal lattices of anhydrous form and solvates of CZPN. In terms of pair-wise interactions, the relative contribution from the top most interaction is significantly less in non-centrosymmetric dimer based structures (CZPN and its DMA solvate) than in the centrosymmetric dimer based structure (CZPN_monohydrate). Particularly, in CZPN solvates the contribution of E_C towards total energy is higher in H-bonded molecular pair as compared to anhydrous CZPN where H-bonded molecular pair is dominated by E_d .

On comparing both the anhydrous crystal structures of OZPN and CZPN, the total lattice energy is dominated by E_d . In contrast to OZPN, where the SC_0 is the main contributor towards total energy, the lattice energy is more evenly distributed amongst the top two molecular pairs (H-bonding dimer and side-ways dimer) in anhydrous CZPN.

The second group of molecules (AXPN and LXP) studied are discussed in the next section.

7.3.2 Physical Form Screening Results of Amoxapine

Across all the crystallisation experiments employed, the same physical form as the starting material, acetic acid salt and an amorphous phase of AXPN was obtained.

No new polymorphs, solvates or hydrates were observed from solution crystallisations from 47 solvents under three conditions (see Sect. 7.2.3) except acetic acid which yielded an acetate salt of AXPN. Clearly the solution experiments did not lead to alternate packing arrangements being produced. Neat and liquid-assisted grinding, vapour phase crystallisation and recrystallisation from amorphous phase

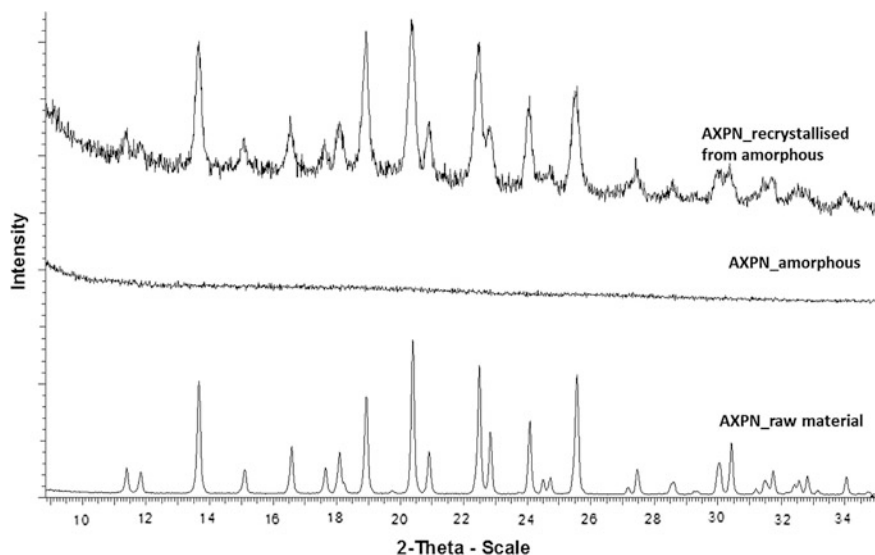


Fig. 7.17 Stack plot of XRPD patterns of amoxapine raw material, melt quenched amorphous phase and partially recrystallised sample of amorphous amoxapine in the range of 10–35° 2 θ

returned the same non-solvated form as the starting material (Fig. 7.17). Crystal structure of AXPN was redetermined at 123 K to allow comparison with CSP.

In DSC, AXPN melts at 453–454 K. In-situ recrystallisation of the amorphous sample and a thermal heat-cool-heat cycle (see Sect. 3.2.3) of the starting material of AXPN yielded the same starting material (endotherm at 454 K, Fig. 7.18). Under these conditions, again no polymorphs other than known anhydrous form were observed.

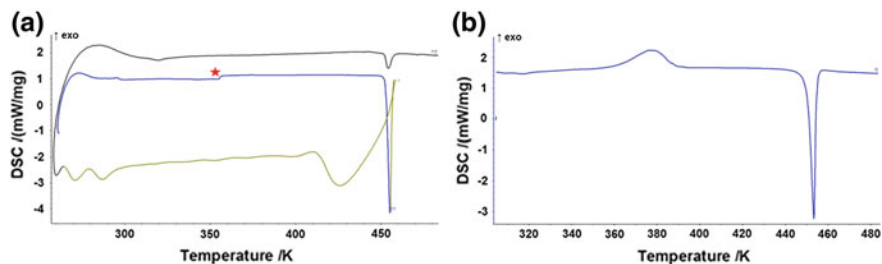


Fig. 7.18 DSC curves of amoxapine **a** heat-cool-heat cycle of amoxapine. The heat-cool-heat segments are shown by blue, golden and black colour respectively. In heating curve, star denotes an instrument artefact. **b** Amorphous amoxapine

7.3.2.1 Molecular Packing Analysis of Crystal Structure of Amoxapine

AXPN molecules form two types of chains along *b*-axis and each chain consists of one enantiomer. These chains stack parallel to each other in a staggered manner to give rise to a layered structure (Fig. 7.19a). The 2-D layers stack over each other along *a*-direction (Fig. 7.19b) and are connected by C-H...O hydrogen bonds.

Although AXPN molecule has one donor and three acceptors, it does not form any conventional intermolecular hydrogen bonds in the crystal lattice (Fig. 7.19). AXPN crystal packing seems to be driven by space filling van der Waals interactions, stabilising the structure with reasonably high packing efficiency (packing coefficient = 70.5 %).

7.3.2.2 Preliminary Crystal Structure Prediction of Amoxapine

Encouragingly, the experimental structure was found in the search as the global minimum in lattice energy (Fig. 7.20). The next lowest energy structure is almost 5 kJ mol⁻¹ higher in energy, and the third lowest energy structure in the search has a gap of 6 kJ mol⁻¹ to the global minimum.

The approximate crystal energy landscape highlights that other polymorphic structures are unlikely to be obtained during routine crystallisation investigation because of the large gap between global minimum and other predicted crystal structures. In other words the known form is the most favourable packing arrangement by far and other structures are not thermodynamically competitive.

This type of landscape provides an answer to the experimentalist question “When should we stop the experimental search?” (Braun et al. 2010). It is notable, however, that this is the first time that this type of landscape has been observed for pharmaceutical molecules in this group’s experience.

7.3.2.3 PIXEL Calculations on Amoxapine

PIXEL calculations show that the majority of the contribution towards crystal stabilisation comes from E_d followed by E_C and E_p terms (Table 7.8).

Eight pair-wise interactions within a threshold of 2.5 kJ mol⁻¹ were identified from the crystal lattice calculations. Analysis of the individual pairwise molecular interactions (Table 7.9 and Fig. 7.21) revealed that the overall intermolecular energy in each molecular pair is dominated by the contribution from the E_d term.

The first three top ranked molecular pairs have been found to have similar intermolecular interaction energies and over 69 % of the contribution towards attractive forces comes from the E_d followed by E_C and E_p (Table 7.9).

1st–3rd ranked molecular pairs involve AXPN molecules from adjacent layers. The top ranked molecular pair involves contributions from C-H...Cl and other van der Waals interactions between piperazine rings (Fig. 7.21a). The 2nd ranked pair

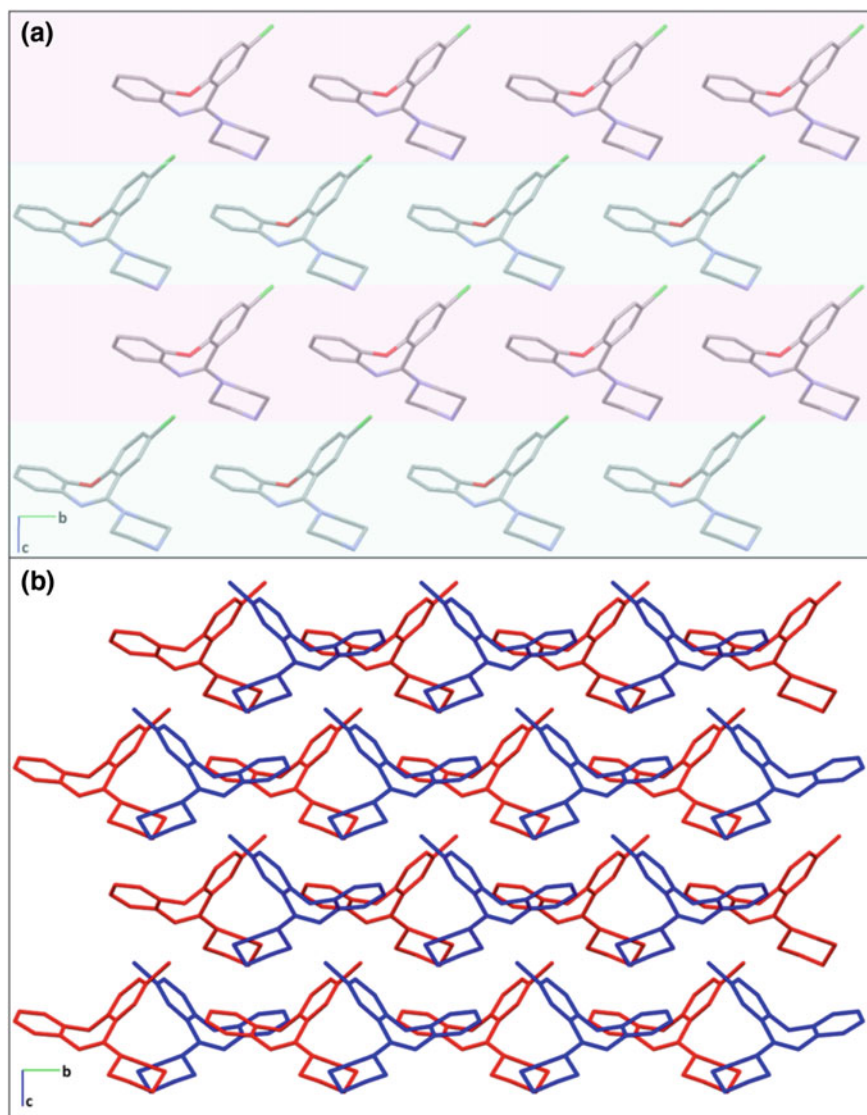


Fig. 7.19 **a** Layer structure formed by stacking of two types of chains (*highlighted in pink and green colour*) of amoxapine molecules. **b** The stacking of layers (shown by *red and blue colours*). All the hydrogen atoms are omitted for clarity

involves contributions from the C-H...O bond and van der Waals interactions between piperazine and phenyl rings (Fig. 7.21b) with CH... π interactions between the piperazine and chlorophenyl rings contributing to the 3rd ranked pair (Fig. 7.21c).

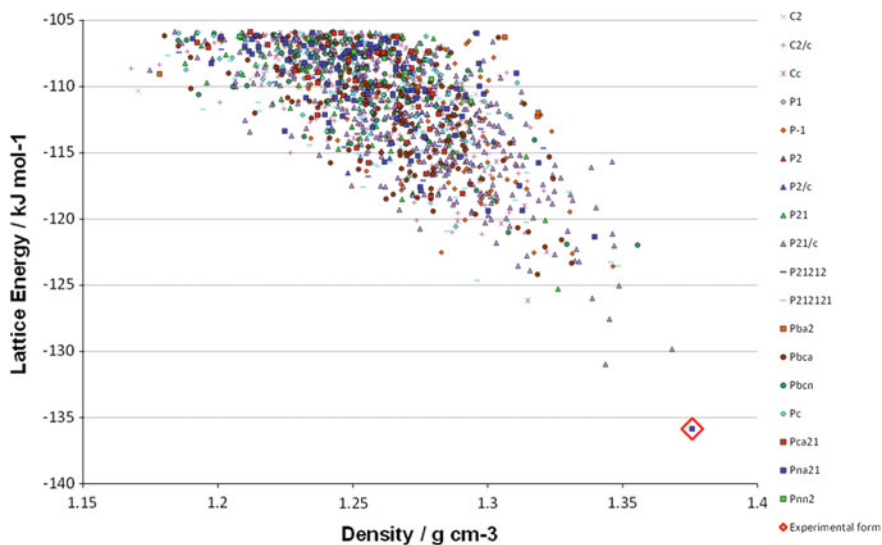


Fig. 7.20 Summary of preliminary crystal structure search of amoxapine. Each *point* represents a hypothetical crystal structure/lattice energy minimum. The *blue square with open red diamond* represents the global minimum in lattice energy, which corresponds to the known experimental structure

Table 7.8 Partitioned intermolecular interaction energies (kJ mol^{-1}) from the PIXEL crystal lattice calculations of amoxapine

Structure	E_c	E_p	E_d	E_{attrac}	E_r	E_t
Form I	-50.2	-23.9	-192.1	-274.0	123.3	-142.9
% of E_{attrac}	18.8 %	9.0 %	72.2 %	—	—	—

Table 7.9 Intermolecular interaction energies (kJ mol^{-1}) for the top three ranked molecular pairs in amoxapine

Rank		E_c	E_p	E_d	E_{attrac}	E_r	E_t	COM (\AA)
1st		-9.7	-4.6	-33.3	-47.6	21.1	-26.5	7.300
	% of E_{attrac}	20.4	9.7	69.9	—	—	—	—
2nd		-7.6	-3.3	-31.8	-42.7	16.6	-26.0	7.903
	% of E_{attrac}	17.8	7.7	74.5	—	—	—	—
3rd		-6.2	-4.6	-37.2	-48.0	23.1	-24.9	7.410
	% of E_{attrac}	12.9	9.6	77.5	—	—	—	—

These pairs are shown in Fig. 7.21

PIXEL calculations indicated that in the absence of strong intermolecular hydrogen bonds, the van der Waals interactions play a significant role in stabilising the crystal lattice of AXPN. These calculations also revealed that a large part of the

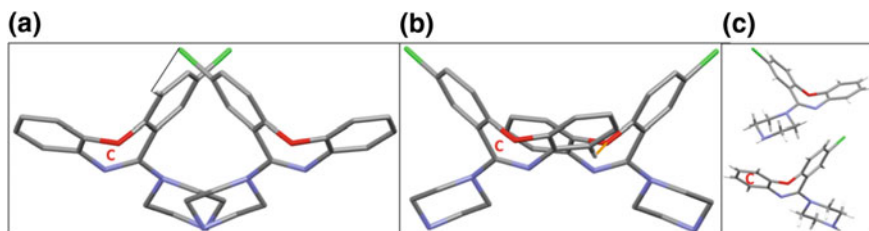


Fig. 7.21 Top five pairwise intermolecular interactions in amoxapine, quantified in Table 7.9, **a, b** molecular pairs involve contribution from C-H...Cl interaction (*black line*) and C-H...O interaction (*orange line*) and **c** a molecule-molecule interaction. The central molecule is labelled as 'C'

cohesive energy in molecular pairs containing weak hydrogen bonds (C-H...O present in 2nd ranked molecular pair and C-H...N present in 4th ranked molecular pair and is not shown here) also arises from the dispersion term which is difficult to characterise and particularly challenging for computational CSP methods (Dunitz and Gavezzotti 2005; Bhardwaj et al. 2013).

The calculated values for intermolecular interactions cannot however explain why the observed associated patterns dominate over other potential molecular pairs that could be formed involving strong H-bonds between N-H groups and O atoms of AXPN molecules during molecular self-assembly. The absence of strong H-bond could be due to the steric effect associated with the benzene rings next to ether moiety which may hinder the access of available oxygen atom for the formation of H-bonds in the crystal lattice. CSD (Frank 2002) (version 5.34) analysis revealed that only 3 % of the structures containing ether motif were found to be involved in conventional H-bonding. This also suggests that oxygen atom in this kind of ether motif is not easily accessible for H-bonding.

7.3.3 Physical Form Screening Results of Loxapine

7.3.3.1 Purity of Supplied Material of Loxapine

LXPN was purchased from Molekula, UK. The XRPD data of LXPN did not match the unit cell of either of the two reported polymorphs (Petcher and Weber 1976; Cosulich and Lovell 1977). STA analysis revealed a 1 % mass loss on heating at ~ 373 K and the melting point of the supplied material (428 K) was much higher than the two known LXPN polymorphs (386 and 388 K). Recrystallisation of the supplied material from 2-butanone yielded a single crystal suitable for structure determination from SXD. The crystallography data confirmed the identity of the sample as monohydrate of the succinate salt of LXPN. XRPD and STA analysis of a recrystallised sample showed that the supplied material was a mixture of hydrated and anhydrous LXPN succinate salts. The LXPN hydrogen succinate monohydrate

crystal structure is known although due to disorder the H-atoms positions were not reported (Fillers and Hawkinson 1982a). Hence, redetermination of the crystal structure in this investigation has enabled a complete description of the structure including disorder with all the H-atoms positions to enable a better understanding of the intermolecular packing.

7.3.3.2 Crystal Structure Determination of Anhydrous Loxapine Succinate Using XRPD

The supplied material was oven dried for 5 h at 373 K to dehydrate the sample. The crystal structure of the anhydrous material was subsequently determined using XRPD. Indexing using DICVOL04 (Boultif and Louer 1991) was unsuccessful, so singular valued decomposition (SVD)-Index algorithm (Coelho 2003) in TOPAS was used to index the powder pattern. A monoclinic solution with unit cell parameters of $a = 36.182 \text{ \AA}$, $b = 7.083 \text{ \AA}$, $c = 18.759 \text{ \AA}$, $\beta = 66.171^\circ$ and volume = 4397.54 \AA^3 was obtained with suggested space group $C2/c$ indicated by consideration of volume and systematic absences. A Pawley type fit of this unit cell and space group against the powder data ($4\text{--}37^\circ 2\theta$) in DASH returned a Pawley $\chi^2 = 3.74$.

It is generally observed that stable salt formation occurs when the difference in pKa between free acid and base counterions is more than 3 (Bastin et al. 2000). The difference in pKa between LXPN and succinic acid is 4.0 (calculated using the Pipeline Pilot Professional Client interface (Accelrys 2010)), which indicates salt formation is likely. Therefore, this structure was assumed to be the succinate salt and structure solution using SA was attempted as a salt configuration. Geometry optimisation using CASTEP was then applied to the structure obtained from structure solution to confirm the positions of all H-atoms and to verify the salt configuration of the structure (Florence et al. 2009).

SA runs were used to optimise the LXPN hydrogen succinate model against the diffraction data set (166 reflections) using the direct space method. An internal coordinate description of protonated LXPN was derived from the single crystal of the hydrated LXPN hydrogen succinate structure (determined in this work) and for succinate anion it was derived from the crystal structure of the succinate salt available in the CSD (refcode: BOVWIT). The O–H and C–H distances were normalised to 0.90–0.95 \AA respectively. The structure was solved using 500 SA runs of 2.5×10^7 moves per run as implemented in DASH in which the position, orientation and conformation of internal coordinate description (z-matrix) of a protonated LXPN and a succinate anion were varied. Each protonated LXPN and succinate anion molecule was allowed 7 (6 external and 1 internal) and 9 (6 external and 3 internal) degrees of freedom respectively. Structures returned from SA with ratios of Profile χ^2 /Pawley χ^2 less than 10 are generally considered to be solved (Florence et al. 2005). 57 % of the runs successfully located the global minimum (Profile χ^2 to Pawley χ^2 ratio threshold <10).

CASTEP was then used to confirm that the diffraction based minimum structure also matches with an energy minimum structure, thus verifying the accuracy of salt configuration of the structure. The SA solution with lowest ratio of Profile χ^2 to Pawley χ^2 was taken for geometry optimisation in CASTEP. Although the pKa difference between LXPN and succinic acid suggests that the resulting structure is most likely a salt, to verify this, the salt configuration was changed to a co-crystal (by manually moving the proton from protonated LXPN to the succinate anion) and a geometry optimisation carried out using CASTEP to confirm its position. After geometry optimisation of the LXPN hydrogen succinate salt structural model, no movement in the proton position (H1) was observed. However, in the structural model corresponding to a co-crystal, the proton from the carboxylic acid of succinic acid (H1 (SA) in Fig. 7.22) was transferred to the nitrogen atom of LXPN molecule, (H1 (DFT) in Fig. 7.22) confirming the salt configuration as accurate. No significant movement was observed for any of the heavier atoms e.g. C, N, O and Cl (Fig. 7.22). These results confirm that the structure obtained from SA is accurate and is a salt.

After SA, the global minimum structure with a Profile χ^2 /Pawley χ^2 ratio (8.73/3.74) was used for subsequent restrained Rietveld refinement in TOPAS Academic (version 4.1). All atomic positions (including H atoms) for this structure were refined, subject to a series of restraints on bond lengths, bond angles and planarity. The final refinement included a total of 188 parameters (17 profile, 4 cell, 1 scale, 1 isotropic temperature factor and 165 positions) yielding a final R_{wp} of 3.164 and goodness of fit of 2.119 (Fig. 7.23).

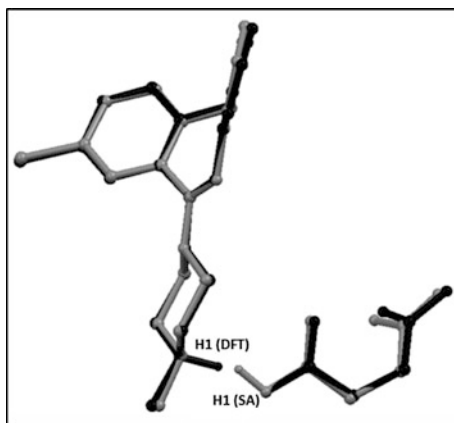


Fig. 7.22 Overlay of the best simulated annealing solution with proton manually placed at succinic acid (co-crystal, *grey*) with the CASTEP geometry optimised structure (*black*) indicating proton transfer from succinic acid to loxapine. H-atom position before and the one obtained after geometry optimisation is denoted by H1 (SA) and H1 (DFT) respectively. Other hydrogen atoms are omitted for clarity. RMSD non-hydrogen atoms = 0.121Å

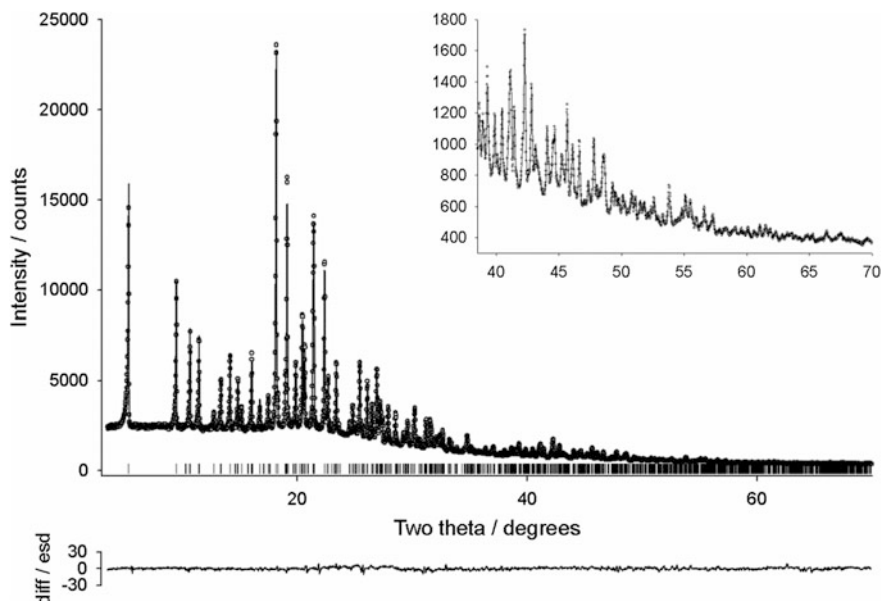


Fig. 7.23 Final fit showing the observed y_{obs} (*lines*), calculated y_{calc} (*points*) and difference $[(y_{\text{obs}} - y_{\text{calc}})/\sigma(y_{\text{obs}})]$ profiles for the restrained Rietveld refinement of the best simulated annealing solution of loxapine hydrogen succinate

The resulting structure from Rietveld refinement was further scrutinised by allowing all fractional coordinates to refine freely (181 parameters, $R_{\text{wp}} = 2.66$). As expected, the improved R_{wp} came at the expense of some chemical sense (e.g. slight distortion in planarity of benzene ring, movement of H-atoms to nonsensical positions), but otherwise, the geometry of the independent molecules was well preserved, confirming the correctness of the restrained refined crystal structure (Florence et al. 2008).

No further work was carried with LXPN succinate salt as it was beyond the scope of this thesis.

7.3.3.3 Physical Form Screening Results on Loxapine Free Base

The supplied material was form I of LXPN as indicated by Pawley type refinement of XRPD data. Across all the crystallisation conditions, 2 known polymorphs and 4 novel physical forms (solvates and/or salts) of LXPN were identified. In comparison to monomorphic AXPN, LXPN exhibit polymorphism and has a tendency to form solvates.

Of the 96 solution crystallisations for LXPN (Table 7.3), 10 (10.4 %) yielded no sample or insufficient solid for XRPD analysis and 3 (3.1 %) provided powder patterns with no diffraction peaks. Of the 83 samples which yielded measurable

diffraction, form I and II were identified in 49 (51.0 %) and 22 (22.9 %) samples respectively. 5 samples were identified as a mixture of forms I and II. The remaining 7 samples were recognised as novel forms (solvates and/or salts) of LXPN.

The outcome of each crystallisation technique is represented by a series of scatter plots (Figs. 7.24 and 7.25). Each point in the plot is positioned according to the value of $t[1]$ and $t[2]$ from the solvent property PCA (shown in Fig. 7.2) and coloured according to the crystallisation outcome. Form I was found in majority of the cases of solvent evaporation from vials at RT and cooling crystallisation whilst in the case of faster solvent evaporation (solvent evaporation on a watch glass at RT), form II was observed in the majority of samples. A detailed listing of the form (s) identifies from each recrystallised sample is provided in the Appendix (Tables A.16–A.18).

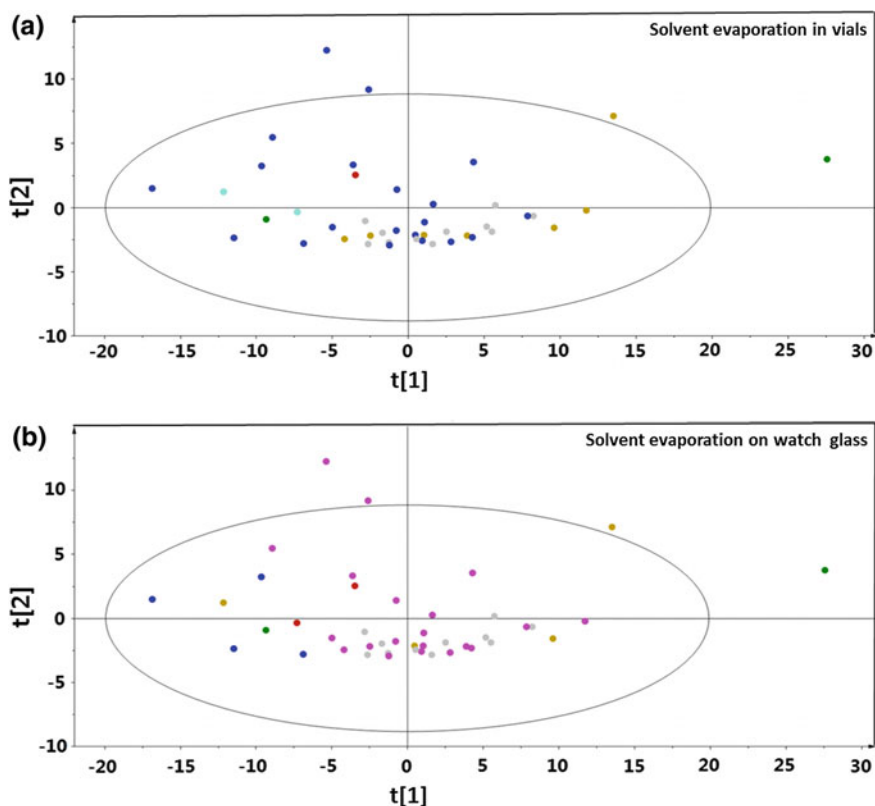


Fig. 7.24 Scatter plot of solvents with positions according to the value of $t[1]$ and $t[2]$ from Fig. 7.2. Solvents are coloured according to the crystallisation outcome: form I (*blue*), form II (*magenta*), mixture of forms I and II (*green*), novel physical forms, solvates and/or salts (*red*), no sample obtained (*golden*) and no spectral information (*cyan*). Solvents which were not used in crystallisation are coloured *grey*. Plots are shown for crystallisation conditions listed in Table 7.3. **a** Solvent evaporation in vials and **b** solvent evaporation on watch glass

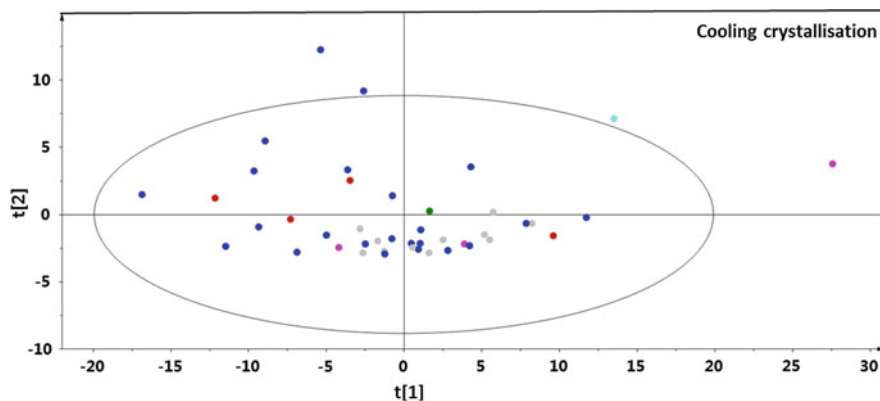


Fig. 7.25 Scatter plot of solvents with positions according to the value of $t[1]$ and $t[2]$ from Fig. 7.2. Solvents are coloured according to the crystallisation outcome: form I (*blue*), form II (*magenta*), mixture of forms I and II (*green*), novel forms, solvates and/or salts (*red*) and no spectral information (*cyan*). Solvents which were not used in crystallisation are coloured *grey*. Plot is shown for cooling crystallisations, listed in Table 7.3

Based on XRPD data and thermal analysis, the physical forms comprise of two known polymorphs (form I and II), 2 solvates (2-butoxyethanol, 2,2,2-trifluoroethanol) and 2 solvates/salts with acetic acid and formic acid. The XRPD patterns of physical forms observed during screening are shown in Fig. 7.26. The lattice parameters of form I and II (redeterminations) are given in Table 7.10. No further characterisation of the novel forms was carried out. Detailed structural analysis of only form I and II is described here.

STA analysis revealed that LXPN form I melts at 384–385 K and form II melts at 381–382 K (Fig. 7.27). During these analyses no signs of any other polymorphs were observed.

Molecular packing analysis was further carried out for form I and II for LXPN to compare it with AXPN.

7.3.3.4 Molecular Packing Analysis of Form I and II of Loxapine Free Base

Both LXPN (form I and II) and AXPN exhibit similar conformation in the crystal structures (Fig. 7.28). It highlights that the methyl group in the LXPN is not affecting its molecular conformation in the crystal lattices.

In form I, LXPN molecules form non-H bonded centrosymmetric dimers. These dimers arrange themselves in a corrugated manner giving rise to a 2-D sheet structure (Fig. 7.29a). In the sheet structure, LXPN dimers are connected via weak C-H...O H-bonds. Alternate sheets stack over each other in a staggered arrangement, giving rise to the 3-D structure (Fig. 7.29b).

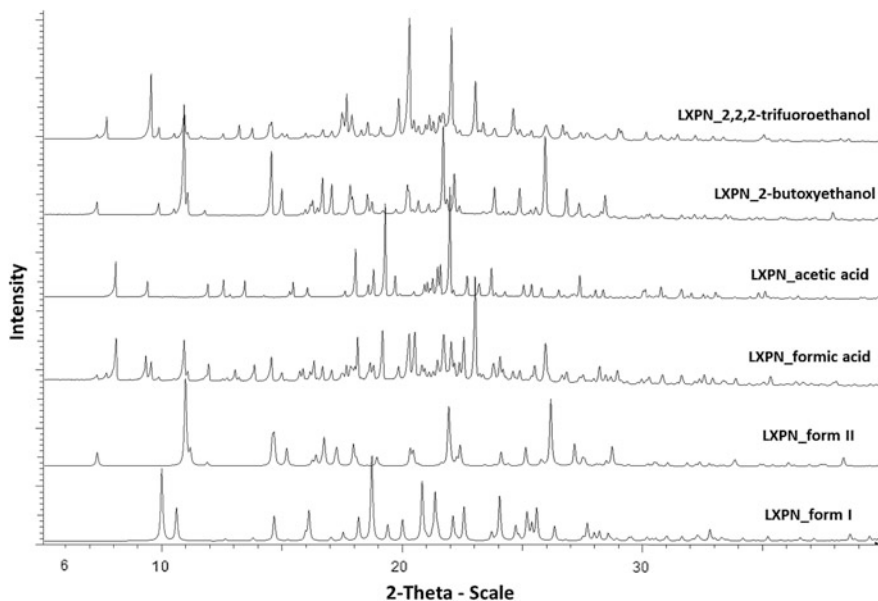


Fig. 7.26 Stack plot of XRPD patterns of physical forms of loxapine identified during experimental screen

Table 7.10 Lattice parameters for loxapine polymorph crystal structures (redeterminations) found in the experimental search (standard uncertainties in parentheses)

Structure	Space group	a (Å)	b (Å)	c (Å)	α (°)	β (°)	γ (°)	Vol (Å ³)
Form I	$Pbca$	14.0245(5)	12.8546(5)	17.7500(7)	90.00	90.00	90.00	3200.0(2)
Form II	$P2_1/c$	12.8867(7)	10.8108(6)	12.3806(6)	90.00	109.484(2)	90.00	1626.0(1)

All parameters were determined from single-crystal diffraction collected at 123(2) K

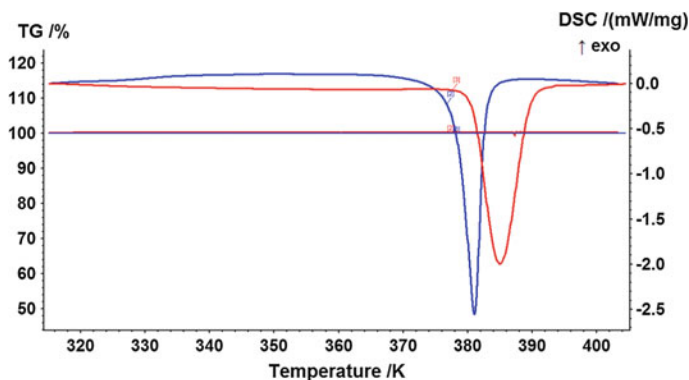


Fig. 7.27 STA thermograms of loxapine form I (red) and form II (blue)

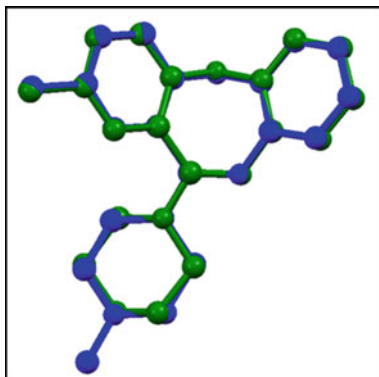


Fig. 7.28 Overlay of the molecular conformations of amoxapine (*green*) and loxapine (*blue*) which are present in the experimental crystal structures (RMSD of non-hydrogen atoms = 0.08Å)

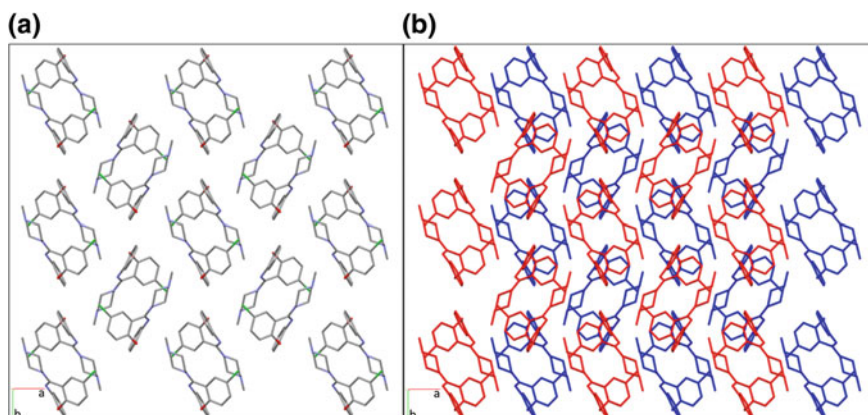


Fig. 7.29 **a** 2-D packing of loxapine. **b** The staggered arrangement of sheets. Alternate sheets are shown by *red* and *blue* colour respectively. All the hydrogen atoms are omitted for clarity

In form II, LXPN molecules form non-H-bonded antiparallel chains (each comprises one enantiomer) along *b*-direction (Fig. 7.30a, b). Alternate chains of enantiomers stack along the *c*-direction to form sheets that stack along *a*-direction (Fig. 7.30c).

Comparison of Crystal Structures of AXPN and LXPN

In spite of having similar molecular conformation in the crystal lattice, the crystal structures of both the compounds do not have a common packing motif. Similar to AXPN, no conventional intermolecular H-bonds were observed in the crystal lattice of either polymorph of LXPN.

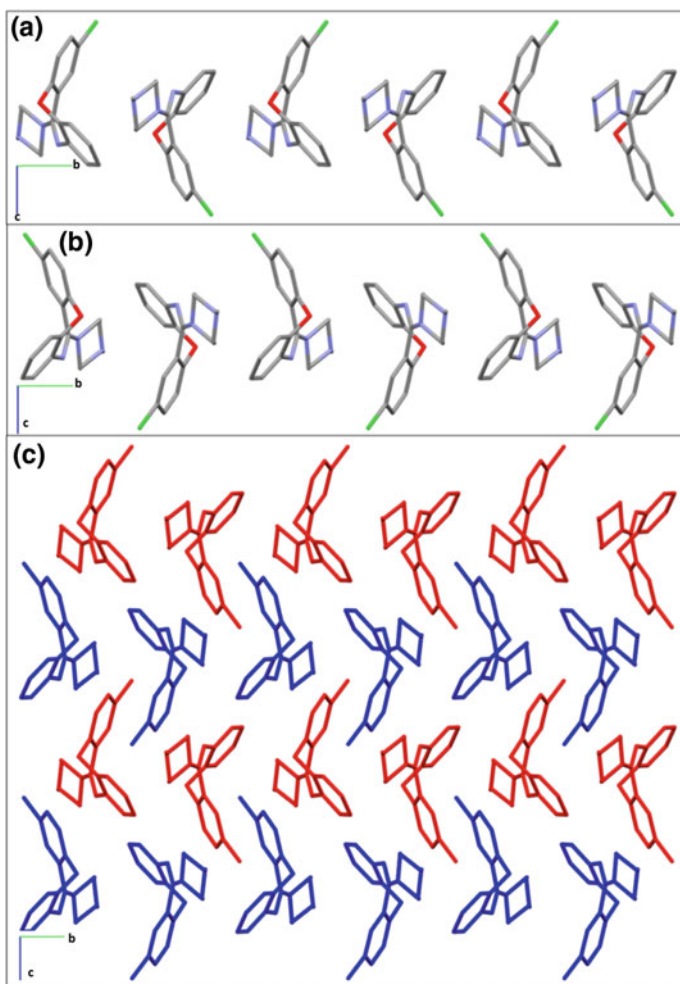


Fig. 7.30 **a, b** 1-D chains of loxapine molecules along *b*-axis. **c** The stacking of chains of loxapine molecules along *c*-direction. All the hydrogen atoms are omitted for clarity

AXPN has comparatively higher packing coefficient (70.5 %) than both polymorphs of LXPN (packing coefficient for form I and II are 68.7 and 67.4 % respectively). This suggests that the methyl substituent leads to less efficient packing of crystal structures of LXPN as compared to AXPN. Efficient packing in crystal structure of AXPN might be one of the potential reasons behind lack of alternate packing arrangements. Whilst in case of LXPN, the alternate packing motifs yield crystal structures with similar packing efficiencies.

7.3.3.5 Preliminary Crystal Structure Prediction of Loxapine Free Base

Two different structures were observed as the lowest energy structures in the crystal energy landscape (Fig. 7.31). One of these matches with the experimentally observed form II. The second, equi-energetic structure bears no resemblance with the experimental observed forms. The other experimental structure form I was not observed during the search.

In contrast to the crystal energy landscape for AXPN, Fig. 7.31 suggests that there are various available options for packing of LXPN molecule that can lead to many thermodynamically competitive crystal structures. The contrasting features of the crystal energy landscapes of LXPN and AXPN therefore explain the differences in their observed solid-state diversity.

PIXEL calculations were undertaken to offer a closer examination of the packing of LXPN in the two experimental crystal structures to examine any comparison with AXPN.

7.3.3.6 PIXEL Calculations on Form I and II of Loxapine Free Base

As expected for non/weak H-bonded systems, the attractive forces are dominated by E_d in both form I and II of LXPN (Table 7.11). The next largest contributions are

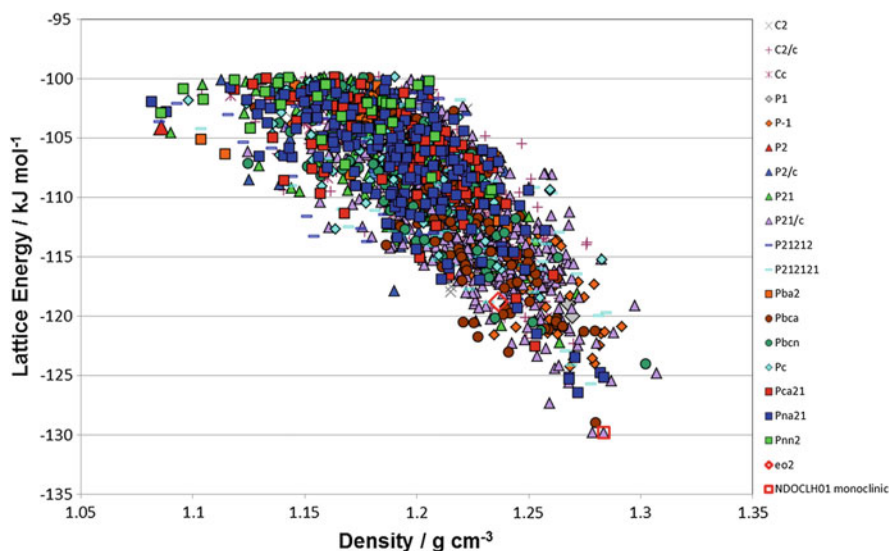


Fig. 7.31 Summary of preliminary crystal structure search of loxapine. Each *point* represents a hypothetical crystal structure. The *violet triangle with open red square* represents one of the lowest energy structures, which corresponds to the known experimental structure

Table 7.11 Partitioned intermolecular interaction energies (kJ mol^{-1}) from the PIXEL calculations of loxapine polymorphs

Structure	E_C	E_p	E_d	E_{attrac}	E_r	E_t	Density g cc^{-1}
Form I	-46.5	-23.1	-188.9	-258.5	121.5	-136.8	1.361
% E_{attrac}	18.0 %	8.9 %	73.1 %	-	-	-	
Form II	-36.9	-19.8	-178.6	-235.3	110.7	-124.6	1.339
% E_{attrac}	15.7 %	8.4 %	75.9 %	-	-	-	

from E_C and E_p , respectively. This trend of relative contributions of the different energy terms (E_d , E_C and E_p) towards the total lattice energy is the same as observed with AXPN.

Similar to AXPN, analysis of the crystal packing in terms of the individual pairwise molecular interactions shows that the individual contribution from different energy terms in each pairwise molecular interaction follows the same trend as observed with the total intermolecular energy ($E_d > E_C > E_p$) (Table 7.12).

The most favourable interaction in form I is between the molecules forming the centrosymmetric dimer (Table 7.12, Fig. 7.32), which is significantly higher than the other interactions within the coordination sphere. The 2nd and 3rd ranked molecular pairs involve contributions from van der Waals contacts between aromatic rings of LXPN molecules from adjacent centrosymmetric dimers and C-H...O interactions, respectively. The molecule-molecule interaction containing centrosymmetric dimer is significantly more favourable than the other interactions within the coordination shell.

The total lattice energy is more evenly distributed between the nearest neighbouring interactions in form II as compared to the centrosymmetric dimer based form I (Table 7.12). The topmost interaction in form II is significantly less

Table 7.12 Intermolecular interaction energies (kJ mol^{-1}) for the top three ranked dimer interactions in loxapine polymorphs

Structure	Rank ^a	E_C	E_p	E_d	E_{attrac}	E_r	E_t	COM (\AA) ^b
Form I	1st	-31.5	-14.8	-106.1	-152.4	82.8	-69.7	4.01
	% E_{attrac}	20.7 %	9.7 %	69.6 %	-	-	-	-
	2nd	-4.3	-3.9	-32.6	-40.8	15.4	-25.4	7.688
	% E_{attrac}	10.5 %	9.6 %	79.9 %	-	-	-	-
	3rd	-10.4	-2.6	-16.5	-29.5	8.2	-21.2	9.356
	% E_{attrac}	35.3 %	8.8 %	55.9 %	-	-	-	-
Form II	1st	-11.8	-7.3	-59.0	-78.1	41.9	-36.1	6.476
	% E_{attrac}	15.1 %	9.3 %	75.6 %	-	-	-	-
	2nd	-10.8	-5.5	-45.9	-62.2	30.3	-31.8	6.849
	% E_{attrac}	17.4 %	8.8 %	73.8 %	-	-	-	-
	3rd	-11.5	-5.1	-29.1	-45.7	20.5	-25.2	8.963
	% E_{attrac}	25.2 %	11.1 %	63.7 %	-	-	-	-

These pairs are shown in Figs. 7.32 and 7.33

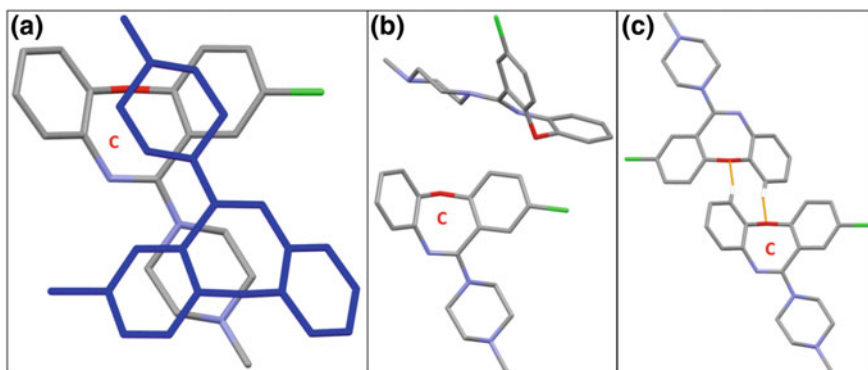


Fig. 7.32 Top three molecular pairs in form I of loxapine, quantified in Table 7.12, **a** centrosymmetric dimer, **b** molecule-molecule interaction and **c** molecular pair involves C-H...O interaction (shown in orange line). The central molecule is labelled as 'C'. Other hydrogen atoms are omitted for clarity

favourable (33.6 kJ mol^{-1}) than that of the centrosymmetric dimer in form I (Table 7.12, Fig. 7.33). This pair involves contributions from C-H...O and CH... π interactions between LXPN molecules from adjacent anti-parallel chains. The 2nd and 3rd ranked molecular pairs involve contribution from CH... π interactions between neighbouring LXPN molecules.

To summarise, PIXEL calculations showed that the dispersion is the key contributor towards crystal stabilisation for AXPN and both polymorphs of LXPN. In the case of the centrosymmetric dimer based form I of LXPN, the centrosymmetric dimer dominates the total energy whilst for the non-centrosymmetric dimer based

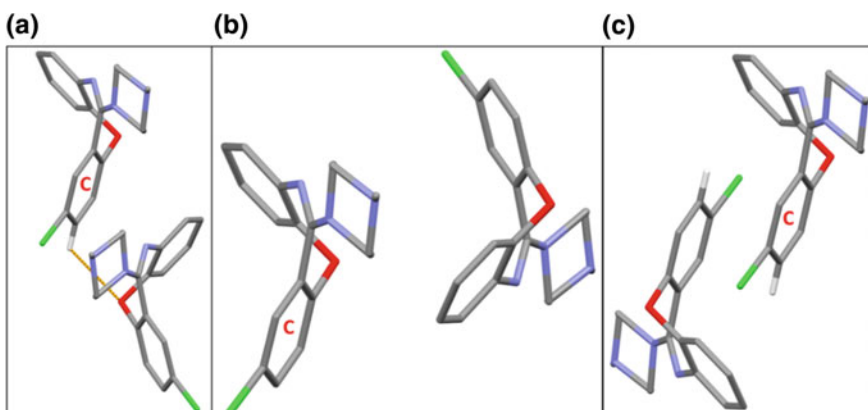


Fig. 7.33 Top three pairwise intermolecular interactions in form II of loxapine quantified in Table 7.12. **a** Molecular pair involving C-H...O (shown by orange line) and CH₂... π interactions and **b**, **c** molecular pairs involving contribution from CH... π interactions. The central molecule is labelled as 'C'. Other hydrogen atoms are omitted for clarity

form II of LXPN and AXPN the lattice energy is more evenly distributed amongst neighbouring interactions. In the absence of strong H-bonds being formed in the crystal structures of AXPN and LXPN, the crystal packing is stabilised by weaker, less directional C-H...O, C-H...N (Desiraju 1991, 2002) and van der Waals contacts. C-H...O and C-H...N H-bonds are not as strong as the conventional H-bonds and provide minor contribution to the cohesive energy in the crystal lattice. However, in sufficient number these interactions can provide additional cohesive stability and clearly cannot be ignored.

7.4 Summary

Multidisciplinary studies involving experimental and computational approaches were applied to pharmaceutical molecules to facilitate the comparison of their solid-state structures. Specifically, this study has focused on exploring how changes in molecular structure affect the molecular conformation, packing motifs, interactions in the resultant crystal lattices and the extent of solid-state diversity of these compounds. The results highlight the value of crystal structure prediction studies and PIXEL calculations in the interpretation of the observed solid-state behaviour and quantifying the intermolecular interactions in the packed structures and identifying the key stabilising interactions.

An experimental screen yielded 4 physical forms for CZPN as compared to 60 distinct physical forms for OZPN. The experimental screening results of CZPN are consistent with its crystal energy landscape which confirms that no alternate packing arrangement is thermodynamically competitive to the experimentally obtained structure. Whilst in case of OZPN, crystal energy landscape highlights that the extensive experimental screening has probably not found all possible polymorphs of OZPN, and further solid form diversity could be targeted with a better understanding of the role of kinetics in its crystallisation. CSP studies were able to offer an explanation for the absence of the centrosymmetric dimer in anhydrous CZPN. PIXEL calculations on all the crystal structures of CZPN revealed that similar to OZPN, the intermolecular interaction energy in each structure is also dominated by the E_d .

Despite the molecular structure similarity between AXPN and LXPN (molecules in group 2), the crystal packing observed in polymorphs of LXPN differs significantly from the AXPN. A combined experimental and computational study demonstrated that the methyl group in LXPN has a significant influence in increasing the range of accessible solid forms and favouring various alternate packing arrangements.

CSP studies have again helped in explaining the observed solid-state diversity of LXPN and AXPN. PIXEL calculations showed that in absence of strong H-bonds, weak H-bonds such as C-H...O, C-H...N and dispersion interactions play a key role in stabilising the crystal lattice of both the molecules. Efficient crystal packing of AXPN seems to be contributing towards its monomorphic behaviour as

compared to the comparatively less efficient packing of LXPN molecules in both polymorphs. The combination of experimental and computational approaches has provided a deeper understanding of the factors influencing the solid-state structure and diversity in these compounds.

Hirshfeld surfaces using Crystal Explorer represent another way of exploring packing modes and intermolecular interactions in molecular crystals (McKinnon et al. 2004). The influence of changes in the small substituents on shape and electron distribution can also be investigated by mapping the total electron density on the electrostatic potential for molecules in the gas phase. This allows straightforward visualisation and comparison of overall shape, electron-rich and electron-deficient regions within molecules. The shape of these molecules can be further investigated to study its influence on diverse solid-state diversity.

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Chapter 8

Conclusions and Further Work

8.1 Conclusions and Further Work

The overall aim of this research was to investigate a range of experimental and computational approaches for the discovery and better understanding of the key factors underpinning solid-structure and diversity. Two groups of structurally similar compounds; olanzapine (OZPN) and clozapine (CZPN) in group 1 and amoxapine (AXPN) and loxapine (LXPN) in group 2 (Fig. 8.1) were studied to investigate the influence of small changes in molecular structure and substituents on molecular conformation, the resultant intermolecular interactions, crystal packing motifs and the extent of solid form diversity. In addition, a fast validated method for physical form screening using Raman microscopy on multi-well plates was developed to explore the experimental crystallisation space. Also developing the theme of prediction, a statistical model for predicting crystallisability of small organic molecules was generated, which afforded $\sim 70\%$ prediction accuracy.

The work therefore spans a broad range of experimental (Table 8.1) and computational approaches (Table 8.2). Underpinning the overall approach has been the use of a combination of analytical approaches to deliver complementary data on the systems under investigation.

During the course of this work the schematic workflow shown in Fig. 8.2 has been developed providing a systematic approach to explore the organic solid state. Across the work presented herein, the complementary application of the experimental and computational approaches has helped in providing a more complete and accurate interpretation of the physical form diversity of the molecules under study and in highlighting the factors impacting on the distinctly different solid-state behaviour of the 4 molecules studied.

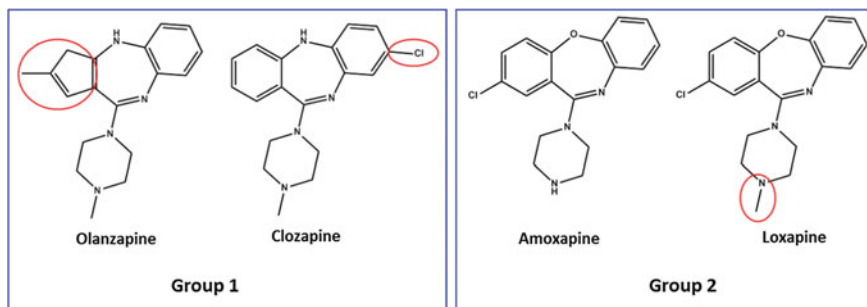


Fig. 8.1 The four compounds studied in this thesis. The differences in the chemical structures within a group are highlighted in red

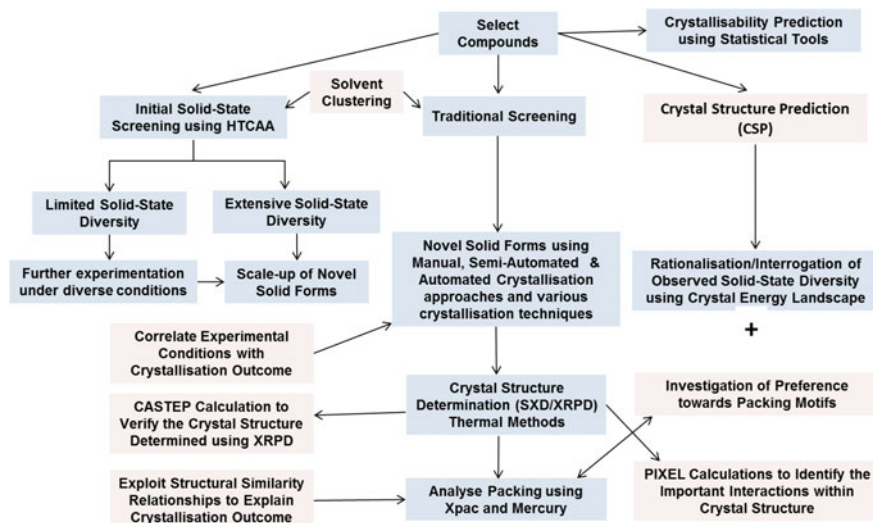
Table 8.1 Recrystallisation methods used in this study to generate various solid forms

Crystallisation method	Degree of freedom used during crystallisation
Solvent evaporation	Solvent, rate of evaporation, initial concentration, temperature
Cooling crystallisation	Solvent, cooling profile, stirring/agitation, vacuum and concentration
Anti-solvent crystallisation	Solvent and anti-solvent
Crystallisation as a function of pH	Rate of change in pH and base
Crystallisation on functionalised surfaces	Surfaces
Mechanical grinding	Solvent, temperature, milling time and frequency
Recrystallisation from amorphous	Temperature and sample presentation (capillary, glass slides and vials)
Melt quenching	Temperature changes (minimum and maximum)
Vapour phase crystallisation	Temperature gradient
Desolvation of solvates	Temperature (isothermal or <i>in-situ</i>) and vacuum
Spray drying	Solvent, concentration, pump speed and temperature programs
Freeze drying	Temperature programs

The conclusions of this thesis can be summarised in three sections namely, (i) development and validation of HTCAA methodology, (ii) crystallisability prediction of organic molecules using statistical modelling techniques and (iii) exploring the physical form landscape of structurally related pharmaceutical molecules in groups 1 (olanzapine and clozapine) and 2 (amoxapine and loxapine).

Table 8.2 List of the computational tools used in this study

Method	Application
DASH, TOPAS and WinGX	Determination of crystal structure from XRPD data and/or SXD data
CASTEP	Verification of the crystal structure solved from XRPD data and determination of accurate positions of H-atoms
Crystal structure prediction (CSP)	Prediction of thermodynamically feasible crystal packing arrangement from molecular structure
PIXEL	Calculation of total lattice energy, contribution of polarisation, dispersion, Coulombic and repulsive interactions towards the total lattice energy and identification of the most significant intermolecular interaction within the crystal structures
Gaussian	Provide molecular geometry and the electronic distribution around the molecules
XPac	Determination of structural similarity at various levels (0-D, 1-D, 2-D and 3-D) amongst crystal structures
Mercury	Visualisation and analysis of crystal structures e.g. H-bonding networks, exploration of crystal packing similarity and propensity of polymorphism etc.
Random forests	Building of classification and regression models, Determination of important descriptors responsible for classification or regression models
Principal component analysis	Identification of clusters, elucidation of similarities and differences within the data
Group analysis	Unsupervised clustering of the data

**Fig. 8.2** Schematic workflow developed in this work

8.1.1 Development and Validation of High Throughput Crystallisation and Analysis Methodology for Physical Form Screening

In the absence of reliable predictive models, systematic and rigorous experimental screening remains the best means to explore the full experimental crystallisation space and to provide a comprehensive understanding of solid form diversity and the conditions under which various solid forms of a molecule can be produced. Moreover in some cases, limited material is available for physical form screening which emphasises the requirement of an efficient means to maximise the information gained with minimal amount of a compound (less than ~250 mg). The physical form screening methodology developed in Chap. 4 can play an important role in achieving a detailed and accurate picture of solid-state diversity of compounds in a shorter period of time by utilising only milligram quantities of material.

However, the results obtained with OZPN suggest that this methodology might not provide a complete picture of the solid form diversity. It is advisable to use other complementary crystallisation techniques e.g. grinding and vapour phase crystallisation to maximise the coverage of experimental search space. Limitations associated with similar Raman spectra for physical forms emphasise the need of a combined use with another analytical tool such as XRPD to maximise the chances of correctly identifying different physical forms. Additionally, this methodology can be tricky for compounds exhibiting fluorescence especially when the interference cannot be overcome by applying background corrections.

Due to its relative simplicity, parallelisation and miniaturisation, this methodology has potential in routine physical form screening and assessing the extent of solid form diversity of compounds. It has considerable scope and by simulating the typical conditions during downstream processing or secondary manufacturing, it can also be employed for wider applications such as in the study of the influence of excipients and process variables on possible phase transformation on a very small scale. This prior knowledge of the landscape of parameters affecting the physico-chemical stability of the physical form can potentially be used during later stages of development by creating the design space for implementation of QbD approaches to guarantee the best quality pharmaceutical product.

8.1.2 Predicting Crystallisability of Organic Molecules Using Statistical Modelling Techniques

The studies in Chaps. 4, 6 and 7 investigate the effects of molecular structure on crystal packing, intermolecular interactions and extent of physical form diversity. Whereas the statistical model built in Chap. 5 explores the impact of molecular structure on crystallisability and provides a means to highlight and understand the molecular factors that inhibit or promote crystallisation.

The RF classification model for predicting crystallisability of small organic molecules yielded a prediction accuracy of $\sim 70\%$. This is the first study on crystallisability prediction for small molecules using statistical modelling techniques and although it does not give 100% accuracy, it shows good potential for further development. This model provides a reasonable opportunity to highlight problematic compounds (e.g. those exhibiting nano/micro crystal formation, agglomeration, oiling out, slow nucleation etc.) so that resource planning can be accommodated to obtain effective crystallisation processes.

Prediction of crystallisability (here defined as the ability of a molecule to come out of solution and form a crystal suitable for SXD) is a challenge. This model essentially deals with the process of crystallisation i.e. nucleation and growth under the conditions tested but not the resultant crystal structure. Although, this model does not provide a mechanistic understanding of the crystallisation process, it still represents a rational and pragmatic approach which enables crystallisability prediction with reasonable degree of confidence.

The use of this approach also allowed identification of the most important descriptors responsible for differences in crystallisation behaviour of structural analogues and they matched well with the experimental observations (Hursthouse et al. 2009). However, the importance of descriptors cannot be quantified using this method. Still this information provides a potential means to identify crystallisation issues during initial studies and can help in designing improved crystallisation processes. These types of statistical models provide reasonably accurate predictions for molecules similar to the molecules used for training the model, but might not be as useful for compounds which are not structurally related to the molecules employed in the training dataset.

8.1.3 Exploring the Physical Form Landscape of Structurally Related Pharmaceutical Molecules in Group 1 (Olanzapine and Clozapine) and 2 (Amoxapine and Loxapine)

The work in Chaps. 6 and 7 was focussed on studying the effect of minor changes in the substituents on the solid-state structure and diversity and to develop a better understanding of the factors underpinning those changes.

Extensive solid form screening of OZPN yielded 60 solid forms including three polymorphs, 56 solvates and an amorphous form. For OZPN, the 124 experiments specifically targeting non-solvated forms (grinding, desolvation, sublimation, melt-quenching, crystallisation from amorphous form, spray and freeze-drying) only produced 3 polymorphs. All these efforts did not find any conditions that could produce phase pure samples of the metastable polymorph III, though a single crystal of form II could be extracted and was used to solve the crystal structure. From a mixed phase sample, no such crystals for form III were obtained. It is

plausible that form III contains the same SC_{24} layers as form II, but stacked in the alternative manner similar to the hypothetical structure, A162, which is only slightly less stable than form II (see Sect. 6.8). Although A162 gave the reasonable fit to the form III powder data in a two-phase refinement, the residual misfit confirms that the space group and/or lattice does not match to that of form III. (see Sect. 6.8). Nonetheless, the close relationship suggested between the known and unknown structures by available experimental and hypothetical structures provides a potential explanation for the observed difficulty of preparing phase pure samples.

In OZPN, there is a favoured layer structure (SC_{21}), which stacks badly with itself, but when water and other solvent molecules are introduced between the layers, it forms three sets of iso-structural solvates. The RF classification model has illustrated that the solvate formation in these three sets of iso-structural solvates is directed by the physicochemical properties of the solvents (see Sects. 6.5 and 6.7). The extensive range of almost three hundred solution crystallisations (evaporations, cooling, anti-solvent, pH change and on functionalised surfaces) of OZPN and the resulting structures of the 56 solvates suggest that other solvates, particularly solvate hydrates, are likely. In contrast only 3 solvates for CZPN have been obtained so far and number of solvates would very likely to be limited.

A key finding from the experimental and CSP studies on CZPN is that the appearance of its alternative polymorph using standard crystallisations techniques is unlikely. The crystal energy landscape highlights limited potential of CZPN in forming crystal structures with a centrosymmetric dimer. However the presence of the centrosymmetric dimer in solvates might be due to the stabilisation of their crystal lattices by the inclusion of solvents. The crystal energy landscape for OZPN shows that there are alternative, probably metastable, structures for anhydrous OZPN. Some are not based on the SC_0 dimer found in all the experimental structures. PIXEL calculations on OZPN show that the strongly dispersion-bound dimer unit SC_0 dominates the lattice energy of form I and II, whereas the lattice energy can be more evenly distributed between the nearest neighbour interactions in some hypothetical structures. This raises the question as to whether the inability to crystallise any novel polymorphs or solvates of OZPN without the SC_0 dimer is a kinetic effect due to the SC_0 dimer being the key growth unit in all the crystallisation experiments. Whether the computed structures without the SC_0 dimer are genuinely credible thermodynamic polymorphs, whose kinetic disadvantage or ease of transformation to form I might be overcome in a specific experiment, or theoretical anomalies, remains an important question.

Another pair of molecules studied in this work was of LXPXN and AXPXN. An important outcome of the multidisciplinary study on AXPXN is that it neither exhibits polymorphism nor has the tendency of solvate formation. This study also illustrated that the presence of methyl substituents at the 4 position of the piperazine ring in LXPXN has a significant influence on the physical form diversity. This study demonstrates that the minor substituents can have a disruptive effect on the intermolecular interactions, packing motifs, resultant crystal structures and the extent of solid-state diversity. It also illustrates the challenges associated with the prediction

of small substituent's effect and its magnitude and importance of computational tools in providing reasonable explanations of the experimental results.

Therefore, further studies of this type have an important role to play in better understanding of substituent effects on solid-state behaviour. Furthermore, these studies might be able to provide information about structural traits which are responsible for polymorphism and whether these structural traits can be used to predict solid-state behaviour of new compounds. The presence of similar SCs in 0-D (dimer) or 1-D (chains) or 2-D (sheets) in two solid forms of structurally similar molecules may indicate the particular preferences in both nucleation and crystal growth processes independent of the bonding environment. The knowledge of common SCs may help in controlling the crystallisation behaviour of a given compound (Gelbrich and Hursthouse 2005). Knowledge of SCs present across different crystal environments may also be used to predict the crystal structures (Sarma and Desiraju 2002).

As has been demonstrated in this study, a realistic crystal energy landscape is an important tool for interpreting the range of experimental solid forms as well as in proposing possible structures that have yet to be crystallised. However, information about the experimental conditions and control to obtain the predicted polymorphs cannot be as yet deduced from the crystal energy landscape. The development of improved theoretical approaches for accurate calculated energy landscapes alongside establishing experimental approaches that enable specific forms to be targeted, rather than found through necessarily limited screening or serendipity is an important and still elusive goal for the control and prediction of pharmaceutical solids.

8.2 Further Work

8.2.1 *Development and Validation of High Throughput Crystallisation and Analysis Methodology for Physical Form Screening*

There is a considerable scope for the further improvement and refinement of this methodology to have better control over crystallisation conditions and reproducible results. For example, implementation of stirring element for each well such as magnetic stir disc or overhead stirrers (VP 721F-1 or VP 177-STIR system, available from VP-Scientific, US) would enable better control and dissolution as compared to currently adopted orbital shaker. Adoption of automated solvent and solute dispensing unit would enable better control over initial concentration of solution in all wells of MWP, reduce errors due to manual dispensing and provide reproducible results. Implementation of a filtration unit (96/48-well filter plate) could potentially remove the seeds or the undissolved solute left due to its less solubility in the respective solvent which can affect the crystallisation outcome.

Implementation of mica insulated temperature units specifically designed for keeping MWPs at constant temperature with/without computer control (e.g. VP 741AW-RCE-MICA-B system available from VP-Scientific, US) would allow uniform and better control over temperature during crystallisation at various temperatures.

At present, this methodology uses Raman microscopy as the analytical technique. Different solid forms of a compound may provide similar Raman spectra and novel solid forms with similar Raman spectra can be missed out (Stahly 2007). Therefore, it would be advantageous to include XRPD also to the set up to confirm the sample assignments. For initial high-throughput screening, XRPD is widely used as an analytical tool for primary identification of recrystallised samples and/or for confirmation of the sample identified by an initial Raman analysis (Morissette et al. 2003; Remenar et al. 2003). An ideal implementation would be the Bruker-AXS General Area Diffraction Detector System (GADDSTM) equipped with automated *x-y-z* sample stage with video and laser-guided sample alignment, X-ray source with small focal point and a large 2-D area detector (Storey et al. 2004). Chemometric analysis of the data obtained from both techniques would reduce chances of false positives/negatives compared to Raman data alone.

This methodology has been applied for salt, polymorph and solvate screening using solvent evaporation technique. Further investigation of this methodology for various crystallisation techniques (e.g. anti-solvent crystallisation, slurry, and co-crystal screening) and studies involving effect of water/relative humidity on API-excipient interaction, role of excipient in salt disproportionation in formulation, possible API-polymer interactions and the effect of process-induced stresses like heat, solvent, shear and pressure on the formulation will provide more confidence in its general applicability.

A large amount of data is generated using HTCAA. The application of statistical modelling techniques to this data offers a potential tool for modelling the property space which involves fitting of the crystallisation outcome (solid form, morphology etc.) with the physicochemical descriptors and experimental conditions. These models can reveal various trends between the molecular properties, experimental conditions and crystallisation outcome thus identifying the key factors responsible for observed outcome (Johnston et al. 2008; McCabe 2010). The significant statistical models can be stored and retrieved later to direct future experiments.

8.2.2 Predicting Crystallisability of Organic Molecules Using Statistical Modelling Techniques

The next step towards achieving this kind of statistical modelling approach would be to incorporate information about crystallisation conditions such as solvent, rate of solvent evaporation, RH, temperature etc. which would certainly improve the value of the training data set and hence, predictive capability. These models need to

be updated with the increasing knowledge to provide valuable information about crystallisation behaviour of a wider range of molecules. The extension and application of this kind of statistical model to salts and co-crystal may also provide additional insights into the ease to crystallisation of multi-component systems.

Various predictive models for peptides and proteins are available (see Sect. 5.1.5.6); however there are no reported models for prediction of crystallisability of small molecules. It is worth considering the reasons for this. One key reason may be the absence of large, suitable and systematically studied datasets and lack of associated data required to make these models. To make robust models, systematic studies are required to obtain sufficiently comprehensive datasets which are not commonly done. However with advancements in instrumentation and automation, it is now possible to generate huge datasets of crystallisation properties (Hursthouse 2004; Storey et al. 2004). In addition, it is also important to store all the relevant data in accessible electronic database formats. These databases with suitable statistical modelling techniques would open the avenues for researchers to study relationships between solute, solvent, physical form and crystallisation conditions (Johnston et al. 2008).

8.2.3 Exploring the Physical Form Landscape of Structurally Related Pharmaceutical Molecules in Group 1 (Olanzapine and Clozapine) and 2 (Amoxapine and Loxapine)

In OZPN, the large SC_0 dimer binding energy dominates the lattice energy. This merits further investigation of the degree of self-association in the prenucleation solution state (Parveen et al. 2005) and amorphous phase (Billinge et al. 2010).

Evidently, during OZPN nucleation in the solution recrystallisations, solid-state desolvation, grinding experiments and vapour phase crystallisations tested, OZPN molecules preferentially associate as the centrosymmetric dimer. The dominant SC_0 interactions may therefore swamp initial short length-scale aggregation such that possible structures based on alternative growth units are starved of single molecule building blocks. The possibility of finding other non-solvated OZPN polymorphs may well be enhanced by less typical crystallisation conditions (Llinàs and Goodman 2008) designed to disrupt the centrosymmetric dimer or favour the alternative molecular conformation. This might be achieved by laser induced nucleation (Sun et al. 2008), ultra-sound assisted crystallisation (Gracin et al. 2005), systematic attempts at templating, for example by crystals of related molecules (Arlin et al. 2011), polymers (Grzesiak et al. 2006; McKellar et al. 2012) or other surfaces including metals or self-assembled monolayers (Hiremath et al. 2005). The chances of success are likely to be increased by the design of a specific template to target the crystallisation of a particular alternative structure. This kind of

experimental interventions might enable the nucleation process to follow an alternative pathway to one based on SC₀.

Experimental work on LXP_N was based only on solution crystallisations. Further investigation of the experimental structure landscape by utilising multiple crystallisation techniques would potentially reveal the full extent of its solid-state diversity. Comparisons of molecular shape of all these molecules using electrostatic potential surfaces calculations and Hirshfeld surface analysis (McKinnon et al. 2004) should be explored to study the influence of overall molecular shape on distinct solid-state behaviour.

CSP studies have demonstrated their valuable role in providing more confidence in the interpretation of the experimental data. Further CSP studies using better approximation and flexible models for CZPN, AXPN and LXP_N would provide additional insights into the preferences of the packing motifs (Johnston et al. 2011). An obvious area of further work is to investigate if any of the experimentally observed crystal structure of these molecules can act as a template for the predicted structure of structurally related molecules on the crystal energy landscape (Arlin et al. 2011).

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Appendix

A.1 Physical Form Screening Results of Olanzapine (OZPN)

Table A.1 Solvent evaporation of olanzapine at room temperature (RT) and 277 K

Solvent	Evaporation at RT	Evaporation at 277 K
1,2-propanediol	Solvate hydrate	Solvate hydrate
1,2-dichloroethane	Form I	Form I
1,2-dimethoxyethane	Solvate hydrate	Solvate hydrate
1,4-butanediol	Solvate hydrate	Solvate hydrate
1,4-dioxane	Solvate hydrate	Solvate hydrate
1,5-pentanediol	No crystallisation	No crystallisation
1-butanol	Solvate hydrate	Solvate hydrate
1-methylnaphthalene	No crystallisation	No crystallisation
1-propanol	Solvate hydrate	Solvate hydrate
2-butanol	Solvate hydrate	Solvate hydrate
2-butanone	No crystallisation	Form I and solvate hydrate
2-butoxyethanol	Solvate	Solvate
2-methoxyethanol	Solvate hydrate	Solvate hydrate
2-methyl-1-butane	Insoluble	–
2-pentanol	Solvate hydrate	Solvate hydrate
3-methyl-1-butanol	Solvate hydrate	Solvate hydrate
4-fluoro toluene	Form I	Form I
Acetic acid + acetone	Solvate	Solvate
Acetone	Form I+ solvate hydrate	Form I and solvate hydrate
Acetonitrile	Solvate hydrate+ form I	Solvate hydrate and form I
Anhydrous acetonitrile	Form I	Form I
Butyl acetate	Form I	Form I and dihydrate B
Dichloromethane (DCM) + acetonitrile + water (1:1:1)	n.a.	Acetonitrile solvate hydrate
Chloroform	Form I	Solvate hydrate
Cyclohexane	Insoluble	–

(continued)

Table A.1 (continued)

Solvent	Evaporation at RT	Evaporation at 277 K
DCM	No crystallisation	Mixture of DCM solvate and DCM solvate hydrate
DCM + cyclohexane (1:1)	Solvate hydrate	Solvate hydrate
Diethyl carbonate	Form I	Form I
Diethylether	Form I	Form I
Diisopropyl ether	Form I	Form I
Dodecane + water (1:1)	Dihydrate B and D	n.a.
Ethanol	Solvate	Solvate
Ethyl acetate + water (1:1)	Dihydrate B	n.a.
Ethyl acetate	Form I	Form I
Ethyl acetate + water + acetone (1:1:1)	Dihydrate B	n.a.
Ethylene glycol	Solvate	Solvate
Formamide	Insoluble	–
Formic acid	Salt/solvate	Salt/solvate
Hexane	Insoluble	–
Isobutyl acetate	Form I	Form I and dihydrate E
Isopropyl acetate	Form I	Form I
Methanol	Solvate	Solvate
Methyl acetate	Solvate hydrate + form I	Solvate hydrate and form I, unidentified peaks
m-xylene	Form I	Form I
N,N-dimethylacetamide	Form I	Form I
N,N-dimethylformamide	Solvate hydrate	Solvate hydrate
Nitrobenzene	No crystallisation	No crystallisation
Nitromethane	Solvate hydrate	Solvate hydrate and form I
N-methyl-2-pyrrolidone (NMP)	No crystallisation	No crystallisation
Pentyl acetate	Form I	Form I
Piperidine	No crystallisation	–
Pyridine	Solvate hydrate	Solvate hydrate
t-butanol	Solvate hydrate	n.a.
t-butyl methyl ether (TBMe)	Form I + solvate hydrate	Form I and solvate hydrate
Tetrahydrofuran (THF)	No crystallisation	Solvate hydrate
Toluene	Form I	Form I
Toluene + water (1:1)	Dihydrate D + E	n.a.
Trichloroethylene	Form I + solvate hydrate	Solvate hydrate
2,2,2-trifluoroethanol	No crystallisation	Solvate

n.a. not attempted

Table A.2 Fast solvent evaporation (on watch glass) of olanzapine at room temperature

Solvent	Results
1,4-dioxane	No sample
1-butanol	Solvate hydrate
1-propanol	Solvate hydrate
2-butanone	Solvate hydrate
Acetic acid	Solvate
Acetone	Solvate hydrate
Acetonitrile	Solvate hydrate
Butyl acetate	Dihydrate B
Chloroform	Solvate hydrate and form I
Ethanol	Solvate
Ethyl acetate	Dihydrate B and dihydrate E
Isopropyl acetate	Dihydrate B
Isoamyl alcohol	Solvate hydrate and dihydrate B
Methanol	Solvate
Nitromethane	Solvate hydrate
NMP	No sample
Pyridine	Solvate hydrate
TBMe	Solvate hydrate
THF	Solvate hydrate
Trichloroethylene	Solvate hydrate and form I
2,2,2-trifluoroethanol	Solvate hydrate

Table A.3 Cooling/evaporative crystallisation of olanzapine on Automated Platform Crystalliser

Solvent	Solvent dose (ml)	Crystallisation method	T sat (K)	T cool (K)	Vortex (rpm)	Vacuum (mbar)	Result
1-bromo-2-chloroethane	3	Cooling	343	298	850	NA	Solvate and form I
1-bromo-2-chloroethane	3	Cooling	343	298	850	NA	Solvate
1-bromobutane	3	Cooling	343	298	850	NA	No sample
1-bromobutane	3	Cooling	343	298	850	NA	No sample
1-methylnaphthalene	3	Cooling/solvent evaporation	343	298	850	NA	Solvate hydrate
1-methylnaphthalene	3	Cooling/solvent evaporation	343	298	850	NA	Form I
1-octanol	3	Cooling	343	298	850	NA/50	Solvate
1-octanol	3	Cooling	343	298	850	NA/50	Solvate
2-butanone	3	Cooling	343	298	850	NA	Form I and solvate hydrate
2-butanone	3	Cooling	343	298	850	NA	Solvate hydrate
2-methoxyethylether	3	Cooling	343	298	850	NA/50	Form I
2-methoxyethylether	3	Cooling	343	298	850	NA/50	Solvate hydrate
Benzene	3	Cooling	343	298	850	NA	Form I
Benzene	3	cooling	343	298	850	NA	Solvate hydrate
Bromoform	3	Cooling	343	298	850	NA/50	Form I
Bromoform	3	Cooling	343	298	850	NA/50	Solvate hydrate
Butyl ether	3	Cooling	343	298	850	NA/50	Solvate hydrate
Butyl ether	3	Cooling	343	298	850	NA/50	Solvate hydrate
Cyclohexane	3	Cooling	343	298	850	NA	Solvate hydrate and form I
Cyclohexane	3	Cooling	343	298	850	NA	Solvate hydrate
N,N-dimethylacetamide	3	Cooling	343	298	850	NA/50	Solvate hydrate
N,N-dimethylacetamide	3	Cooling	343	298	850	NA/50	Solvate hydrate
Dimethyl sulphoxide	3	Cooling	343	298	850	NA/50	Solvate hydrate

(continued)

Table A.3 (continued)

Solvent	Solvent dose (ml)	Crystallisation method	T sat (K)	T cool (K)	Vortex (rpm)	Vacuum (mbar)	Result
Dimethyl sulphoxide	3	Cooling	343	298	850	NA/50	Solvate hydrate
Dodecane	3	Cooling/solvent evaporation	343	298	850	NA	Solvate hydrate
Dodecane	3	Cooling/solvent evaporation	343	298	850	NA	Form I
Formamide	3	Cooling/solvent evaporation	343	298	850	NA	No crystallisation
Formamide	3	Cooling/solvent evaporation	343	298	850	NA	No crystallisation
Furfural	3	Cooling	343	298	850	NA/50	Solvate hydrate
Furfural	3	Cooling	343	298	850	NA/50	Solvate hydrate
Methanoic acid	3	Cooling	343	298	850	NA	No sample
Methanoic acid	3	Cooling	343	298	850	NA	No sample
Nitromethane	3	Cooling	343	298	850	NA	Form I
Nitromethane	3	Cooling	343	298	850	NA	Form I
NMP	3	Cooling/solvent evaporation	343	298	850	NA	Solvate hydrate
NMP	3	Cooling/solvent evaporation	343	298	850	NA	Solvate hydrate
Pentyl acetate	3	Cooling	343	298	850	NA/50	Solvate hydrate
Pentyl acetate	3	Cooling	343	298	850	NA/50	Form I and solvate hydrate
Tetrahydrothiophene	3	Cooling	343	298	850	NA	No sample
Tetrahydrothiophene	3	Cooling	343	298	850	NA	No sample
Thioacetic acid	3	Cooling	343	298	850	NA	No sample
Thioacetic acid	3	Cooling	343	298	850	NA	No sample
Trichloroethylene	3	Cooling	343	298	850	NA	Form I

(continued)

Table A.3 (continued)

Solvent	Solvent dose (ml)	Crystallisation method	T sat (K)	T cool (K)	Vortex (rpm)	Vacuum (mbar)	Result
Trichloroethylene	3	Cooling	343	298	850	NA	Solvate hydrate
N,N,N-triethylamine	3	Cooling	343	298	850	NA	Solvate hydrate
N,N,N-triethylamine	3	Cooling	343	298	850	NA	Solvate hydrate
Water	3	Cooling	343	298	850	NA	No sample
Water	3	Cooling	343	298	850	NA	No sample
Acetonitrile	3	Evaporative	303	303	850	NA	Solvate hydrate and unidentified phase
Acetonitrile	3	Evaporative	303	303	850	NA	Solvate hydrate
Chloroform	3	Evaporative	303	303	850	NA	Solvate hydrate
Chloroform	3	Evaporative	303	303	850	NA	Solvate hydrate
DCM	3	Evaporative	303	303	850	NA	Form I
DCM	3	Evaporative	303	303	850	NA	DCM solvate and DCM solvate hydrate
Iodomethane	3	Evaporative	303	303	850	NA	No sample
Iodomethane	3	Evaporative	303	303	850	NA	No sample
1-butanol	3	Evaporative	323	323	850	50	Solvate hydrate
1-butanol	3	Evaporative	323	323	850	50	Solvate hydrate
Acetonitrile	3	Evaporative	323	323	850	50	Form I
Acetonitrile	3	Evaporative	323	323	850	50+RT ^a	Solvate hydrate
Bromoform	3	Evaporative	323	323	850	50	Form I
Carbon tetrachloride	3	Evaporative	323	323	850	50	Form I
Carbon tetrachloride	3	Evaporative	323	323	850	50/RT ^a	Solvate hydrate
Ethanol	3	Evaporative	323	323	850	50	Solvate
Ethanol	3	Evaporative	323	323	850	50	Solvate
Methanol	3	Evaporative	323	323	850	50	Form I and solvate hydrate

(continued)

Table A.3 (continued)

Solvent	Solvent dose (ml)	Crystallisation method	T sat (K)	T cool (K)	Vortex (rpm)	Vacuum (mbar)	Result
Methanol	3	Evaporative	323	323	850	50+RT ^a	Solvate hydrate
Nitromethane	3	Evaporative	323	323	850	50	Form I
Nitromethane	3	Evaporative	323	323	850	50+RT ^a	Solvate hydrate
Pyridine	3	Evaporative	323	323	850	50	Form I
Tetrachloroethylene	3	Evaporative	323	323	850	50	Form I
Tetrachloroethylene	3	Evaporative	323	323	850	50/RT ^a	Solvate hydrate
2,2,2-trifluoroethanol	3	Evaporative	323	323	850	50	No sample
2,2,2-trifluoroethanol	3	Evaporative	323	323	850	50/RT ^a	Solvate hydrate
Water	3	Evaporative	323	323	850	50	No sample

NA not applicable

^aafter 9 h at 323 K, the temperature was decreased to room temperature

Table A.4 Antisolvent crystallisation of olanzapine

Solvent	Antisolvent	Result
1-butanol	Cyclohexane	Solvate hydrate
	Diisopropylether	Solvate hydrate
	Heptane	Solvate hydrate
2-butanone	Cyclohexane	Form I and solvate hydrate
	Diisopropylether	Form I and solvate hydrate
	Heptane	Form I and solvate hydrate
1,4-dioxane	Cyclohexane	Solvate hydrate
	Diisopropylether	Solvate hydrate
	Heptane	Solvate hydrate
1-propanol	Cyclohexane	Solvate hydrate
	Diisopropylether	Solvate hydrate
	Heptane	Solvate hydrate
Acetonitrile	Cyclohexane	Solvate hydrate
	Diisopropylether	Solvate hydrate
	Heptane	Solvate hydrate
Acetic acid	Cyclohexane	Solvate and unidentified phase
	Diisopropylether	Solvate and unidentified phase
	Heptane	Solvate and unidentified phase
Acetone	Cyclohexane	Form I and solvate hydrate
	Diisopropylether	Form I and solvate hydrate
	Heptane	Solvate hydrate+ form I
Butyl acetate	Cyclohexane	Form I and dihydrate B
	Diisopropylether	Dihydrate B
	Heptane	Form I and dihydrate B
Chloroform	Cyclohexane	Solvate hydrate
	Diisopropylether	Solvate hydrate
	Heptane	Solvate hydrate
Ethanol	Cyclohexane	Solvate hydrate
	Diisopropylether	Solvate hydrate
	Heptane	Solvate hydrate
Ethyl acetate	Cyclohexane	Dihydrate B
	Diisopropylether	Dihydrate B
	Heptane	Form I and dihydrate B
Isoamyl alcohol	Cyclohexane	Solvate hydrate
	Diisopropylether	Solvate hydrate
	Heptane	Solvate hydrate
Isopropyl acetate	Cyclohexane	Form I and dihydrate B
	Diisopropylether	Form I
	Heptane	Form I

(continued)

Table A.4 (continued)

Solvent	Antisolvent	Result
Methanol	Cyclohexane	Solvate
	Diisopropylether	Solvate
	Heptane	Solvate
Nitromethane	Cyclohexane	Solvate hydrate
	Diisopropylether	Solvate hydrate
	Heptane	Solvate hydrate
NMP	Cyclohexane	No sample
	Diisopropylether	No sample
	Heptane	No sample
Pyridine	Cyclohexane	Solvate hydrate
	Diisopropylether	Solvate hydrate
	Heptane	Solvate hydrate
TBMe	Cyclohexane	Form 1 and solvate hydrate
	Diisopropylether	Form 1 and + solvate hydrate
	Heptane	Dihydrate B
2,2,2-trifluoroethanol	Cyclohexane	Solvate hydrate (isostructural to C ₂ /c group)
	Diisopropylether	Solvate hydrate (isostructural to C ₂ /c group) and trifluoroethanol solvate
	Heptane	Solvate hydrate (isostructural to C ₂ /c group)
THF	Cyclohexane	Solvate hydrate
	Diisopropylether	Solvate hydrate
	Heptane	Solvate hydrate
Trichloroethylene	Cyclohexane	Form I
	Diisopropylether	No sample
	Heptane	Dihydrate E and B

Table A.5 Solution crystallisation of olanzapine on functionalised surfaces

Surface	Results
(3-Aminopropyl)triethoxysilane (APTES)	Form I
(3-Aminopropyl)triethoxysilane (APTES)	Form I
(3-glycidoxypropyl) trimethoxysilane (GPTMS)	Form I
(3-glycidoxypropyl) trimethoxysilane (GPTMS)	Form I
(3-Mercaptopropyl)trimethoxysilane (MPTMS)	Form I
(3-Mercaptopropyl)trimethoxysilane (MPTMS)	Form I
Mica	Form I
Mica	Form I
Silicon wafer	Form I
Silicon wafer	Form I
Trimethoxy(propyl)silane (TPS)	Form I
Trimethoxy(propyl)silane (TPS)	Form I

Table A.6 Crystallisation of olanzapine by pH swing

(a)			
	pH	Base	Results
OZPN and acetic acid	9	15 % Ammonium hydroxide	Dihydrate B
OZPN and acetic acid	10	30 % Ammonium hydroxide	Dihydrate B
OZPN and acetic acid	9	50 % Aq NaOH	Dihydrate B
OZPN and acetic acid	8	10 % Methanolic NaOH	Methanol solvate
OZPN and acetic acid	10	50 % Aq NaOH	Dihydrate B
(b)			
Salt	pH	Base	Results
Adipate	12	50 % Aq NaOH	Dihydrate B
Citrate	12	50 % Aq NaOH	Dihydrate B
Formate	12	50 % Aq NaOH	Dihydrate B
Fumarate	12	50 % Aq NaOH	Dihydrate B
Glutarate	12	50 % Aq NaOH	Dihydrate B
Glycolate	12	50 % Aq NaOH	Dihydrate B
Hydrochloride	8	50 % Aq NaOH	Dihydrate B + D
Hydrochloride	12	50 % Aq NaOH	Dihydrate B
L-Tartrate	12	50 % Aq NaOH	Dihydrate B
L-malate	12	50 % Aq NaOH	Dihydrate B
Maleate	12	50 % Aq NaOH	Dihydrate B
Tosylate	12	50 % Aq NaOH	Dihydrate B
Succinate	12	50 % Aq NaOH	Dihydrate B

Table A.7 X-ray crystallographic crystal data, data collection and refinement details for olanzapine and its solvates

	Form I	Form II	2-butoxyethanol	2,2,2-trifluoroethanol
Chemical formula	$C_{17}H_{20}N_4S$	$C_{17}H_{20}N_4S$	$C_{17}H_{20}N_4S \cdot (C_4H_{14}O_2)$	$C_{17}H_{20}N_4S \cdot 2(C_2F_3H_3O)$
M_r	312.43	312.43	430.60	512.52
Crystal system, space group	Monoclinic, $P2_1/c$	Monoclinic, $P2_1/c$	Monoclinic, $P2_1/c$	Monoclinic, $P2_1/c$
Temperature (K)	123	123	123	123
a, b, c (Å)	10.3411 (13), 14.521 (2), 10.5314 (14)	9.8544 (14), 16.314 (2), 9.9754 (12)	10.442 (1), 17.7328 (15), 15.5165 (13)	12.7244 (9), 11.7538 (8), 16.0067 (11)
α, β, γ (°)	90, 100.291 (4), 90	90, 98.304 (8), 90	90, 126.279 (5), 90	90, 94.782 (2), 90
V (Å ³)	1555.9 (4)	1586.9 (4)	2316.2 (4)	2385.6 (3)
Z	4	4	4	4
Radiation type	Mo $K\alpha$	Mo $K\alpha$	Mo $K\alpha$	Mo $K\alpha$
μ (mm ⁻¹)	0.21	0.21	0.17	0.21
Crystal size (mm)	$0.20 \times 0.18 \times 0.09$	$0.34 \times 0.14 \times 0.03$	$0.12 \times 0.10 \times 0.04$	$0.39 \times 0.23 \times 0.21$
Data collection				
Diffractometer	Bruker APEX-II CCD	Bruker APEX-II CCD	Bruker APEX-II CCD	Bruker APEX-II CCD
Absorption correction	Multi-scan SADABS	Multi-scan SADABS	Multi-scan SADABS	Multi-scan SADABS
T_{\min}, T_{\max}	0.648, 0.745	0.537, 0.745	0.672, 0.746	0.648, 0.745
No. of measured, independent and observed $ I > 2\sigma(I)$ reflections	12077, 3194, 2735	11000, 3115, 1892	47912, 6074, 4445	16124, 4689, 3190
R_{int}	0.028	0.085	0.048	0.039
Refinement				
$R[F^2 > 2s(F^2)], wR(F^2), S$	0.033, 0.087, 1.03	0.054, 0.142, 1.00	0.039, 0.101, 1.02	0.058, 0.156, 1.06
No. of reflections	3194	3115	6074	4689
No. of parameters	205	205	282	321
No. of restraints	0	1	0	1
H-atom treatment	Mixed [†]	Mixed [†]	Mixed [†]	Mixed [†]
$\Delta)_{\text{max}}, \Delta)_{\text{min}}$ (e Å ⁻³)	0.34, -0.22	0.47, -0.43	0.29, -0.32	0.49, -0.44

(continued)

Table A.7 (continued)

	Acetic acid	Ethylene glycol	Ethanol	TBMe hydrate
Chemical formula	$C_{17}H_{20}N_4S \cdot (C_2H_4O_2)$	$C_{17}H_{20}N_4S \cdot (C_2H_6O_2)$	$C_{17}H_{20}N_4S \cdot (C_2H_6O)$	$C_{17}H_{20}N_4S \cdot (C_5H_{12}O) \cdot 2(H_2O)$
M_r	372.48	375.51	358.50	436.61
Crystal system, space group	Monoclinic, $P2_1/c$	Monoclinic, $P2_1/c$	Monoclinic, $P2_1/c$	Monoclinic, $P2_1/c$
Temperature (K)	123	123	123	123
a, b, c (Å)	10.0427(11), 12.7430(13), 14.3886(15)	9.8393(16), 13.278(2), 14.588(2)	10.3489(18), 13.003(2), 13.870(2)	14.2070(1), 12.221(9), 14.550(1)
α, β, γ (°)	90, 92.436(4), 90	90, 96.328(7), 90	90, 92.496(6), 90	90, 109.239(3), 90
V (Å ³)	1839.7(3)	1894.4(5)	1864.7(5)	2385.2(2)
Z	4	4	4	4
Radiation type	Mo $K\alpha$	Mo $K\alpha$	Mo $K\alpha$	Mo $K\alpha$
μ (mm ⁻¹)	0.2	0.19	0.19	0.17
Crystal size (mm)	$0.60 \times 0.30 \times 0.15$	$0.12 \times 0.08 \times 0.04$	$0.15 \times 0.07 \times 0.04$	$0.51 \times 0.32 \times 0.12$
<i>Data collection</i>				
Diffractometer	Bruker APEX-II CCD	Bruker APEX-II CCD	Bruker APEX-II CCD	Bruker APEX-II CCD
Absorption correction	Multi-scan SADABS	Multi-scan SADABS	Multi-scan SADABS	Multi-scan SADABS
T_{\min}, T_{\max}	0.701, 0.746	0.540, 0.745	0.656, 0.745	0.643, 0.745
No. of measured, independent and observed $ l > 2s(I)$ reflections	19550, 4040, 3686	14389, 3718, 2441	14895, 3746, 2596	44786, 4915, 3962
R_{int}	0.014	0.093	0.047	0.040
<i>Refinement</i>				
$R[F^2 > 2s(F^2)], wR(F^2), S$	0.031, 0.100, 1.14	0.064, 0.172, 1.01	0.041, 0.094, 1.03	0.049, 0.143, 1.02
No. of reflections	4040	3718	3746	4915
No. of parameters	246	249	237	326
No. of restraints	1	0	0	5
H-atom treatment	Mixed ¹	Mixed ¹	Mixed ¹	Mixed ¹
$\Delta)_{\text{max}}, \Delta)_{\text{min}}$ (e Å ⁻³)	0.40, -0.31	0.87, -0.37	0.35, -0.25	1.37, -0.51

(continued)

Table A.7 (continued)

	2-pentanol hydrate	N,N,N-triethylamine hydrate	t-butanol hydrate	3-methyl-1-butanol hydrate
Chemical formula	$C_{17}H_{20}N_4S \cdot (C_5H_{12}O) \cdot (H_2O)$	$C_{17}H_{20}N_4S \cdot 0.5 (C_6H_{15}N) \cdot 2(H_2O)$	$2(C_{17}H_{20}N_4S) \cdot 2C_4H_{10}O \cdot 5(H_2O)$	$2(C_{17}H_{20}N_4S) \cdot 2(C_3H_7O) \cdot 2(H_2O)$
M_r	418.59	399.06	863.18	837.18
Crystal system, space group	Monoclinic, $P2_1/c$	Monoclinic, $P2_1/c$	Monoclinic, $P2_1/c$	Triclinic, $P-1$
Temperature (K)	123	123	123	123
a, b, c (Å)	13.4466 (10), 12.3833 (9), 14.5522 (9)	14.817(1), 12.623(1), 14.461(1)	14.2491 (9), 12.3838 (8), 27.1418 (17)	12.3420 (17), 13.3559 (18), 14.630 (2)
α, β, γ (°)	90, 104.839 (2), 90	90, 113.36 (2), 90	90, 99.052 (2), 90	105.883 (6), 90.290 (6), 92.005 (6)
V (Å ³)	2342.3 (3)	2483.0 (3)	4729.7 (5)	2317.9 (5)
Z	4	4	12	2
Radiation type	Mo $K\alpha$	Mo $K\alpha$	Mo $K\alpha$	Mo $K\alpha$
μ (mm ⁻¹)	0.16	0.15	0.17	0.16
Crystal size (mm)	$0.53 \times 0.19 \times 0.08$	$0.55 \times 0.25 \times 0.12$	$0.21 \times 0.19 \times 0.05$	$0.51 \times 0.21 \times 0.12$
<i>Data collection</i>				
Diffractometer	Bruker APEX-II CCD	Bruker APEX-II CCD	Bruker APEX-II CCD	Bruker APEX-II CCD
Absorption correction	Multi-scan SADABS	Multi-scan SADABS	Multi-scan SADABS	Multi-scan SADABS
T_{\min}, T_{\max}	0.688, 0.746	0.651, 0.745	0.449, 0.745	0.608, 0.745
No. of measured, independent and observed [$I > 2\sigma(I)$] reflections	33467, 4604, 3805	23283, 5090, 3419	35550, 9701, 7175	30830, 8815, 7345
R_{int}	0.028	0.042	0.046	0.039
<i>Refinement</i>				
$R[F^2 > 2\sigma(F^2)], wR(F^2), S$	0.044, 0.126, 1.03	0.092, 0.331, 1.28	0.047, 0.142, 1.02	0.082, 0.240, 1.03
No. of reflections	4604	5090	9701	8815
No. of parameters	290	364	598	560

(continued)

Table A.7 (continued)

No. of restraints	2-pentanol hydrate	N,N,N-triethylamine hydrate	t-butanol hydrate	3-methyl-1-butanol hydrate
H-atom treatment	8	322	6	0
$\Delta/\max, \Delta/\min$ ($e \text{ \AA}^{-3}$)	Mixed ¹ 0.59, -0.33	Mixed ¹ 1.04, -0.67	Mixed ¹ 0.46, -0.26	Mixed ¹ 1.93, -0.52
Chemical formula	1,4-butanediol hydrate $2(\text{C}_{17}\text{H}_{30}\text{N}_4\text{S}) \cdot (\text{C}_4\text{O}_2\text{H}_{10}) \cdot 2(\text{H}_2\text{O})$	DMF hydrate $2(\text{C}_{17}\text{H}_{30}\text{N}_4\text{S}) \cdot (\text{C}_3\text{H}_7\text{NO}) \cdot 2(\text{H}_2\text{O})$	Pyridine hydrate $2(\text{C}_{17}\text{H}_{20}\text{N}_4\text{S}) \cdot (\text{C}_5\text{H}_5\text{O}) \cdot 2(\text{H}_2\text{O})$	THF hydrate $\text{C}_{17}\text{H}_{30}\text{N}_4\text{S} \cdot 0.5(\text{C}_4\text{H}_8\text{O}) \cdot (\text{H}_2\text{O})$
M_r	751.01	733.99	739.99	366.50
Crystal system, space group	Triclinic, $P-1$	Monoclinic, $P2_1/c$	Monoclinic, $P2_1/c$	Monoclinic, $C2/c$
Temperature (K)	123	123	123	123
a, b, c (\AA)	12.2637 (11), 14.1146 (10), 14.1783 (12)	14.9885 (9), 12.7558 (7), 19.8567 (12)	14.8824 (7), 12.7289 (7), 20.3218 (11)	24.2355 (10), 12.5913 (5), 15.0767 (6)
α, β, γ ($^\circ$)	63.985 (3), 65.649 (4), 65.437 (4)	90, 93.348 (2), 90	90, 93.465 (2), 90	90, 124.999 (1), 90
V (\AA^3)	1924.9 (3)	3789.9 (4)	3842.7 (3)	3768.8 (3)
Z	2	4	4	8
Radiation type	Mo $K\alpha$	Mo $K\alpha$	Mo $K\alpha$	Mo $K\alpha$
μ (mm^{-1})	0.19	0.19	0.19	0.19
Crystal size (mm)	$0.10 \times 0.07 \times 0.05$	$0.41 \times 0.34 \times 0.12$	$0.15 \times 0.08 \times 0.03$	$0.35 \times 0.24 \times 0.05$
<i>Data collection</i>				
Diffractionmeter	Bruker APEX-II CCD	Bruker APEX-II CCD	Bruker APEX-II CCD	Bruker APEX-II CCD
Absorption correction	Multi-scan SADABS	Multi-scan SADABS	Multi-scan SADABS	Multi-scan SADABS
T_{\min}, T_{\max}	0.670, 0.745	0.539, 0.745	0.662, 0.746	0.634, 0.745
No. of measured, independent and observed [$I > 2s(I)$] reflections	35551, 7560, 6322	29202, 7753, 5522	63158, 7558, 5873	15067, 3637, 3219
R_{int}	0.03	0.045	0.034	0.026

(continued)

Table A.7 (continued)

	1,4-butanediol hydrate	DMF hydrate	Pyridine hydrate	THF hydrate
<i>Refinement</i>				
$R[F^2 > 2s(F^2)]$, $wR(F^2)$, S	0.035, 0.092, 1.02	0.040, 0.114, 1.01	0.035, 0.103, 1.03	0.042, 0.115, 1.03
No. of reflections	7560	7753	7558	3637
No. of parameters	505	494	497	267
No. of restraints	4	0	0	34
H-atom treatment	Mixed ¹	Mixed ¹	Mixed ¹	Mixed ¹
$\Delta\rho_{\max}$, $\Delta\rho_{\min}$ (e Å ⁻³)	0.29, -0.26	0.35, -0.26	0.40, -0.25	0.54, -0.56
	1,4-dioxane hydrate	Acetone hydrate	1-butanol hydrate ^a	Acetonitrile ^b
Chemical formula	C ₁₇ H ₂₀ N ₄ S · 0.5 (C ₄ H ₈ O ₂) · (H ₂ O)	C ₁₇ H ₂₀ N ₄ S · 0.5 (C ₃ H ₆ O) · H ₂ O	C ₁₇ H ₂₀ N ₄ S · 0.5 (C ₄ H ₁₀ O) · H ₂ O	(C ₁₇ H ₂₀ N ₄ S) · (C ₂ H ₃ N) · (H ₂ O)
M_r	372.48	359.48	367.50	368.48
Crystal system, space group	Monoclinic, C2/c	Monoclinic, C2/c	Monoclinic, C2/c	Monoclinic, C2/c
Temperature (K)	123	123	123	123
a , b , c (Å)	24.447 (3), 12.5660 (16), 14.9591 (19)	24.226 (2), 12.5269 (12), 15.0737 (15)	24.575 (6), 12.429 (3), 15.006 (3)	24.381 (2), 12.3856 (9), 15.0565 (14)
α , β , γ (°)	90, 125.421 (5), 90	90, 124.976 (4), 90	90, 125.255 (7), 90	90, 125.321 (7), 90
V (Å ³)	3744.9 (8)	3748.3 (6)	3743.1 (15)	3709.8 (6)
Z	8	8	8	8
Radiation type	Mo $K\alpha$	Mo $K\alpha$	Mo $K\alpha$	Mo $K\alpha$
μ (mm ⁻¹)	0.19	0.19	0.18	0.19
Crystal size (mm)	0.35 × 0.24 × 0.05	0.24 × 0.18 × 0.05	0.40 × 0.35 × 0.10	0.40 × 0.20 × 0.10
<i>Data collection</i>				
Diffractometer	Bruker APEX-II CCD	Bruker APEX-II CCD	Bruker APEX-II CCD	Bruker APEX-II CCD
Absorption correction	Multi-scan SADABS	Multi-scan SADABS	Multi-scan SADABS	Multi-scan SADABS

(continued)

Table A.7 (continued)

	1,4-dioxane hydrate	Acetone hydrate	1-butanol hydrate ^a	Acetonitrile ^b
T_{\min}, T_{\max}	0.680, 0.745	0.691, 0.745	0.701, 0.745	0.693, 0.746
No. of measured, independent and observed $[I > 2\sigma(I)]$ reflections	25185, 3686, 2615	25336, 3850, 2421	20876, 3827, 3457	64953, 5672, 4818
R_{int}	0.046	0.076	0.017	0.024
<i>Refinement</i>				
$R[F^2 > 2\sigma(F^2)], wR(F^2), S$	0.081, 0.237, 1.03	0.046, 0.118, 1.03	0.047, 0.121, 1.07	0.058, 0.195, 1.14
No. of reflections	3686	3850	3827	5672
No. of parameters	238	267	219	247
No. of restraints	0	15	3	216
H-atom treatment	Mixed ^l	Mixed ^l	Mixed ^l	Mixed ^l
$\Delta_{\text{max}}, \Delta_{\text{min}} (\text{e } \text{\AA}^{-3})$	2.32, -0.51	0.31, -0.46	0.49, -0.55	1.85, -1.07
	Nitromethane hydrate ^a	1,2-dimethoxyethane hydrate ^c	2-methoxyethanol hydrate	Methyl acetate hydrate
Chemical formula	$\text{C}_{17}\text{H}_{20}\text{N}_4\text{S} \cdot 0.5 (\text{CH}_3\text{NO}_2) \cdot \text{H}_2\text{O}$	$(\text{C}_{17}\text{H}_{20}\text{N}_4\text{S}) \cdot (\text{C}_4\text{H}_{10}\text{O}_2) \cdot (\text{H}_2\text{O})$	$\text{C}_{17}\text{H}_{20}\text{N}_4\text{S} \cdot 0.5 (\text{C}_3\text{H}_8\text{O}_2) \cdot (\text{H}_2\text{O})$	$\text{C}_{17}\text{H}_{20}\text{N}_4\text{S} \cdot 0.5(\text{C}_3\text{H}_8\text{O}_2) \cdot \text{H}_2\text{O}$
M_r	361.95	330.45	368.49	367.48
Crystal system, space group	Monoclinic, C2/c	Monoclinic, C2/c	Monoclinic, C2/c	Monoclinic, C2/c
Temperature (K)	123	123	123	123
a, b, c (Å)	24.352 (3), 12.3706 (13), 15.0182 (18)	24.4675 (13), 12.2298 (8), 15.1073 (8)	25.0869 (8), 12.3821 (4), 15.1983 (5)	24.899 (4), 12.5316 (19), 15.243 (2)
α, β, γ (°)	90, 125.531 (5), 90	90, 125.675 (2), 90	90, 126.872 (1), 90	90, 126.990 (5), 90
V (Å ³)	3681.9 (7)	3672.3 (4)	3776.7 (2)	3798.9 (10)
Z	8	8	8	8
Radiation type	Mo $K\alpha$	Mo $K\alpha$	Mo $K\alpha$	Mo $K\alpha$
μ (mm ⁻¹)	0.19	0.19	0.19	0.19
Crystal size (mm)	0.39 × 0.25 × 0.07	0.44 × 0.28 × 0.10	0.24 × 0.18 × 0.05	0.42 × 0.39 × 0.07

(continued)

Table A.7 (continued)

	Nitromethane hydrate ^a	1,2-dimethoxyethane hydrate ^c	2-methoxyethanol hydrate	Methyl acetate hydrate
<i>Data collection</i>				
Diffractometer	Bruker APEX-II CCD diffractometer	Bruker APEX-II CCD	Bruker APEX-II CCD	Bruker APEX-II CCD
Absorption correction	Multi-scan SADABS	Multi-scan SADABS	Multi-scan SADABS	Multi-scan SADABS
T_{\min} , T_{\max}	0.673, 0.745	0.663, 0.745	0.697, 0.746	0.680, 0.746
No. of measured, independent and observed $[I > 2\sigma(I)]$ reflections	32496, 3620, 3219	13280, 3598, 2382	26974, 3722, 3105	26450, 3751, 3148
R_{int}	0.033	0.042	0.029	0.030
<i>Refinement</i>				
$R[F^2 > 2\sigma(F^2)]$, $wR(F^2)$, S	0.033, 0.101, 1.12	0.053, 0.133, 1.02	0.068, 0.191, 1.04	0.045, 0.129, 1.07
No. of reflections	3620	3598	3722	3751
No. of parameters	222	220	236	257
No. of restraints	2	3	13	6
H-atom treatment	Mixed ¹	Mixed ¹	Mixed ¹	Mixed ¹
Δ_{max} , Δ_{min} ($e \text{ \AA}^{-3}$)	0.32, -0.24	0.28, -0.24	1.43, -1.12	0.96, -0.44
Chemical formula	1,2-propanediol hydrate ^d $\text{C}_{17}\text{H}_{20}\text{N}_4\text{S} \cdot (\text{C}_3\text{H}_8\text{O}_2) \cdot (\text{H}_2\text{O})$	1-propanol hydrate $\text{C}_{17}\text{H}_{20}\text{N}_4\text{S} \cdot 0.5 (\text{C}_3\text{H}_8\text{O}) \cdot (\text{H}_2\text{O})$	Methanol $\text{C}_{17}\text{H}_{20}\text{N}_4\text{S}(\text{CH}_3\text{O})$	Dichloromethane $2(\text{C}_{17}\text{H}_{20}\text{N}_4\text{S}) \cdot (\text{CH}_2\text{Cl}_2)$
M_r	369.47	360.49	344.47	709.79
Crystal system, space group	Monoclinic, $C2/c$	Monoclinic, $C2/c$	Monoclinic, $P2_1/c$	Triclinic, $P-1$
Temperature (K)	123	123	123	123
a , b , c (Å)	24.704 (2), 12.1883 (10), 15.1242 (12)	24.4748 (13), 12.3515 (6), 15.1109 (8)	10.1493 (9), 12.2895 (10), 14.0944 (13)	9.6671 (15), 11.5070 (17), 16.697 (2)
α , β , γ ($^\circ$)	90, 125.206 (3), 90	90, 125.649 (1), 90	90, 91.905 (5), 90	103.991 (6), 96.989 (6), 99.825 (6)

(continued)

Table A.7 (continued)

	1,2-propanediol hydrate ^d	1-propanol hydrate	Methanol	Dichloromethane
V (Å ³)	3712.0 (5)	3712.0 (3)	1757.0 (3)	1749.8 (4)
Z	8	8	4	2
Radiation type	Mo $K\alpha$	Mo $K\alpha$	Mo $K\alpha$	Mo $K\alpha$
μ (mm ⁻¹)	0.20	0.19	0.2	0.34
Crystal size (mm)	$0.28 \times 0.22 \times 0.08$	$0.39 \times 0.36 \times 0.07$	$0.14 \times 0.07 \times 0.04$	$0.60 \times 0.30 \times 0.15$
<i>Data collection</i>				
Diffractometer	Bruker APEX-II CCD	Bruker APEX-II CCD	Bruker APEX-II CCD	Bruker APEX-II CCD
Absorption correction	Multi-scan SADABS	Multi-scan SADABS	Multi-scan SADABS	Multi-scan SADABS
T_{\min} , T_{\max}	0.699, 0.746	0.674, 0.745	0.665, 0.746	0.680, 0.745
No. of measured, independent and observed [$I > 2s(I)$] reflections	26423, 3649, 2911	15925, 3775, 3337	18613, 4068, 2964	22706, 6166, 5615
R_{int}	0.034	0.019	0.033	0.016
<i>Refinement</i>				
$R[F^2 > 2s(F^2)]$, $wR(F^2)$, S	0.053, 0.154, 1.06	0.034, 0.091, 1.04	0.039, 0.100, 1.03	0.028, 0.073, 1.05
No. of reflections	3649	3775	4068	6166
No. of parameters	258	266	225	436
No. of restraints	13	4	0	0
H-atom treatment	Mixed ¹	Mixed ¹	Mixed ¹	Mixed ¹
$\Delta\rho_{\text{max}}$, $\Delta\rho_{\text{min}}$ (e Å ⁻³)	1.26, -0.62	0.43, -0.21	0.29 -0.24	0.28, -0.24
Chemical formula		Dihydrate B	Higher hydrate	
M_r		C ₁₇ H ₂₀ N ₄ S ₂ (H ₂ O)	C ₁₇ H ₂₀ N ₄ S ₂ ·2.5(H ₂ O)	
Crystal system, space group		348, 46	357, 47	
Temperature (K)		Monoclinic, $P2_1/c$	Monoclinic, $C2/c$	
a , b , c (Å)		123	123	
α , β , γ (°)		9.846 (2), 12.672 (3), 14.384 (3)	24.940 (6), 12.156 (3), 14.867 (3)	
		90, 92.724 (9), 90	90, 124.928 (6), 90	

(continued)

Table A.7 (continued)

	Dihydrate B	Higher hydrate
V (\AA^3)	1792.7 (7)	3695.2 (14)
Z	4	8
Radiation type	Mo $K\alpha$	Mo $K\alpha$
μ (mm^{-1})	0.20	0.20
Crystal size (mm)	$0.27 \times 0.26 \times 0.02$	$0.24 \times 0.21 \times 0.10$
<i>Data collection</i>		
Diffractometer	Bruker APEX-II CCD	Bruker APEX-II CCD
Absorption correction	Multi-scan SADABS	Multi-scan SADABS
$T_{\text{min}}, T_{\text{max}}$	0.688, 0.745	0.374, 0.745
No. of measured, independent and observed [$I > 2s(I)$] reflections	13492, 3655, 2881	12338, 3582, 2479
R_{int}	0.028	0.063
<i>Refinement</i>		
$R[F^2 > 2s(F^2)], wR(F^2), S$	0.039, 0.098, 1.02	0.070, 0.210, 1.05
No. of reflections	3655	3582
No. of parameters	235	250
No. of restraints	4	10
H-atom treatment	Mixed ^l	Mixed ^l
$\Delta_{\text{max}}, \Delta_{\text{min}}$ (\AA^{-3})	0.57, -0.37	0.60, -0.48

^lH atoms treated by a mixture of independent and constrained refinement

^aStoichiometric information was obtained from TGA analysis

^bStoichiometric information reported in Chap. 6 was obtained from multiple TGA analysis. Refinement of the structure with stoichiometric information from TGA was not stable

^cNo stoichiometric information

^dStoichiometric information reported in Chap. 6 was obtained from multiple TGA analysis. Refinement of the structure with stoichiometric information from TGA was not stable and provide high ADP for solvent

Table A.8 Grinding experiments of olanzapine

Solvent	XRPD	Solvent	XRPD
Neat	Form II	DCM, acetonitrile and water (1:1:1)	Solvate hydrate
Neat, cryogenic	Form I	N,N-dimethylformamide	Solvate hydrate
1,4-butanediol	Solvate hydrate	Ethanol	Solvate hydrate
1-butanol	Solvate hydrate + form I	Ethylacetate	Form I
2-butoxyethanol	Solvate	Ethylene glycol	Solvate
2-methoxyethanol	Solvate hydrate + form I	Isoamylalcohol	Solvate hydrate + form I
2-pentanol	Form I	Methanol	Solvate
1,2-dimethoxyethane	Form I	Methanol, cryogenic grinding	Solvate
1,4-dioxane	Solvate hydrate + form I	Methanol:water (1:1)	Solvate hydrate
1,2-propanediol	Solvate hydrate	Methyl acetate	Form I
2,2,2-trifluoroethanol	Solvate	Nitromethane	Form I
Acetic acid	Acetic acid solvate	Pyridine	Solvate hydrate + form I
Acetonitrile	Form I	TBMe	Form I
Acetone	Form I	N,N,N-triethylamine	Form I
Chloroform	Form I	Toluene	Form I
1,2-dichloroethane	Form I	THF	Form I + solvate hydrate
DCM and water (1:1)	Solvate hydrate	Water	Higher hydrate transforms to dihydrate E and B within minutes
DCM	Solvate / form I		

Table A.9 Desolvation results of various olanzapine solvates

Solvate	At 318 K	At 333 K
1-butanol hydrate	Form I +II + III	Form I + II +III
2-butoxyethanol solvate	Form I+ II + III	Form I
2-methoxyethanol hydrate	Form I	Form I
2 pentanol hydrate	Form I	Form I
1,2-dimethoxyethane hydrate	Form I	Form I
1,2-propanediol hydrate	Form I	Form I
1,4-butanediol dihydrate	Form I	Form I
1,4-dioxane hydrate	Form I	Form I
2,2,2-trifluoroethanol solvate	Form I + II + III	Form I + II + III
3-methyl 1-butanol hydrate	Form I	Form I
Acetone hydrate	Form I	Form I

(continued)

Table A.9 (continued)

Solvate	At 318 K	At 333 K
Acetic acid solvate	Form I	Form I
Acetonitrile hydrate	Form I	Form I
Chloroform hydrate	Form I + II + III	form I
DCM solvate	Form II +III	Form I
Dihydrate B	Form II + III	Form I + II + III
Dihydrate E	Form I	Form I
Ethanol solvate	Form I+II + III	Form I + II + III
Ethylene glycol solvate	Form I	Form I
Methanol solvate	Form I	Form I
Methyl acetate solvate hydrate	Form I	Form I
N,N-dimethylformamide solvate hydrate	Form I	Form I
Nitromethane solvate hydrate	Form I	Form I
Pyridine solvate hydrate	Form I	Form I
TBMe solvate hydrate	Form I	Form I
THF hydrate	Form I	Form

2-butoxyethanol solvate, DCM solvate, 1-butanol hydrate, 2,2,2-trifluoroethanol solvate, ethanol solvate, dihydrate B and chloroform hydrate were further subjected to desolvation in vacuum at RT and at 313 K at ambient pressure. Mixtures of form II and III were obtained in varying proportions

Table A.10 Recrystallisation of amorphous olanzapine under various conditions

S. No	Sample	Temperature	Results
1	Undisturbed on slide	RT	Amorphous
2	Undisturbed invial	RT	Form I + II + III
3	Boro silicate capillary <i>in-situ</i>	RT	Form II + III
4	Boro silicate capillary <i>in-situ</i>	-50 °C	Amorphous
5	Boro silicate capillary <i>in-situ</i>	-25 °C	Amorphous
6	Boro silicate capillary <i>in-situ</i>	-10 °C	Amorphous
7	Boro silicate capillary <i>in-situ</i>	0 °C	Amorphous
8	Boro silicate capillary <i>in-situ</i>	40 °C	Form I + II + III
9	Boro silicate capillary <i>in-situ</i>	100 °C	Form I
10	Boro silicate capillary <i>in-situ</i>	100 °C	Form I
11	Boro silicate capillary fridge	-80 °C	Amorphous
12	Boro silicate capillary_ fridge	4 °C	Form I +II + III

A.2 Physical Form Screening Results of Clozapine (CZPN)

Table A.11 Solvent evaporation of clozapine at room temperature

Solvent	Evaporation at RT
1,2-dichloroethane	Form I
1,4-butanediol	No crystallisation
1,4-dioxane	Form I
1,5-pentanediol	No crystallisation
1-butanol	Form I
1-chlorobutane	Form I
1-propanol	Form I
2,2,2-trifluoroethanol	Form I
2-butanol	Form I
2-butanone	Form I
2-butoxyethanol	Form I
2-methoxyethanol	Form I
Acetic acid + acetone	Form I
Acetic acid + Isobutyl acetate	Form I
Acetic acid + cyclohexane	Form I
Acetone	Form I
Acetonitrile	Form I
Benzyl alcohol	Form I
Butyl acetate	Form I
Cyclohexanol	Non-crystalline
DCM	Form I
Diethylether	Form I
Dimethyl sulphoxide	Form I
Ethanol	Monohydrate
Ethanol + water	Monohydrate
Ethyl acetate	Form I
Ethylene glycol	Solvate
Isoamyl alcohol	Form I
Isobutyl acetate	Monohydrate
Methanol	Form I
Methanol + water	Monohydrate
Methyl acetate	Form I
N,N-dimethylacetamide	Solvate
N,N-dimethylformamide	Form I
Nitromethane	Form I

(continued)

Table A.11 (continued)

Solvent	Evaporation at RT
NMP	Non-crystalline
Propyl acetate	Form I
Propyleneglycol	No crystallisation
Pyridine	Form I
Toluene	Form I
Water	Form I

Table A.12 Fast solvent evaporation (on watch glass) of clozapine at room temperature

Solvent	XRPD results
1,2-dichloroethane	Form I
1,2-dimethoxyethane	Form I
1,4-dioxane	Non-crystalline
1-chlorobutane	Form I
1-methyl naphthalene	Form I
1-propanol	Form I
2,2,2-trifluoroethanol	Form I + monohydrate
2-butoxy ethanol	Form I
Acetic acid	Form I + amorphous
Acetone	Form I + monohydrate
Acetonitrile	Form I
Carbon tetrachloride	Form I
DCM	Form I
Dimethyl sulphoxide	Form I
Dodecane	Form I
Ethanol	Monohydrate
Ethyl acetate	Form I
Ethyl methyl ketone	Form I
Formic acid	Non-crystalline
Isobutyl acetate	Form I
Methanol	Form I + monohydrate
N,N-dimethylacetamide	Form I
N,N-dimethylformamide	Form I
1-butanol	Form I
Nitromethane	Form I
Pentyl acetate	Form I
Pyridine	Form I + monohydrate
TBMe	Form I
THF	Form I
Toluene	Form I
Trichloroethylene	Form I
Water	Form I

Table A.13 Cooling crystallisation of clozapine on React Array

Solvent	XRPD results
1,2-dichloroethane	Form I
1,2-dimethoxyethane	Form I
1,4-dioxane	Monohydrate + form I
1-chlorobutane	Form I
1-methyl naphthalene	Form I
2,2,2-trifluoroethanol	Form I
2-butoxy ethanol	Form I
Acetic acid	No diffraction
Acetone	Form I
Acetonitrile	Form I
Carbon tetrachloride	Form I
DCM	Monohydrate + form I
Dimethyl sulphoxide	Form I
Dodecane	Form I
Ethanol	Form I
Ethyl acetate	Monohydrate
Ethyl methyl ketone	Form I
Formic acid	Form I
Isoamyl alcohol	Form I
Isobutyl acetate	Form I
Methanol	Form I
N,N-dimethylacetamide	Solvate
N,N-dimethylformamide	Form I
n-butanol	Form I
Nitromethane	Form I
Pentyl acetate	Form I
Pyridine	Form I
TBMe	Form I
THF	Form I
Toluene	Form I
Trichloroethylene	Form I
Water	Form I

Table A.14 Grinding results of clozapine

Solvent	XRPD results
1,2-dichloroethane	Form I
1,2-dimethoxyethane	Form I
1,4-dioxane	Form I
1-butanol	Form I
1-chlorobutane	Form I
1-methyl naphthalene	Form I
1-propanol	Form I
2,2,2-trifluoroethanol	Form I
2-butoxy ethanol	Form I
Acetic acid	Form I
Acetone	Form I
Acetonitrile	Form I
Carbon tetrachloride	Form I
DCM	Form I
N,N-dimethylacetamide	Form I
N,N-dimethylformamide	Form I
DMSO	Form I
Dodecane	Form I
Ethanol	Form I
Ethyl acetate	Form I
Ethyl methyl ketone	Form I
Formic acid	Form I
Isobutyl acetate	Form I
Methanol	Form I
Methanol_cryo grinding	Form I
Neat cryo grinding	Form I
Nitromethane	Form I
Pentyl acetate	Form I
Pyridine	Form I
TBMe	Form I
THF	Form I
Toluene	Form I
Trichloroethylene	Form I
Water	Monohydrate

Table A.15 X-ray crystallographic crystal data, data collection and refinement details for clozapine and its solvates

	Clozapine	Clozapine monohydrate	Clozapine_DMA	Clozapine_EG
Chemical formula	C ₁₈ H ₁₉ ClN ₄	C ₁₈ H ₂₁ ClN ₄ O	C ₂₂ H ₂₈ ClN ₅ O	C ₂₀ H ₂₅ ClN ₄ O ₂
<i>M_r</i>	326.82	344.84	413.94	370.83
Crystal system, space group	Orthorhombic, <i>P</i> ₂ ₁ ₂ ₁ ₂ ₁	Monoclinic, <i>P</i> ₂ ₁ <i>c</i>	Orthorhombic, <i>P</i> <i>bca</i>	Monoclinic, <i>P</i> ₂ ₁ <i>c</i>
Temperature (K)	123	123	123	123
<i>a</i> , <i>b</i> , <i>c</i> (Å)	9.328 (7), 9.632 (7), 17.836 (13)	9.9149 (3), 16.3646 (4), 10.9198 (3)	8.8660 (4), 17.5418 (7), 28.1238 (12)	20.6282 (9), 10.8488 (5), 17.5021 (8)
β (°)	90	102.229 (1)	90	93.134 (2)
<i>V</i> (Å ³)	1603 (2)	1731.57 (8)	4374.0 (3)	3911.0 (3)
<i>Z</i>	4	4	8	8
Radiation type	Mo Kα	Mo Kα	Mo Kα	Mo Kα
<i>m</i> (mm ⁻¹)	0.24	0.23	0.20	0.22
Crystal size (mm)	0.24 × 0.20 × 0.08	0.30 × 0.25 × 0.05	0.20 × 0.19 × 0.06	0.250 × 0.22 × 0.09
<i>Data collection</i>				
Diffractometer	Bruker APEX-II CCD	Bruker APEX-II CCD	Bruker APEX-II CCD	Bruker APEX-II CCD
Absorption correction	Multi-scan SADABS	Multi-scan SADABS	Multi-scan SADABS	Multi-scan SADABS
<i>T_{min}</i> , <i>T_{max}</i>	0.4329, 0.7454	0.6856, 0.7454	0.6856, 0.7454	0.4596, 0.7454
No. of measured, independent and observed [<i>I</i> > 2σ(<i>I</i>)] reflections	12686, 3146, 1771	15541, 3510, 3301	18417, 4460, 3730	29562, 8005, 7122
<i>R_{int}</i>	0.187	0.013	0.018	0.039
<i>Refinement</i>				
<i>R</i> [<i>F</i> ² > 2σ(<i>F</i> ²)], <i>wR</i> (<i>F</i> ²), <i>S</i>	0.062, 0.148, 0.99	0.029, 0.076, 1.04	0.083, 0.239, 1.04	0.079, 0.232, 1.02
No. of reflections	3146	3510	4460	8005

(continued)

Table A.15 (continued)

	Clozapine	Clozapine monohydrate	Clozapine_DMA	Clozapine_EG
No. of parameters	213	230	270	513
No. of restraints	1	0	4	15
H-atom treatment	Mixed [†]	Mixed [†]	Mixed [†]	Mixed [†]
$\Delta)_{\max} \Delta)_{\min}$ ($e \text{ \AA}^{-3}$)	0.32, -0.38	0.33, -0.22	2.35, -1.59	1.69, -1.26

[†]Cif files will be dealt with publication

[†]H atoms treated by a mixture of independent and constrained refinement

A.3 Physical Form Screening Results of Loxapine (LXPN)

Table A.16 Solvent evaporation of loxapine at room temperature

Solvent	Results
1,2-dichloroethane	Form I
1,2-dimethoxyethane	Form I
1,4-dioxane	Form I
1-butanol	No crystallisation
1-chlorobutane	Form I
1-methyl naphthalene	No crystallisation
2,2,2-trichloroethylene	Form I
2,2,2-trifluoroethanol	New
2-butoxy ethanol	No crystallisation
3-methyl-1-butanol	No crystallisation
Acetic acid	Non-crystalline
Acetone	Form I
Acetonitrile	Form I
Carbon tetrachloride	Form I
DCM	Form I
Dimethyl sulfoxide	No crystallisation
Dodecane	No crystallisation
Ethanol	Form I
Ethyl acetate	Form I
Ethyl methyl ketone	Form I
Formic acid	Flat
Isobutyl acetate	No crystallisation
Methanol	Form I
N,N-dimethyl acetamide	No crystallisation
N,N-dimethylformamide	No crystallisation
Nitromethane	Form I
Pentyl acetate	No crystallisation
Pyridine	No crystallisation
TBMe	Form I
THF	Form I
Toluene	Form I
Water	Not soluble, slurry same form

Table A.17 Cooling crystallisation of loxapine on React array

Solvent	Results
1,2-dichloroethane	Form I
1,2-dimethoxyethane	Form I
1,4-dioxane	Form I
1-butanol	Form I
1-chlorobutane	Form II (major) + I
1-methyl naphthalene	Flat spectra
2,2,2,-trifluoroethanol	New
2-butoxy ethanol	New
3-methyl-1-butanol	Form II
Acetic acid	New
Acetone	Form I
Acetonitrile	Form I
Carbon tetrachloride	Form I
DCM	Form I
Dimethyl sulphoxide	Form II
Dodecane	Form II
Ethanol	Form I
Ethyl acetate	Form I
Ethyl methyl ketone	Form I
Formic acid	New
Isobutyl acetate	Form I
Methanol	Form I
N,N-dimethylacetamide	Form I
N,N-dimethylformamide	Form I
Nitromethane	Form I
Pentyl acetate	Form I
Pyridine	Form I
TBMe	Form I
THF	Form I
Toluene	Form I
Trichloroethylene	Form I
Water	Form I

Table A.18 Fast solvent evaporation (on watch glass) of loxapine at room temperature

Solvent	Results
1,2-dichloroethane	Form II
1,2-dimethoxyethane	Form II
1,4-dioxane	No crystallisation
1-butanol	Form II
1-chlorobutane	Form II

(continued)

Table A.18 (continued)

Solvent	Results
1-methyl naphthalene	No crystallisation
1-propanol	Form II
2,2,2-trifluoroethanol	New
2-butoxy ethanol	No crystallisation
Acetic acid	New
Acetone	Form II
Acetonitrile	Form I + II
Carbon tetrachloride	Form II
DCM	Form II
Dimethyl sulphoxide	Form II
Dodecane	Form I
Ethanol	Form I
Ethyl acetate	Form II
Ethyl methyl ketone	Form II
Formic acid	no crystallisation
Isobutyl acetate	Form II
Methanol	Form I
N,N-dimethylacetamide	Form II
N,N-dimethylformamide	Form II
Nitromethane	Form I
Pentyl acetate	Form II
Pyridine	Form II
TBMe	Form II
THF	Form II
Toluene	Form II
Trichloroethylene	Form II
Water	Form I

Table A.19 X-ray crystallographic crystal data, data collection and refinement details for amoxapine and loxapine crystal structures

	Amoxapine	Loxapine_form I	Loxapine_form II
Chemical formula	$C_{17}H_{16}ClN_3O$	$C_{18}H_{18}ClN_3O$	$C_{18}H_{18}ClN_3O$
M_r	313.78	327.80	327.80
Crystal system, space group	Orthorhombic, <i>Pna</i> 21	Orthorhombic, <i>Pbca</i>	Monoclinic, <i>P2</i> ₁ / <i>c</i>
Temperature (K)	123	123	123
a, b, c (Å)	11.670 (8), 9.733 (7), 12.904 (9)	14.0245 (5), 12.8546 (5), 17.7500 (7)	12.8867 (7), 10.8108 (6), 12.3806 (6)

(continued)

Table A.19 (continued)

	Amoxapine	Loxapine_form I	Loxapine_form II
b (°)	90	90	109.484 (2)
V (Å ³)	1465.6 (18)	3200.0 (2)	1626.04 (15)
Z	4	8	4
Radiation type	Mo K α	Mo K α	Mo K α
m (mm ⁻¹)	0.27	0.25	0.24
Crystal size (mm)	0.24 × 0.22 × 0.07	0.22 × 0.19 × 0.06	0.20 × 0.19 × 0.09
<i>Data collection</i>			
Diffractometer	Bruker APEX-II CCD	Bruker APEX-II CCD	Bruker APEX-II CCD
Absorption correction	Multi-scan SADABS	Multi-scan SADABS	Multi-scan SADABS
T _{min} , T _{max}	0.1299 0.7454	0.6392 0.7454	0.6129 0.7454
No. of measured, independent and observed [<i>I</i> > 2s(<i>I</i>) reflections	5727, 2283, 1973	16853, 3243, 3044	20163, 3307, 2714
R _{int}	0.070	0.018	0.032
<i>Refinement</i>			
R[F ² > 2s(F ²)], wR(F ²), S	0.067, 0.185, 1.08	0.031, 0.079, 1.04	0.040, 0.115, 1.10
No. of reflections	2283	3243	3307
No. of parameters	203	209	209
No. of restraints	1	0	0
H-atom treatment	Mixed ¹	Mixed ¹	Mixed ¹
Δ _{max} , Δ _{min} (e Å ⁻³)	0.59, -1.25	0.31, -0.24	0.42, -0.31

All cif files will be dealt with the publication

¹H atoms treated by a mixture of independent and constrained refinement

Table A.20 X-ray crystallographic crystal data, data collection and refinement details for loxapine succinate and its monohydrate

	Loxapine succinate	Loxapine succinate monohydrate
Chemical formula	C ₁₈ H ₁₉ ClN ₃ O ⁺ · C ₄ H ₅ O ₄	2C ₁₈ H ₁₉ ClN ₃ O ⁺ · C ₄ H ₄ O ₄ ²⁻ · C ₄ H ₆ O ₄ · 2H ₂ O
M _r	445.89	927.82
Crystal system, space group	Monoclinic, C2/c	Triclinic, P $\bar{1}$
Temperature (K)	298	123
a, b, c (Å)	36.1824 (5), 7.08622 (14), 18.7690 (2)	9.4171 (6), 9.7604 (7), 13.7949 (9)
A, β , γ (°)	90, 113.8402 (10), 90	74.708 (2), 86.102 (2), 65.518 (2)
V (Å ³)	90, 113.8402 (10), 90	1111.86(13)

(continued)

Table A.20 (continued)

	Loxapine succinate	Loxapine succinate monohydrate
<i>Z</i>	8	1
Radiation type	Cu K α 1	Mo K α
μ (mm ⁻¹)	1.87	0.22
Specimen shape, size (mm)	Cylinder, 12 \times 0.7	0.33 \times 0.18 \times 0.06
<i>Data collection</i>		
Diffractometer	Bruker AXS D8 Advance diffractometer	Bruker APEX-II CCD
Specimen mounting	0.7 mm borosilicate capillary	–
Data collection mode	Transmission	–
Data collection method	Step	–
Absorption correction	–	Multi-scan <i>SADABS</i>
T_{\min} , T_{\max}	–	0.6392 0.7454
No. of measured, independent and observed [$I > 2s(I)$] reflections	–	15591, 4287, 3385
R_{int}	–	0.027
θ values (°)	$2\theta_{\min} = 3.5$, $2\theta_{\max} = 70.0$, $2\theta_{\text{step}} = 0.014$	$\theta_{\max} = 26.0$, $\theta_{\min} = 2.4$
Distance from source to specimen (mm)	–	0.617
<i>Refinement</i>		
R factors and goodness of fit	$R_p = 0.030$, $R_{\text{wp}} = 0.033$, $R_{\text{exp}} = 0.015$, $R_{\text{Bragg}} = 0.025$, $\chi^2 = 4.831$	$R[F^2 > 2s(F^2)] = 0.038$, $wR(F^2) = 0.100$, $S = 1.03$
Profile function	Fundamental parameters with axial divergence correction	–
No. of reflections/data points	988	4287
No. of parameters	50	306
No. of restraints	–	3
H-atom treatment	–	Mixed ¹
$\Delta\rho_{\max}$, $\Delta\rho_{\min}$ (e \AA^{-3})	–	0.25, –0.25
Preferred orientation correction	A spherical harmonics-based preferred orientation correction was applied with TOPAS during the Rietveld refinement	–

¹H atoms treated by a mixture of independent and constrained refinement