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(71) Applicant: **ABBVIE INC.** [US/US]; 1 North Waukegan Road, North Chicago, Illinois 60064 (US).

(72) Inventors: **BRACKEMEYER, Paul J.**; 1717 W. Catalpa Lane, Mount Prospect, Illinois 60056 (US). **GARRETT, Colleen C.**; 4510 N. Greenview Avenue, Apt. 1N, Chicago, Illinois 60640 (US). **NORDSTROEM, Lars Fredrik**; 1651 Church Street, Evanston, Illinois 60201

(US). **SHEIKH, Ahmad Y.**; 700 Pine Street, Deerfield, Illinois 60015 (US). **ZHANG, Geoff G.**; 1372 N. Maidstone Drive, Vernon Hills, Illinois 60061 (US). **ZHU, Donghua**; 1 N. Waukegan Road, North Chicago, Illinois 60064 (US).

(74) Agent: **SRIVASTAVA, Sonali S.** et al.; 1 N. Waukegan Road, North Chicago, IL 60064 (US).

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(54) Title: CRYSTALLINE POLYMORPHS OF OMBITASVIR

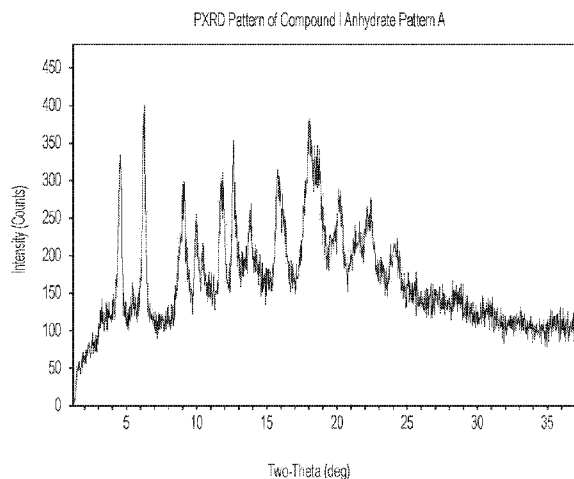
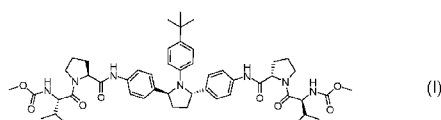


Figure 1.



(57) Abstract: The present invention features crystalline polymorphs of dimethyl (2S, 2'S)-1,1, -((2S,2'S)-2, 2, -(4, 4, -(2S,5S)-1-(4-tert-butylphenyl) pyrrolidine-2,5-diyl) bis (4, 1-phenylene)) bis (azanediyl) bis (oxomethylene) bis (pyrrolidine-2,1-diyl)) bis (3-methyl-1-oxobutane-2,1-diyl) dicarbamate i.e. ombitasvir, compound (I), which is a potent HCV NS5A inhibitor. In one embodiment, a crystalline form of Compound (I) has characteristic peaks in the PXRD pattern as shown in one of Figures 1-11.



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CRYSTALLINE POLYMORPHS OF OMBITASVIR

FIELD OF THE INVENTION

[0001] The present invention relates to crystalline polymorphs of ombitasvir (also referred to herein as “Compound I”), pharmaceutical compositions comprising the same, and methods of using the same to prepare pharmaceutical compositions.

BACKGROUND

[0002] The hepatitis C virus (HCV) is an RNA virus belonging to the Hepacivirus genus in the Flaviviridae family. The enveloped HCV virion contains a positive stranded RNA genome encoding all known virus-specific proteins in a single, uninterrupted, open reading frame. The open reading frame comprises approximately 9500 nucleotides and encodes a single large polyprotein of about 3000 amino acids. The polyprotein comprises a core protein, envelope proteins E1 and E2, a membrane bound protein p7, and the non-structural proteins NS2, NS3, NS4A, NS4B, NS5A and NS5B.

[0003] HCV infection is associated with progressive liver pathology, including cirrhosis and hepatocellular carcinoma. Chronic hepatitis C may be treated with peginterferon-alpha in combination with ribavirin. Substantial limitations to efficacy and tolerability remain as many users suffer from side effects, and viral elimination from the body is often inadequate. Therefore, there is a need for new drugs to treat HCV infection.

BRIEF DESCRIPTION OF THE DRAWINGS

- [0004] The drawings are provided for illustration, not limitation.
- [0005] Figure 1 shows the PXRD patterns of Compound I anhydrate pattern A.
- [0006] Figure 2 depicts the PXRD pattern of Compound I anhydrate pattern B.
- [0007] Figure 3 describes the PXRD pattern of Compound I anhydrate pattern C.
- [0008] Figure 4 shows the PXRD pattern of Compound I anhydrate pattern D.
- [0009] Figure 5 illustrates the PXRD pattern of Compound I hydrate pattern A.
- [0010] Figure 6 depicts the calculated PXRD pattern of Compound I hydrate pattern B (Form I).
- [0011] Figure 7 shows the PXRD pattern of Compound I methanol/water mix solvate.

[0012] Figure 8 describes the calculated PXRD pattern of Compound I ethanol/water mix solvate.

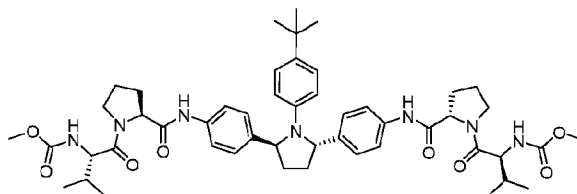
[0013] Figure 9 shows the PXRD pattern of Compound I L-malic acid co-crystal hydrate.

[0014] Figure 10 depicts the PXRD pattern of Compound I hydrate pattern C.

[0015] Figure 11 illustrates the calculated PXRD pattern of Compound I methanol solvate.

DETAILED DESCRIPTION

[0016] The present invention features crystalline polymorphs of dimethyl (2S,2'S)-1,1'-((2S,2'S)-2,2'-(4,4'-((2S,5S)-1-(4-*tert*-butylphenyl)pyrrolidine-2,5-diyl)bis(4,1-phenylene))bis(azanediyl)bis(oxomethylene)bis(pyrrolidine-2,1-diyl))bis(3-methyl-1-oxobutane-



2,1-diyl)dicarbamate (, i.e. ombitasvir, hereinafter “Compound I”). Compound I is a potent HCV NS5A inhibitor and is described in U.S. Patent Application Publication No. 2010/0317568, which is incorporated herein by reference in its entirety.

[0017] In one aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 1.

[0018] In another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) as shown in Table 1.

[0019] The relative intensity, as well as the two theta value, of each peak in Tables 1-11 (i.e., Tables 1-5, 6A, 6B, 7, 8A, 8B, 9, 10, 11A and 11B), as well as Figures 1-11, may change or shift under certain conditions, although the crystalline form is the same. One of ordinary skill in the art should be able to readily determine whether a given crystalline form is the same crystalline form as described in one of Figures 1-11 or Tables 1-11 by comparing their PXRD profiles.

[0020] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 4.62, 6.31, 9.11, 11.93, 12.68, 15.82, 18.09, and 18.77.

[0021] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 4.62, 6.31, 9.11, 10.05, 10.50, 11.93, 12.68, 13.90, 15.82, 16.26, 18.09, 18.77, 20.27, 21.61, 21.61, 22.45, and 24.14.

[0022] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 2.

[0023] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) as shown in Table 2.

[0024] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 4.84, 9.34, 10.28, 11.06, 12.88, 13.20, 15.08, and 15.67.

[0025] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 4.84, 7.31, 8.50, 9.34, 10.28, 10.54, 11.06, 12.88, 13.20, 13.66, 15.08, 15.67, 16.72, 17.60, 19.20, 19.54, 19.76, 20.58, 22.30, 23.70, and 24.46.

[0026] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 3.

[0027] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) as shown in Table 3.

[0028] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 7.57, 8.69, 9.43, 10.54, 11.93, 12.51, 15.13, and 15.34.

[0029] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two

theta ($^{\circ}$ 2 θ) of 5.98, 7.57, 8.69, 9.43, 10.54, 11.38, 11.93, 12.51, 12.89, 13.50, 15.13, 15.34, 15.57, 16.52, 16.83, 17.90, 18.24, 18.63, 19.76, 20.89, 21.21, 21.81, and 22.77.

[0030] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 4.

[0031] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) as shown in Table 4.

[0032] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 4.66, 9.32, 12.36, 16.26, 16.88, 17.50, 18.78, and 21.98.

[0033] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 4.66, 6.46, 8.12, 9.32, 10.45, 12.12, 12.36, 13.06, 16.26, 16.88, 17.50, 18.78, 19.14, 20.50, 20.98, 21.52, and 21.98.

[0034] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 5.

[0035] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) as shown in Table 5.

[0036] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 4.76, 9.26, 10.16, 11.00, 13.06, 14.90, 15.56, and 19.06.

[0037] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 4.76, 8.40, 9.26, 10.16, 11.00, 12.72, 13.06, 13.52, 14.26, 14.90, 15.56, 16.56, 17.00, 17.36, 17.88, 18.26, 19.06, 19.32, 20.33, 22.20, 23.48, and 24.30.

[0038] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 4.76, 6.36, 7.20, 8.40, 9.26, 10.16, 10.38, 11.00, 12.72, 13.06, 13.52, 14.26, 14.90,

15.56, 16.56, 17.00, 17.36, 17.88, 18.26, 18.56, 19.06, 19.32, 20.33, 20.93, 21.52, 22.20, 22.99, 23.48, and 24.30.

[0039] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 6.

[0040] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ} 2\theta$) as shown in Table 6A.

[0041] In yet another aspect, the invention features a crystalline form of Compound I as defined in Table 6B.

[0042] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ} 2\theta$) of 8.60, 10.88, 12.00, 13.54, 15.70, 17.24, 17.70, and 21.18.

[0043] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ} 2\theta$) of 5.92, 7.82, 8.60, 8.92, 9.12, 10.00, 10.88, 12.00, 13.54, 14.78, 14.96, 15.70, 16.18, 17.24, 17.70, 18.36, 18.96, 19.64, and 21.18.

[0044] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ} 2\theta$) of 5.92, 7.82, 8.60, 8.92, 9.12, 9.52, 10.00, 10.88, 11.38, 12.00, 13.20, 13.54, 14.78, 14.96, 15.28, 15.70, 16.18, 17.24, 17.70, 18.36, 18.96, 19.64, 20.18, 20.86, and 21.18.

[0045] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 7.

[0046] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ} 2\theta$) as shown in Table 7.

[0047] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ} 2\theta$) of 7.60, 9.34, 10.72, 11.92, 12.40, 15.24, 15.54, and 21.20.

[0048] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 7.60, 8.48, 8.70, 9.34, 10.72, 11.92, 12.40, 13.02, 13.44, 15.24, 15.54, 15.92, 16.86, 17.84, 18.06, 18.36, 18.70, 19.70, and 21.20.

[0049] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 5.92, 7.60, 8.48, 8.70, 9.34, 9.77, 10.72, 11.28, 11.92, 12.40, 13.02, 13.44, 15.24, 15.54, 15.92, 16.86, 17.17, 17.84, 18.06, 18.36, 18.70, 19.70, and 21.20.

[0050] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 8.

[0051] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) as shown in Table 8A.

[0052] In yet another aspect, the invention features a crystalline form of Compound I as defined in Table 8B.

[0053] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 7.58, 8.70, 9.36, 10.32, 11.82, 17.28, 18.78, and 22.86.

[0054] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 3.80, 7.58, 8.70, 9.12, 9.36, 10.32, 11.44, 11.82, 12.56, 13.38, 14.88, 15.60, 16.86, 17.28, 17.48, 18.44, 18.78, 18.94, 19.52, 19.96, 20.36, 20.64, 22.04, 22.86, and 23.04.

[0055] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 3.80, 5.72, 7.58, 8.70, 9.12, 9.36, 10.32, 11.44, 11.82, 12.16, 12.56, 12.88, 13.38, 14.26, 14.60, 14.88, 15.22, 15.60, 15.80, 16.86, 17.28, 17.48, 18.44, 18.78, 18.94, 19.52, 19.96, 20.36, 20.64, 20.80, 21.10, 21.82, 22.04, 22.56, 22.86, 23.04, and 23.38.

[0056] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 9.

[0057] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) as shown in Table 9.

[0058] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 8.47, 10.00, 16.74, 17.00, 19.27, 20.21, 22.35, and 24.31.

[0059] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 5.57, 7.40, 8.47, 8.88, 9.20, 10.00, 11.16, 11.45, 12.39, 13.20, 14.24, 14.44, 16.74, 17.00, 18.01, 19.27, 20.21, 20.67, 22.35, and 24.31.

[0060] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 5.57, 7.40, 8.47, 8.88, 9.20, 10.00, 11.16, 11.45, 11.70, 12.39, 13.20, 13.80, 14.24, 14.44, 14.67, 15.27, 15.92, 16.74, 17.00, 17.73, 18.01, 18.51, 19.27, 20.21, 20.67, 21.55, 22.35, 23.09, 24.31, and 25.80.

[0061] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 10.

[0062] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) as shown in Table 10.

[0063] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 7.62, 8.72, 9.42, 10.68, 11.98, 15.28, 15.56, and 21.26.

[0064] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 6.00, 7.62, 8.72, 9.42, 10.68, 11.98, 12.54, 13.04, 13.50, 15.28, 15.56, 16.84, 17.98, 18.32, 18.64, 19.74, 21.26, 21.86, and 22.70.

[0065] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two

theta ($^{\circ}$ 2 θ) of 6.00, 7.62, 8.72, 9.42, 10.68, 11.40, 11.98, 12.54, 13.04, 13.50, 15.28, 15.56, 15.89, 16.84, 17.98, 18.32, 18.64, 19.10, 19.74, 21.26, 21.86, 22.32, 22.70, 23.48, and 24.62.

[0066] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 11.

[0067] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) as shown in Table 11A.

[0068] In yet another aspect, the invention features a crystalline form of Compound I as defined in Table 11B.

[0069] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 7.50, 8.68, 10.36, 11.28, 14.92, 15.06, 19.00, and 23.02.

[0070] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 3.74, 7.50, 8.42, 8.68, 10.36, 11.28, 11.48, 14.26, 14.92, 15.06, 16.86, 17.28, 19.00, 19.38, 19.92, 20.80, 23.02, and 23.56.

[0071] In yet another aspect, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 3.74, 7.50, 8.42, 8.68, 9.46, 10.36, 11.28, 11.48, 12.08, 14.26, 14.40, 14.92, 15.06, 16.72, 16.86, 17.28, 17.84, 18.32, 19.00, 19.38, 19.92, 20.80, 22.62, 23.02, and 23.56.

[0072] As used herein, PXRD data can be collected using a G3000 diffractometer (Inel Corp., Ardenay, France) equipped with a curved position-sensitive detector and parallel-beam optics. The diffractometer is operated with a copper anode tube (1.5 kW fine focus) at 40 kV and 30 mA. An incident-beam germanium monochromator provides monochromatic Cu-K α radiation, which has a wavelength of 1.54178 Å. The diffractometer is calibrated using the attenuated direct beam at one-degree intervals. Calibration is checked using a silicon powder line position reference standard (NIST 640c). The instrument is computer-controlled using Symphonix software (Inel Corp., Ardenay, France) and the data are analyzed using Jade software (version 6.5, Materials Data, Inc., Livermore, CA). The sample can be loaded onto an aluminum

sample holder and leveled with a glass slide. PXRD peak position measurements are typically ± 0.2 degrees two-theta ($^{\circ} 2\theta$).

[0073] In another aspect, the present invention features a crystalline form described above which is substantially pure. As used herein, the term “substantially pure”, when used in reference to a given crystalline form, refers to the crystalline form which is at least about 90% pure. This means that the crystalline form does not contain more than about 10% of any other form of Compound I. More preferably, the term “substantially pure” refers to a crystalline form of Compound I which is at least about 95% pure. This means that the crystalline form of Compound I does not contain more than about 5% of any other form of Compound I. Even more preferably, the term “substantially pure” refers to a crystalline form of Compound I which is at least about 97% pure. This means that the crystalline form of Compound I does not contain more than about 3% of any other form of Compound I.

[0074] In one embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 1 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0075] In another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ} 2\theta$) as shown in Table 1 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0076] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ} 2\theta$) of 4.62, 6.31, 9.11, 11.93, 12.68, 15.82, 18.09, and 18.77 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0077] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ} 2\theta$) of 4.62, 6.31, 9.11, 10.05, 10.50, 11.93, 12.68, 13.90, 15.82, 16.26, 18.09, 18.77, 20.27, 21.61, 21.61, 22.45, and 24.14 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0078] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 2 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0079] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2θ) as shown in Table 2 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0080] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2θ) of 4.84, 9.34, 10.28, 11.06, 12.88, 13.20, 15.08, and 15.67 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0081] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2θ) of 4.84, 7.31, 8.50, 9.34, 10.28, 10.54, 11.06, 12.88, 13.20, 13.66, 15.08, 15.67, 16.72, 17.60, 19.20, 19.54, 19.76, 20.58, 22.30, 23.70, and 24.46 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0082] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 3 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0083] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2θ) as shown in Table 3 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0084] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at

values of two theta ($^{\circ}$ 2θ) of 7.57, 8.69, 9.43, 10.54, 11.93, 12.51, 15.13, and 15.34 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0085] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2θ) of 5.98, 7.57, 8.69, 9.43, 10.54, 11.38, 11.93, 12.51, 12.89, 13.50, 15.13, 15.34, 15.57, 16.52, 16.83, 17.90, 18.24, 18.63, 19.76, 20.89, 21.21, 21.81, and 22.77 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0086] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 4 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0087] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2θ) as shown in Table 4 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0088] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2θ) of 4.66, 9.32, 12.36, 16.26, 16.88, 17.50, 18.78, and 21.98 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0089] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2θ) of 4.66, 6.46, 8.12, 9.32, 10.45, 12.12, 12.36, 13.06, 16.26, 16.88, 17.50, 18.78, 19.14, 20.50, 20.98, 21.52, and 21.98 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0090] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as

shown in Figure 5 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0091] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) as shown in Table 5 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0092] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 4.76, 9.26, 10.16, 11.00, 13.06, 14.90, 15.56, and 19.06 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0093] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 4.76, 8.40, 9.26, 10.16, 11.00, 12.72, 13.06, 13.52, 14.26, 14.90, 15.56, 16.56, 17.00, 17.36, 17.88, 18.26, 19.06, 19.32, 20.33, 22.20, 23.48, and 24.30 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0094] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 4.76, 6.36, 7.20, 8.40, 9.26, 10.16, 10.38, 11.00, 12.72, 13.06, 13.52, 14.26, 14.90, 15.56, 16.56, 17.00, 17.36, 17.88, 18.26, 18.56, 19.06, 19.32, 20.33, 20.93, 21.52, 22.20, 22.99, 23.48, and 24.30 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0095] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 6 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0096] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) as shown in Table 6A and which is substantially pure. For example,

the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0097] In yet another embodiment, the invention features a crystalline form of Compound I as defined in Table 6B and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0098] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2θ) of 8.60, 10.88, 12.00, 13.54, 15.70, 17.24, 17.70, and 21.18 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0099] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2θ) of 5.92, 7.82, 8.60, 8.92, 9.12, 10.00, 10.88, 12.00, 13.54, 14.78, 14.96, 15.70, 16.18, 17.24, 17.70, 18.36, 18.96, 19.64, and 21.18 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0100] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2θ) of 5.92, 7.82, 8.60, 8.92, 9.12, 9.52, 10.00, 10.88, 11.38, 12.00, 13.20, 13.54, 14.78, 14.96, 15.28, 15.70, 16.18, 17.24, 17.70, 18.36, 18.96, 19.64, 20.18, 20.86, and 21.18 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0101] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 7 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0102] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2θ) as shown in Table 7 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0103] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 7.60, 9.34, 10.72, 11.92, 12.40, 15.24, 15.54, and 21.20 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0104] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 7.60, 8.48, 8.70, 9.34, 10.72, 11.92, 12.40, 13.02, 13.44, 15.24, 15.54, 15.92, 16.86, 17.84, 18.06, 18.36, 18.70, 19.70, and 21.20 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0105] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 5.92, 7.60, 8.48, 8.70, 9.34, 9.77, 10.72, 11.28, 11.92, 12.40, 13.02, 13.44, 15.24, 15.54, 15.92, 16.86, 17.17, 17.84, 18.06, 18.36, 18.70, 19.70, and 21.20 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0106] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 8 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0107] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) as shown in Table 8A and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0108] In yet another embodiment, the invention features a crystalline form of Compound I as defined in Table 8B and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0109] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 7.58, 8.70, 9.36, 10.32, 11.82, 17.28, 18.78, and 22.86 and which is substantially

pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0110] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 3.80, 7.58, 8.70, 9.12, 9.36, 10.32, 11.44, 11.82, 12.56, 13.38, 14.88, 15.60, 16.86, 17.28, 17.48, 18.44, 18.78, 18.94, 19.52, 19.96, 20.36, 20.64, 22.04, 22.86, and 23.04 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0111] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 3.80, 5.72, 7.58, 8.70, 9.12, 9.36, 10.32, 11.44, 11.82, 12.16, 12.56, 12.88, 13.38, 14.26, 14.60, 14.88, 15.22, 15.60, 15.80, 16.86, 17.28, 17.48, 18.44, 18.78, 18.94, 19.52, 19.96, 20.36, 20.64, 20.80, 21.10, 21.82, 22.04, 22.56, 22.86, 23.04, and 23.38 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0112] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 9 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0113] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) as shown in Table 9 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0114] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 8.47, 10.00, 16.74, 17.00, 19.27, 20.21, 22.35, and 24.31 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0115] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 5.57, 7.40, 8.47, 8.88, 9.20, 10.00, 11.16, 11.45, 12.39, 13.20, 14.24, 14.44, 16.74,

17.00, 18.01, 19.27, 20.21, 20.67, 22.35, and 24.31 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0116] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 5.57, 7.40, 8.47, 8.88, 9.20, 10.00, 11.16, 11.45, 11.70, 12.39, 13.20, 13.80, 14.24, 14.44, 14.67, 15.27, 15.92, 16.74, 17.00, 17.73, 18.01, 18.51, 19.27, 20.21, 20.67, 21.55, 22.35, 23.09, 24.31, and 25.80 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0117] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 10 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0118] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) as shown in Table 10 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0119] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 7.62, 8.72, 9.42, 10.68, 11.98, 15.28, 15.56, and 21.26 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0120] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 6.00, 7.62, 8.72, 9.42, 10.68, 11.98, 12.54, 13.04, 13.50, 15.28, 15.56, 16.84, 17.98, 18.32, 18.64, 19.74, 21.26, 21.86, and 22.70 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0121] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 6.00, 7.62, 8.72, 9.42, 10.68, 11.40, 11.98, 12.54, 13.04, 13.50, 15.28, 15.56,

15.89, 16.84, 17.98, 18.32, 18.64, 19.10, 19.74, 21.26, 21.86, 22.32, 22.70, 23.48, and 24.62 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0122] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 11 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0123] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) as shown in Table 11A and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0124] In yet another embodiment, the invention features a crystalline form of Compound I as defined in Table 11B and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0125] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 7.50, 8.68, 10.36, 11.28, 14.92, 15.06, 19.00, and 23.02 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0126] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 3.74, 7.50, 8.42, 8.68, 10.36, 11.28, 11.48, 14.26, 14.92, 15.06, 16.86, 17.28, 19.00, 19.38, 19.92, 20.80, 23.02, and 23.56 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0127] In yet another embodiment, the invention features a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 3.74, 7.50, 8.42, 8.68, 9.46, 10.36, 11.28, 11.48, 12.08, 14.26, 14.40, 14.92, 15.06, 16.72, 16.86, 17.28, 17.84, 18.32, 19.00, 19.38, 19.92, 20.80, 22.62, 23.02, and 23.56 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0128] In yet another aspect, the present invention features processes of using a crystalline form of the invention to make a composition comprising Compound I. The processes comprise dissolving a crystalline form of the invention in a solvent.

[0129] Any crystalline form described herein, including any crystalline form described in any aspect, embodiment or example of this application, can be used in any process of the invention described herein.

[0130] In one embodiment, the solvent is a volatile solvent such as ethanol or methanol. A suitable excipient, such as a hydrophilic polymer described below or a sugar alcohol, can also be dissolved in the solvent. The solution thus produced can then be dried to remove the solvent, such as via spray drying, freeze drying or other solvent evaporation techniques, thereby creating a solid dispersion that comprises Compound I and the excipient. Preferably, Compound I is in an amorphous form in the solid dispersion. More preferably, the solid dispersion is a solid solution or a glassy solution. In many cases, a pharmaceutically acceptable surfactant described below can also be added to the solution prior to solvent removal; and as a result, the solid dispersion/solid solution/glassy solution produced according to this embodiment also comprises the surfactant.

[0131] In another embodiment, the solvent is an excipient, such as a hydrophilic polymer described below or a sugar alcohol, in a molten or rubbery state. The crystalline form of Compound I dissolves in the molten or rubbery excipient. Heating may be used to facilitate the dissolving and mixing of the crystalline form of Compound I in the molten or rubbery excipient. Preferably, melt extrusion is used to dissolve and mix the crystalline form of Compound I in the excipient. A solution or melt thus produced can be cooled and solidified to form a solid dispersion that comprises Compound I and the excipient. Preferably, Compound I is in an amorphous form in the solid dispersion. More preferably, the solid dispersion is a solid solution or a glassy solution. The solid dispersion, solid solution or glassy solution can be milled, ground or granulated, and then compressed into a tablet or another suitable solid dosage form with or without other additives. The solid dispersion, solid solution or glassy solution can also be directly shaped or configured into a tablet or another suitable solid dosage form. In many cases, a pharmaceutically acceptable surfactant described below can be added to the solution or melt prior to solidification; and as a result, the solid dispersion/solid solution/glassy solution produced according to this embodiment also comprises the surfactant.

[0132] In yet another embodiment, both heating and a volatile solvent are used to dissolve a crystalline form of Compound I in a solution comprising a suitable excipient.

[0133] As used herein, the term “solid dispersion” defines a system in a solid state (as opposed to a liquid or gaseous state) comprising at least two components, wherein one component is dispersed throughout the other component or components. For example, an active ingredient or a combination of active ingredients can be dispersed in a matrix comprised of a pharmaceutically acceptable hydrophilic polymer(s) and a pharmaceutically acceptable surfactant(s). The term “solid dispersion” encompasses systems having small particles of one phase dispersed in another phase. When a solid dispersion of the components is such that the system is chemically and physically uniform or homogenous throughout or consists of one phase (as defined in thermodynamics), such a solid dispersion is called a “solid solution.” A glassy solution is a solid solution in which a solute is dissolved in a glassy solvent.

[0134] Non-limiting examples of excipients suitable for use in a process of the invention include numerous hydrophilic polymers. Preferably, a hydrophilic polymer employed in a process of the invention has a T_g of at least 50 °C, more preferably at least 60 °C, and highly preferably at least 80 °C including, but not limited to from, 80 °C to 180 °C, or from 100 °C to 150 °C. Methods for determining T_g values of organic polymers are described in INTRODUCTION TO PHYSICAL POLYMER SCIENCE (2nd Edition by L.H. Sperling, published by John Wiley & Sons, Inc., 1992). The T_g value can be calculated as the weighted sum of the T_g values for homopolymers derived from each of the individual monomers, i.e., the polymer $T_g = \sum W_i \cdot X_i$ where W_i is the weight percent of monomer i in the organic polymer, and X_i is the T_g value for the homopolymer derived from monomer i . T_g values for the homopolymers may be taken from POLYMER HANDBOOK (2nd Edition by J. Brandrup and E.H. Immergut, Editors, published by John Wiley & Sons, Inc., 1975). Hydrophilic polymers with a T_g as described above may allow for the preparation of solid dispersions that are mechanically stable and, within ordinary temperature ranges, sufficiently temperature stable so that the solid dispersions may be used as dosage forms without further processing or be compacted to tablets with only a small amount of tableting aids. Hydrophilic polymers having a T_g of below 50°C may also be used.

[0135] Preferably, a hydrophilic polymer employed in the present invention is water-soluble. A solid composition of the present invention can also comprise poorly water-soluble or water-insoluble polymer or polymers, such as cross-linked polymers. A hydrophilic polymer

comprised in a solid composition of the present invention preferably has an apparent viscosity, when dissolved at 20 °C in an aqueous solution at 2 % (w/v), of 1 to 5000 mPa·s, and more preferably of 1 to 700 mPa·s, and most preferably of 5 to 100 mPa·s.

[0136] Hydrophilic polymers suitable for use in a process of the invention include, but are not limited to, homopolymers or copolymers of N-vinyl lactams, such as homopolymers or copolymers of N-vinyl pyrrolidone (e.g., polyvinylpyrrolidone (PVP), or copolymers of N-vinyl pyrrolidone and vinyl acetate or vinyl propionate); cellulose esters or cellulose ethers, such as alkylcelluloses (e.g., methylcellulose or ethylcellulose), hydroxyalkylcelluloses (e.g., hydroxypropylcellulose), hydroxyalkylalkylcelluloses (e.g., hydroxypropylmethylcellulose), and cellulose phthalates or succinates (e.g., cellulose acetate phthalate and hydroxypropylmethylcellulose phthalate, hydroxypropylmethylcellulose succinate, or hydroxypropylmethylcellulose acetate succinate); high molecular polyalkylene oxides, such as polyethylene oxide, polypropylene oxide, and copolymers of ethylene oxide and propylene oxide; polyacrylates or polymethacrylates, such as methacrylic acid/ethyl acrylate copolymers, methacrylic acid/methyl methacrylate copolymers, butyl methacrylate/2-dimethylaminoethyl methacrylate copolymers, poly(hydroxyalkyl acrylates), and poly(hydroxyalkyl methacrylates); polyacrylamides; vinyl acetate polymers, such as copolymers of vinyl acetate and crotonic acid, and partially hydrolyzed polyvinyl acetate (also referred to as partially saponified “polyvinyl alcohol”); polyvinyl alcohol; oligo- or polysaccharides, such as carrageenans, galactomannans, and xanthan gum; polyhydroxyalkylacrylates; polyhydroxyalkyl-methacrylates; copolymers of methyl methacrylate and acrylic acid; polyethylene glycols (PEGs); or any mixture thereof.

[0137] Non-limiting examples of preferred hydrophilic polymers for use in a process of the invention include polyvinylpyrrolidone (PVP) K17, PVP K25, PVP K30, PVP K90, hydroxypropyl methylcellulose (HPMC) E3, HPMC E5, HPMC E6, HPMC E15, HPMC K3, HPMC A4, HPMC A15, HPMC acetate succinate (AS) LF, HPMC AS MF, HPMC AS HF, HPMC AS LG, HPMC AS MG, HPMC AS HG, HPMC phthalate (P) 50, HPMC P 55, Ethocel 4, Ethocel 7, Ethocel 10, Ethocel 14, Ethocel 20, copovidone (vinylpyrrolidone-vinyl acetate copolymer 60/40), polyvinyl acetate, methacrylate/methacrylic acid copolymer (Eudragit) L100-55, Eudragit L100, Eudragit S100, polyethylene glycol (PEG) 400, PEG 600, PEG 1450, PEG 3350, PEG 4000, PEG 6000, PEG 8000, poloxamer 124, poloxamer 188, poloxamer 237, poloxamer 338, and poloxamer 407.

[0138] Of these, homopolymers or copolymers of N-vinyl pyrrolidone, such as copolymers of N-vinyl pyrrolidone and vinyl acetate, are preferred. A non-limiting example of a preferred polymer is a copolymer of 60 % by weight of N-vinyl pyrrolidone and 40 % by weight of vinyl acetate. Other preferred polymers include, without limitation, hydroxypropyl methylcellulose (HPMC, also known as hypromellose in USP), such as hydroxypropyl methylcellulose grade E5 (HPMC-E5); and hydroxypropyl methylcellulose acetate succinate (HPMC-AS).

[0139] A pharmaceutically acceptable surfactant employed in a process of the invention is preferably a non-ionic surfactant. More preferably, the non-ionic surfactant has an HLB value of from 2-20. The HLB system (Fiedler, H.B., *ENCYCLOPEDIA OF EXCIPIENTS*, 5th ed., Aulendorf: ECV-Editio-Cantor-Verlag (2002)) attributes numeric values to surfactants, with lipophilic substances receiving lower HLB values and hydrophilic substances receiving higher HLB values.

[0140] Non-limiting examples of pharmaceutically acceptable surfactants that are suitable for use in a process of the invention include polyoxyethylene castor oil derivatives, e.g. polyoxyethyleneglycerol triricinoleate or polyoxyl 35 castor oil (Cremophor® EL; BASF Corp.) or polyoxyethyleneglycerol oxystearate such as polyethyleneglycol 40 hydrogenated castor oil (Cremophor® RH 40, also known as polyoxyl 40 hydrogenated castor oil or macrogolglycerol hydroxystearate) or polyethyleneglycol 60 hydrogenated castor oil (Cremophor® RH 60); or a mono fatty acid ester of polyoxyethylene sorbitan, such as a mono fatty acid ester of polyoxyethylene (20) sorbitan, e.g. polyoxyethylene (20) sorbitan monooleate (Tween® 80), polyoxyethylene (20) sorbitan monostearate (Tween® 60), polyoxyethylene (20) sorbitan monopalmitate (Tween® 40), or polyoxyethylene (20) sorbitan monolaurate (Tween® 20). Other non-limiting examples of suitable surfactants include polyoxyethylene alkyl ethers, e.g. polyoxyethylene (3) lauryl ether, polyoxyethylene (5) cetyl ether, polyoxyethylene (2) stearyl ether, polyoxyethylene (5) stearyl ether; polyoxyethylene alkylaryl ethers, e.g. polyoxyethylene (2) nonylphenyl ether, polyoxyethylene (3) nonylphenyl ether, polyoxyethylene (4) nonylphenyl ether, polyoxyethylene (3) octylphenyl ether; polyethylene glycol fatty acid esters, e.g. PEG-200 monolaurate, PEG-200 dilaurate, PEG-300 dilaurate, PEG-400 dilaurate, PEG-300 distearate, PEG-300 dioleate; alkylene glycol fatty acid mono esters, e.g. propylene glycol monolaurate (Lauroglycol®); sucrose fatty acid esters, e.g. sucrose monostearate, sucrose distearate, sucrose monolaurate, sucrose dilaurate; sorbitan fatty acid mono esters such as sorbitan mono laurate (Span® 20), sorbitan monooleate, sorbitan monopalmitate (Span® 40), or sorbitan stearate. Other

suitable surfactants include, but are not limited to, block copolymers of ethylene oxide and propylene oxide, also known as polyoxyethylene polyoxypropylene block copolymers or polyoxyethylene polypropyleneglycol, such as Poloxamer® 124, Poloxamer® 188, Poloxamer® 237, Poloxamer® 388, or Poloxamer® 407 (BASF Wyandotte Corp.).

[0141] Non-limiting examples of preferred surfactants for use in a process of the invention include polysorbate 20, polysorbate 40, polysorbate 60, polysorbate 80, Cremophor RH 40, Cremophor EL, Gelucire 44/14, Gelucire 50/13, D-alpha-tocopheryl polyethylene glycol 1000 succinate (vitamin E TPGS), propylene glycol laurate, sodium lauryl sulfate, and sorbitan monolaurate.

[0142] A pharmaceutically acceptable surfactant as used herein can be a mixture of pharmaceutically acceptable surfactants, such as a combination of a surfactant having an HLB value of below 10 and another surfactant having an HLB value of no less than 10.

[0143] In one embodiment, a surfactant having an HLB value of at least 10 is used in a process of the invention. In another embodiment, a surfactant having an HLB value of below 10 is used in a process of the invention. In yet another embodiment, a mixture of two or more surfactants (e.g., a combination of one surfactant having an HLB value of at least 10 and another surfactant having an HLB value of below 10) is used in a process of the invention.

[0144] In one embodiment, a process of the invention comprises dissolving a crystalline form of the invention, a hydrophilic polymer described above, and a surfactant described above to form a solution (e.g., a melt). The hydrophilic polymer can be selected, for example, from the group consisting of homopolymer of N-vinyl lactam, copolymer of N-vinyl lactam, cellulose ester, cellulose ether, polyalkylene oxide, polyacrylate, polymethacrylate, polyacrylamide, polyvinyl alcohol, vinyl acetate polymer, oligosaccharide, and polysaccharide. As a non-limiting example, the hydrophilic polymer is selected from the group consisting of homopolymer of N-vinyl pyrrolidone, copolymer of N-vinyl pyrrolidone, copolymer of N-vinyl pyrrolidone and vinyl acetate, copolymer of N-vinyl pyrrolidone and vinyl propionate, polyvinylpyrrolidone, methylcellulose, ethylcellulose, hydroxyalkylcelluloses, hydroxypropylcellulose, hydroxyalkylalkylcellulose, hydroxypropylmethylcellulose, cellulose phthalate, cellulose succinate, cellulose acetate phthalate, hydroxypropylmethylcellulose phthalate, hydroxypropylmethylcellulose succinate, hydroxypropylmethylcellulose acetate succinate, polyethylene oxide, polypropylene oxide, copolymer of ethylene oxide and propylene oxide,

methacrylic acid/ethyl acrylate copolymer, methacrylic acid/methyl methacrylate copolymer, butyl methacrylate/2-dimethylaminoethyl methacrylate copolymer, poly(hydroxyalkyl acrylate), poly(hydroxyalkyl methacrylate), copolymer of vinyl acetate and crotonic acid, partially hydrolyzed polyvinyl acetate, carrageenan, galactomannan, and xanthan gum. Preferably, the hydrophilic polymer is selected from polyvinylpyrrolidone (PVP) K17, PVP K25, PVP K30, PVP K90, hydroxypropyl methylcellulose (HPMC) E3, HPMC E5, HPMC E6, HPMC E15, HPMC K3, HPMC A4, HPMC A15, HPMC acetate succinate (AS) LF, HPMC AS MF, HPMC AS HF, HPMC AS LG, HPMC AS MG, HPMC AS HG, HPMC phthalate (P) 50, HPMC P 55, Ethocel 4, Ethocel 7, Ethocel 10, Ethocel 14, Ethocel 20, copovidone (vinylpyrrolidone-vinyl acetate copolymer 60/40), polyvinyl acetate, methacrylate/methacrylic acid copolymer (Eudragit) L100-55, Eudragit L100, Eudragit S100, polyethylene glycol (PEG) 400, PEG 600, PEG 1450, PEG 3350, PEG 4000, PEG 6000, PEG 8000, poloxamer 124, poloxamer 188, poloxamer 237, poloxamer 338, or poloxamer 407. More preferably, the hydrophilic polymer is selected from homopolymers of vinylpyrrolidone (e.g., PVP with Fikentscher K values of from 12 to 100, or PVP with Fikentscher K values of from 17 to 30), or copolymers of 30 to 70% by weight of N-vinylpyrrolidone (VP) and 70 to 30% by weight of vinyl acetate (VA) (e.g., a copolymer of 60% by weight VP and 40% by weight VA). The surfactant can be selected, for example, from the group consisting of polyoxyethyleneglycerol triricinoleate or polyoxyl 35 castor oil (Cremophor® EL; BASF Corp.) or polyoxyethyleneglycerol oxystearate, mono fatty acid ester of polyoxyethylene sorbitan, polyoxyethylene alkyl ether, polyoxyethylene alkylaryl ether, polyethylene glycol fatty acid ester, alkylene glycol fatty acid mono ester, sucrose fatty acid ester, and sorbitan fatty acid mono ester. As a non-limited example, the surfactant is selected from the group consisting of polyethyleneglycol 40 hydrogenated castor oil (Cremophor® RH 40, also known as polyoxyl 40 hydrogenated castor oil or macrogolglycerol hydroxystearate), polyethyleneglycol 60 hydrogenated castor oil (Cremophor® RH 60), a mono fatty acid ester of polyoxyethylene (20) sorbitan (e.g. polyoxyethylene (20) sorbitan monooleate (Tween® 80), polyoxyethylene (20) sorbitan monostearate (Tween® 60), polyoxyethylene (20) sorbitan monopalmitate (Tween® 40), or polyoxyethylene (20) sorbitan monolaurate (Tween® 20)), polyoxyethylene (3) lauryl ether, polyoxyethylene (5) cetyl ether, polyoxyethylene (2) stearyl ether, polyoxyethylene (5) stearyl ether, polyoxyethylene (2) nonylphenyl ether, polyoxyethylene (3) nonylphenyl ether, polyoxyethylene (4) nonylphenyl ether, polyoxyethylene (3) octylphenyl

ether, PEG-200 monolaurate, PEG-200 dilaurate, PEG-300 dilaurate, PEG-400 dilaurate, PEG-300 distearate, PEG-300 dioleate, propylene glycol monolaurate, sucrose monostearate, sucrose distearate, sucrose monolaurate, sucrose dilaurate, sorbitan monolaurate, sorbitan monooleate, sorbitan monopalmitate, and sorbitan stearate. Preferably, the surfactant is selected from polysorbate 20, polysorbate 40, polysorbate 60, polysorbate 80, Cremophor RH 40, Cremophor EL, Gelucire 44/14, Gelucire 50/13, D-alpha-tocopheryl polyethylene glycol 1000 succinate (vitamin E TPGS), propylene glycol laurate, sodium lauryl sulfate, or sorbitan monolaurate. More preferably, the surfactant is selected from sorbitan monolaurate or D-alpha-tocopheryl polyethylene glycol 1000 succinate.

[0145] In another embodiment, a process of the invention comprises dissolving a crystalline form of the invention, a hydrophilic polymer described above, and a surfactant described above to form a solution (e.g., a melt). The hydrophilic polymer is a homopolymer or copolymer of N-vinyl pyrrolidone (e.g., copovidone). The pharmaceutically acceptable surfactant can be, e.g., vitamin E TPGS, or sorbitan monolaurate.

[0146] A melt-extrusion process of the invention typically comprises preparing a melt from (1) a crystalline form of the invention, (2) a hydrophilic polymer described above (or another suitable binder), and (3) preferably a surfactant described above. The melt can then be cooled until it solidifies. The crystalline form of Compound I initially used will disappear upon the formation of the melt. The melt may also include other additives. "Melting" means a transition into a liquid or rubbery state in which it is possible for one component to get embedded, preferably homogeneously embedded, in the other component or components. In many cases, the polymer component will melt and the other components including the crystalline form of Compound I and the surfactant will dissolve in the melt thereby forming a solution. Melting usually involves heating above the softening point of the polymer. The preparation of the melt can take place in a variety of ways. The mixing of the components can take place before, during or after the formation of the melt. For example, the components can be mixed first and then melted or be simultaneously mixed and melted. The melt can also be homogenized in order to disperse Compound I efficiently. In addition, it may be convenient first to melt the polymer and then to mix in and homogenize Compound I. In one example, all materials except the surfactant are blended and fed into an extruder, while the surfactant is molten externally and pumped in during extrusion.

[0147] In another example, the melt comprises Compound I and a hydrophilic polymer described above, and the melt temperature is in the range of from 100 to 170 °C, preferably from 120 to 150 °C, and highly preferably from 135 to 140 °C. The melt can also include a pharmaceutically acceptable surfactant described above.

[0148] In still another example, the melt comprises Compound I, at least another anti-HCV agent (e.g., a HCV polymerase inhibitor, or a NS5A inhibitor, or a combination of a HCV polymerase inhibitor and a NS5A inhibitor), and a hydrophilic polymer described above. The melt can also include a pharmaceutically acceptable surfactant described above.

[0149] To start a melt-extrusion process, Compound I is employed in a crystalline form of the invention, e.g., any crystalline form described in any aspect, embodiment or example of this application. A crystalline form of the invention may also be first dissolved in a suitable liquid solvent such as alcohols, aliphatic hydrocarbons, esters or, in some cases, liquid carbon dioxide; the solvent can be removed, e.g. evaporated, upon preparation of the melt.

[0150] Various additives can also be included in the melt, for example, flow regulators (e.g., colloidal silica), lubricants, fillers, disintegrants, plasticizers, colorants, or stabilizers (e.g., antioxidants, light stabilizers, radical scavengers, and stabilizers against microbial attack).

[0151] The melting and/or mixing can take place in an apparatus customary for this purpose. Particularly suitable ones are extruders or kneaders. Suitable extruders include single screw extruders, intermeshing screw extruders or multiscrew extruders, preferably twin screw extruders, which can be corotating or counterrotating and, optionally, be equipped with kneading disks. It will be appreciated that the working temperatures will be determined by the kind of extruder or the kind of configuration within the extruder that is used. Part of the energy needed to melt, mix and dissolve the components in the extruder can be provided by heating elements. However, the friction and shearing of the material in the extruder may also provide a substantial amount of energy to the mixture and aid in the formation of a homogeneous melt of the components.

[0152] The melt can range from thin to pasty to viscous. Shaping of the extrudate can be conveniently carried out by a calender with two counter-rotating rollers with mutually matching depressions on their surface. The extrudate can be cooled and allow to solidify. The extrudate can also be cut into pieces, either before (hot-cut) or after solidification (cold-cut).

[0153] The solidified extrusion product can be further milled, ground or otherwise reduced to granules. The solidified extrudate, as well as each granule produced, comprises a solid dispersion, preferably a solid solution, of Compound I in a matrix comprised of the hydrophilic polymer and optionally the pharmaceutically acceptable surfactant. Where the granules do not contain any surfactant, a pharmaceutically acceptable surfactant described above can be added to and blended with the granules. The extrusion product can also be blended with other active ingredient(s) (e.g., ritonavir) and/or additive(s) before being milled or ground to granules. The granules can be further processed into suitable solid oral dosage forms.

[0154] In one example, copovidone and a surfactant described above are mixed and granulated, followed by the addition of aerosil and a crystalline form of Compound I of the invention. The mixture can also contain ritonavir. The mixture, which may contain for example 5% by weight of Compound I, is then milled. The mixture is then subject to extrusion, and the extrudate thus produced can be milled and sieved for further processing to make capsules or tablets. The surfactant employed in this example can also be added through liquid dosing during extrusion.

[0155] The approach of solvent evaporation, e.g., via spray-drying, provides the advantage of allowing for processability at lower temperatures, if needed, and allows for other modifications to the process in order to further improve powder properties. The spray-dried powder can then be formulated further, if needed, and final drug product is flexible with regards to whether capsule, tablet or any other solid dosage form is desired.

[0156] Exemplary spray-drying processes and spray-drying equipment are described in K. Masters, *SPRAY DRYING HANDBOOK* (Halstead Press, New York, 4th ed., 1985). Non-limiting examples of spray-drying devices that are suitable for the present invention include spray dryers manufactured by Niro Inc. or GEA Process Engineering Inc., Buchi Labortechnik AG, and Spray Drying Systems, Inc. A spray-drying process generally involves breaking up a liquid mixture into small droplets and rapidly removing solvent from the droplets in a container (spray drying apparatus) where there is a strong driving force for evaporation of solvent from the droplets. Atomization techniques include, for example, two-fluid or pressure nozzles, or rotary atomizers. The strong driving force for solvent evaporation can be provided, for example, by maintaining the partial pressure of solvent in the spray drying apparatus well below the vapor pressure of the solvent at the temperatures of the drying droplets. This may be accomplished by either (1)

maintaining the pressure in the spray drying apparatus at a partial vacuum; (2) mixing the liquid droplets with a warm drying gas (e.g., heated nitrogen); or (3) both.

[0157] The temperature and flow rate of the drying gas, as well as the spray dryer design, can be selected so that the droplets are dry enough by the time they reach the wall of the apparatus. This help to ensure that the dried droplets are essentially solid and can form a fine powder and do not stick to the apparatus wall. The spray-dried product can be collected by removing the material manually, pneumatically, mechanically or by other suitable means. The actual length of time to achieve the preferred level of dryness depends on the size of the droplets, the formulation, and spray dryer operation. Following the solidification, the solid powder may stay in the spray drying chamber for additional time (e.g., 5-60 seconds) to further evaporate solvent from the solid powder. The final solvent content in the solid dispersion as it exits the dryer is preferably at a sufficiently low level so as to improve the stability of the final product. For instance, the residual solvent content of the spray-dried powder can be less than 2% by weight. Highly preferably, the residual solvent content is within the limits set forth in the International Conference on Harmonization (ICH) Guidelines. In addition, it may be useful to subject the spray-dried composition to further drying to lower the residual solvent to even lower levels. Methods to further lower solvent levels include, but are not limited to, fluid bed drying, infra-red drying, tumble drying, vacuum drying, and combinations of these and other processes.

[0158] Like the solid extrudate described above, the spray dried product contains a solid dispersion, preferably a solid solution, of Compound I in a matrix comprised of a hydrophilic polymer described above and optionally a pharmaceutically acceptable surfactant described above. Where the spray dried product does not contain any surfactant, a pharmaceutically acceptable surfactant described above can be added to and blended with the spray-dried product before further processing.

[0159] Before feeding into a spray dryer, a crystalline form of Compound I of the invention, a hydrophilic polymer described above, as well as other optional active ingredients or excipients such as a pharmaceutically acceptable surfactant described above, can be dissolved in a solvent. Suitable solvents include, but are not limited to, alkanols (e.g., methanol, ethanol, 1-propanol, 2-propanol or mixtures thereof), acetone, acetone/water, alkanol/water mixtures (e.g., ethanol/water mixtures), or combinations thereof. The solution can also be preheated before

being fed into the spray dryer. In many cases, ritonavir is dissolved together with the crystalline form of Compound I.

[0160] The solid dispersion produced by melt-extrusion, spray-drying or other techniques can be prepared into any suitable solid oral dosage forms. In one embodiment, the solid dispersion prepared by melt-extrusion, spray-drying or other techniques (e.g., the extrudate or the spray-dried powder) can be compressed into tablets. The solid dispersion can be either directly compressed, or milled or ground to granules or powders before compression. Compression can be done in a tablet press, such as in a steel die between two moving punches. When a solid composition comprises Compound I and another anti-HCV agent, it is possible to separately prepare solid dispersions of each individual active ingredient and then blend the optionally milled or ground solid dispersions before compacting. Compound I and another anti-HCV agent can also be prepared in the same solid dispersion, optionally milled and/or blended with other additives, and then compressed into tablets. Likewise, when a solid composition comprises Compound I and ritonavir, it is possible to separately prepare solid dispersions of each individual active ingredient and then blend the optionally milled or ground solid dispersions before compacting. Compound I and ritonavir can also be prepared in the same solid dispersion, optionally milled and/or blended with other additives, and then compressed into tablets.

[0161] At least one additive, such as one selected from flow regulators, lubricants, fillers, disintegrants or plasticizers, may be used in compressing the solid dispersion. These additives can be mixed with ground or milled solid dispersion before compacting. Disintegrants promote a rapid disintegration of the compact in the stomach and keeps the liberated granules separate from one another. Non-limiting examples of suitable disintegrants are cross-linked polymers such as cross-linked polyvinyl pyrrolidone, cross-linked sodium carboxymethylcellulose or sodium croscarmellose. Non-limiting examples of suitable fillers (also referred to as bulking agents) are lactose monohydrate, calcium hydrogenphosphate, microcrystalline cellulose (e.g., Avicell), silicates, in particular silicium dioxide, magnesium oxide, talc, potato or corn starch, isomalt, or polyvinyl alcohol. Non-limiting examples of suitable flow regulators include highly dispersed silica (e.g., colloidal silica such as Aerosil), and animal or vegetable fats or waxes. Non-limiting examples of suitable lubricants include polyethylene glycol (e.g., having a molecular weight of from 1000 to 6000), magnesium and calcium stearates, sodium stearyl fumarate, and the like.

[0162] Various other additives may also be used in preparing a solid composition prepared according to a process of the invention, for example dyes such as azo dyes, organic or inorganic pigments such as aluminium oxide or titanium dioxide, or dyes of natural origin; stabilizers such as antioxidants, light stabilizers, radical scavengers, stabilizers against microbial attack.

[0163] In one embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 1 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0164] In another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) as shown in Table 1 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0165] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 4.62, 6.31, 9.11, 11.93, 12.68, 15.82, 18.09, and 18.77 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0166] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 4.62, 6.31, 9.11, 10.05, 10.50, 11.93, 12.68, 13.90, 15.82, 16.26, 18.09, 18.77, 20.27, 21.61, 21.61, 22.45, and 24.14 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0167] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as

shown in Figure 2 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0168] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) as shown in Table 2 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0169] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 4.84, 9.34, 10.28, 11.06, 12.88, 13.20, 15.08, and 15.67 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0170] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 4.84, 7.31, 8.50, 9.34, 10.28, 10.54, 11.06, 12.88, 13.20, 13.66, 15.08, 15.67, 16.72, 17.60, 19.20, 19.54, 19.76, 20.58, 22.30, 23.70, and 24.46 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0171] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 3 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0172] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) as shown in Table 3 and which is substantially pure. For example, the

crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0173] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 7.57, 8.69, 9.43, 10.54, 11.93, 12.51, 15.13, and 15.34 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0174] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 5.98, 7.57, 8.69, 9.43, 10.54, 11.38, 11.93, 12.51, 12.89, 13.50, 15.13, 15.34, 15.57, 16.52, 16.83, 17.90, 18.24, 18.63, 19.76, 20.89, 21.21, 21.81, and 22.77 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0175] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 4 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0176] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) as shown in Table 4 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0177] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 4.66, 9.32, 12.36, 16.26, 16.88, 17.50, 18.78, and 21.98 and which is

substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0178] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 4.66, 6.46, 8.12, 9.32, 10.45, 12.12, 12.36, 13.06, 16.26, 16.88, 17.50, 18.78, 19.14, 20.50, 20.98, 21.52, and 21.98 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0179] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 5 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0180] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) as shown in Table 5 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0181] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 4.76, 9.26, 10.16, 11.00, 13.06, 14.90, 15.56, and 19.06 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0182] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 4.76, 8.40, 9.26, 10.16, 11.00, 12.72, 13.06, 13.52, 14.26, 14.90, 15.56, 16.56, 17.00, 17.36, 17.88, 18.26, 19.06, 19.32, 20.33, 22.20, 23.48, and 24.30 and which

is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0183] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 4.76, 6.36, 7.20, 8.40, 9.26, 10.16, 10.38, 11.00, 12.72, 13.06, 13.52, 14.26, 14.90, 15.56, 16.56, 17.00, 17.36, 17.88, 18.26, 18.56, 19.06, 19.32, 20.33, 20.93, 21.52, 22.20, 22.99, 23.48, and 24.30 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0184] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 6 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0185] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) as shown in Table 6A and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0186] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I as defined in Table 6B and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0187] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 8.60, 10.88, 12.00, 13.54, 15.70, 17.24, 17.70, and 21.18 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0188] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 5.92, 7.82, 8.60, 8.92, 9.12, 10.00, 10.88, 12.00, 13.54, 14.78, 14.96, 15.70, 16.18, 17.24, 17.70, 18.36, 18.96, 19.64, and 21.18 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0189] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 5.92, 7.82, 8.60, 8.92, 9.12, 9.52, 10.00, 10.88, 11.38, 12.00, 13.20, 13.54, 14.78, 14.96, 15.28, 15.70, 16.18, 17.24, 17.70, 18.36, 18.96, 19.64, 20.18, 20.86, and 21.18 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0190] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 7 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0191] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) as shown in Table 7 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0192] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 7.60, 9.34, 10.72, 11.92, 12.40, 15.24, 15.54, and 21.20 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0193] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2θ) of 7.60, 8.48, 8.70, 9.34, 10.72, 11.92, 12.40, 13.02, 13.44, 15.24, 15.54, 15.92, 16.86, 17.84, 18.06, 18.36, 18.70, 19.70, and 21.20 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0194] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2θ) of 5.92, 7.60, 8.48, 8.70, 9.34, 9.77, 10.72, 11.28, 11.92, 12.40, 13.02, 13.44, 15.24, 15.54, 15.92, 16.86, 17.17, 17.84, 18.06, 18.36, 18.70, 19.70, and 21.20 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0195] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 8 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0196] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2θ) as shown in Table 8A and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0197] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I as defined in Table 8B and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0198] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2θ) of 7.58, 8.70, 9.36, 10.32, 11.82, 17.28, 18.78, and 22.86 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0199] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2θ) of 3.80, 7.58, 8.70, 9.12, 9.36, 10.32, 11.44, 11.82, 12.56, 13.38, 14.88, 15.60, 16.86, 17.28, 17.48, 18.44, 18.78, 18.94, 19.52, 19.96, 20.36, 20.64, 22.04, 22.86, and 23.04 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0200] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2θ) of 3.80, 5.72, 7.58, 8.70, 9.12, 9.36, 10.32, 11.44, 11.82, 12.16, 12.56, 12.88, 13.38, 14.26, 14.60, 14.88, 15.22, 15.60, 15.80, 16.86, 17.28, 17.48, 18.44, 18.78, 18.94, 19.52, 19.96, 20.36, 20.64, 20.80, 21.10, 21.82, 22.04, 22.56, 22.86, 23.04, and 23.38 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0201] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 9 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0202] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2θ) as shown in Table 9 and which is substantially pure. For example, the

crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0203] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 8.47, 10.00, 16.74, 17.00, 19.27, 20.21, 22.35, and 24.31 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0204] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 5.57, 7.40, 8.47, 8.88, 9.20, 10.00, 11.16, 11.45, 12.39, 13.20, 14.24, 14.44, 16.74, 17.00, 18.01, 19.27, 20.21, 20.67, 22.35, and 24.31 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0205] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 5.57, 7.40, 8.47, 8.88, 9.20, 10.00, 11.16, 11.45, 11.70, 12.39, 13.20, 13.80, 14.24, 14.44, 14.67, 15.27, 15.92, 16.74, 17.00, 17.73, 18.01, 18.51, 19.27, 20.21, 20.67, 21.55, 22.35, 23.09, 24.31, and 25.80 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0206] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 10 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0207] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at

values of two theta ($^{\circ}$ 2θ) as shown in Table 10 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0208] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2θ) of 7.62, 8.72, 9.42, 10.68, 11.98, 15.28, 15.56, and 21.26 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0209] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2θ) of 6.00, 7.62, 8.72, 9.42, 10.68, 11.98, 12.54, 13.04, 13.50, 15.28, 15.56, 16.84, 17.98, 18.32, 18.64, 19.74, 21.26, 21.86, and 22.70 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0210] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2θ) of 6.00, 7.62, 8.72, 9.42, 10.68, 11.40, 11.98, 12.54, 13.04, 13.50, 15.28, 15.56, 15.89, 16.84, 17.98, 18.32, 18.64, 19.10, 19.74, 21.26, 21.86, 22.32, 22.70, 23.48, and 24.62 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0211] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern as shown in Figure 11 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0212] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at

values of two theta ($^{\circ}$ 2 θ) as shown in Table 11A and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0213] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I as defined in Table 11B and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0214] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 7.50, 8.68, 10.36, 11.28, 14.92, 15.06, 19.00, and 23.02 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0215] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 3.74, 7.50, 8.42, 8.68, 10.36, 11.28, 11.48, 14.26, 14.92, 15.06, 16.86, 17.28, 19.00, 19.38, 19.92, 20.80, 23.02, and 23.56 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0216] In yet another embodiment, a process of the invention described above (including any process described in any aspect, embodiment, example or preference) uses a crystalline form of Compound I which has characteristic peaks in the powder X-ray diffraction (PXRD) pattern at values of two theta ($^{\circ}$ 2 θ) of 3.74, 7.50, 8.42, 8.68, 9.46, 10.36, 11.28, 11.48, 12.08, 14.26, 14.40, 14.92, 15.06, 16.72, 16.86, 17.28, 17.84, 18.32, 19.00, 19.38, 19.92, 20.80, 22.62, 23.02, and 23.56 and which is substantially pure. For example, the crystalline form can be at least 90% pure, preferably at least 95% pure, or more preferably at least 97%.

[0217] In yet another aspect, the present invention features compositions comprising a crystalline form of Compound I of the invention. Any crystalline form described herein (including any crystalline form described in any aspect, embodiment or example) can be used to

make a composition of the invention. Preferably, the crystalline form is substantially pure, such as at least 90% pure, preferably at least 95% pure, or more preferably at least 97% pure. In one embodiment, a composition of the invention comprises at least 5% by weight of a substantially pure crystalline form of the invention. In another embodiment, the composition of the invention comprises at least 10% by weight of a substantially pure crystalline form of the invention. In still another embodiment, a composition of the invention comprises at least 5% by weight of one or more crystalline forms of the invention. In yet another embodiment, a composition of the invention comprises at least 10% by weight of one or more crystalline forms of the invention.

Example 1. Compound I Anhydrate Pattern A

[0218] Amorphous Compound I solid was suspended in 32 w% EtOH in heptane at ambient temperature overnight. The slurry was filtered and the solids analyzed by polarized microscopy. The solid exhibited partial crystallinity.

[0219] Amorphous Compound I solid was suspended in 37 w% EtOH in heptane at ambient temperatures to reach its solubility. The slurry was filtered to remove excess amorphous solid and seeded with the partially crystalline Compound I prepared above. The solids were isolated after crystallization at ambient temperature using vacuum filtration.

[0220] Powder X-ray diffraction pattern and peak listing with relative intensities are shown in Figure 1 and Table 1, respectively.

Table 1. PXRD Peak Listing of Compound I Anhydrate Pattern A

Peak Position (° 2θ)	Relative Intensity
4.621	76.4
6.313	100.0
9.111	60.2
10.052	40.7
10.496	26.6
11.926	53.8
12.676	64.5
13.903	36.3
15.819	53.9
16.261	35.1
18.085	71.9
18.769	51.2
20.266	38.4
21.609	24.6

21.609	24.6
22.447	29.8
24.135	23.0

Example 2. Compound I Anhydrate Pattern B

[0221] Compound I, anhydrate Pattern B was identified by dehydration of Compound I Hydrate Pattern A at RH below 30%. Powder X-ray diffraction pattern and peak listing with relative intensities are shown in Figure 2 and Table 2, respectively.

Table 2. PXRD Peak Listing of Compound I Anhydrate pattern B

Peak Position (° 2θ)	Relative Intensity
4.843	100.0
7.310	23.5
8.502	23.5
9.340	60.7
10.280	100.0
10.543	28.9
11.057	36.4
12.875	40.3
13.199	95.6
13.663	32.3
15.082	59.5
15.665	71.8
16.719	27.2
17.597	30.4
19.202	43.2
19.539	36.1
19.759	31.2
20.578	32.9
22.297	29.6
23.700	32.4
24.462	28.4

Example 3. Compound I Anhydrate Pattern C

[0222] Compound I, Anhydrate Pattern C was identified by dehydration of Compound I Hydrate Pattern B at RH below 30%. Powder X-ray diffraction pattern and peak listing with relative intensities are shown in Figure 3 and Table 3, respectively.

Table 3. PXRD Peak Listing of Compound I Anhydrate Pattern C

Peak Position ($^{\circ}$ 2 θ)	Relative Intensity
5.978	13.6
7.567	62.9
8.694	71.9
9.431	100.0
10.538	84.4
11.378	15.9
11.932	74.4
12.507	57.0
12.885	17.6
13.503	30.3
15.132	72.2
15.343	49.0
15.571	16.6
16.518	13.0
16.834	25.3
17.902	25.2
18.236	42.9
18.633	37.5
19.755	31.4
20.888	21.5
21.209	37.2
21.810	22.0
22.773	16.1

Example 4. Compound I Anhydrate Pattern D

[0223] Anhydrate Pattern D was obtained from solvent mixture comprising EtOAc and cyclohexane. Amorphous Compound I was partially dissolved in 34 w% EtOAc in cyclohexane at ambient temperatures and agitated for 3 weeks. Solids were isolated by vacuum filtration. Powder X-ray diffraction pattern and peak listing with relative intensities are shown in Figure 4 and Table 4, respectively.

Table 4: PXRD Peak Listing of Compound I Anhydrate Pattern D

Peak Position ($^{\circ}$ 2 θ)	Relative Intensity
4.661	100.0

6.462	6.6
8.121	22.2
9.319	35.2
10.453	6.9
12.120	12.2
12.361	27.7
13.057	6.3
16.259	74.3
16.882	44.6
17.499	38.2
18.780	39.7
19.143	8.5
20.499	10.5
20.977	18.5
21.520	21.4
21.980	28.4

Example 5. Compound I Hydrate Pattern A

[0224] Compound I Hydrate Pattern A was prepared from its methanol/water solvate by desolvating the solvate in vacuum oven at 50 °C overnight. The resulting solid was equilibrated at ambient conditions for a short period of time prior to characterization. Powder X-ray diffraction pattern and peak listing with relative intensities are shown in Figure 5 and Table 5 respectively.

Table 5. PXRD Peak Listing of Compound I Hydrate Pattern A

Peak Position (° 2θ)	Relative Intensity
4.758	46.8
6.356	10.5
7.199	18.7
8.400	23.3
9.261	67.3
10.158	87.3
10.380	17.3
10.998	37.8
12.719	35.8
13.06	100.0
13.519	35.0
14.261	27.8
14.898	57.7
15.561	75.9

16.56	27.0
16.999	21.2
17.364	28.4
17.880	31.4
18.257	26.3
18.561	10.0
19.061	61.0
19.319	34.9
20.325	37.7
20.931	9.0
21.520	18.0
22.20	37.8
22.991	13.3
23.482	27.8
24.300	28.5

Example 6. Compound I Hydrate Pattern B (Form I)

[0225] Compound I Hydrate Pattern B (Form I) was prepared from its ethanol/water solvate. The ethanol/water solvate solid was placed at 50 °C overnight under vacuum at a pressure of around 150 mmHg, while being purged with air. A tray of water was added to the vacuum oven and the solids were placed in the humidified atmosphere at a pressure of 120 mmHg and 50 °C overnight. The resulting solid was equilibrated at ambient for a short period of time prior to characterization.

[0226] A solution comprising 37 mg/g solvent, 57.7 w% EtOH in H₂O, was left at ambient temperature without agitation for approximately 2 months. Single crystals of the EtOH-H₂O solvate were isolated from the crystallized solution and placed in a humidified atmosphere of 75% RH at a pressure of around 120 mmHg and 30 °C overnight to convert over to Hydrate pattern B.

[0227] The crystal structure of Hydrate Pattern B (Form I) was solved using Single Crystal XRD. The experimental Powder X-ray diffraction pattern and calculated Powder X-ray diffraction pattern from the crystal structure determination and associated peak listing with relative intensities are shown in Figure 6 and Table 6A, respectively. Crystallographic information is shown in Table 6B. 4.5 H₂O molecules per molecule Compound I exist in the crystal structure.

Table 6A. Calculated PXRD Peak Listing of Compound I Hydrate Pattern B (Form I)

Peak Position ($^{\circ}$ 2 θ)	Relative Intensity
5.919	29.1
7.819	24.9
8.599	49.7
8.921	26.5
9.118	30.1
9.517	10.9
9.999	31.4
10.881	100.0
11.381	15.0
11.999	52.2
13.199	14.3
13.540	35.5
14.779	21.1
14.957	30.8
15.282	17.3
15.699	84.3
16.183	22.7
17.241	41.6
17.698	67.0
18.357	24.7
18.958	29.7
19.639	23.5
20.182	12.2
20.861	12.1
21.180	43.4

Table 6B. Crystallographic Information of Compound I Hydrate Pattern B (Form I)

Lattice Type	Monoclinic
Space Group	P21
Cell Length a	11.9216 Å
Cell Length b	20.280 Å
Cell Length c	22.103 Å
Cell Angle α	90.0 $^{\circ}$
Cell Angle β	100.215 $^{\circ}$
Cell Angle γ	90.0 $^{\circ}$
Cell Volume	5259.14 Å ³

Z	4
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Example 7. Compound I Methanol/water Mix Solvate

[0228] A methanol suspension comprising about 20 mg of amorphous Compound I solid in methanol was prepared and equilibrated at ambient temperatures. Crystallization occurred in the filtrate upon centrifuge filtration. Powder X-ray diffraction pattern and peak listing with relative intensities can be seen in Figure 7, and Table 7, respectively.

Table 7: PXRD Peak Listing of Compound I Methanol/Water Mix Solvate

Peak Position ($^{\circ}$ 2 θ)	Relative Intensity
5.918	11.4
7.597	81.4
8.482	58.0
8.702	45.2
9.339	100.0
9.770	19.0
10.717	93.3
11.280	15.2
11.924	94.0
12.401	72.0
13.017	28.8
13.438	46.6
15.242	68.0
15.543	74.5
15.918	32.3
16.856	41.4
17.174	23.5
17.838	45.2
18.058	49.7
18.360	40.7
18.703	34.7
19.696	36.1
21.201	62.3

Example 8. Compound I Ethanol/water Mix Solvate

[0229] The EtOH/H₂O solvate was obtained by dissolving 49 mg of amorphous Compound I solid in 1.09 g of 60 wt% EtOH in H₂O, and seeding the solution with Anhydrate Pattern A and

desolvated EtOH solvate at 5 °C. Solids were isolated after crystallization using vacuum filtration.

[0230] A clear solution comprising 37 mg/g solvent, 57.7 w% EtOH in H₂O, was left at ambient temperature without agitation for approximately 2 months. Single crystals were isolated from the crystallized solution and directly cooled using liquid nitrogen. The crystal structure of the EtOH/H₂O solvate was resolved using Single Crystal XRD. The experimental Powder X-ray diffraction pattern and calculated Powder X-ray diffraction pattern from the crystal structure determination and associated peak listing with relative intensities are shown in Figure 8 and Table 8A, respectively. Crystallographic information is shown in Table 8B. 2.5 EtOH and 2.5 H₂O molecules per molecule of Compound I exist in the crystal lattice.

Table 8A: PXRD (calculated) Peak Listing of Compound I Ethanol/Water Mix Solvate

Peak Position (° 2θ)	Relative Intensity
3.797	28.3
5.717	10.5
7.582	93.5
8.701	72.8
9.123	28.2
9.360	100.0
10.318	97.3
11.437	60.1
11.818	82.3
12.162	21.5
12.562	25.6
12.879	23.7
13.383	25.1
14.261	18.8
14.601	17.6
14.882	58.6
15.219	18.6
15.602	56.8
15.799	17.5
16.860	35.2
17.279	67.8
17.480	61.2
18.437	29.0
18.778	86.1

18.939	48.8
19.519	33.2
19.958	51.1
20.360	29.8
20.639	47.0
20.800	23.9
21.097	8.3
21.819	23.6
22.038	31.8
22.563	14.2
22.859	84.9
23.037	64.9
23.377	24.9

Table 8B: Crystallographic information of Compound I Ethanol/Water Mix Solvate

Lattice Type	Monoclinic
Space Group	P21
Cell Length a	12.310 Å
Cell Length b	20.463 Å
Cell Length c	23.951 Å
Cell Angle α	90.0 °
Cell Angle β	102.840 °
Cell Angle γ	90.0 °
Cell Volume	5882.38 Å ³
Z	4

Example 9. Compound I L-Malic acid Co-Crystal Hydrate

[0231] About 30 mg of Compound I parent solid was added to L-malic acid saturated solution in IPA/water (15/85 v/v). The suspension was stirred at ambient temperatures overnight. The resulting solid was collected by centrifuge filtration.

[0232] Compound I parent (4168 mg) and L-malic acid (794 mg) solids was suspended in 5 mL of IPA/water (15/85 v/v). The suspension was stirred at ambient temperatures overnight. The resulting solid was collected by centrifuge filtration.

[0233] Powder X-ray diffraction pattern and peak listing with relative intensities can be seen in Figure 9, and Table 9, respectively.

Table 9: PXRD Peak Listing Compound I L-Malic Co-crystal Hydrate

Peak Position ($^{\circ} 2 \theta$)	Relative Intensity
5.567	32.3
7.403	25.7
8.466	48.6
8.878	28.1
9.198	25
10.003	52.2
11.156	26.2
11.449	33.3
11.703	10.7
12.394	27.4
13.201	33.8
13.802	10.0
14.236	34.3
14.438	24.6
14.669	12.8
15.270	11.3
15.923	8.4
16.744	41.4
16.996	39.7
17.733	18.2
18.008	28.5
18.509	15.8
19.273	100.0
20.214	45.1
20.674	21.1
21.549	15.1
22.354	44.0
23.089	16.8
24.307	59.9
25.802	13.4

Example 10. Compound I Hydrate Pattern C

[0234] An aqueous suspension comprising about 10 mg of Compound I L-malic acid co-crystal in water was prepared. The suspension was stirred at ambient temperatures for 4 days. The resulting solid was collected by centrifuge filtration.

[0235] 8 g of a wet filter cake comprising the EtOH/H₂O mix solvate was suspended in 80 g pure water and distilled at constant volume at 40 °C and 70-100 mm Hg for approximately 4 h until all the ethanol was removed. The suspension was cooled to 20 °C and the solids isolated by vacuum filtration.

[0236] Powder X-ray diffraction pattern and peak listing with relative intensities can be seen in Figure 10, and Table 10, respectively.

Table 10: PXRD Peak Listing Compound I Hydrate Pattern C

Peak Position (° 2θ)	Relative Intensity
6.002	29.8
7.621	97.1
8.720	91.5
9.420	100.0
10.679	89.2
11.396	23.9
11.981	83.5
12.543	55.8
13.041	37.6
13.501	41.0
15.278	89.2
15.558	72.3
15.894	22.9
16.84	35.1
17.979	35.6
18.321	42.4
18.641	49.7
19.100	25.6
19.737	39.4
21.262	57.4
21.859	32.4
22.320	22.3
22.700	32.4
23.479	23.9
24.620	18.5

Example 11. Compound I Methanol Solvate

[0237] Compound I (~100 mg) solid was suspended in methanol (1 mL) at 50 °C for about 1 hour. The suspension was syringe filtered and the supernatant was cooled to room temperature. Single crystals observed 24 hours later.

[0238] Simulated powder X-ray diffraction and peak listing with relative intensities can be seen in Figure 11 and Table 11A, respectively. Crystallographic information can be seen in Table 11B.

Table 11A: PXRD (calculated) Peak Listing Compound I Methanol Solvate

Peak Position (° 2θ)	Relative Intensity
3.74	24.7
7.50	100.0
8.42	24.0
8.68	61.8
9.46	20.1
10.36	37.6
11.28	56.6
11.48	30.4
12.08	16.2
14.26	24.8
14.40	15.7
14.92	74.8
15.06	63.5
16.72	17.8
16.86	20.2
17.28	32.9
17.84	19.4
18.32	18.0
19.00	33.3
19.38	29.7
19.92	30.4
20.80	24.0
22.62	15.1
23.02	49.2
23.56	21.7

Table 11B: Crystallographic information of Compound I Methanol Solvate

Lattice Type	Monoclinic
--------------	------------

Space Group	P21
Cell Length a	12.465 Å
Cell Length b	20.323 Å
Cell Length c	24.019 Å
Cell Angle α	90.0 °
Cell Angle β	100.333 °
Cell Angle γ	90.0 °
Cell Volume	5985.96 Å ³
Z	4

[0239] The foregoing description of the present invention provides illustration and description, but is not intended to be exhaustive or to limit the invention to the precise one disclosed. Modifications and variations are possible in light of the above teachings or may be acquired from practice of the invention. Thus, it is noted that the scope of the invention is defined by the claims and their equivalents.

What is claimed is:

1. A crystalline form of Compound I, wherein said crystalline form has characteristic peaks in PXRD pattern at values of two theta as described in one of Tables 1-11, provided that said crystalline form is not Form I.
2. A crystalline form of Compound I, wherein said crystalline form has characteristic peaks in PXRD pattern as described in one of Figures 1-11, provided that said crystalline form is not Form I.
3. A crystalline form of Compound I, wherein said crystalline form has characteristic peaks in PXRD pattern as described in the specification, provided that said crystalline form is not Form I.
4. A composition comprising a crystalline form according to one of claims 1-3.
5. A process for making a pharmaceutical composition comprising Compound I, comprising dissolving a crystalline form according to one of claims 1-3.

1/11

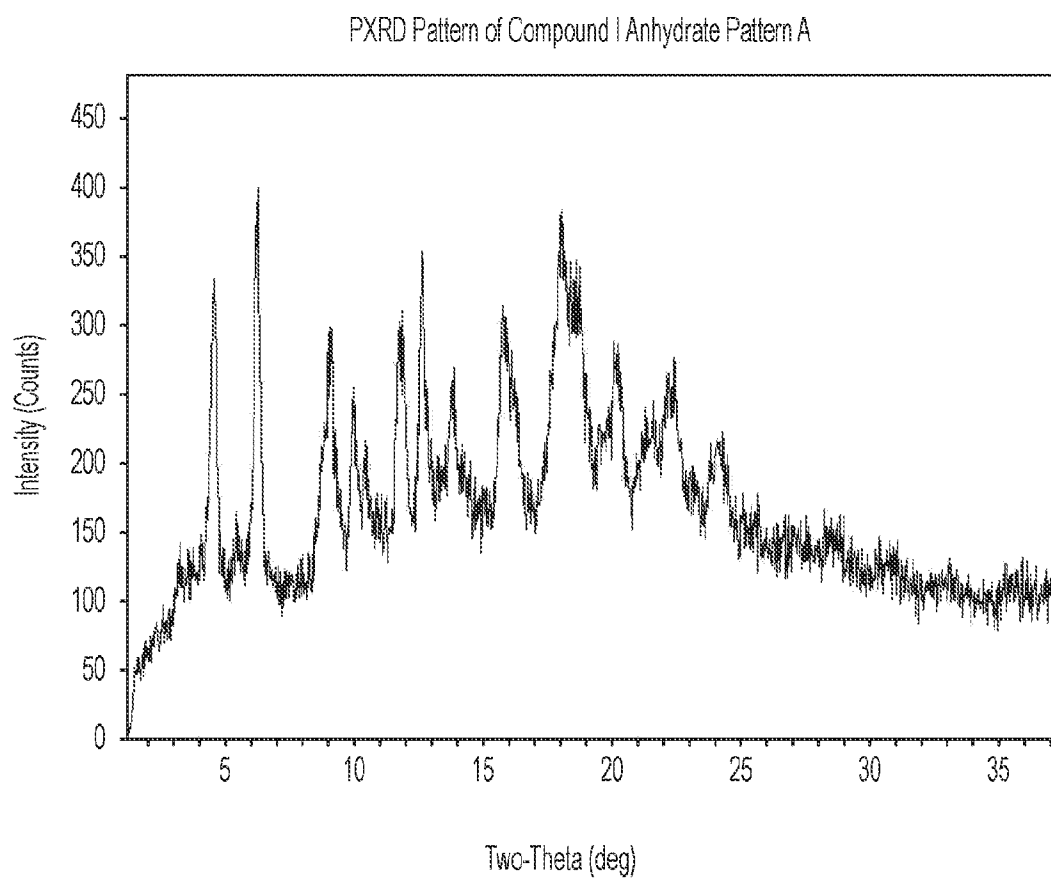


Figure 1.

2/11

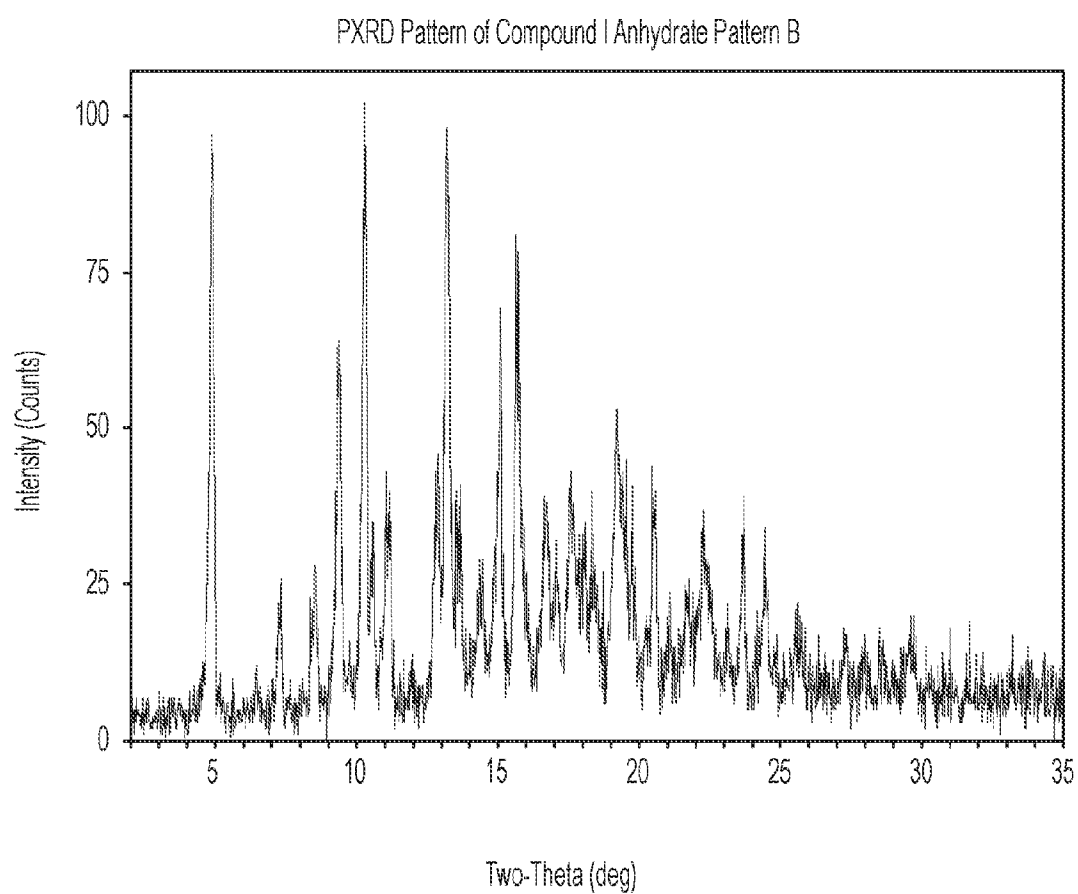


Figure 2.

3/11

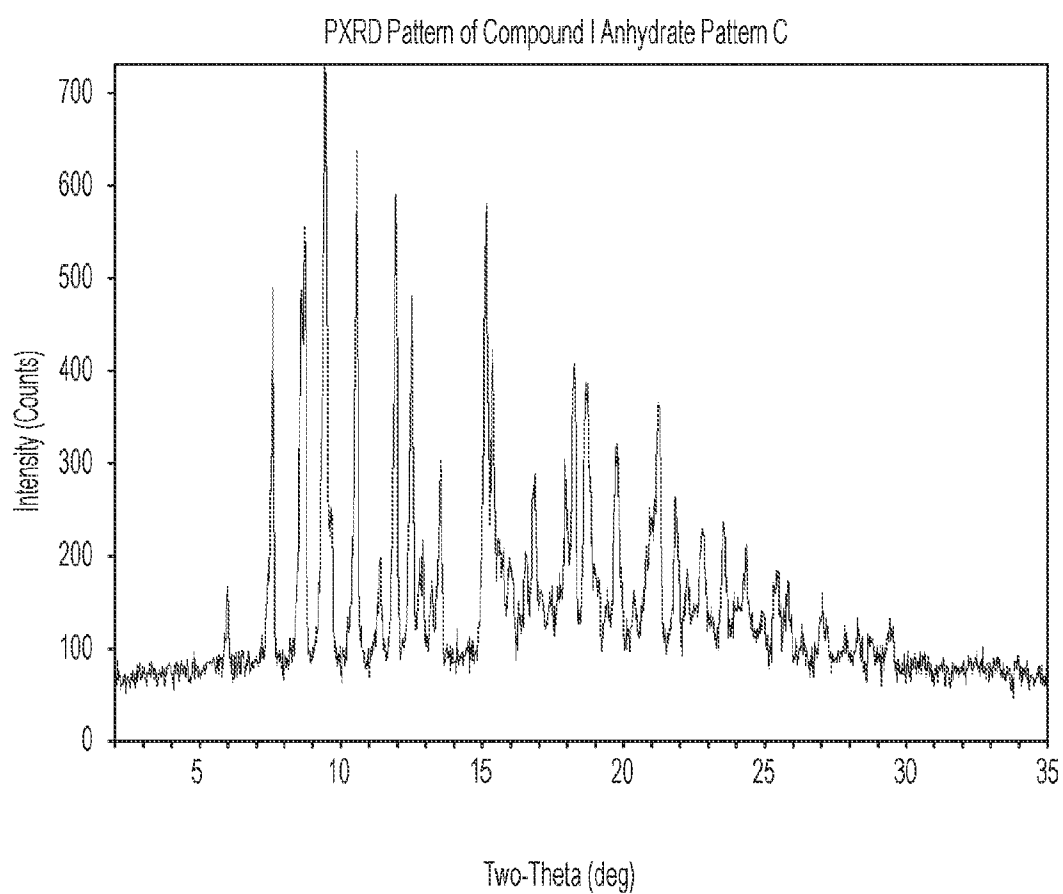


Figure 3.

4/11

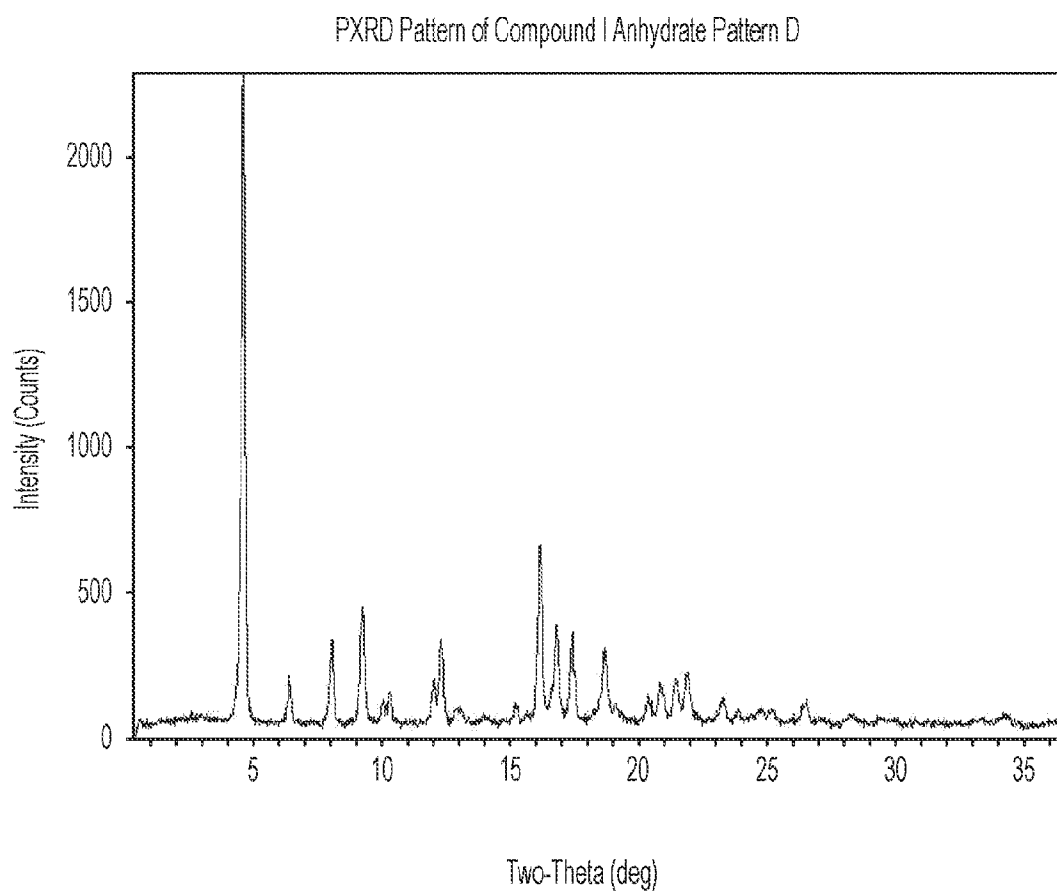


Figure 4.

5/11

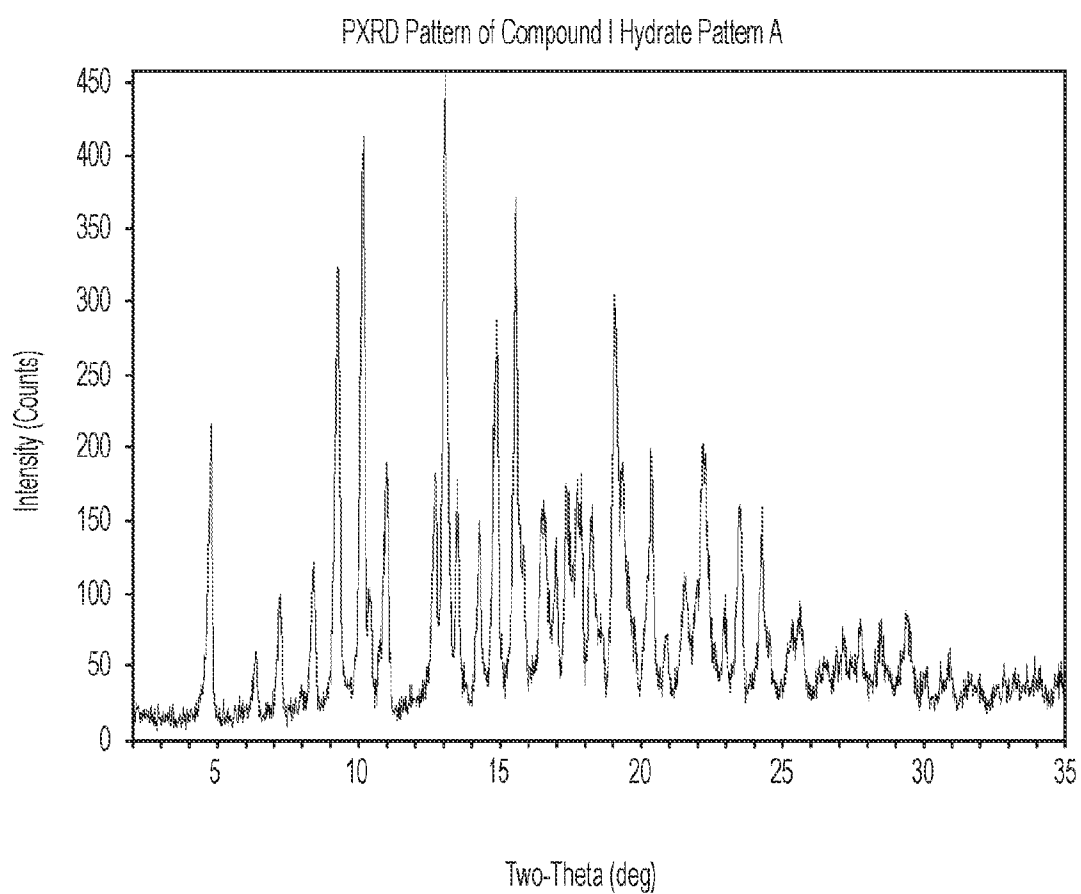


Figure 5.

6/11

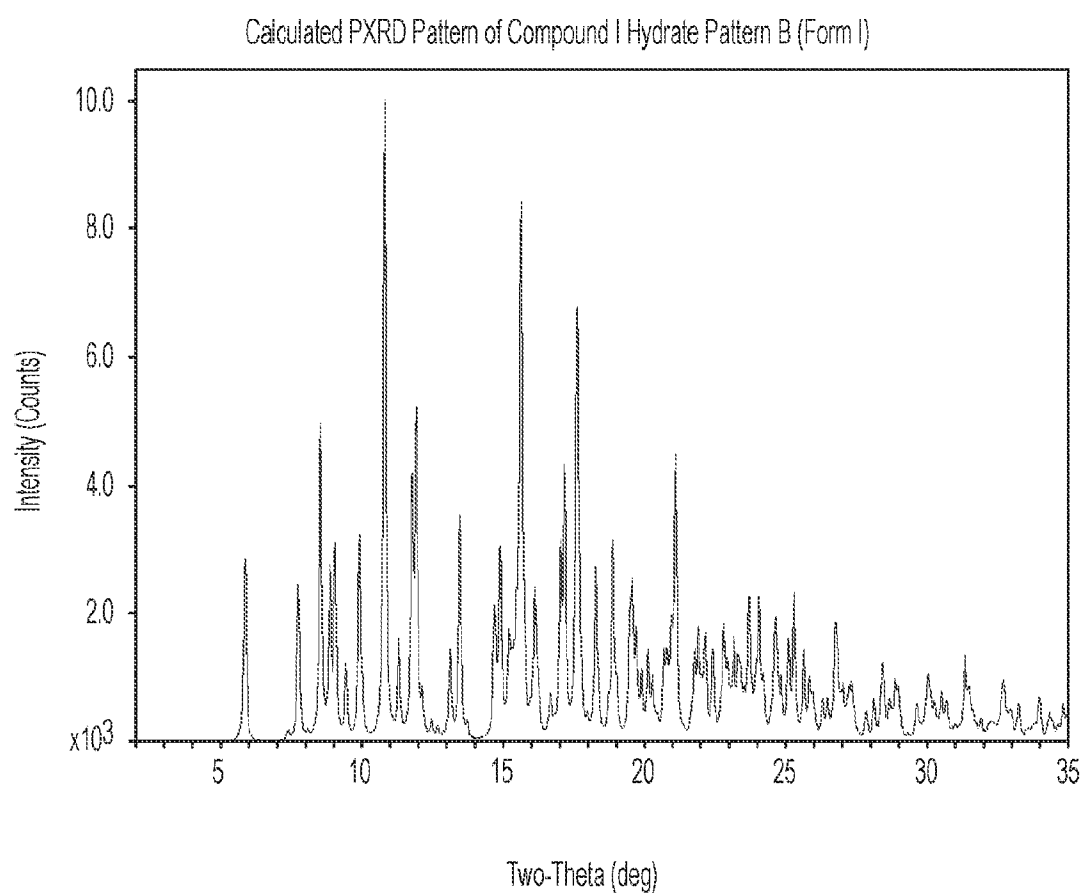


Figure 6.

7/11

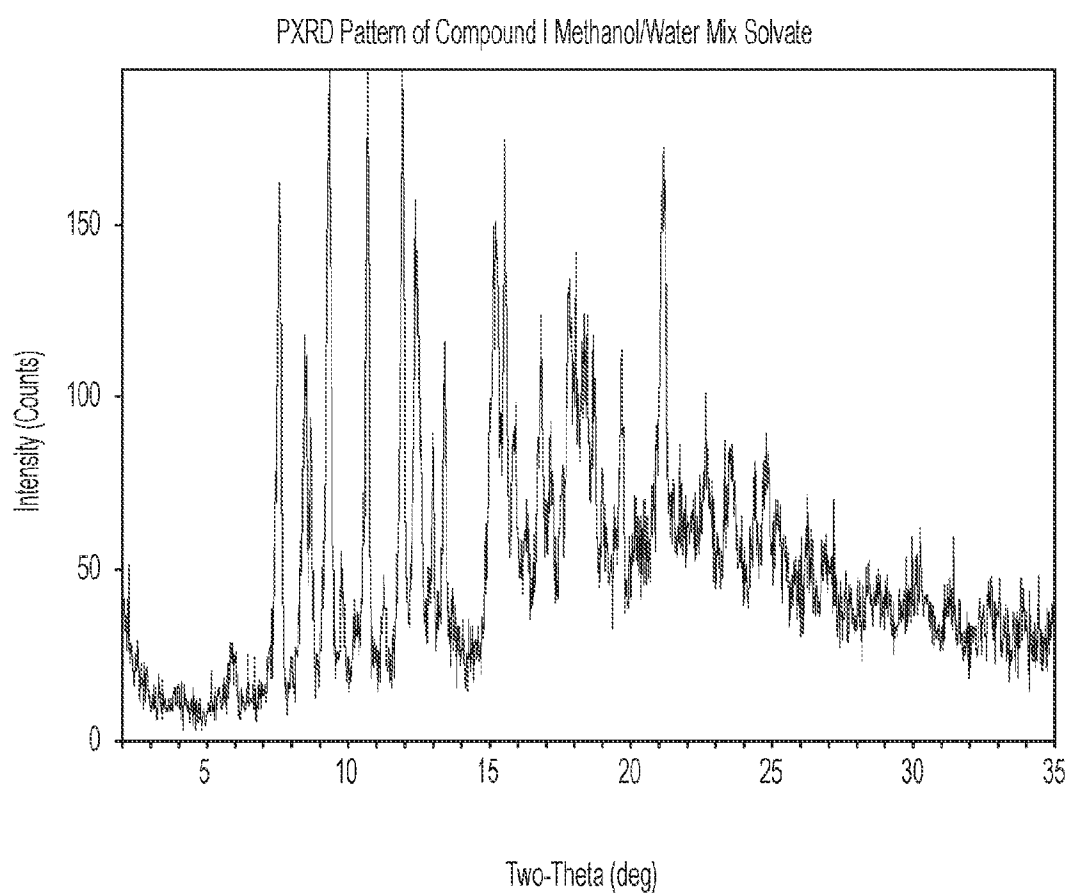


Figure 7.

8/11

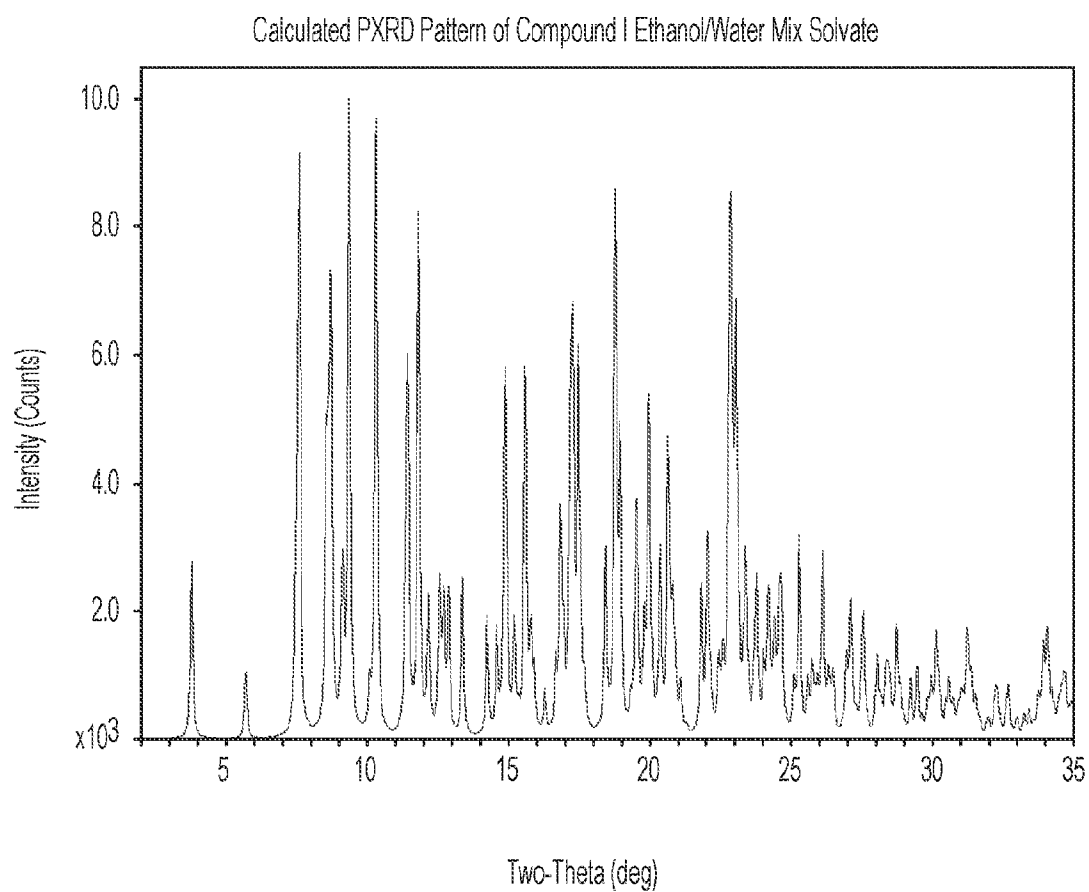


Figure 8.

9/11

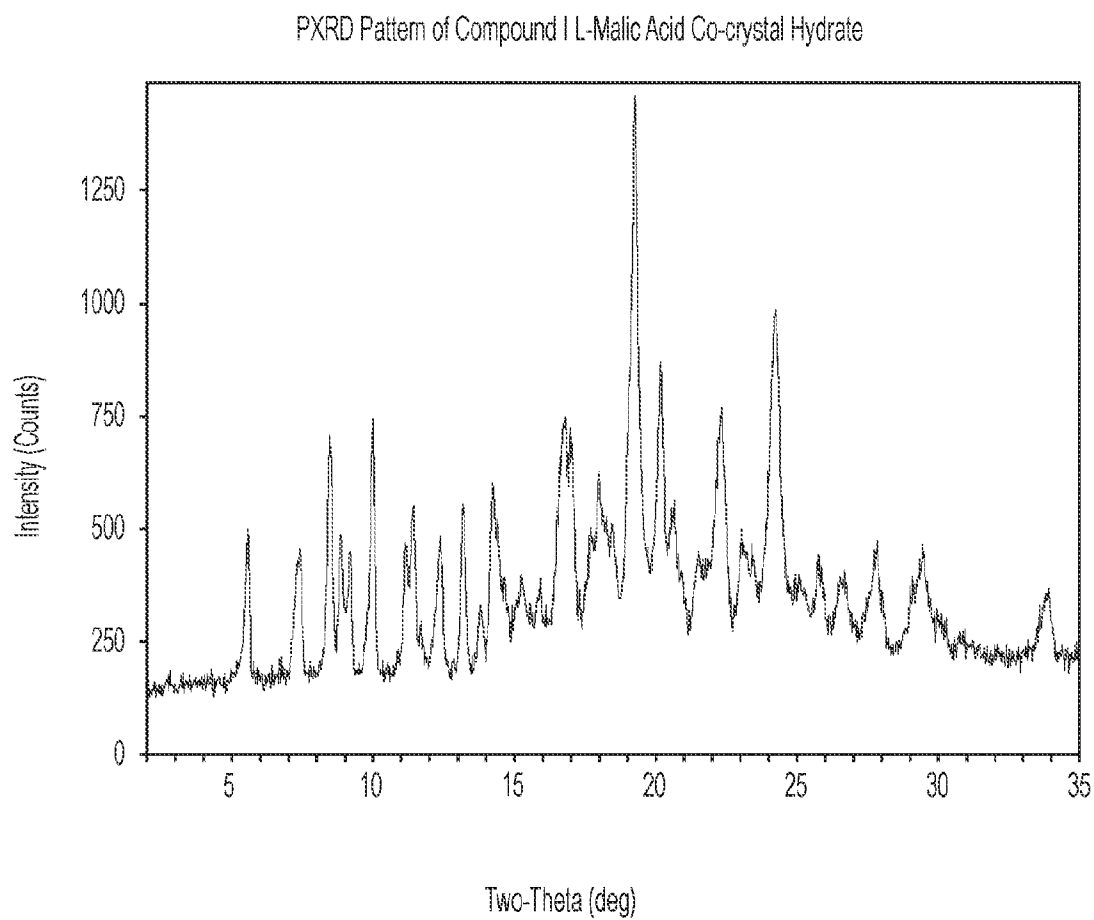


Figure 9.

10/11

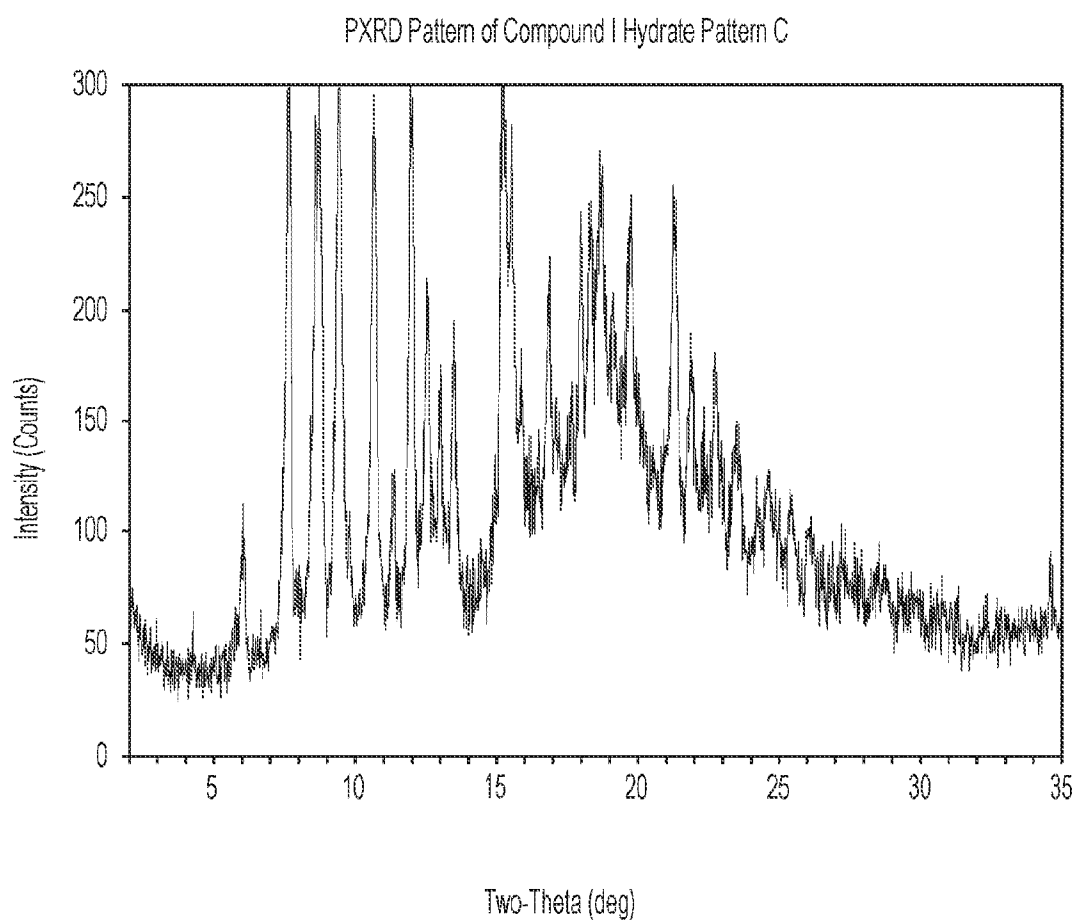


Figure 10.

11/11

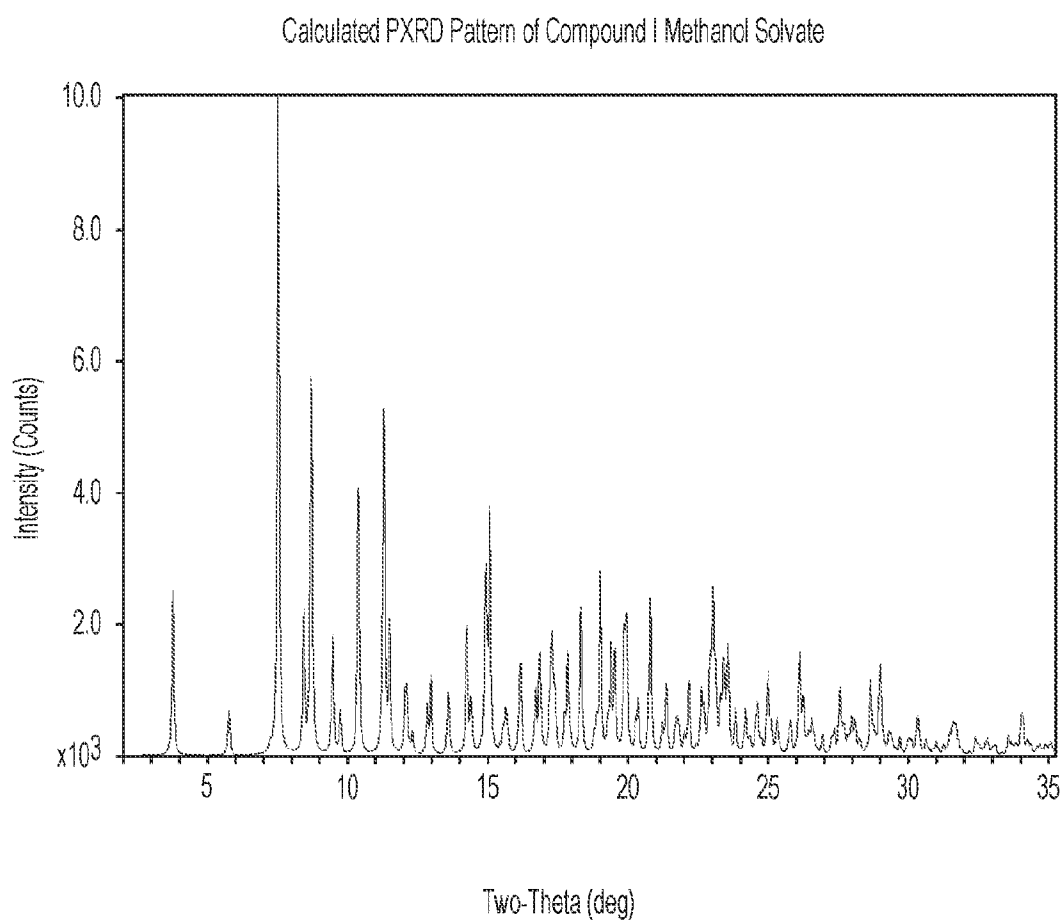


Figure 11.

INTERNATIONAL SEARCH REPORT

International application No

PCT/US2017/029410

A. CLASSIFICATION OF SUBJECT MATTER

INV. C07D403/14 A61K31/4025 A61P31/14
ADD.

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

C07D A61K A61P

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EPO-Internal, CHEM ABS Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	WO 2015/171162 A1 (ABBVIE INC [US]) 12 November 2015 (2015-11-12) paragraph [0029] - paragraph [0032] -----	1-5
X	CN 105 294 828 A (SUZHOU MIRACPHARMA TECHNOLOGY CO LTD) 3 February 2016 (2016-02-03) example 6 -----	1-5
A	FLICK ANDREW C ET AL: "Synthetic approaches to the 2014 new drugs", BIOORGANIC & MEDICINAL CHEMISTRY, PERGAMON, GB, vol. 24, no. 9, 9 March 2016 (2016-03-09), pages 1937-1980, XP029500703, ISSN: 0968-0896, DOI: 10.1016/J.BMC.2016.03.004 point 26. on page 1962-1963 and scheme 34 -----	1-5



Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents :

"A" document defining the general state of the art which is not considered to be of particular relevance

"E" earlier application or patent but published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

1 June 2017

Date of mailing of the international search report

07/08/2017

Name and mailing address of the ISA/

European Patent Office, P.B. 5818 Patentlaan 2
NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040,
Fax: (+31-70) 340-3016

Authorized officer

Gregoire, Ariane

INTERNATIONAL SEARCH REPORT

International application No.
PCT/US2017/029410

Box No. II Observations where certain claims were found unsearchable (Continuation of item 2 of first sheet)

This international search report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☐ Claims Nos.:
because they relate to subject matter not required to be searched by this Authority, namely:
2. ☐ Claims Nos.:
because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out, specifically:
3. ☐ Claims Nos.:
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box No. III Observations where unity of invention is lacking (Continuation of item 3 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

see additional sheet

1. ☐ As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying an additional fees, this Authority did not invite payment of additional fees.
3. ☐ As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims for which fees were paid, specifically claims Nos.:
4. ☒ No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

see annexes

Remark on Protest

- ☐ The additional search fees were accompanied by the applicant's protest and, where applicable, the payment of a protest fee.
- ☐ The additional search fees were accompanied by the applicant's protest but the applicable protest fee was not paid within the time limit specified in the invitation.
- ☐ No protest accompanied the payment of additional search fees.

FURTHER INFORMATION CONTINUED FROM PCT/ISA/ 210

This International Searching Authority found multiple (groups of) inventions in this international application, as follows:

1. claims: 1-5(partially)

Compound I anhydrate pattern A

2. claims: 1-5(partially)

Compound I anhydrate pattern B

3. claims: 1-5(partially)

Compound I anhydrate pattern C

4. claims: 1-5(partially)

Compound I anhydrate pattern D

5. claims: 1-5(partially)

Compound I hydrate pattern A

6. claims: 1-5(partially)

Compound I hydrate pattern B

7. claims: 1-5(partially)

Compound I methanol/water mix solvate

8. claims: 1-5(partially)

Compound I ethanol/water mix solvate

9. claims: 1-5(partially)

Compound I L-malic acid co-crystal hydrate

10. claims: 1-5(partially)

Compound I hydrate pattern C

11. claims: 1-5(partially)

FURTHER INFORMATION CONTINUED FROM PCT/ISA/ 210

Compound I methanol solvate

INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/US2017/029410

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
WO 2015171162	A1	12-11-2015	NONE

CN 105294828	A	03-02-2016	NONE
