Title: CARVEDILOL SALTS, CORRESPONDING COMPOSITIONS, METHODS OF DELIVERY AND/OR TREATMENT

Abstract: The present invention relates to a salt of carvedilol and/or corresponding solvates thereof, compositions containing such carvedilol and/or corresponding solvates thereof, and/or methods of using the aforementioned compound(s) in the treatment of certain disease states in mammals, in particular man. The present invention further relates to carvedilol phosphate salts, and/or solvates thereof, which include a novel crystalline form of carvedilol dihydrogen phosphate (i.e., which is the dihydrogen phosphate salt of (1-carbazol-4-yloxy-3-[2-o-methoxyphenoxy]ethyl)amino]-2-propanol) and/or carvedilol hydrogen phosphate, etc. and/or other corresponding solvates thereof, compositions containing these carvedilol phosphate salts and/or solvates, and methods of using the aforementioned salts and/or solvates to treat hypertension, congestive heart failure and angina, etc.
Carvedilol Salts, Corresponding Compositions, Methods of Delivery and/or Treatment

Field of the Invention

The present invention relates to salts of carvedilol, corresponding anhydrous forms or solvates thereof, pharmaceutical compositions, and/or methods of using the aforementioned compound(s) in treatment of certain disease states in mammals, in particular man.

The present invention further relates to a novel crystalline salt or solvate form of carvedilol, a salt of 1-(carbazol-4-yloxy-3-[[2-(o-methoxyphenoxy)ethyl] amino]-2-propanol), corresponding pharmaceutical compositions (i.e., containing such salts, anhydrous forms or solvates thereof, etc.) and methods of using the aforementioned compound(s) and/or pharmaceutical compositions to treat cardiovascular diseases, which may include, but are not limited to hypertension, congestive heart failure, and angina.

Background of the Invention

The compound, 1-(carbazol-4-yloxy-3-[[2-(o-methoxyphenoxy) ethyl]-amino]-2-propanol is known as Carvedilol. Carvedilol is depicted by the following chemical structure:

![Chemical structure of Carvedilol]

Carvedilol is disclosed in U.S. Patent No. 4,503,067 to Wiedemann et al. (i.e., assigned to Boehringer Mannheim, GmbH, Mannheim-Waldhof, Fed. Rep. of Germany), which was issued on March 5, 1985.

Currently, carvedilol is synthesized as free base for incorporation in
medication that is available commercially. The aforementioned free base form of Carvedilol is a racemic mixture of R(+) and S(-) enantiomers, where non-selective β-adrenoreceptor blocking activity is exhibited by the S(-) enantiomer and α-adrenergic blocking activity is exhibited by both R(+) and S(-) enantiomers. Those unique features or characteristics associated with such a racemic Carvedilol mixture contributes to two complementary pharmacologic actions: i.e., mixed venous and arterial vasodilation and non-cardioselective, beta-adrenergic blockade.

Carvedilol is used for treatment of hypertension, congestive heart failure and angina. The currently commercially available carvedilol product is a conventional, tablet prescribed as a twice-a-day (BID) medication in the United States.

Carvedilol contains an α-hydroxyl secondary amine functional group, which has a pKa of 7.8. Carvedilol exhibits predictable solubility behaviour in neutral or alkaline media, i.e. above a pH of 9.0, the solubility of carvedilol is relatively low (< 1 µg/mL). The solubility of carvedilol increases with decreasing pH and reaches a plateau near pH = 5, i.e. where saturation solubility is about 23 µg/mL at pH = 7 and about 100 µg/mL at pH = 5 at room temperature. At lower pH values (i.e., at a pH of 1 to 4 in various buffer systems), solubility of carvedilol is limited by the solubility of its protonated form or its corresponding salt formed in-situ. For example, a hydrochloride salt of carvedilol generated in situ an acidic medium, which simulates gastric fluid, is less soluble in such medium.

In addition, the presence of the α-hydroxyl secondary amine group in the Carvedilol chemical structure confers a propensity upon the compound to chemically react with excipients normally included in a dosage form to aid manufacture, maintain quality, or enhances dissolution rate. For example, the α-hydroxyl secondary amine group of Carvedilol can react with aldehydes or ester functional groups through nucleophilic reactions. Common chemical functional group residues associated with conventionally used excipients, include ester, aldehyde and/or other chemical residue functional groups. This often results in marginal or unacceptable chemical stability upon storage.
In light of the foregoing, novel salt forms of carvedilol with greater aqueous solubility, chemical stability, etc. would offer many potential benefits for provision of medicinal products containing the drug carvedilol.

Such benefits would include products with the ability to achieve desired or prolonged drug levels in a systemic system by sustaining absorption along the gastro-intestinal tract of mammals (i.e., such as humans), particularly in regions of neutral pH, where a drug, such as carvedilol, has minimal solubility.

Surprisingly, it has now been shown that novel crystalline forms of carvedilol salts, may be isolated as a pure crystalline solid, which exhibit much higher aqueous solubility than the corresponding free base or other prepared crystalline carvedilol salts.

This novel crystalline form also has potential to improve the stability of carvedilol in formulations due to the fact that the secondary amine functional group attached to the carvedilol core structure, a moiety pivotal to degradation processes, is protonated as a salt.

In light of the above, a need exists to develop different carvedilol salt forms and/or different corresponding compositions, respectively, which have greater aqueous solubility, chemical stability, sustained or prolonged drug or absorption properties (i.e., such as in neutral gastrointestinal tract pH regions, etc.).

There also exists a need to develop methods of treatment for cardiovascular diseases and/or associated disorders, which may include, but are not limited to hypertension, congestive heart failure or angina, etc., which comprises administration of the such carvedilol salt forms, and/or corresponding pharmaceutical compositions.

The present invention is directed to overcoming these and other problems encountered in the art.

**Summary of the Invention**

The present invention relates to a salt of carvedilol and/or corresponding solvates thereof, pharmaceutical compositions containing such carvedilol and/or corresponding solvates thereof, and/or methods of using the
aforementioned compound(s) and/or pharmaceutical compositions in the
treatment of certain disease states in mammals, in particular man.

The present invention further relates to carvedilol salt forms, which may,
but are not limited to include novel crystalline salt forms of carvedilol
mandelate, carvedilol lactate, carvedilol maleate, carvedilol sulfate, carvedilol
glutарате, carvedilol mesylate, carvedilol phosphate, carvedilol citrate,
carvedilol hydrogen bromide, carvedilol oxalate, carvedilol hydrochloride,
carvedilol hydrogen bromide, carvedilol benzoate, and/or corresponding
anhydrous, solvates, thereof.

The present invention relates to a pharmaceutical composition, which
contain such aforementioned carvedilol salt forms, and/or corresponding
anhydrous, solvates thereof, and/or pharmaceutically acceptable adjuvants,
carriers, excipients.

The present invention further relates to a method of treating
hypertension, congestive heart failure and angina, which comprises
administering to a subject in need thereof an effective amount of a carvedilol
salt form (which include corresponding novel crystalline forms, anhydrous
forms, solvates thereof) and/or such aforementioned corresponding
pharmaceutical compositions (i.e., which contain such carvedilol salt forms,
anhydrous, solvates thereof).

**Brief Description of the Figures**

**Carvedilol Phosphate Salts**

Figure 1 is an x-ray powder diffractogram for carvedilol dihydrogen
phosphate hemihydrate (Form I).

Figure 2 shows the thermal analysis results for carvedilol dihydrogen
phosphate hemihydrate (Form I).

Figure 3 is an FT-Raman spectrum for carvedilol dihydrogen phosphate
hemihydrate (Form I).

Figure 4 is an FT-Raman spectrum for carvedilol dihydrogen phosphate
hemihydrate in the 4000-2000 cm⁻¹ region of the spectrum (Form I).
Figure 5 is an FT-Raman spectrum for carvedilol dihydrogen phosphate hemihydrate in the 2000-400 cm\(^{-1}\) region of the spectrum (Form I).

Figure 6 is an FT-IR spectrum for carvedilol dihydrogen phosphate hemihydrate (Form I).

Figure 7 is an FT-IR spectrum for carvedilol dihydrogen phosphate hemihydrate in the 4000-2000 cm\(^{-1}\) region of the spectrum (Form I).

Figure 8 is an FT-IR spectrum for carvedilol dihydrogen phosphate hemihydrate in the 2000-500 cm\(^{-1}\) region of the spectrum (Form I).

Figure 9 is an x-ray powder diffractogram for carvedilol dihydrogen phosphate dihydride (Form II).

Figure 10 shows the thermal analysis results for carvedilol dihydrogen phosphate dihydrate (Form II).

Figure 11 is an FT-Raman spectrum for carvedilol dihydrogen phosphate dihydrate (Form II).

Figure 12 is an FT-Raman spectrum for carvedilol dihydrogen phosphate dihydrate in the 4000-2000 cm\(^{-1}\) region of the spectrum (Form II).

Figure 13 is an FT-Raman spectrum for carvedilol dihydrogen phosphate dihydrate in the 2000-400 cm\(^{-1}\) region of the spectrum (Form II).

Figure 14 is an FT-IR spectrum for carvedilol dihydrogen phosphate dihydrate (Form II).

Figure 15 is an FT-IR spectrum for carvedilol dihydrogen phosphate dihydrate in the 4000-2000 cm\(^{-1}\) region of the spectrum (Form II).

Figure 16 is an FT-IR spectrum for carvedilol dihydrogen phosphate dihydrate in the 2000-500 cm\(^{-1}\) region of the spectrum (Form II).

Figure 17 shows the thermal analysis results for carvedilol dihydrogen phosphate methanol solvate (Form III).

Figure 18 is an FT-Raman spectrum for carvedilol dihydrogen phosphate methanol solvate (Form III).

Figure 19 is an FT-Raman spectrum for carvedilol dihydrogen phosphate methanol solvate in the 4000-2000 cm\(^{-1}\) region of the spectrum (Form III).
Figure 20 is an FT-Raman spectrum for carvedilol dihydrogen phosphate methanol solvate in the 2000-400 cm\(^{-1}\) region of the spectrum (Form III).

Figure 21 is an FT-IR spectrum for carvedilol dihydrogen phosphate methanol solvate (Form III).

Figure 22 is an FT-IR spectrum for carvedilol dihydrogen phosphate methanol solvate in the 4000-2000 cm\(^{-1}\) region of the spectrum (Form III).

Figure 23 is an FT-IR spectrum for carvedilol dihydrogen phosphate methanol solvate in the 2000-500 cm\(^{-1}\) region of the spectrum (Form III).

Figure 24 is an x-ray powder diffractogram for carvedilol dihydrogen phosphate methanol solvate (Form III).

Figure 25 is an x-ray powder diffractogram for carvedilol dihydrogen phosphate dihydrate (Form IV).

Figure 26 is a solid state \(^{13}\)C NMR for carvedilol dihydrogen phosphate dihydrate (Form I).

Figure 27 is a solid state \(^{31}\)P NMR for carvedilol dihydrogen phosphate dihydrate (Form I).

Figure 28 is an x-ray powder diffractogram for carvedilol dihydrogen phosphate (Form V).

Figure 29 is an x-ray powder diffractogram for carvedilol hydrogen phosphate (Form VI).

**Carvedilol HBr Salts**

Figure 30 is an x-ray powder diffractogram for carvedilol hydrobromide monohydrate.

Figure 31 is a differential scanning calorimetry thermogram for carvedilol hydrobromide monohydrate.

Figure 32 is an FT-Raman spectrum for carvedilol hydrobromide monohydrate.

Figure 33 is an FT-Raman spectrum for carvedilol hydrobromide monohydrate in the 4000-2000 cm\(^{-1}\) region of the spectrum.

Figure 34 is an FT-Raman spectrum for carvedilol hydrobromide monohydrate in the 2000-400 cm\(^{-1}\) region of the spectrum.
Figure 35 is an FT-IR spectrum for carvedilol hydrobromide monohydrate.

Figure 36 is an FT-IR spectrum for carvedilol hydrobromide monohydrate in the 4000-2000 cm\(^{-1}\) region of the spectrum.

Figure 37 is an FT-IR spectrum for carvedilol hydrobromide monohydrate in the 2000-500 cm\(^{-1}\) region of the spectrum.

Figure 38 is a view of a single molecule of carvedilol hydrobromide monohydrate. The hydroxyl group and the water molecule are disordered.

Figure 39 are views of molecules of carvedilol hydrobromide monohydrate showing the N-H···Br···H-N interactions. The top view focuses on Br1 and the bottom view focuses on Br2. The interaction between the carvedilol cation and the bromine anion is unusual. Each carvedilol molecule makes two chemically different contacts to the bromine anions. Each bromine anion sits on a crystallographic special position (that is, on a crystallographic two-fold axis) which means that there are two half bromine anions interacting with each carvedilol cation.

Figure 40 is a differential scanning calorimetry thermogram for carvedilol hydrobromide dioxane solvate.

Figure 41 is an FT-Raman spectrum for carvedilol hydrobromide dioxane solvate.

Figure 42 is an FT-Raman spectrum for carvedilol hydrobromide dioxane solvate in the 4000-2000 cm\(^{-1}\) region of the spectrum.

Figure 43 is an FT-Raman spectrum for carvedilol hydrobromide dioxane solvate in the 2000-400 cm\(^{-1}\) region of the spectrum.

Figure 44 is an FT-IR spectrum for carvedilol hydrobromide dioxane solvate.

Figure 45 is an FT-IR spectrum for carvedilol hydrobromide dioxane solvate in the 4000-2000 cm\(^{-1}\) region of the spectrum.

Figure 46 is an FT-IR spectrum for carvedilol hydrobromide dioxane solvate in the 2000-500 cm\(^{-1}\) region of the spectrum.

Figure 47 is a differential scanning calorimetry thermogram for carvedilol
hydrobromide 1-pentanol solvate.

Figure 48 is an FT-Raman spectrum for carvedilol hydrobromide 1-pentanol solvate.

Figure 49 is an FT-Raman spectrum for carvedilol hydrobromide 1-pentanol solvate in the 4000-2000 cm⁻¹ region of the spectrum.

Figure 50 is an FT-Raman spectrum for carvedilol hydrobromide 1-pentanol solvate in the 2000-400 cm⁻¹ region of the spectrum.

Figure 51 is an FT-IR spectrum for carvedilol hydrobromide 1-pentanol solvate.

Figure 52 is an FT-IR spectrum for carvedilol hydrobromide 1-pentanol solvate in the 4000-2000 cm⁻¹ region of the spectrum.

Figure 53 is an FT-IR spectrum for carvedilol hydrobromide 1-pentanol solvate in the 2000-500 cm⁻¹ region of the spectrum.

Figure 54 is a differential scanning calorimetry thermogram for carvedilol hydrobromide 2-methyl-1-propanol solvate.

Figure 55 is an FT-Raman spectrum for carvedilol hydrobromide 2-methyl-1-propanol solvate.

Figure 56 is an FT-Raman spectrum for carvedilol hydrobromide 2-methyl-1-propanol solvate in the 4000-2000 cm⁻¹ region of the spectrum.

Figure 57 is an FT-Raman spectrum for carvedilol hydrobromide 2-methyl-1-propanol solvate in the 2000-400 cm⁻¹ region of the spectrum.

Figure 58 is an FT-IR spectrum for carvedilol hydrobromide 2-methyl-1-propanol solvate.

Figure 59 is an FT-IR spectrum for carvedilol hydrobromide 2-methyl-1-propanol solvate in the 4000-2000 cm⁻¹ region of the spectrum.

Figure 60 is an FT-IR spectrum for carvedilol hydrobromide 2-methyl-1-propanol solvate in the 2000-500 cm⁻¹ region of the spectrum.

Figure 61 is a differential scanning calorimetry thermogram for carvedilol hydrobromide trifluoroethanol solvate.

Figure 62 is an FT-Raman spectrum for carvedilol hydrobromide trifluoroethanol solvate.
Figure 63 is an FT-Raman spectrum for carvedilol hydrobromide trifluoroethanol solvate in the 4000-2000 cm\(^{-1}\) region of the spectrum.

Figure 64 is an FT-Raman spectrum for carvedilol hydrobromide trifluoroethanol solvate in the 2000-400 cm\(^{-1}\) region of the spectrum.

Figure 65 is an FT-IR spectrum for carvedilol hydrobromide trifluoroethanol solvate.

Figure 66 is an FT-IR spectrum for carvedilol hydrobromide trifluoroethanol solvate in the 4000-2000 cm\(^{-1}\) region of the spectrum.

Figure 67 is an FT-IR spectrum for carvedilol hydrobromide trifluoroethanol solvate in the 2000-500 cm\(^{-1}\) region of the spectrum.

Figure 68 is a differential scanning calorimetry thermogram for carvedilol hydrobromide 2-propanol solvate.

Figure 69 is an FT-Raman spectrum for carvedilol hydrobromide 2-propanol solvate.

Figure 70 is an FT-Raman spectrum for carvedilol hydrobromide 2-propanol solvate in the 4000-2000 cm\(^{-1}\) region of the spectrum.

Figure 71 is an FT-Raman spectrum for carvedilol hydrobromide 2-propanol solvate in the 2000-400 cm\(^{-1}\) region of the spectrum.

Figure 72 is an FT-IR spectrum for carvedilol hydrobromide 2-propanol solvate.

Figure 73 is an FT-IR spectrum for carvedilol hydrobromide 2-propanol solvate in the 4000-2000 cm\(^{-1}\) region of the spectrum.

Figure 74 is an FT-IR spectrum for carvedilol hydrobromide 2-propanol solvate in the 2000-500 cm\(^{-1}\) region of the spectrum.

Figure 75 is an x-ray powder diffractogram for carvedilol hydrobromide n-propanol solvate #1.

Figure 76 shows the thermal analysis results for carvedilol hydrobromide n-propanol solvate #1.

Figure 77 is an FT-Raman spectrum for carvedilol hydrobromide n-propanol solvate #1.

Figure 78 is an FT-Raman spectrum for carvedilol hydrobromide n-
propanol solvate #1 in the 4000-2000 cm\(^{-1}\) region of the spectrum.

Figure 79 is an FT-Raman spectrum for carvedilol hydrobromide n-propanol solvate #1 in the 2000-400 cm\(^{-1}\) region of the spectrum.

Figure 80 is an FT-IR spectrum for carvedilol hydrobromide n-propanol solvate #1.

Figure 81 is an FT-IR spectrum for carvedilol hydrobromide n-propanol solvate #1 in the 4000-2000 cm\(^{-1}\) region of the spectrum.

Figure 82 is an FT-IR spectrum for carvedilol hydrobromide n-propanol solvate #1 in the 2000-500 cm\(^{-1}\) region of the spectrum.

Figure 83 is an x-ray powder diffractogram for carvedilol hydrobromide n-propanol solvate #2.

Figure 84 shows the thermal analysis results for carvedilol hydrobromide n-propanol solvate #2.

Figure 85 is an FT-Raman spectrum for carvedilol hydrobromide n-propanol solvate #2.

Figure 86 is an FT-Raman spectrum for carvedilol hydrobromide n-propanol solvate #2 in the 4000-2000 cm\(^{-1}\) region of the spectrum.

Figure 87 is an FT-Raman spectrum for carvedilol hydrobromide n-propanol solvate #2 in the 2000-400 cm\(^{-1}\) region of the spectrum.

Figure 88 is an FT-IR spectrum for carvedilol hydrobromide n-propanol solvate #2.

Figure 89 is an FT-IR spectrum for carvedilol hydrobromide n-propanol solvate #2 in the 4000-2000 cm\(^{-1}\) region of the spectrum.

Figure 90 is an FT-IR spectrum for carvedilol hydrobromide n-propanol solvate #2 in the 2000-500 cm\(^{-1}\) region of the spectrum.

Figure 91 is an x-ray powder diffractogram for carvedilol hydrobromide anhydrous.

Figure 92 shows the thermal analysis results for carvedilol hydrobromide anhydrous.

Figure 93 is an FT-Raman spectrum for carvedilol hydrobromide anhydrous.
Figure 94 is an FT-Raman spectrum for carvedilol hydrobromide anhydrous forms in the 4000-2000 cm\(^{-1}\) region of the spectrum.

Figure 95 is an FT-Raman spectrum for carvedilol hydrobromide anhydrous forms in the 2000-400 cm\(^{-1}\) region of the spectrum.

Figure 96 is an FT-IR spectrum for carvedilol hydrobromide anhydrous.

Figure 97 is an FT-IR spectrum for carvedilol hydrobromide anhydrous forms in the 4000-2000 cm\(^{-1}\) region of the spectrum.

Figure 98 is an FT-IR spectrum for carvedilol hydrobromide anhydrous forms in the 2000-500 cm\(^{-1}\) region of the spectrum.

Figure 99 is an x-ray powder diffractogram for carvedilol hydrobromide ethanol solvate.

Figure 100 shows the thermal analysis results for carvedilol hydrobromide ethanol solvate.

Figure 101 is an FT-Raman spectrum for carvedilol hydrobromide ethanol solvate.

Figure 102 is an FT-Raman spectrum for carvedilol hydrobromide ethanol solvate in the 4000-2000 cm\(^{-1}\) region of the spectrum.

Figure 103 is an FT-Raman spectrum for carvedilol hydrobromide ethanol solvate in the 2000-400 cm\(^{-1}\) region of the spectrum.

Figure 104 is an FT-IR spectrum for carvedilol hydrobromide ethanol solvate.

Figure 105 is an FT-IR spectrum for carvedilol hydrobromide ethanol solvate in the 4000-2000 cm\(^{-1}\) region of the spectrum.

Figure 106 is an FT-IR spectrum for carvedilol hydrobromide ethanol solvate in the 2000-500 cm\(^{-1}\) region of the spectrum.

Figure 107 is an x-ray powder diffractogram for carvedilol hydrobromide dioxane solvate.

Figure 108 is an x-ray powder diffractogram for carvedilol hydrobromide 1-pentanol solvate.

Figure 109 is an x-ray powder diffractogram for carvedilol hydrobromide 2-methyl-1-propanol solvate.
Figure 110 is an x-ray powder diffractogram for carvedilol hydrobromide trifluoroethanol solvate.

Figure 111 is an x-ray powder diffractogram for carvedilol hydrobromide 2-propanol solvate.

5 Carvedilol Citrate Salts

Figure 112 is a FT-IR spectrum of carvedilol monicitrate salt.

Figure 113 depicts XRPD patterns of two different batches of Carvedilol monocitrate salt.

Carvedilol Mandelate Salts

Figure 114 is a FT-IR spectrum of carvedilol mandelate salt.

Figure 115 is a FT-Raman spectrum of carvedilol mandelate salt.

Carvedilol Lactate Salts

Figure 116 is a FT-IR spectrum of carvedilol lactate salt.

Figure 117 is a FT-Raman spectrum of carvedilol lactate salt.

15 Carvedilol Maleate Salts

Figure 118 is a FT-IR spectrum of carvedilol maleate salt.

Figure 119 is a FT-Raman spectrum of carvedilol maleate salt.

Carvedilol Sulfate Salts

Figure 120 is a FT-IR spectrum of carvedilol sulfate salt.

Figure 121 is a FT-Raman spectrum of carvedilol sulfate salt.

Carvedilol Glutarate Salts

Figure 122 is a FT-IR spectrum of carvedilol glutarate salt.

Figure 123 is a FT-Raman spectrum of carvedilol glutarate salt.

Carvedilol Benzoate Salts

Figure 124 is a FT-IR spectrum of carvedilol benzoate salt.

Figure 125 is a FT-Raman spectrum of carvedilol benzoate salt.

Drug Solubility Enhancement in GI tract

Figure 126 depicts a pH-solubility profile for carvedilol.

Figure 127 depicts mean plasma profiles in beagle dogs following intra-colonic administration of a carvedilol solution containing captisol or carvedilol in aqueous suspension.

Figure 128 depicts dissolution/solubility profile of carvedilol phosphate in
pH = 7.1 tris buffer.

Figure 129 depicts mean plasma profiles in beagle dogs following oral administration of the formulations listed in Table 4.

Figure 130 depicts mean plasma profiles following oral administration of companion capsules filled with four formulations at 10 mg strength to beagle dogs.

**Detailed Description of the Invention**

The present invention relates to a salt of carvedilol and/or corresponding anhydrous forms or solvates thereof, compositions containing such carvedilol and/or corresponding anhydrous forms or solvates thereof, and/or methods of using the aforementioned compound(s) in the treatment of certain disease states in mammals, in particular man.

The present invention further relates to carvedilol salt forms, which may, but are not limited to include novel crystalline salt forms of carvedilol mandelate, carvedilol lactate, carvedilol maleate, carvedilol sulfate, carvedilol glutarate, carvedilol mesylate, carvedilol phosphate, carvedilol citrate, carvedilol hydrogen bromide, carvedilol oxalate, carvedilol hydrochloride, carvedilol hydrogen bromide, carvedilol benzoate, and/or corresponding anhydrous, solvates thereof.

The present invention relates to a pharmaceutical composition, which contain such aforementioned carvedilol salt forms, and/or corresponding anhydrous, solvates thereof, and/or pharmaceutically acceptable adjuvants, carriers, excipients.

The present invention further relates to a method of treating hypertension, congestive heart failure and angina, which comprises administering to a subject in need thereof an effective amount of a carvedilol salt form (which include corresponding novel crystalline forms, anhydrous forms, solvates thereof) and/or such aforementioned corresponding pharmaceutical compositions (i.e., which contain such carvedilol salt forms, anhydrous, solvates thereof).
All carvedilol salt and/or solvate compound forms suitable for use in the present invention, which include starting materials (i.e., such as carvedilol), intermediates or products, etc., are prepared as described herein, and/or by the application or adaptation of known methods, which may be methods used heretofore or described in the literature.

Carvedilol is disclosed and claimed in U.S. Patent No. 4,503,067 to Wiedemann et al. ("U.S. '067 Patent"). Reference should be made to U.S. '067 Patent for its full disclosure, which include methods of preparing and/or using the carvedilol compound. The entire disclosure of the U.S. '067 Patent is incorporated hereby by reference in its entirety.

U.S. Pat. No. 6,515,010 to Franchini et al. discloses a novel salt form of carvedilol, namely carvedilol methanesulfonate salt form, pharmaceutical compositions containing carvedilol methanesulfonate and the use of the aforementioned compound in the treatment of hypertension, congestive heart failure and angina, which is hereby incorporated by reference in its entirety.

The present invention relates to a compound, which is a novel crystalline salt form of carvedilol.

In accordance with the present invention, it has been unexpectedly found that carvedilol compounds may be isolated readily as novel crystalline forms, which display much higher solubility when compared to the free base form of carvedilol.

As indicated above, the present invention relates to carvedilol salt forms, which include a novel crystalline salt forms of carvedilol mandelate, carvedilol lactate, carvedilol maleate, carvedilol sulfate, carvedilol glutarate, carvedilol mesylate, carvedilol phosphate, carvedilol citrate, carvedilol hydrogen bromide, carvedilol oxalate, carvedilol hydrochloride, carvedilol hydrogen bromide, carvedilol benzoate, and/or corresponding solvates thereof.

More particularly, the present invention relates to carvedilol salt forms, which may include, but are not limited to carvedilol hydrogen phosphate, carvedilol dihydrogen phosphate, carvedilol dihydrogen phosphate hemihydrate, carvedilol dihydrogen phosphate dihydrate, carvedilol dihydrogen phosphate methanol solvate, carvedilol hydrobromide monohydrate, carvedilol
hydrobromide dioxane solvate, carvedilol hydrobromide 1-pentanol solvate,
carvedilol hydrobromide 2-methyl-1-propanol solvate, carvedilol hydrobromide
trifluoroethanol solvate, carvedilol hydrobromide 2-propanol solvate, carvedilol
hydrobromide n-propanol solvate #1, carvedilol hydrobromide n-propanol
solvate #2, carvedilol hydrobromide anhydrous forms or anhydrous, carvedilol
hydrobromide ethanol solvate, carvedilol hydrobromide dioxane solvate,
carvedilol mononitrate monohydrate, carvedilol mandelate, carvedilol lactate
salt, carvedilol maleate, carvedilol sulfate, carvedilol glutarate, and/or
corresponding anhydrous, solvates thereof.

According to one aspect of the present invention, novel crystalline carvedilol
salt forms, may exist as different polymorphs, anhydrous forms, and/or solvates
thereof, etc.

In light of this, crystalline carvedilol salt forms of the present invention
(i.e., which may include different polymorphs, anhydrous forms, solvates, and/or-
hydrates thereof) may exhibit characteristic polymorphism. As conventionally
understood in the art, polymorphism is defined as an ability of a compound to
crystallize as more than one distinct crystalline or "polymorphic" species. A
polymorph is defined as a solid crystalline phase of a compound with at least
two different arrangements or polymorphic forms of that compound molecule in
the solid state.

Polymorphic forms of any given compound, including those of the present
invention, are defined by the same chemical formula and/or composition and
are as distinct in chemical structure as crystalline structures of two different chemical
compounds. Such compounds may differ in packing, geometrical arrangement of
respective crystalline lattices, etc.

In light of the foregoing, chemical and/or physical properties or
characteristics vary with each distinct polymorphic form, which may include
variations in solubility, melting point, density, hardness, crystal shape, optical and
electrical properties, vapor pressure, stability, etc.

Solvates and/or hydrates of crystalline carvedilol salt forms of the
present invention also may be formed when solvent molecules are incorporated
into the crystalline lattice structure of the compound molecule during the
crystallization process. For example, solvate forms of the present invention may incorporate nonaqueous solvents such as methanol and the like as described herein below. Hydrate forms are solvate forms, which incorporate water as a solvent into a crystalline lattice.

In accordance with the present invention, other salts and/or solvates of carvedilol of the present invention may be isolated as different solid and/or crystalline forms. Moreover, a specific identified species of such carvedilol salts (or a specific identified corresponding solvate species) also may be isolated in various different crystalline or solid forms, which may include anhydrous forms or solvate forms. For example, carvedilol dihydrogen phosphate, may be isolated in two different and distinct crystalline forms, Forms II and IV, respectively represented and substantially shown Figures 9 to 6 (for Form II) and Figure 25 (for Form IV), which are represent spectroscopic and/or other characterizing data.

In general, Figures 1-125 depict spectroscopic and other characterizing data for different, specific, and distinct crystalline carvedilol salt, anhydrous, and/or solvate forms thereof. For example, carvedilol dihydrogen phosphate, may be isolated as two different and distinct crystalline forms, Forms II and IV, respectively represented and substantially shown Figures 9 to 6 (for Form II) and Figure 25 (for Form IV), which represent spectroscopic and/or other characterizing data.

It is recognized that the compounds of the present invention may exist in forms as stereoisomers, regioisomers, or diastereomers. These compounds may contain one or more asymmetric carbon atoms and may exist in racemic and optically active forms. For example, carvedilol may exist as racemic mixture of R(+)- and S(-)- enantiomers, or in separate respectively optical forms, i.e., existing separately as either the R(+) enantiomer form or in the S(+) enantiomer form. All of these individual compounds, isomers, and mixtures thereof are included within the scope of the present invention.

Carvedilol salts of the present invention may be prepared by various techniques, such as those exemplified below.
For example, crystalline carvedilol dihydrogen phosphate hemihydrate of the instant invention can be prepared by crystallization from an acetone-water solvent system containing carvedilol and H₃PO₄. Also suitable solvates of carvedilol phosphate salts of present invention may be prepared by preparing a slurry of a carvedilol phosphate salt, such as a carvedilol dihydrogen salt, in a solvent, such as methanol.

In another example, crystalline carvedilol hydrobromide monohydrate of the present invention can be prepared by crystallization from an acetone-water solvent system containing carvedilol and hydrobromic acid. Also, suitable solvates of carvedilol hydrobromide salts may be made by preparing a slurry of the carvedilol hydrobromide salt in a solvent (i.e., such as dioxane, 1-pentanol, 2-methyl-1-propanol, trifluoroethanol, 2-propanol and n-propanol. In particular, solvates of carvedilol hydrobromide as defined in the present invention, include, but are not limited to carvedilol hydrobromide 1-pentanol solvate, carvedilol hydrobromide 2-methyl-1-pentanol solvate, carvedilol hydrobromide trifluoroethanol solvate, carvedilol hydrobromide 2-propanol solvate, carvedilol hydrobromide n-propanol solvate #1, carvedilol hydrobromide n-propanol solvate #2, carvedilol hydrobromide ethanol solvate, carvedilol hydrobromide anhydrous), and/or dissolving the carvedilol hydrobromide salt in the aforementioned solvents and allowing the salt to crystallize out. Carvedilol hydrobromide anhydrous forms can be prepared by dissolving carvedilol in a solvent, such as dichloromethane, acetonitrile or isopropyl acetate, followed by the addition of anhydrous HBr (HBr in acetic acid or gaseous HBr).

In yet another example, the crystalline carvedilol citrate salt of the instant invention can be prepared by making an aqueous citric acid solution saturated with carvedilol, either by lowering the temperature of the solution, or slowly evaporating water from the solution. In addition, it can be prepared by crystallization from an acetone-water solvent system containing carvedilol and citric acid. A particularly useful and surprising characteristic of the crystalline form of carvedilol citrate salt stems from the fact that citric acid is a prochiral molecule. Consequently, a 1 to 1 ratio of racemic diasteromers are present in the crystalline carvedilol citrate salt lattice. This avoids generation of yet more
optically active forms that could potentially complicate stability, dissolution rates, *in vivo* absorption metabolism and possibly pharmacologic effects.

According to the instant invention, the various salt forms of carvedilol and/or corresponding solvates thereof are distinguished from each other using different characterization or identification techniques. Such techniques, include solid state $^{13}$C Nuclear Magnetic Resonance (NMR), $^{31}$P Nuclear Magnetic Resonance (NMR), Infrared (IR), Raman, X-ray powder diffraction, etc. and/or other techniques, such as Differential Scanning Calorimetry (DSC) (i.e., which measures the amount of energy (heat) absorbed or released by a sample as it is heated, cooled or held at constant temperature).

In general, the aforementioned solid state NMR techniques are non-destructive techniques to yield spectra, which depict an NMR peak for each magnetically non-equivalent carbon site the solid-state

For example, in identification of compounds of the present invention, $^{13}$C NMR spectrum of a powdered microcrystalline organic molecules reflect that the number of peaks observed for a given sample will depend on the number of chemically unique carbons per molecule and the number of non-equivalent molecules per unit cell. Peak positions (chemical shifts) of carbon atoms reflect the chemical environment of the carbon in much the same manner as in solution-state $^{13}$C NMR. Although peaks can overlap, each peak is in principle assignable to a single type of carbon. Therefore, an approximate count of the number of carbon sites observed yields useful information about the crystalline phase of a small organic molecule.

Based upon the foregoing, the same principles apply to phosphorus, which has additional advantages due to high sensitivity of the $^{31}$P nucleus.

Polymorphism also can be studied by comparison of $^{13}$C and $^{31}$P spectra. In the case of amorphous material, broadened peak shapes are usually observed, reflecting the range of environments experienced by the $^{13}$C or $^{31}$P sites in amorphous material types.

Specifically, novel crystalline forms of carvedilol salts, anhydrous forms or solvates thereof, are characterized substantially by spectroscopic data as described below and depicted in Figures 1-125.
Examples of spectroscopic data associated with specific carvedilol salt, anhydrous forms or solvate forms are described below.

For example, crystalline carvedilol dihydrogen phosphate hemihydrate (see, Example 1: Form I) is identified by an x-ray diffraction pattern as shown substantially in Figure 1, which depicts characteristic peaks in degrees two-theta (2θ): i.e., 7.0 ± 0.2 (2θ), 11.4 ± 0.2 (2θ), 15.9 ± 0.2 (2θ), 18.8 ± 0.2 (2θ), 20.6 ± 0.2 (2θ), 22.8 ± 0.2 (2θ), and 25.4 ± 0.2 (2θ).

Crystalline carvedilol dihydrogen phosphate dihydrate (see, Example 2: Form II) is identified by an x-ray diffraction pattern as shown substantially in Figure 9, which depicts characteristic peaks in degrees two-theta (2θ): i.e., 6.5 ± 0.2 (2θ), 7.1 ± 0.2 (2θ), 13.5 ± 0.2 (2θ), 14.0 ± 0.2 (2θ), 17.8 ± 0.2 (2θ), 18.9 ± 0.2 (2θ), and 21.0 ± 0.2 (2θ).

Crystalline carvedilol dihydrogen phosphate methanol solvate (see, Example 3: Form III) is identified by an x-ray diffraction pattern as shown substantially in Figure 24, which depicts characteristic peaks in degrees two-theta (2θ): i.e., 6.9 ± 0.2 (2θ), 7.2 ± 0.2 (2θ), 13.5 ± 0.2 (2θ), 14.1 ± 0.2 (2θ), 17.8 ± 0.2 (2θ), and 34.0 ± 0.2 (2θ).

Crystalline carvedilol dihydrogen phosphate dihydrate (see, Example 4: Form IV) is identified by an x-ray diffraction pattern as shown substantially in Figure 24, which depicts characteristic peaks in degrees two-theta (2θ): i.e., 6.4 ± 0.2 (2θ), 9.6 ± 0.2 (2θ), 16.0 ± 0.2 (2θ), 18.4 ± 0.2 (2θ), 20.7 ± 0.2 (2θ), and 24.5 ± 0.2 (2θ).

Crystalline carvedilol dihydrogen phosphate preparation (see, Example 5: Form V) is identified by an x-ray diffraction pattern as shown substantially in Figure 28, which depicts characteristic peaks in degrees two-theta (2θ): i.e., 13.2 ± 0.2 (2θ), 15.8 ± 0.2 (2θ), 16.3 ± 0.2 (2θ), 21.2 ± 0.2 (2θ), 23.7 ± 0.2 (2θ), and 26.0 ± 0.2 (2θ).

Crystalline carvedilol hydrogen phosphate preparation (see, Example 6: Form VI) is identified by an x-ray diffraction pattern as shown substantially in Figure 29, which depicts characteristic peaks in degrees two-theta (2θ): i.e., 5.5 ± 0.2 (2θ), 12.3 ± 0.2 (2θ), 15.3 ± 0.2 (2θ), 19.5 ± 0.2 (2θ), 21.6 ± 0.2 (2θ), and 24.9 ± 0.2 (2θ).
Crystalline carvedilol hydrobromide monohydrate (see, Example 8: Form 1) is identified by an x-ray diffraction pattern as shown substantially in Figure 1, which depicts characteristic peaks in degrees two-theta (2θ): i.e., 6.5 ± 0.2 (2θ), 10.3 ± 0.2 (2θ), 15.7 ± 0.2 (2θ), 16.3 ± 0.2 (2θ), 19.8 ± 0.2 (2θ), 20.1 ± 0.2 (2θ), 21.9 ± 0.2 (2θ), 25.2 ± 0.2 (2θ), and 30.6 ± 0.2 (2θ).

Crystalline carvedilol hydrobromide dioxane solvate (see, Example 9: Form 2) also is identified by an x-ray diffraction pattern as shown substantially in Figure 78, which depicts characteristic peaks in degrees two-theta (2θ): i.e., 7.7 ± 0.2 (2θ), 8.4 ± 0.2 (2θ), 15.6 ± 0.2 (2θ), 17.0 ± 0.2 (2θ), 18.7 ± 0.2 (2θ), 19.5 ± 0.2 (2θ), 21.4 ± 0.2 (2θ), 23.7 ± 0.2 (2θ), and 27.9 ± 0.2 (2θ).

Crystalline carvedilol hydrobromide 1-pentanol solvate (see, Example 10: Form 3) also is identified by an x-ray diffraction pattern as shown substantially in Figure 79, which depicts characteristic peaks in degrees two-theta (2θ): i.e., 77.5 ± 0.2 (2θ), 7.8 ± 0.2 (2θ), 15.2 ± 0.2 (2θ), 18.9 ± 0.2 (2θ), 22.1 ± 0.2 (2θ), and 31.4 ± 0.2 (2θ).

Crystalline carvedilol hydrobromide 2-methyl-1-propanol solvate (see, Example 11: Form 4) also is identified by an x-ray diffraction pattern as shown substantially in Figure 80, which depicts characteristic peaks in degrees two-theta (2θ): i.e., 7.8 ± 0.2 (2θ), 8.1 ± 0.2 (2θ), 16.3 ± 0.2 (2θ), 18.8 ± 0.2 (2θ), 21.8 ± 0.2 (2θ), and 28.5 ± 0.2 (2θ).

Crystalline carvedilol hydrobromide trifluoroethanol solvate (see, Example 12: Form 5) also is identified by an x-ray diffraction pattern as shown substantially in Figure 81, which depicts characteristic peaks in degrees two-theta (2θ): i.e., 7.7 ± 0.2 (2θ), 8.4 ± 0.2 (2θ), 15.6 ± 0.2 (2θ), 16.9 ± 0.2 (2θ), 18.9 ± 0.2 (2θ), 21.8 ± 0.2 (2θ), 23.8 ± 0.2 (2θ), 23.7 ± 0.2 (2θ), and 32.7 ± 0.2 (2θ).

Crystalline carvedilol hydrobromide 2-propanol solvate (see, Example 13: Form 6) also is identified by an x-ray diffraction pattern as shown substantially in Figure 82, which depicts characteristic peaks in degrees two-theta (2θ): i.e., 7.9 ± 0.2 (2θ), 8.3 ± 0.2 (2θ), 18.8 ± 0.2 (2θ), 21.7 ± 0.2 (2θ), 23.2 ± 0.2 (2θ), 23.6 ± 0.2 (2θ), and 32.1 ± 0.2 (2θ).

Crystalline carvedilol hydrobromide n-propanol solvate #1 (see, Example
14: Form 7) also is identified by an x-ray diffraction pattern as shown substantially in Figure 46, which depicts characteristic peaks in degrees two-theta (2θ): i.e., 7.9 ± 0.2 (2θ), 8.5 ± 0.2 (2θ), 17.0 ± 0.2 (2θ), 18.8 ± 0.2 (2θ), 21.6 ± 0.2 (2θ), 23.1 ± 0.2 (2θ), 23.6 ± 0.2 (2θ), and 21.2 ± 0.2 (2θ).

Crystalline carvedilol hydrobromide n-propanol solvate #2 (see, Example 15: Form 8) also is identified by an x-ray diffraction pattern as shown substantially in Figure 54, which depicts characteristic peaks in degrees two-theta (2θ): i.e., 8.0 ± 0.2 (2θ), 18.8 ± 0.2 (2θ), 21.6 ± 0.2 (2θ), 23.1 ± 0.2 (2θ), 25.9 ± 0.2 (2θ), 27.2 ± 0.2 (2θ), 30.6 ± 0.2 (2θ), and 32.2 ± 0.2 (2θ).

Crystalline carvedilol hydrobromide anhydrous forms (see, Example 16: Form 9) also is identified by an x-ray diffraction pattern as shown substantially in Figure 62, which depicts characteristic peaks in degrees two-theta (2θ): i.e., 6.6 ± 0.2 (2θ), 16.1 ± 0.2 (2θ), 17.3 ± 0.2 (2θ), 21.2 ± 0.2 (2θ), 22.1 ± 0.2 (2θ), 24.1 ± 0.2 (2θ), and 27.9 ± 0.2 (2θ).

Crystalline carvedilol hydrobromide ethanol solvate (see, Example 17: Form 10) also is identified by an x-ray diffraction pattern as shown substantially in Figure 70, which depicts characteristic peaks in degrees two-theta (2θ): i.e., 8.1 ± 0.2 (2θ), 8.6 ± 0.2 (2θ), 13.2 ± 0.2 (2θ), 17.4 ± 0.2 (2θ), 18.6 ± 0.2 (2θ), 21.8 ± 0.2 (2θ), 23.2 ± 0.2 (2θ), 23.7 ± 0.2 (2θ), and 27.4 ± 0.2 (2θ).

Crystalline carvedilol hydrobromide monohydrate further is identified by an infrared spectrum as shown substantially in Figure 6.

Carvedilol hydrobromide anhydrous forms also an infrared spectrum which comprises characteristic absorption bands expressed in wave numbers as shown substantially in Figure 67.

Crystalline carvedilol hydrobromide monohydrate is identified also by a Raman spectrum as shown substantially in Figure 3.

Carvedilol hydrobromide anhydrous forms also a Raman spectrum which comprises characteristic peaks as shown substantially in Figure 64.

Crystalline carvedilol benzoate (see, Example 22) is identified by an FT-IR spectrum pattern as shown substantially in Figure 124, which depicts characteristic peaks in wavenumbers (cm⁻¹): i.e., 672 cm⁻¹, 718 cm⁻¹, 754 cm⁻¹, 767 cm⁻¹, 1022 cm⁻¹, 1041 cm⁻¹, 1106 cm⁻¹, 1260 cm⁻¹, 1498 cm⁻¹, 1582 cm⁻¹.
1604 cm\(^{-1}\), 1626 cm\(^{-1}\), 2932 cm\(^{-1}\), 3184 cm\(^{-1}\), and 3428 cm\(^{-1}\). Also, crystalline carvedilol benzoate (see, Example 22) is identified by an FT-Raman spectrum pattern as shown substantially in Figure 125, which depicts characteristic peaks in wavenumbers (cm\(^{-1}\)): i.e., 108 cm\(^{-1}\), 244 cm\(^{-1}\), 424 cm\(^{-1}\), 538 cm\(^{-1}\), 549 cm\(^{-1}\), 728 cm\(^{-1}\), 1001 cm\(^{-1}\), 1015 cm\(^{-1}\), 1128 cm\(^{-1}\), 1286 cm\(^{-1}\), 1598 cm\(^{-1}\), 1626 cm\(^{-1}\), 2934 cm\(^{-1}\), 3058 cm\(^{-1}\), and 3072 cm\(^{-1}\).

Crystalline carvedilol mandelate (see, Example 23) is identified by an FT-IR spectrum pattern as shown substantially in Figure 114, which depicts characteristic peaks in wavenumbers (cm\(^{-1}\)): i.e., 699 cm\(^{-1}\), 723 cm\(^{-1}\), 752 cm\(^{-1}\), 784 cm\(^{-1}\), 1053 cm\(^{-1}\), 1583 cm\(^{-1}\), 1631 cm\(^{-1}\), 3189 cm\(^{-1}\), 3246 cm\(^{-1}\), and 3396 cm\(^{-1}\). Also crystalline carvedilol mandelate (see, Example 23) is identified by an FT-Raman spectrum pattern as shown substantially in Figure 115, which depicts characteristic peaks in wavenumbers (cm\(^{-1}\)): i.e., 233 cm\(^{-1}\), 252 cm\(^{-1}\), 322 cm\(^{-1}\), 359 cm\(^{-1}\), 423 cm\(^{-1}\), 744 cm\(^{-1}\), 1002 cm\(^{-1}\), 1286 cm\(^{-1}\), 1631 cm\(^{-1}\), 3052 cm\(^{-1}\), 3063 cm\(^{-1}\), and 3077 cm\(^{-1}\).

Crystalline carvedilol lactate (see, Example 24) is identified by an FT-IR spectrum pattern as shown substantially in Figure 116, which depicts characteristic peaks in wavenumbers (cm\(^{-1}\)): i.e., 720 cm\(^{-1}\), 753 cm\(^{-1}\), 785 cm\(^{-1}\), 1097 cm\(^{-1}\), 1124 cm\(^{-1}\), 1253 cm\(^{-1}\), 1584 cm\(^{-1}\), and 3396 cm\(^{-1}\). Also, crystalline carvedilol lactate (see, Example 24) is identified by an FT-Raman spectrum pattern as shown substantially in Figure 117, which depicts characteristic peaks in wavenumbers (cm\(^{-1}\)): i.e., 321 cm\(^{-1}\), 422 cm\(^{-1}\), 549 cm\(^{-1}\), 765 cm\(^{-1}\), 1015 cm\(^{-1}\), 1284 cm\(^{-1}\), 1626 cm\(^{-1}\), 3066 cm\(^{-1}\), and 3078 cm\(^{-1}\).

Crystalline carvedilol sulfate (see, Example 25) is identified by an FT-IR spectrum pattern as shown substantially in Figure 120, which depicts characteristic peaks in wavenumbers (cm\(^{-1}\)): i.e., 727 cm\(^{-1}\), 743 cm\(^{-1}\), 787 cm\(^{-1}\), 1026 cm\(^{-1}\), 1089 cm\(^{-1}\), 1251 cm\(^{-1}\), 1215 cm\(^{-1}\), 1586 cm\(^{-1}\), 1604 cm\(^{-1}\), and 3230 cm\(^{-1}\). Also, crystalline carvedilol sulfate (see, Example 25) also is identified by an FT-Raman spectrum pattern as shown substantially in Figure 121, which depicts characteristic peaks in wavenumbers (cm\(^{-1}\)): i.e., 242 cm\(^{-1}\), 318 cm\(^{-1}\), 423 cm\(^{-1}\), 549 cm\(^{-1}\), 1014 cm\(^{-1}\), 1214 cm\(^{-1}\), 1282 cm\(^{-1}\), 1627 cm\(^{-1}\), 2969 cm\(^{-1}\), and 3066 cm\(^{-1}\).
Crystalline carvedilol maleate (see, Example 26) is identified by an FT-IR spectrum pattern as shown substantially in Figure 118, which depicts characteristic peaks in wavenumbers (cm\(^{-1}\)): i.e., 725 cm\(^{-1}\), 741 cm\(^{-1}\), 756 cm\(^{-1}\), 786 cm\(^{-1}\), 1024 cm\(^{-1}\), 1109 cm\(^{-1}\), 1215 cm\(^{-1}\), 1586 cm\(^{-1}\), and 3481 cm\(^{-1}\). Also, crystalline carvedilol maleate (see, Example 26) also is identified by an FT-Raman spectrum pattern as shown substantially in Figure 119, which depicts characteristic peaks in wavenumbers (cm\(^{-1}\)): i.e., 249 cm\(^{-1}\), 324 cm\(^{-1}\), 423 cm\(^{-1}\), 549 cm\(^{-1}\), 751 cm\(^{-1}\), 1012 cm\(^{-1}\), 1216 cm\(^{-1}\), 1286 cm\(^{-1}\), 1629 cm\(^{-1}\), and 3070 cm\(^{-1}\).

Crystalline carvedilol glutarate (see, Example 27) is identified by an FT-IR spectrum pattern as shown substantially in Figure 122, which depicts characteristic peaks in wavenumbers (cm\(^{-1}\)): i.e., 724 cm\(^{-1}\), 743 cm\(^{-1}\), 786 cm\(^{-1}\), 1024 cm\(^{-1}\), 1044 cm\(^{-1}\), 1089 cm\(^{-1}\), 1251 cm\(^{-1}\), 1586 cm\(^{-1}\), 1604 cm\(^{-1}\), and 3229 cm\(^{-1}\). Also, crystalline carvedilol glutarate (see, Example 27) is identified by an FT-Raman spectrum pattern as shown substantially in Figure 123, which depicts characteristic peaks in wavenumbers (cm\(^{-1}\)): i.e., 141 cm\(^{-1}\), 246 cm\(^{-1}\), 322 cm\(^{-1}\), 423 cm\(^{-1}\), 551 cm\(^{-1}\), 749 cm\(^{-1}\), 1011 cm\(^{-1}\), 1213 cm\(^{-1}\), 1284 cm\(^{-1}\), 1628 cm\(^{-1}\), 2934 cm\(^{-1}\), and 3073 cm\(^{-1}\).

The present invention also relates to a pharmaceutical composition, which contains a salt of carvedilol, anhydrous forms and/or corresponding solvates thereof as described herein.

Importantly, the chemical and/or physical properties of carvedilol forms described herein, which include, but are not limited to the above-identified salts, anhydrous forms or solvates thereof of carvedilol indicate that those forms may be particularly suitable for inclusion in medicinal agents, pharmaceutical compositions, etc.

For example, solubility of various carvedilol salts, and/or solvates as those described herein may facilitate provision or development of a dosage form from which the drug substance becomes available for bioabsorption throughout the gastrointestinal tract (i.e., in particular the lower small intestine and colon). Parts of the gastrointestinal tract are defined to include generally the stomach (i.e. which includes the antrum and pylorus bowel), small intestine
(i.e., which has three parts: the duodenum, jejunum, illeum), large intestine
(i.e., which has three parts: the cecum, colon, rectum), liver, gall bladder and
pancreas.

In light of the foregoing, it may be possible to develop stable controlled
release dosage forms containing such carvedilol phosphate salts and/or
solvates of the present invention, for once-per-day dosage, delayed release,
controlled-release formulations or pulsatile release to optimize therapy by
matching pharmacokinetic performance with pharmacodynamic requirements.

Compounds or compositions within the scope of this invention include all
compounds or compositions, wherein the compound of the present invention is
contained in an amount effective to achieve its intended purpose. While
individual needs vary, determination of optimal ranges of effective amounts of
each component is within the skill of the art.

In accordance with a pharmaceutical composition of the present
invention as described herein, a specific embodiment may include a carvedilol
free base, which may be, but is not limited to, be in a combination with a
solubility enhanced carvedilol salt, solvate and/or anhydrous form or forms.

Also in accordance with a pharmaceutical composition of the present
invention as described herein, a specific embodiment may include a solubility
enhanced carvedilol salt, solvate and/or anhydrous form or forms selected from
the group consisting of a novel crystalline salt forms of carvedilol mandelate,
carvedilol lactate, carvedilol maleate, carvedilol sulfate, carvedilol glutarate,
carvedilol mesylate, carvedilol phosphate, carvedilol citrate, carvedilol
hydrogen bromide, carvedilol oxalate, carvedilol hydrochloride, carvedilol
hydrogen bromide, carvedilol benzoate, and/or corresponding solvates thereof.

Further in accordance with a pharmaceutical composition of the present
invention as described herein, a specific embodiment may include novel
crystalline salt forms of carvedilol hydrogen phosphate, carvedilol dihydrogen
phosphate, carvedilol dihydrogen phosphate hemihydrate, carvedilol
dihydrogen phosphate dihydrate, carvedilol dihydrogen phosphate methanol
solvate, carvedilol hydrobromide monohydrate, carvedilol hydrobromide
dioxane solvate, carvedilol hydrobromide 1-pentanol solvate, carvedilol
hydrobromide 2-methyl-1-propanol solvate, carvedilol hydrobromide trifluoroethanol solvate, carvedilol hydrobromide 2-propanol solvate, carvedilol hydrobromide n-propanol solvate #1, carvedilol hydrobromide n-propanol solvate #2, carvedilol hydrobromide anhydrous forms or anhydrous, carvedilol hydrobromide ethanol solvate, carvedilol hydrobromide dioxane solvate, carvedilol monocitrate monohydrate, carvedilol mandelate, carvedilol lactate salt, carvedilol maleate, carvedilol sulfate, carvedilol glutarate, and/or corresponding anhydrous, solvates thereof.

Also suitable for use in any of the pharmaceutical compositions of the present invention are solubility enhanced carvedilol salt, solvate and/or anhydrous form is selected from the group consisting of a novel crystalline salt forms of carvedilol hydrogen phosphate, carvedilol dihydrogen phosphate, carvedilol dihydrogen phosphate hemihydrate, carvedilol dihydrogen phosphate dihydrate, carvedilol dihydrogen phosphate methanol solvate.

In particular, in accordance with a pharmaceutical composition of the present invention as described herein, a specific embodiment may include a carvedilol salt, solvate, and/or anhydrous forms thereof, such as a carvedilol phosphate salt, which may include, but is not limited to or selected from the group consisting of a carvedilol dihydrogen phosphate hemihydrate (Form I), carvedilol dihydrogen phosphate dihydrate (Form II), carvedilol dihydrogen phosphate methanol solvate (Form III), carvedilol dihydrogen phosphate dihydrate (Form IV), carvedilol dihydrogen phosphate (Form V) and carvedilol hydrogen phosphate (Form VI), and the like.

Thus, this invention also relates to a pharmaceutical composition comprising an effective amount of carvedilol dihydrogen phosphate salts and/or solvates thereof, with any of the characteristics noted herein, in association with one or more non-toxic pharmaceutically acceptable carriers and/or diluents thereof, and if desired, other active ingredients. Also, suitable for use in any of the pharmaceutical compositions of the present invention is carvedilol dihydrogen phosphate hemihydrate.

Moreover, the quantity of the compound or composition of the present invention administered will vary depending on the patient and the mode of
administration and can be any effective amount.

Treatment regimen for the administration of the compounds and/or compositions of the present invention can also be determined readily by those with ordinary skill in art. The quantity of the compound and/or composition of the present invention administered may vary over a wide range to provide in a unit dosage an effective amount based upon the body weight of the patient per day to achieve the desired effect.

In particular, a composition of the present invention is presented as a unit dose and taken preferably from 1 to 2 times daily, most preferably once daily to achieve the desired effect.

Depending upon the treatment being effected, the compounds, and/or or compositions of the present invention can be administered orally, intraperitoneally, or topically, etc. Preferably, the composition is adapted for oral administration.

In general, pharmaceutical compositions of the present invention are prepared using conventional materials and techniques, such as mixing, blending and the like.

In accordance with the present invention, compounds and/or pharmaceutical composition can also include, but are not limited to, suitable adjuvants, carriers, excipients, or stabilizers, etc. and can be in solid or liquid form such as, tablets, capsules, powders, solutions, suspensions, or emulsions, etc.

Typically, the composition will contain a compound of the present invention, such as a salt of carvedilol or active compound(s), together with the adjuvants, carriers and/or excipients. In particular, a pharmaceutical composition of the present invention comprises an effective amount of a salt of carvedilol (i.e., such as carvedilol dihydrogen phosphate salts) and/or corresponding solvates (i.e., as identified herein) thereof, with any of the characteristics noted herein, in association with one or more non-toxic pharmaceutically acceptable carriers and/or diluents thereof, and if desired, other active ingredients.

In accordance with the present invention, solid unit dosage forms can be
conventional types known in the art. The solid form can be a capsule and the like, such as an ordinary gelatin type containing the compounds of the present invention and a carrier, for example, lubricants and inert fillers such as, lactose, sucrose, or cornstarch, etc. In another embodiment, these compounds are tableted with conventional tablet bases such as lactose, sucrose, or cornstarch in combination with binders like acacia, cornstarch, or gelatin, disintegrating agents, such as cornstarch, potato starch, or alginic acid, and a lubricant, like stearic acid or magnesium stearate, etc.

The tablets, capsules, and the like can also contain a binder, such as gum tragacanth, acacia, corn starch, or gelatin; excipients such as dicalcium phosphate; a disintegrating agent such as corn starch, potato starch, alginic acid; a lubricant such as magnesium stearate; and a sweetening agent such as sucrose, lactose, or saccharin, etc. When the dosage unit form is a capsule, it can contain, in addition to materials of the above type, a liquid carrier such as a fatty oil.

Various other materials may be present as coatings or to modify the physical form of the dosage unit. For instance, tablets can be coated with shellac, sugar, or both, etc. A syrup can contain, in addition to active ingredient, sucrose as a sweetening agent, methyl and propylparabens as preservatives, a dye, and flavoring such as cherry or orange flavor, etc.

For oral therapeutic administration, these active compounds can be incorporated with excipients and used in the form of tablets, capsules, elixirs, suspensions, syrups, and the like. The percentage of the compound in compositions can, of course, be varied as the amount of active compound in such therapeutically useful compositions is such that a suitable dosage will be obtained.

Typically in accordance with the present invention, the oral maintenance dose is between about 25 mg and about 70 mg, preferably given once daily. In accordance with the present invention, the preferred unit dosage forms include tablets or capsules.

The active compounds of the present invention may be orally administered, for example, with an inert diluent, or with an assimilable edible
carrier, or they can be enclosed in hard or soft shell capsules, or they can be compressed into tablets, or they can be incorporated directly with the food of the diet, etc.

These active compounds may also be administered parenterally.

Solutions or suspensions of these active compounds for use in such parental administrations can be prepared in water suitably mixed with a surfactant such as hydroxypropylcellulose. Dispersions can also be prepared in glycerol, liquid polyethylene glycols, and mixtures thereof in oils. Illustrative oils are those of petroleum, animal, vegetable, or synthetic origin, for example, peanut oil, soybean oil, or mineral oil, etc. In general, water, saline, aqueous dextrose and related sugar solution, and glycols such as, propylene glycol or polyethylene glycol, etc., are preferred liquid carriers, particularly for injectable solutions. Under ordinary conditions of storage and use, these preparations contain a preservative to prevent the growth of microorganisms.

The compounds and/or pharmaceutical compositions prepared according to the present invention can be used to treat warm-blooded animals, such as mammals, which include humans.

The present invention further relates to a method of treating hypertension, congestive heart failure and angina, which comprises administering to a subject in need thereof an effective amount of a carvedilol phosphate salt (which include novel crystalline forms) and/or solvates thereof or a pharmaceutical composition (i.e., which contains such salts and/or solvates of carvedilol phosphate), etc.

The present invention also relates to a method of delivering carvedilol to lower gastrointestinal tract of a subject in need thereof, which comprises administering a compound which is a crystalline salt, anhydrous forms or solvate of carvedilol.

Conventional administration methods as described in examples above may be suitable for such use in delivery or treatment methods of the present invention.

The Examples set forth below are illustrative of the present invention and are not intended to limit, in any way, the scope of the present invention.
Examples

Carvedilol Phosphate Examples

Example 1

Form I Carvedilol Dihydrogen Phosphate Hemihydrate Preparation
A suitable reactor is charged with acetone. The acetone solution is sequentially charged with carvedilol and water. Upon addition of the water, the slurry dissolves quickly. To the solution is added aqueous $\text{H}_3\text{PO}_4$. The reaction mixture is stirred at room temperature and carvedilol dihydrogen phosphate seeds are added in one portion. The solid precipitate formed is stirred, then filtered and the collected cake is washed with aqueous acetone. The cake is dried under vacuum to a constant weight. The cake is weighed and stored in a polyethylene container.

Example 2

Form II Carvedilol Dihydrogen Phosphate Dihydrate Preparation
Form I is slurried in acetone/water mixture between 10 and 30°C for several days.

Example 3

Form III Carvedilol Dihydrogen phosphate Methanol Solvate Preparation
Form I is slurried in methanol between 10 and 30°C for several days.

Example 4

Form IV - Carvedilol Dihydrogen Phosphate Dihydrate Preparation
Carvedilol dihydrogen dihydrogen phosphate is dissolved in an acetone/water mixture. The acetone is removed by distillation. A solid crystallizes during acetone removal and is filtered and dried.
Example 5

Form V - Carvedilol Dihydrogen Phosphate Preparation

Carvedilol dihydrogen phosphate hemihydrate (Form I) was suspended in water, and the suspension was placed on a mechanical shaker at room temperature. After 48 hours of shaking, the solid was isolated from suspension by filtration, then dried in a desiccator under vacuum for a few days.

Example 6

Form VI - Carvedilol Hydrogen Phosphate Preparation

A suitable reactor is charged with acetone. The acetone solution is sequentially charged with SK&F 105517 and water. Upon addition of the water, the slurry dissolves quickly. To the solution is added aqueous H₃PO₄ (at 1/2 the molar quantity of Carvedilol). The reaction mixture is stirred and allowed to crystallize. The solid precipitate formed is stirred and cooled, then filtered and the collected cake is washed with aqueous acetone.

Example 7

¹³C and ³¹P Solid State NMR Data Analysis of Carvedilol Dihydrogen Phosphate

A sample of carvedilol dihydrogen phosphate was analyzed by solid-state ¹³C NMR and ³¹P NMR (i.e., to probe solid compound form structure).

Carvedilol dihydrogen phosphate (Parent MW = 406.5; Salt MW = 504.5) has the following structure and numbering scheme:
**Experimental Details and $^{13}$C and $^{31}$P Analysis**

The solid state $^{13}$C NMR methods used to analyze compounds of the present invention produce a *qualitative* picture of the types of carbon sites within the solid material. Because of variable polarization transfer rates and the need for sideband suppression, the peak intensities are not quantitative (much like the case in solution-state $^{13}$C NMR).

However, the $^{31}$P spectra are inherently quantitative.

For the $^{13}$C analysis, approximately 100 mg of sample was packed into a 7-mm O.D. magic-angle spinning rotor and spun at 5 kHz. The $^{13}$C spectrum of the sample was recorded using a CP-TOSS pulse sequence (cross-polarization with total suppression of sidebands). An edited spectrum containing only quaternary and methyl carbons was then obtained using an CP-TOSS sequence with NQS (non-quaternary suppression). The $^{13}$C spectra are referenced externally to tetramethylsilane via a sample of solid hexamethyldisiloxane.

For $^{31}$P Solid State NMR, approximately 40 mg of sample was packed into a 4-mm O.D. rotor and spun at 10 kHz. Both CP-MAS and single-pulse MAS $^{31}$P pulse sequences were used with $^{1}$H decoupling. The $^{31}$P data are externally referenced to 85% phosphoric acid by a secondary solid-state reference (triphenylphosphine oxide). The Bruker AMX2-360 spectrometer used for this work operates at $^{13}$C, $^{31}$P and $^{1}$H frequencies of 90.556, 145.782 and 360.097 MHz, respectively. All spectra were obtained at 298 K.

**Results and Discussion**

The highly sensitive $^{13}$C and $^{31}$P Solid State NMR identification methods were used for the analysis and characterization of a polymorphic form of Carvedilol phosphate, which confirms its chemical structure in the solid-state.

The form of Carvedilol dihydrogen phosphate is defined by these spectra, where both $^{13}$C and $^{31}$P spectra show clear and distinct differences.
In particular, Figure 26 shows the $^{13}$C CP-TOSS spectrum of carvedilol dihydrogen phosphate. An assignment of the numerous $^{13}$C resonances in Figure 1 can be made by chemical shift assignment, the NQS spectrum and comparisons with solution-state $^{13}$C assignments. At least two non-equivalent molecules per unit cell are observed in this form of Carvedilol phosphate.

Figure 27 shows the $^{31}$P MAS spectrum of carvedilol dihydrogen phosphate. A single phosphorus signal is observed at 4.7 ppm, which is characteristic of phosphate salts.

**Carvedilol Hydrogen Bromide Examples**

**Example 8**

**Form 1. Carvedilol HBr Monohydrate.**

A suitable reactor is charged with acetone. The acetone solution is sequentially charged with carvedilol, water and 48% aqueous HBr. On addition of the water, the acetone slurry becomes a solution. The reaction mixture is stirred at room temperature. A solid precipitates during the course of the stir. The precipitate is filtered and the collected cake is washed with acetone. The cake is dried under vacuum to a constant weight. The cake is weighed and stored in a polyethylene container.

The single crystal x-ray data for carvedilol hydrobromide monohydrate is provided below.

**Table 1. Sample and Crystal Data for Carvedilol Hydrobromide Monohydrate.**

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Crystallization solvents</td>
<td>Acetone, water</td>
</tr>
<tr>
<td>Crystallization method</td>
<td>Slow cooling</td>
</tr>
<tr>
<td>Empirical formula</td>
<td>C$<em>{24}$H$</em>{29}$BrN$_2$O$_5$</td>
</tr>
<tr>
<td>Formula weight</td>
<td>505.40</td>
</tr>
<tr>
<td>Temperature</td>
<td>150(2) K</td>
</tr>
<tr>
<td>Wavelength</td>
<td>0.71073 Å</td>
</tr>
<tr>
<td>Crystal size</td>
<td>0.18 x 0.14 x 0.08 mm</td>
</tr>
<tr>
<td>Crystal habit</td>
<td>Clear colorless prism</td>
</tr>
<tr>
<td>Crystal system</td>
<td>Monoclinic</td>
</tr>
<tr>
<td>Space group</td>
<td>C2/c</td>
</tr>
<tr>
<td>Unit cell dimensions</td>
<td>a = 18.0356(3) Å   $\alpha$= 90°</td>
</tr>
<tr>
<td></td>
<td>b = 20.8385(5) Å   $\beta$= 103.5680(10)°</td>
</tr>
</tbody>
</table>
\[
c = 12.9342(3) \text{ Å} \quad \gamma = 90^\circ
\]

**Volume**

4725.46(18) Å³

**Z**

8

**Density (calculated)**

1.421 Mg/m³

<table>
<thead>
<tr>
<th>Absorption coefficient</th>
<th>1.777 mm⁻¹</th>
</tr>
</thead>
<tbody>
<tr>
<td>F(000)</td>
<td>2096</td>
</tr>
</tbody>
</table>

**Table 2. Data collection and structure refinement for Carvedilol Hydrobromide Monohydrate.**

<table>
<thead>
<tr>
<th><strong>Diffractometer</strong></th>
<th>KappaCCD</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Radiation source</strong></td>
<td>Fine-focus sealed tube, MoKα</td>
</tr>
<tr>
<td><strong>Data collection method</strong></td>
<td>CCD; rotation images; thick slices</td>
</tr>
<tr>
<td><strong>Theta range for data collection</strong></td>
<td>3.42 to 23.27°</td>
</tr>
<tr>
<td><strong>Index ranges</strong></td>
<td>0 ≤ h ≤ 20, 0 ≤ k ≤ 23, -14 ≤ l ≤ 13</td>
</tr>
<tr>
<td><strong>Reflections collected</strong></td>
<td>30823</td>
</tr>
<tr>
<td><strong>Independent reflections</strong></td>
<td>3404 [R(int) = 0.042]</td>
</tr>
<tr>
<td><strong>Coverage of independent reflections</strong></td>
<td>99.7%</td>
</tr>
<tr>
<td><strong>Variation in check reflections</strong></td>
<td>N/A</td>
</tr>
<tr>
<td><strong>Absorption correction</strong></td>
<td>Symmetry-related measurements</td>
</tr>
<tr>
<td><strong>Max. and min. transmission</strong></td>
<td>0.8709 and 0.7404</td>
</tr>
<tr>
<td><strong>Structure solution technique</strong></td>
<td>Direct methods</td>
</tr>
<tr>
<td><strong>Structure solution program</strong></td>
<td>SHELXTL V5.10 UNIX (Bruker, 1997)</td>
</tr>
<tr>
<td><strong>Refinement technique</strong></td>
<td>Full-matrix least-squares on F²</td>
</tr>
<tr>
<td><strong>Refinement program</strong></td>
<td>SHELXTL V5.10 UNIX (Bruker, 1997)</td>
</tr>
<tr>
<td><strong>Function minimized</strong></td>
<td>( \sum w(F_o^2 - F_c^2)^2 )</td>
</tr>
<tr>
<td><strong>Data / restraints / parameters</strong></td>
<td>3404 / 11 / 336</td>
</tr>
<tr>
<td><strong>Goodness-of-fit on F²</strong></td>
<td>1.020</td>
</tr>
<tr>
<td><strong>( \Delta/\sigma_{max} )</strong></td>
<td>0.000</td>
</tr>
<tr>
<td><strong>Final R indices</strong></td>
<td>R1 = 0.0353, wR2 = 0.0797</td>
</tr>
<tr>
<td><strong>all data</strong></td>
<td>R1 = 0.0405, wR2 = 0.0829</td>
</tr>
<tr>
<td><strong>Weighting scheme</strong></td>
<td>( w = 1/[\sigma^2(F_o^2) + ([0.0304P]^2 + 14.1554P]) )</td>
</tr>
<tr>
<td><strong>Largest diff. peak and hole</strong></td>
<td>0.786 and -0.914 e.Å⁻³</td>
</tr>
</tbody>
</table>

**Refinement summary:**

Ordered Non-H atoms, XYZ Freely refined
Ordered Non-H atoms, U
H atoms (on carbon), XYZ
H atoms (on carbon), U
H atoms (on heteroatoms), XYZ
H atoms (on heteroatoms), U
Disordered atoms, OCC
Disordered atoms, XYZ
Disordered atoms, U

Table 3. Atomic Coordinates and Equivalent Isotropic Atomic Displacement Parameters (Å²) for Carvedilol Hydrobromide Monohydrate.

U(eq) is defined as one third of the trace of the orthogonalized Uᵢⱼ tensor.

<table>
<thead>
<tr>
<th></th>
<th>x/a</th>
<th>y/b</th>
<th>z/c</th>
<th>U(eq)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Br1</td>
<td>0.500</td>
<td>0.22079(2)</td>
<td>-0.2500</td>
<td>0.04329(15)</td>
</tr>
<tr>
<td>Br2</td>
<td>0.000</td>
<td>0.40821(2)</td>
<td>-0.2500</td>
<td>0.04510(16)</td>
</tr>
<tr>
<td>O1</td>
<td>0.19543(10)</td>
<td>0.37037(10)</td>
<td>-0.00168(15)</td>
<td>0.0328(6)</td>
</tr>
<tr>
<td>O2</td>
<td>0.08860(19)</td>
<td>0.48508(15)</td>
<td>0.1085(2)</td>
<td>0.0312(7)</td>
</tr>
<tr>
<td>O3</td>
<td>0.0825(3)</td>
<td>0.4816(3)</td>
<td>-0.0328(4)</td>
<td>0.0311(13)</td>
</tr>
<tr>
<td>O4</td>
<td>-0.19428(10)</td>
<td>0.39492(10)</td>
<td>-0.01310(15)</td>
<td>0.0347(5)</td>
</tr>
<tr>
<td>O99A</td>
<td>-0.0860(5)</td>
<td>0.4236(3)</td>
<td>0.1987(7)</td>
<td>0.0430(19)</td>
</tr>
<tr>
<td>O99B</td>
<td>-0.0833(5)</td>
<td>0.4514(4)</td>
<td>0.1784(7)</td>
<td>0.0431(19)</td>
</tr>
<tr>
<td>N1</td>
<td>0.34092(16)</td>
<td>0.25072(13)</td>
<td>-0.1793(2)</td>
<td>0.0390(7)</td>
</tr>
<tr>
<td>N2</td>
<td>-0.03151(14)</td>
<td>0.39706(13)</td>
<td>-0.0026(2)</td>
<td>0.0314(6)</td>
</tr>
<tr>
<td>C1</td>
<td>0.28859(15)</td>
<td>0.35551(14)</td>
<td>-0.0070(2)</td>
<td>0.0301(7)</td>
</tr>
<tr>
<td>C2</td>
<td>0.33380(16)</td>
<td>0.38188(15)</td>
<td>0.0568(2)</td>
<td>0.0339(7)</td>
</tr>
<tr>
<td>C3</td>
<td>0.40553(17)</td>
<td>0.36537(16)</td>
<td>0.0409(3)</td>
<td>0.0402(8)</td>
</tr>
<tr>
<td>C4</td>
<td>0.41433(17)</td>
<td>0.32249(16)</td>
<td>-0.0364(3)</td>
<td>0.0401(8)</td>
</tr>
<tr>
<td>C5</td>
<td>0.34850(16)</td>
<td>0.29538(15)</td>
<td>-0.0986(2)</td>
<td>0.0343(7)</td>
</tr>
<tr>
<td>C6</td>
<td>0.26499(17)</td>
<td>0.23737(14)</td>
<td>-0.2202(2)</td>
<td>0.0343(7)</td>
</tr>
<tr>
<td>C7</td>
<td>0.23145(19)</td>
<td>0.19604(15)</td>
<td>-0.3022(2)</td>
<td>0.0401(8)</td>
</tr>
<tr>
<td>C8</td>
<td>0.15313(19)</td>
<td>0.19096(15)</td>
<td>-0.3275(2)</td>
<td>0.0412(8)</td>
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<tr>
<td>C9</td>
<td>0.10866(18)</td>
<td>0.22594(14)</td>
<td>-0.2721(2)</td>
<td>0.0364(7)</td>
</tr>
<tr>
<td>C10</td>
<td>0.14185(17)</td>
<td>0.26731(14)</td>
<td>-0.1910(2)</td>
<td>0.0323(7)</td>
</tr>
<tr>
<td>C11</td>
<td>0.22085(16)</td>
<td>0.27356(13)</td>
<td>-0.1639(2)</td>
<td>0.0300(7)</td>
</tr>
<tr>
<td>C12</td>
<td>0.27490(16)</td>
<td>0.31103(13)</td>
<td>-0.0855(2)</td>
<td>0.0294(6)</td>
</tr>
<tr>
<td>C13</td>
<td>0.18523(16)</td>
<td>0.41746(14)</td>
<td>0.0740(2)</td>
<td>0.0301(7)</td>
</tr>
<tr>
<td>C14</td>
<td>0.10181(16)</td>
<td>0.43671(13)</td>
<td>0.0452(2)</td>
<td>0.0305(7)</td>
</tr>
<tr>
<td>C15</td>
<td>0.05016(15)</td>
<td>0.37919(14)</td>
<td>0.0363(2)</td>
<td>0.0289(6)</td>
</tr>
<tr>
<td>C16</td>
<td>-0.08143(16)</td>
<td>0.33991(14)</td>
<td>-0.0272(2)</td>
<td>0.0361(7)</td>
</tr>
<tr>
<td>C17</td>
<td>-0.16200(16)</td>
<td>0.35626(16)</td>
<td>-0.0833(2)</td>
<td>0.0380(7)</td>
</tr>
<tr>
<td>C18</td>
<td>-0.27156(15)</td>
<td>0.40680(14)</td>
<td>-0.0445(2)</td>
<td>0.0300(6)</td>
</tr>
<tr>
<td>C19</td>
<td>-0.30049(16)</td>
<td>0.44705(14)</td>
<td>0.0236(2)</td>
<td>0.0316(7)</td>
</tr>
<tr>
<td>C20</td>
<td>-0.37754(18)</td>
<td>0.46060(16)</td>
<td>0.0007(3)</td>
<td>0.0409(8)</td>
</tr>
<tr>
<td>C21</td>
<td>-0.42545(18)</td>
<td>0.43467(17)</td>
<td>-0.0895(3)</td>
<td>0.0499(9)</td>
</tr>
<tr>
<td>C22</td>
<td>-0.39733(18)</td>
<td>0.39693(17)</td>
<td>-0.1567(3)</td>
<td>0.0504(9)</td>
</tr>
<tr>
<td>C23</td>
<td>-0.31949(17)</td>
<td>0.38199(15)</td>
<td>-0.1342(3)</td>
<td>0.0388(7)</td>
</tr>
<tr>
<td>C24</td>
<td>-0.2743(2)</td>
<td>0.50989(17)</td>
<td>0.1833(3)</td>
<td>0.0482(9)</td>
</tr>
</tbody>
</table>
Table 4. Selected Bond Lengths (Å) for Carvedilol Hydrobromide Monohydrate.

| O1-C1   | 1.373(3)  | O1-C13  | 1.428(3)  |
| O2-C14  | 1.366(4)  | O2'-C14 | 1.360(6)  |
| O3-C18  | 1.380(3)  | O3-C17  | 1.435(3)  |
| O4-C19  | 1.376(4)  | O4-C24  | 1.433(4)  |
| N1-C6   | 1.376(4)  | N1-C5   | 1.381(4)  |
| N2-C16  | 1.482(4)  | N2-C15  | 1.488(4)  |
| C1-C2   | 1.382(4)  | C1-C12  | 1.399(4)  |
| C2-C3   | 1.399(4)  | C3-C4   | 1.378(5)  |
| C4-C5   | 1.388(4)  | C5-C12  | 1.415(4)  |
| C6-C7   | 1.389(4)  | C6-C11  | 1.416(4)  |
| C7-C8   | 1.377(5)  | C8-C9   | 1.399(4)  |
| C9-C10  | 1.381(4)  | C10-C11 | 1.391(4)  |
| C11-C12 | 1.458(4)  | C13-C14 | 1.517(4)  |
| C14-C15 | 1.506(4)  | C16-C17 | 1.503(4)  |
| C18-C23 | 1.374(4)  | C18-C19 | 1.403(4)  |
| C19-C20 | 1.380(4)  | C20-C21 | 1.388(5)  |
| C21-C22 | 1.368(5)  | C22-C23 | 1.396(4)  |

Table 5. Selected bond angles (°) for Carvedilol Hydrobromide Monohydrate.

| C1-O1-C13 | 118.0(2)  | C18-O3-C17 | 116.5(2)  |
| C19-O4-C24 | 117.2(2)  | C6-N1-C5   | 109.9(3)  |
| C18-N2-C15 | 112.0(2)  | O1-C1-C2   | 125.0(3)  |
| O1-C1-C12  | 115.4(2)  | C2-C1-C12  | 119.6(3)  |
| C1-C2-C3   | 120.1(3)  | C4-C3-C2   | 122.3(3)  |
| C3-C4-C5   | 117.1(3)  | N1-C5-C4   | 129.2(3)  |
| N1-C5-C12  | 108.5(3)  | C4-C5-C12  | 122.4(3)  |
| N1-C6-C7   | 129.4(3)  | N1-C6-C11  | 108.9(3)  |
| C7-C8-C11  | 121.7(3)  | C8-C7-C6   | 117.9(3)  |
| C7-C8-C9   | 121.1(3)  | C10-C9-C8  | 121.0(3)  |
| C9-C10-C11 | 119.1(3)  | C10-C11-C6 | 119.1(3)  |
| C10-C11-C12 | 134.7(3) | C6-C11-C12 | 106.2(3)  |
| C1-C12-C5  | 118.6(3)  | C1-C12-C11 | 134.8(3)  |
| C5-C12-C11 | 106.6(3)  | O1-C13-C14 | 107.0(2)  |
| O2'-C14-O2 | 83.4(3)   | O2'-C14-C15| 116.4(3)  |
| O2'-C14-C15| 115.2(3)  | O2'-C14-C13| 115.6(3)  |
| O2'-C14-C13| 112.0(3)  | C15-C14-C13| 111.6(2)  |
| N2-C15-C14 | 111.8(2)  | N2-C16-C17 | 113.0(3)  |
| O3-C17-C16 | 108.1(2)  | C23-C18-O3 | 125.0(3)  |
| C23-C18-C19| 120.1(3)  | O3-C18-C19 | 114.9(2)  |
| O4-C19-C20 | 125.4(3)  | O4-C19-C18 | 115.1(2)  |
| C20-C19-C18 | 119.4(3) | C19-C20-C21| 119.8(3)  |
| C22-C21-C20 | 120.9(3) | C21-C22-C23| 119.7(3)  |
| C18-C23-C22 | 120.0(3) |
Table 6. Hydrogen Bonds and Short C-H⋯X Contacts for Carvedilol Hydrobromide Monohydrate (Å and °).

<table>
<thead>
<tr>
<th></th>
<th>D-H⋯A</th>
<th>d(D-H)</th>
<th>d(H⋯A)</th>
<th>d(D⋯A)</th>
<th>°(DHA)</th>
</tr>
</thead>
<tbody>
<tr>
<td>N1-H1N⋯Br1</td>
<td>0.76(3)</td>
<td>2.63(4)</td>
<td>3.269(3)</td>
<td>166(3)</td>
<td></td>
</tr>
<tr>
<td>N2-H2NA⋯O99A</td>
<td>0.83(4)</td>
<td>2.29(4)</td>
<td>3.037(10)</td>
<td>149(3)</td>
<td></td>
</tr>
<tr>
<td>N2-H2NA⋯O99B</td>
<td>0.83(4)</td>
<td>2.13(4)</td>
<td>2.943(10)</td>
<td>165(4)</td>
<td></td>
</tr>
<tr>
<td>N2-H2NB⋯O2#1</td>
<td>0.89(5)</td>
<td>2.17(4)</td>
<td>2.873(4)</td>
<td>135(4)</td>
<td></td>
</tr>
<tr>
<td>O2′-H2O⋯Br2</td>
<td>0.67(5)</td>
<td>2.65(7)</td>
<td>3.237(6)</td>
<td>149(12)</td>
<td></td>
</tr>
<tr>
<td>O99A-H99A⋯Br1#2</td>
<td>0.94(3)</td>
<td>2.48(4)</td>
<td>3.395(8)</td>
<td>163(6)</td>
<td></td>
</tr>
<tr>
<td>O99B-H99B⋯Br2#1</td>
<td>0.94(3)</td>
<td>2.38(3)</td>
<td>3.320(8)</td>
<td>173(6)</td>
<td></td>
</tr>
<tr>
<td>C15-H15A⋯O1</td>
<td>0.99</td>
<td>2.38</td>
<td>2.783(3)</td>
<td>103.2</td>
<td></td>
</tr>
<tr>
<td>C15-H15B⋯Br1#2</td>
<td>0.99</td>
<td>2.85</td>
<td>3.738(3)</td>
<td>149.3</td>
<td></td>
</tr>
<tr>
<td>C16-H16A⋯Br1#2</td>
<td>0.99</td>
<td>2.88</td>
<td>3.790(3)</td>
<td>148.2</td>
<td></td>
</tr>
</tbody>
</table>

Symmetry transformations used to generate equivalent atoms:
#1 -x,-y+1,-z #2 -x+1/2,-y+1/2,-z

Table 7. Selected torsion angles (°) for Carvedilol Hydrobromide Monohydrate.

<table>
<thead>
<tr>
<th></th>
<th>C13-O1-C1-C2</th>
<th>C13-O1-C1-C12</th>
<th>-177.5(2)</th>
</tr>
</thead>
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Table 8. Anisotropic Atomic Displacement Parameters (Å²) for Carvedilol Hydrobromide Monohydrate.

The anisotropic atomic displacement factor exponent takes the form:

\[-2\pi^2 \left( h^2a^2U_{11} + \ldots + 2hka^*b^*U_{12} \right)\]

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Table 9. Hydrogen Atom Coordinates and Isotropic Atomic Displacement Parameters (Å²) for Carvedilol Hydrobromide Monohydrate.

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Table 10. Site Occupation Factors that Deviate from Unity for Carvedilol Hydrobromide Monohydrate.

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<td>H99</td>
<td>1</td>
</tr>
<tr>
<td>H14</td>
<td>0.65</td>
<td>H14'</td>
<td>0.35</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

- 38 -
Example 9

Form 2. Carvedilol HBr (dioxane solvate)
Form 1 is slurried in dioxane between 0 and 40°C for 2 days. The product is filtered and mildly dried.

Example 10

Form 3. Carvedilol HBr (1-pentanol solvate)
Form 1 is slurried in 1-pentanol between 0°C and 40°C for 2 days. The product is filtered and mildly dried.

Example 11

Form 4. Carvedilol HBr (2-Methyl-1-Propanol solvate)
Form 1 is slurried in 2-Methyl-1-Propanol between 0°C and 40°C for 2 days. The product is filtered and mildly dried.

Example 12

Form 5. Carvedilol HBr (trifluoroethanol solvate)
Form 1 is slurried in trifluoroethanol between 0°C and 40°C for 2 days. The product is filtered and mildly dried.

Example 13

Form 6. Carvedilol HBr (2-propanol solvate)
Form 1 is slurried in 2-propanol between 0°C and 40°C for 2 days. The product is filtered and mildly dried.

Example 14

Form 7. Carvedilol HBr (n-propanol solvate #1)
Carvedilol free base is dissolved in n-propanol/water (95:5), and stoichiometric hydrobromic acid is added. The solution is cooled, and crystallization ensues. The product is filtered, washed with process solvent, and dried.
Example 15

Form 8. Carvedilol HBr (n-propanol solvate #2)

Carvedilol HBr monohydrate (Form 1) is dissolved in n-propanol at ambient temperature. The n-propanol is slowly evaporated off, giving a white solid.

Example 16

Form 9. Carvedilol HBr (anhydrous forms and solvent free)

Carvedilol free base is dissolved in a solvent (dichloromethane, isopropyl acetate, and acetonitrile have been used) and anhydrous forms HBr is added (HBr in acetic acid or gaseous HBr). The solution is cooled, and crystallization ensues. The product is filtered, washed with process solvent, and dried.

Example 17

Form 10. Carvedilol HBr (ethanol solvate)

Carvedilol free base is dissolved in ethanol, and anhydrous forms HBr is added (HBr in acetic acid). The solution is cooled, and crystallization ensues. The product is filtered, washed with process solvent, and dried.

Carvedilol Monocitrate Monohydrate

Example 18

Carvedilol Monocitrate Monohydrate Preparation

In a 150 mL glass beaker, 100 gram of 20% w/w citric acid solution was prepared and 2.2 gram of carvedilol was added. The solution became slightly brownish after 15 minutes stirring, with only a little solid sticking on the bottom of the beaker. The beaker was then placed in a fume hood for evaporation. After staying in the hood overnight, large single crystals appeared in the beaker. The solid crystals were isolated and dried in a desiccator under vacuum. Similarly single crystals of citrate salt could be obtained by slow evaporation of carvedilol/citric acid solutions (containing citric acid 5%, 10% or 20% w/w) in Petri dishes (150 mm diameter) placed in a desiccator connected to a house vacuum.
Example 19

Carvedilol Monocitrate Monohydrate Preparation

A 250 mL three-necked flask equipped with stirrer bar, thermometer, and an addition funnel is charged with acetone (20 mL, 2.5 volumes). The solution is sequentially charged with carvedilol (8 g, 19.7 mmol), and 2 M citric acid solution (40 mL, 5 volumes). Upon addition of the citric acid solution, the slurry dissolves quickly. The solution is filtered through a Buchner funnel fitted with Whatman filter paper and the solution is returned to a 250 mL flask fitted with a stirrer. To the light brown solution is added water (20 mL, 2.5 volumes). No exotherm is noted. The reaction mixture becomes cloudy but disappears upon stirring (heating up to 40 °C maybe needed to remove cloudiness). The mixture is stirred at room temperature and when judged clear is charged with carvedilol monocitrate monohydrate seeds (80 mgs) in one portion. An immediate cloudiness is observed (solid starts to precipitate out over 12-24 hours). The precipitate formed is stirred for 24-48 hours and is filtered through a Buchner funnel fitted with Whatman filter paper and the collected cake is washed with water (2 x 16 mL). The cake is dried in the oven under house vacuum at 50 °C to a constant weight. The cake (7.95 g, 67 %) is weighed and stored in a polyethylene container.

Example 20

Carvedilol Monocitrate Monohydrate Preparation

A suitable reactor is charged with acetone. The solution is sequentially charged with carvedilol, and aqueous citric acid solution. Upon addition of the citric acid solution, the slurry dissolves quickly. The solution is added water. The mixture is stirred at room temperature and is charged with carvedilol seeds in one portion. The precipitate formed is stirred for a period of time, filtered and the collected cake is washed with water. The cake is dried under vacuum to a constant weight and stored in a polyethylene container.
Example 21
Characterization of Carvedilol Monocitrate Monohydrate Preparation

The HPLC assay and $^1$H-NMR revealed that the molar ratio of carvedilol and citric acid in carvedilol citrate salt prepared was approximately 1:1. The characterization by several other techniques are listed below:

Scanning Electron Microscopy (SEM)

The SEM used for the study was a Hitachi S-3500N. SEM was performed using an acceleration voltage of 5 kV. The samples were gold sputtered.

The carvedilol monocitrate salt consists of crystals with plate-shape, and various sizes depending on the preparation method. Crystals as large as 1mm width and length were observed.

Differential Scanning Calorimetry (DSC)

DSC measurements were performed with a MDSC 2920 (TA Instruments, Inc.). Approximately 5 mg of the sample was placed in an open aluminum pan. The sample was scanned at 10 °C/min. An endothermic event was observed with an onset temperature near 82-83 °C. The heat of fusion was calculated as 63 kJ/mol.

Fourier Transform Infrared Spectroscopy (FT-IR)

Approximately 2 mg of sample was diluted with 300 mg of dried potassium bromide (KBr). The mixture was ground with a mortar and pestle, then transferred to a die that is placed under high pressure for 3 minutes. The instrument was a PerkinElmer Spectrum GX FTIR instrument. Forty scans were collected at 4 cm$^{-1}$ resolution. The typical FT-IR spectrum of carvedilol monocitrate salt is shown in Figure 1. The characteristic peaks in the 1800 to 600 cm$^{-1}$ region are found at about 1727, 1709, 1636, 1625, 1604, 1586, 1508, 1475, 1454, 1443, 1396, 1346, 1332, 1305, 1256, 1221, 1129, 1096, 1077, 1054, 1021, 1008, 984, 939, 919, 902, 826, 787, 755, 749, 729, 676, 664, 611 cm$^{-1}$.
**X-Ray Powder Diffraction (XRPD)**

XRPD patterns were collected using a Philips X'Pert Pro Diffractometer. Approximately 30 mg of sample was gently flattened on a silicon sample holder and scanned from 2-35 degrees two-theta, at 0.02 degrees two-theta per step and a step time of 2.5 seconds. The sample was rotated at 25 rpm. The XRPD patterns of two different batches of Carvedilol monocitrate salt are shown in Figure 2.

**Solubility in Water**

Glass vials containing water and excess amount of carvedilol salts were shaken by a mechanical shaker at ambient conditions. Aliquots were taken out at various time-point, filtered through 0.45 μm Acrodisc GHP filter. The pH of the filtered solutions was measured and suitable dilution was performed prior to UV-Vis analysis of carvedilol concentration.

The solubility of carvedilol monicitrate salt in water at room temperature was determined. The drug concentrations and pH values at different time-points are presented in Table 11. This crystalline form of carvedilol monicitrate salt exhibited high solubility in water (1.63 mg/mL at 1 hour and 1.02 mg/mL at 48 hour).
Table 11: Aqueous Solubility (expressed as mg of carvedilol free base/mL of solution) over time at 25°C for Carvedilol Free Base and Its Monocitrate Salt.

<table>
<thead>
<tr>
<th>Time, hr</th>
<th>Carvedilol Free Base</th>
<th>Carvedilol Monocitrate Salt</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>0.0098</td>
<td>1.63 (pH=3.5)</td>
</tr>
<tr>
<td>4</td>
<td></td>
<td>1.47 (pH=3.4)</td>
</tr>
<tr>
<td>24</td>
<td>0.0116</td>
<td>1.07 (pH=3.0)</td>
</tr>
<tr>
<td>48</td>
<td></td>
<td>1.02 (pH=3.0)</td>
</tr>
</tbody>
</table>

Carvedilol monocitrate salt has two free carboxylic acid groups in one unit salt, which contributes the low pH value (near pH 3) observed for monocitrate salt when dissolved in water. This may potentially lead to improved formulations by providing a low pH microenvironment within the formulation as it traverses the GI tract. This may provide an environment at a molecular level that is more conductive to dissolution, particularly in the lower GI tract, where the pH of the environment is near neutral pH and the intrinsic solubility of the drug substance is limited. Such a microenvironmental pH should lead to greater dissolution rate because of higher solubility in the solid/liquid interface, leading to improved absorption of drug in the lower GI tract thereby sustaining overall absorption and, in consequence providing prolonged blood levels and allowing less frequent dosing. Therefore, a once-per-day carvedilol formulation may be possible by incorporating carvedilol monocitrate salt. Such a unit is more convenient for patients and result in higher patient compliance with the dosage regimen and hence a better therapeutic effect.

**Crystalline Structure of Carvedilol Monocitrate Salt**

The crystalline structure of carvedilol citrate salt was determined by Single Crystal X-Ray Diffraction analysis on the large crystals formed by
evaporation. The result indicated that the salt form was a carvedilol monocitrate, where the molar ratio of carvedilol and citric acid was 1:1. Surprisingly, the hydroxyl of carvedilol is disordered in the crystalline packing. In other words, the monocitrate salt has both R(+) and S(-) carvedilol enantiomers at 1:1 molar ratio, and the two enantiomers are randomly distributed, without any specific order.

This crystalline packing habit is very unusual for a salt formed between a chiral compound and a chiral counter-ion (monocitrate). Typically, chiral counter-ion tends to differentiate the two stereoisomers of the compound when forming crystals. However, in the case of the monocitrate salt, there seems to be enough space in the crystal packing to allow the carbonyl group of the terminal carboxylic acid group of citrate to form equivalent hydrogen bond with the hydroxyl from either the R(+) or the S(-) carvedilol stereoisomer.

This avoids generation of yet more optically active forms that could potentially complicate stability, dissolution rates and possibly in vivo absorption and pharmacologic effects.

The above data demonstrates that a novel crystalline form of carvedilol monocitrate monohydrate can be prepared with a unique crystalline packing habit, which exhibits high aqueous solubility and can provide a low pH microenvironment for enhanced dissolution.

**Example 22**

**Crystalline Carvedilol Benzoate Preparation**

A suitable reactor is charged with acetone. The solution is sequentially charged with carvedilol (4.1 grams, 0.1 moles), and benzoic acid solution. Upon addition of the benzoic acid (1.4 grams, 0.011 moles) solution, all material dissolves into the solution. To the stirred solution is added tert-butyl methyl ether (60 ml). The precipitate formed is stirred for a period of time, filtered and the collected cake is washed with water. The cake is dried under vacuum to a constant weight and stored in a polyethylene container.
Example 23

**Crystalline Carvedilol Mandelate Preparation**

A suitable reactor is charged with acetone (38 mL). The acetone solution is sequentially charged with carvedilol (11.08 grams) and water (8 mL). Upon addition of the water, the slurry dissolves completely with heating. To the solution, 1N Mandelic acid in methanol (1 Equiv. 27.3 mL.) is added. The resulting mixture is stirred at the range between 17°C and 35 °C, and the solid precipitate is formed over 10 hours to 24 hours. Later, the mixture filtered and the cake is washed with a mixture of acetone and water (10 to 1) at 3 volumes or 33 mL. The cake is then dried under vacuum to a constant weight. The final weight is 8.34 g, 54.5% yield.

Example 24

**Crystalline Carvedilol Lactate Preparation**

A suitable reactor is charged with acetone (50 mL). The acetone solution is sequentially charged with carvedilol (15.0 grams) and water (7 mL). Upon addition of the water, the slurry dissolves completely with heating. To the solution is added 1N aqueous D, L-Lactic acid (1 equiv., 36.9 mL). The reaction mixture is stirred at between 17°C and 35 °C and seeded in one portion. The solid precipitate is formed over 10 hours to 24 hours. Later, the mixture is filtered and the cake is washed with a mixture of acetone and water (10 to 1) at 2 volume or 30 mL. The cake is dried under vacuum to a constant weight. The final weight is 9.16 grams.

Example 25

**Crystalline Carvedilol Sulfate Preparation**

A suitable reactor is charged with acetone (38 mL). The acetone solution is sequentially charged with carvedilol (10.25 grams) and water (6 mL). Upon addition of the water, the slurry dissolves completely with heating. To the solution, 1N aqueous sulfuric acid (1 equiv., 25.2 mL) is added. The reaction mixture is stirred at between 17°C and 35 °C, and the solid precipitate is formed over 10 hours to 24 hours. Later, the mixture is filtered and the cake is washed with a mixture of acetone and water at 2 volumes or 20.5 mL. The cake is then added a
mixture of acetone and water (10 to 1) for ripening between 20 °C - 35°C over 24 hours to 48 hours. The slurry is filtered and the cake is dried under vacuum to a constant weight. The final weight is 5.48 grams.

Example 26

Crystalline Carvedilol Maleate Preparation

A suitable reactor is charged with acetone (56 mL). The acetone solution is sequentially charged with carvedilol (15.0 grams) and water (8 mL). Upon addition of the water, the slurry dissolves completely with heating. To the solution is added 1 M of aqueous Maleic acid (1 Equiv. 36.9 mL.) The reaction mixture is stirred at between 17°C and 35 °C. The solid precipitate is formed over 10 hours to 24 hours. Later, the mixture is filtered and the cake is washed with a mixture of acetone and water (10 to 1) at 3 volume or 45.0 mL. The cake is dried under vacuum to a constant weight. The final weight is 14.08 grams.

Example 27

Crystalline Carvedilol Glutarate Preparation

A suitable reactor is charged with 2 grams of carvedilol and a mixture of acetone and water (in a 7 to 1 ratio) at 8 mL. The contents were warmed to 35°C to 40 °C to a clear solution. 1N D,L-Glutaric acid in water (1 equivalent. 4.9 mL.) is added to the solution. The resulting mixture is stirred at the temperature between 17°C and 35°C until the solid precipitate is formed over 10 hours to 24 hours. Subsequently, the mixture filtered and the cake is washed with a mixture of acetone and water (in a 10 to 1) at about 5 mL. The cake is then dried under vacuum to a constant weight. The final weight is 1.35 grams.

Example 28

Solubility Enhancement in the GI tract

Background:
Drug absorption following oral dosage requires that drug first dissolves in the gastro-intestinal milieu. In most cases such dissolution is primarily a function of drug solubility. If solubility is affected by pH it is likely that absorption will vary in different regions of the gastro intestinal tract, because pH varies from acidic in the stomach to more neutral values in the intestine.

Such pH-dependent solubility can complicate dosage form design when drug absorption needs to be prolonged, delayed or otherwise controlled, to evince a sustained or delayed action effect. Variations in solubility can lead to variable dissolution, absorption and subsequent therapeutic effect.

Carvedilol is a drug used to treat hypertension and congestive heart failure, being usually administered twice daily. For chronic diseases such as these a once-daily dosage regimen is desirable, to enhance patient compliance and reduce "pill burden". However, the dose response and time course of carvedilol in the body is such that a conventional dosage form, releasing all the drug immediately on ingestion does not provide once-a-day therapy. Release from the dosage form needs to be slowed down so that absorption and subsequent systemic residence is prolonged. This however requires that release and dissolution occurs along the GI tract, not just in the stomach.

The pH-dependent solubility of the currently used form of carvedilol (free base) is such that, while gastric solubility is adequate, solubility is much poorer at pH values encountered in the small intestine and beyond (see, Figure 126), which depicts a pH-solubility profile for carvedilol.

Consequently, while drug dissolution rate and extent from an immediate release dosage form is likely to be acceptable (such dissolution occurring in the stomach) it could be inadequate in regions beyond the stomach, with absorption compromised as a consequence.

However, when drug is administered as a solution (in cyclodextrin in this example), directly to the colon it can be seen that absorption is significantly improved (Figure 127, which depicts mean plasma profiles in beagle dogs following intra-colonic administration of a carvedilol solution containing Captisol or carvedilol in aqueous suspension.). All this information suggests that
absorption throughout the GI tract could be significant, provided that drug can be solubilised.

Moreover, solubilization may mean that drug stability is compromised. The secondary amino group of carvedilol is prone to chemically react with excipients normally included in a dosage form to aid manufacture, maintain quality or enhance dissolution rate. For example, this type of amine groups can react with aldehydes or ester functional groups through nucleophilic reactions. Many excipients have ester functional groups. Furthermore, aldehydes and other such residues are common residues in excipients. This often results in marginal or unacceptable chemical stability of conventionally formulated carvedilol dosage forms, where drug is simply blended with excipients before being compressed to tablets. As drug-excipient interactions are likely to be even faster in the solvated state it follows that solubilization does not provide facile resolution of dissolution-limited absorption challenges. This is illustrated in Table 12. Solutions of carvedilol in oleic acid degraded rapidly. Other approaches to solubilization evince the same effect. Thus solubilization might enhance absorption but is not a practical approach because of the destabilising effect.

<table>
<thead>
<tr>
<th>Table 12</th>
<th>Drug content (mg/g) in carvedilol/Oleic acid solution during storage.</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Initial</td>
</tr>
<tr>
<td>7.788%w/w carvedilol solution in Oleic acid</td>
<td>76.6</td>
</tr>
</tbody>
</table>

It has now been unexpectedly shown that salts of carvedilol afford significant improvement in absorption from the lower GI tract in dogs over that seen when carvedilol base is used. There is no reason to believe that this surprising effect does not also apply to humans and it may be feasible as a consequence to design dosage forms that enable drug to be absorbed as the unit traverses the gastrointestinal tract. This ought to provide more gradual absorption and prolonged plasma profiles that facilitate once-a-day dosage.

The better absorption may be partially due to the better solubilities of salts of carvedilol. It can be seen from the data in Table 13 that citrate,
hydrobromide and phosphate salts have much better aqueous solubility than
the free base.

<table>
<thead>
<tr>
<th>Table 13</th>
<th>Aqueous Solubility (expressed as mg of Carvedilol free base/mL of solution) at 25°C for Carvedilol free base and three salts.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Time</td>
<td>Free Base</td>
</tr>
<tr>
<td>1 hr</td>
<td>--</td>
</tr>
<tr>
<td>4 hr</td>
<td>--</td>
</tr>
<tr>
<td>24 hr</td>
<td>0.024 (pH=7.0)</td>
</tr>
</tbody>
</table>

Ostensibly, it can be claimed that these acidic salts simply generate low pH when dissolved in water (Table 13), leading to solubility enhancement (because of the pH/solubility relationship shown in Figure 126). However, it is also possible that any pH-lowering effect contributed by the modest amounts of drug (that would be included in a dosage form to provide a therapeutic effect) would be readily swamped in the in vivo situation, with pH soon reverting to that of the general intestinal milieu. Consequently, any short-term solubilization would be quickly negated. However, it has been surprisingly shown that when pH is adjusted to neutral, the solubilities of salts remain higher than free base for a significant period, rather than equilibrating rapidly. Such prolonged solubility could be crucial in vivo, allowing dissolution and absorption to occur more readily at neutral pH than for free base (Figure 128, which depicts dissolution/solubility profile of carvedilol phosphate in pH = 7.1 Tris buffer (for comparison, carvedilol free base has a solubility of ~20-30 ug/mL at this pH).

Furthermore, it has been shown that, if carvedilol salts are dissolved in solubilizing agents, stability is much better than when free base is used in the same system (Table 14). Thus, if solubilizing agents were to be required in the formulation, to provide even greater solubility enhancement, salts would be preferred to the base because of such better stability.
Table 14  Chemical stability data of carvedilol/Vitamin E TPGS granulation containing carvedilol free base or carvedilol HBr salt.

<table>
<thead>
<tr>
<th>Formulation</th>
<th>Assay/Impurity after 1 month's storage at 40°C/75%RH (open vials)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>% of initial level *</td>
</tr>
<tr>
<td>Carvedilol free base granulation containing</td>
<td>81.5*</td>
</tr>
<tr>
<td>Vitamin E TPGS (Lot 200412-144)</td>
<td></td>
</tr>
<tr>
<td>Carvedilol HBr salt granulation containing</td>
<td>89.9*</td>
</tr>
<tr>
<td>Vitamin E TPGS (Lot 200746-102)</td>
<td></td>
</tr>
</tbody>
</table>

* Lower % of nominal due to additional moisture in the system.

The foregoing facts and considerations suggest but do not provide conclusive proof that forms of carvedilol with superior solubility, whether effected by using a solvent to dissolve carvedilol base, or by using a carvedilol salt have better potential than conventionally formulated base for prolonged absorption along the GI tract. To provide stronger evidence that solubilization enhances absorption, formulations containing carvedilol base, formulated in a conventional manner, and also fully solvated by dissolving in n-methyl pyrroldione were dosed to beagle dogs in units that were activated to make drug available after the dosage unit had passed the pyloric sphincter separating the stomach from the duodenum. Intestinal absorption efficiency was determined by monitoring plasma levels of carvedilol following such dosage. Results are provided in Table 5 and Figure 128 (which depicts mean plasma profiles in beagle dogs following oral administration of the formulations listed in Table 15).
Table 15  Pharmacokinetic values following dosage of 10 mg carvedilol (base) to three fasted beagle dogs.

<table>
<thead>
<tr>
<th>Formulation</th>
<th>Solubility in pH 6.8 Phosphate Buffer Over 4-hour Period (ug/mL)</th>
<th>C&lt;sub&gt;max&lt;/sub&gt; (ng/mL)</th>
<th>T&lt;sub&gt;max&lt;/sub&gt; (min)</th>
<th>AUC (0-t) (ug.min/mL)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Carvedilol Pharmasolve® Granulation</td>
<td>86 – 120</td>
<td>31.32 ± 3.43 (n=3)</td>
<td>15&lt;sup&gt;b&lt;/sup&gt;, 30, 45&lt;sup&gt;a&lt;/sup&gt; (n=3)</td>
<td>4.03 ± 1.34 (n=3)</td>
</tr>
<tr>
<td>Carvedilol ETPGS Granulation</td>
<td>108 – 94</td>
<td>16.26 ± 1.20 (n=3)</td>
<td>30, 120, 45&lt;sup&gt;a&lt;/sup&gt; (n=3)</td>
<td>2.75 ± 0.55 (n=3)</td>
</tr>
<tr>
<td>Carvedilol in conventional granules</td>
<td>29 – 36</td>
<td>13.08, 12.74, 2.89&lt;sup&gt;a&lt;/sup&gt; (n=3)</td>
<td>45, 30, 120&lt;sup&gt;a&lt;/sup&gt; (n=3)</td>
<td>2.14, 1.19, 0.60&lt;sup&gt;a&lt;/sup&gt; (n=3)</td>
</tr>
</tbody>
</table>

<sup>a</sup> = values listed individually due to large variability; animals always listed in the same order.

AUC(0-t) refers to the area from time 0 to the last quantifiable concentration.

<sup>b</sup> = Pharmasolve® capsule was leaking slightly before firing in-vivo.

It can be seen that, when drug was fully dissolved absorption was rapid and high, contrasting with lower concentrations in dogs that were dosed intraduodenally with base in a conventional solid dosage unit. These findings indicated that bioavailability from carvedilol base in the small intestine is constrained by its low solubility at neutral pH. When units are introduced to the stomach the low gastric pH can be expected to facilitate dissolution and absorption but this will not be the case in the more neutral small intestine or beyond.

A further dog study utilised salts of carvedilol, formulated using conventional (non-solubilizing) excipients. The mode of dosage was the same as for the first dog study, the formulations being delivered such that drug did not become available until units were beyond the gastric milieu. Results are provided in Table 16 and Figure 129 (which depicts mean plasma profiles following oral administration of Companion capsules filled with four formulations at 10 mg strength to Beagle dogs).
Table 16  Pharmacokinetic analysis of 10 mg dose formulations in three fasted beagle dogs from study DM18086-38.

<table>
<thead>
<tr>
<th>Formulation</th>
<th>C_{max} (ng/mL)</th>
<th>T_{max} (min)</th>
<th>AUC (0-t)^a (ug.min/mL)</th>
<th>AUC (0-inf) (ug.min/mL)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Carvedilol HBr Salt granules</td>
<td>12.9 ± 7.11</td>
<td>45 ± 15</td>
<td>2.22 ± 1.37</td>
<td>2.35 ± 1.46</td>
</tr>
<tr>
<td>Carvedilol Phosphate Salt Granules^b</td>
<td>61.8, 28.4</td>
<td>45, 60</td>
<td>6.69, 4.56</td>
<td>6.75, 4.90</td>
</tr>
<tr>
<td>Carvedilol Citrate Salt Granules</td>
<td>30.4 ± 16.9</td>
<td>45 ± 15</td>
<td>4.41 ± 2.43</td>
<td>4.66 ± 2.54</td>
</tr>
<tr>
<td>Carvedilol Base Granules^c</td>
<td>13.08, 12.74,</td>
<td>45, 30, 120</td>
<td>2.14, 1.19, 0.60</td>
<td>---</td>
</tr>
<tr>
<td></td>
<td>2.89</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

^a. AUC(0-t) refers to the area from time 0 to the last quantifiable concentration

^b. n=2 only, due to malfunction of one InteliSite® Companion capsule; animals always listed in the same order

^c. data from dog study DI01251; values listed individually due to large variability; animals always listed in the same order.

The findings from the second dog study, illustrated graphically in Figure 130 conclusively showed that drug, administered in salt form was rapidly and more completely absorbed than the free base form.

It is to be understood that the invention is not limited to the embodiments illustrated hereinabove and the right is reserved to the illustrated embodiments and all modifications coming within the scope of the following claims.

The various references to journals, patents, and other publications which are cited herein comprise the state of the art and are incorporated herein by reference as though fully set forth.
What is claimed is:

1. A compound which is a crystalline salt, anhydrous forms or solvate of carvedilol selected from the group consisting of carvedilol mandelate, carvedilol lactate, carvedilol maleate, carvedilol sulfate, carvedilol glutarate, carvedilol mesylate, carvedilol phosphate, carvedilol citrate, carvedilol hydrogen bromide, carvedilol oxalate, carvedilol hydrochloride, carvedilol hydrogen bromide, carvedilol benzoate, and corresponding anhydrous forms or solvates thereof.

2. A compound which is a crystalline salt, anhydrous forms or solvate of carvedilol selected from the group consisting of carvedilol hydrogen phosphate, carvedilol dihydrogen phosphate, carvedilol dihydrogen phosphate hemihydrate, carvedilol dihydrogen phosphate dihydrate, carvedilol dihydrogen phosphate methanol solvate, carvedilol hydrobromide monohydrate, carvedilol hydrobromide dioxane solvate, carvedilol hydrobromide 1-pentanol solvate, carvedilol hydrobromide 2-methyl-1-propanol solvate, carvedilol hydrobromide trifluoroethanol solvate, carvedilol hydrobromide 2-propanol solvate, carvedilol hydrobromide n-propanol solvate #1, carvedilol hydrobromide n-propanol solvate #2, carvedilol hydrobromide anhydrous forms or anhydrous, carvedilol hydrobromide ethanol solvate, carvedilol hydrobromide dioxane solvate, carvedilol mononitrate monohydrate, carvedilol mandelate, carvedilol lactate salt, carvedilol maleate, carvedilol sulfate, carvedilol glutarate, and corresponding anhydrous, solvates thereof.

3. A compound which is a carvedilol mandelate salt.

4. The compound according to claim 3 having an FT-IR spectrum pattern which comprises characteristic peaks in wavenumbers (cm\(^{-1}\)) as substantially shown in Figure 114.
5. The compound according to claim 4 having characteristic peaks from 0 wavenumbers (cm\(^{-1}\)) to 4000 wavenumbers (cm\(^{-1}\)) at about 699 cm\(^{-1}\), 723 cm\(^{-1}\), 752 cm\(^{-1}\), 784 cm\(^{-1}\), 1053 cm\(^{-1}\), 1583 cm\(^{-1}\), 1631 cm\(^{-1}\), 3189 cm\(^{-1}\), 3246 cm\(^{-1}\), and 3396 cm\(^{-1}\).

6. The compound according to claim 3 having an FT-Raman spectrum pattern which comprises characteristic peaks in wavenumbers (cm\(^{-1}\)) as substantially shown in Figure 115.

7. The compound according to claim 6 having characteristic peaks from 0 wavenumbers (cm\(^{-1}\)) to 4000 wavenumbers (cm\(^{-1}\)) at about 233 cm\(^{-1}\), 252 cm\(^{-1}\), 322 cm\(^{-1}\), 359 cm\(^{-1}\), 423 cm\(^{-1}\), 744 cm\(^{-1}\), 1002 cm\(^{-1}\), 1286 cm\(^{-1}\), 1631 cm\(^{-1}\), 3052 cm\(^{-1}\), 3063 cm\(^{-1}\), and 3077 cm\(^{-1}\).

8. A compound which is a carvedilol lactate salt.

9. The compound according to claim 8 having an FT-IR spectrum pattern which comprises characteristic peaks in wavenumbers (cm\(^{-1}\)) as substantially shown in Figure 116.

10. The compound according to claim 9 having characteristic peaks from 0 wavenumbers (cm\(^{-1}\)) to 4000 wavenumbers (cm\(^{-1}\)) at about 720 cm\(^{-1}\), 753 cm\(^{-1}\), 785 cm\(^{-1}\), 1097 cm\(^{-1}\), 1124 cm\(^{-1}\), 1253 cm\(^{-1}\), 1584 cm\(^{-1}\), and 3396 cm\(^{-1}\).

11. The compound according to claim 8 having an FT-Raman spectrum pattern which comprises characteristic peaks in wavenumbers (cm\(^{-1}\)) as substantially shown in Figure 117.

12. The compound according to claim 11 having characteristic peaks from 0 wavenumbers (cm\(^{-1}\)) to 4000 wavenumbers (cm\(^{-1}\)) at about 321 cm\(^{-1}\), 422 cm\(^{-1}\), 549 cm\(^{-1}\), 765 cm\(^{-1}\), 1015 cm\(^{-1}\), 1284 cm\(^{-1}\), 1626 cm\(^{-1}\), 3066 cm\(^{-1}\)}
13. A compound which is a carvedilol maleate salt.

14. The compound according to claim 13 having an FT-IR spectrum pattern which comprises characteristic peaks in wavenumbers (cm\(^{-1}\)) as substantially shown in Figure 118.

15. The compound according to claim 14 having characteristic peaks from 0 wavenumbers (cm\(^{-1}\)) to 4000 wavenumbers (cm\(^{-1}\)) at about 725 cm\(^{-1}\), 741 cm\(^{-1}\), 756 cm\(^{-1}\), 786 cm\(^{-1}\), 1024 cm\(^{-1}\), 1109 cm\(^{-1}\), 1215 cm\(^{-1}\), 1586 cm\(^{-1}\), and 3481 cm\(^{-1}\).

16. The compound according to claim 13 having an FT-Raman spectrum pattern which comprises characteristic peaks in wavenumbers (cm\(^{-1}\)) as substantially shown in Figure 119.

17. The compound according to claim 16 having characteristic peaks from 0 wavenumbers (cm\(^{-1}\)) to 4000 wavenumbers (cm\(^{-1}\)) at about 249 cm\(^{-1}\), 324 cm\(^{-1}\), 423 cm\(^{-1}\), 549 cm\(^{-1}\), 751 cm\(^{-1}\), 1012 cm\(^{-1}\), 1216 cm\(^{-1}\), 1286 cm\(^{-1}\), 1629 cm\(^{-1}\), and 3070 cm\(^{-1}\).

18. A compound which is a carvedilol sulfate salt.

19. The compound according to claim 18 having an FT-IR spectrum pattern which comprises characteristic peaks in wavenumbers (cm\(^{-1}\)) as substantially shown in Figure 120.

20. The compound according to claim 19 having characteristic peaks from 0 wavenumbers (cm\(^{-1}\)) to 4000 wavenumbers (cm\(^{-1}\)) at about 727 cm\(^{-1}\), 743 cm\(^{-1}\), 787 cm\(^{-1}\), 1026 cm\(^{-1}\), 1089 cm\(^{-1}\), 1251 cm\(^{-1}\), 1215 cm\(^{-1}\), 1586 cm\(^{-1}\), 1604 cm\(^{-1}\), and 3230 cm\(^{-1}\).
21. The compound according to claim 18 having an FT-Raman spectrum pattern which comprises characteristic peaks in wavenumbers (cm\(^{-1}\)) as substantially shown in Figure 121.

22. The compound according to claim 21 having characteristic peaks from 0 wavenumbers (cm\(^{-1}\)) to 4000 wavenumbers (cm\(^{-1}\)) at about 242 cm\(^{-1}\), 318 cm\(^{-1}\), 423 cm\(^{-1}\), 549 cm\(^{-1}\), 1014 cm\(^{-1}\), 1214 cm\(^{-1}\), 1282 cm\(^{-1}\), 1627 cm\(^{-1}\), 2969 cm\(^{-1}\), and 3066 cm\(^{-1}\).

23. A compound which is a carvedilol glutarate salt.

24. The compound according to claim 23 having an FT-IR spectrum pattern which comprises characteristic peaks in wavenumbers (cm\(^{-1}\)) as substantially shown in Figure 122.

25. The compound according to claim 24 having characteristic peaks from 0 wavenumbers (cm\(^{-1}\)) to 4000 wavenumbers (cm\(^{-1}\)) at about 724 cm\(^{-1}\), 743 cm\(^{-1}\), 786 cm\(^{-1}\), 1024 cm\(^{-1}\), 1044 cm\(^{-1}\), 1089 cm\(^{-1}\), 1251 cm\(^{-1}\), 1586 cm\(^{-1}\), 1604 cm\(^{-1}\), and 3229 cm\(^{-1}\).

26. The compound according to claim 23 having an FT-Raman spectrum pattern which comprises characteristic peaks in wavenumbers (cm\(^{-1}\)) as substantially shown in Figure 123.

27. The compound according to claim 26 having characteristic peaks from 0 wavenumbers (cm\(^{-1}\)) to 4000 wavenumbers (cm\(^{-1}\)) at about 141 cm\(^{-1}\), 246 cm\(^{-1}\), 322 cm\(^{-1}\), 423 cm\(^{-1}\), 551 cm\(^{-1}\), 749 cm\(^{-1}\), 1011 cm\(^{-1}\), 1213 cm\(^{-1}\), 1284 cm\(^{-1}\), 1628 cm\(^{-1}\), 2934 cm\(^{-1}\), and 3073 cm\(^{-1}\).

28. A compound which is a carvedilol benzoate salt.
29. The compound according to claim 23 having an FT-IR spectrum pattern which comprises characteristic peaks in wavenumbers (cm\(^{-1}\)) as substantially shown in Figure 124.

30. The compound according to claim 24 having characteristic peaks from 0 wavenumbers (cm\(^{-1}\)) to 4000 wavenumbers (cm\(^{-1}\)) at about 672 cm\(^{-1}\), 718 cm\(^{-1}\), 754 cm\(^{-1}\), 767 cm\(^{-1}\), 1022 cm\(^{-1}\), 1041 cm\(^{-1}\), 1106 cm\(^{-1}\), 1260 cm\(^{-1}\), 1498 cm\(^{-1}\), 1582 cm\(^{-1}\), 1604 cm\(^{-1}\), 1626 cm\(^{-1}\), 2932 cm\(^{-1}\), 3184 cm\(^{-1}\), and 3428 cm\(^{-1}\).

31. The compound according to claim 23 having an FT-Raman spectrum pattern which comprises characteristic peaks in wavenumbers (cm\(^{-1}\)) as substantially shown in Figure 125.

32. The compound according to claim 26 having characteristic peaks from 0 wavenumbers (cm\(^{-1}\)) to 4000 wavenumbers (cm\(^{-1}\)) at about 108 cm\(^{-1}\), 244 cm\(^{-1}\), 424 cm\(^{-1}\), 538 cm\(^{-1}\), 549 cm\(^{-1}\), 728 cm\(^{-1}\), 1001 cm\(^{-1}\), 1015 cm\(^{-1}\), 1128 cm\(^{-1}\), 1286 cm\(^{-1}\), 1598 cm\(^{-1}\), 1626 cm\(^{-1}\), 2934 cm\(^{-1}\), 3058 cm\(^{-1}\), and 3072 cm\(^{-1}\).

33. A pharmaceutical composition comprising the compound according to claim 1 and a pharmaceutically acceptable adjuvant, carrier, diluent, and/or excipient.

34. A pharmaceutical composition comprising the compound according to claim 2 and a pharmaceutically acceptable adjuvant, carrier, diluent, and/or excipient.

35. A pharmaceutical composition comprising the compound according to claim 3 and a pharmaceutically acceptable adjuvant, carrier, diluent, and/or excipient.
36. A pharmaceutical composition comprising the compound according to claim 8 and a pharmaceutically acceptable adjuvant, carrier, diluent, and/or excipient.

37. A pharmaceutical composition comprising the compound according to claim 13 and a pharmaceutically acceptable adjuvant, carrier, diluent, and/or excipient.

38. A pharmaceutical composition comprising the compound according to claim 18 and a pharmaceutically acceptable carrier.

39. A pharmaceutical composition comprising the compound according to claim 23 and a pharmaceutically acceptable carrier.

40. A pharmaceutical composition comprising the compound according to claim 28 and a pharmaceutically acceptable carrier.

41. A method of treating hypertension, congestive heart failure or angina which comprises administering to a subject in need thereof an effective amount of the compound according to claim 1.

42. A method of treating hypertension, congestive heart failure or angina which comprises administering to a subject in need thereof an effective amount of the compound according to claim 2.

43. A method of treating hypertension, congestive heart failure or angina which comprises administering to a subject in need thereof an effective amount of the compound according to claim 3.

44. A method of treating hypertension, congestive heart failure or angina which comprises administering to a subject in need thereof an effective amount of the compound according to claim 8.
45. A method of treating hypertension, congestive heart failure or angina which comprises administering to a subject in need thereof an effective amount of the compound according to claim 13.

46. A method of treating hypertension, congestive heart failure or angina which comprises administering to a subject in need thereof an effective amount of the compound according to claim 18.

47. A method of treating hypertension, congestive heart failure or angina which comprises administering to a subject in need thereof an effective amount of the compound according to claim 23.

48. A method of treating hypertension, congestive heart failure or angina which comprises administering to a subject in need thereof an effective amount of the compound according to claim 28.

49. A method of treating hypertension, congestive heart failure or angina which comprises administering to a subject in need thereof an effective amount of the pharmaceutical composition according to claim 33.

50. A method of treating hypertension, congestive heart failure or angina which comprises administering to a subject in need thereof an effective amount of the pharmaceutical composition according to claim 34.

51. A method of treating hypertension, congestive heart failure or angina which comprises administering to a subject in need thereof an effective amount of the pharmaceutical composition according to claim 35.

52. A method of treating hypertension, congestive heart failure or angina which comprises administering to a subject in need thereof an effective amount of the pharmaceutical composition according to claim 36.
53. A method of treating hypertension, congestive heart failure or angina which comprises administering to a subject in need thereof an effective amount of the pharmaceutical composition according to claim 37.

54. A method of treating hypertension, congestive heart failure or angina which comprises administering to a subject in need thereof an effective amount of the pharmaceutical composition according to claim 38.

55. A method of treating hypertension, congestive heart failure or angina which comprises administering to a subject in need thereof an effective amount of the pharmaceutical composition according to claim 39.

56. A method of treating hypertension, congestive heart failure or angina which comprises administering to a subject in need thereof an effective amount of the pharmaceutical composition according to claim 40.

57. A method of delivering carvedilol to lower gastrointestinal tract of a subject in need thereof, which comprises administering a compound which is a crystalline salt, anhydrous forms or solvate of carvedilol according to claim 1.

58. A method of delivering carvedilol to lower gastrointestinal tract of a subject in need thereof, which comprises administering a compound which is a crystalline salt, anhydrous forms or solvate of carvedilol according to claim 2.

59. A method of delivering carvedilol to lower gastrointestinal tract of a subject in need thereof, which comprises administering an effective amount of the pharmaceutical composition according to claim 33.
60. A method of delivering carvedilol to lower gastrointestinal tract of a subject in need thereof, which comprises administering an effective amount of the pharmaceutical composition according to claim 34.

61. A method of delivering carvedilol to lower gastrointestinal tract of a subject in need thereof, which comprises administering an effective amount of the pharmaceutical composition according to claim 35.

62. A method of delivering carvedilol to lower gastrointestinal tract of a subject in need thereof, which comprises administering an effective amount of the pharmaceutical composition according to claim 36.

63. A method of delivering carvedilol to lower gastrointestinal tract of a subject in need thereof, which comprises administering an effective amount of the pharmaceutical composition according to claim 37.

64. A method of delivering carvedilol to lower gastrointestinal tract of a subject in need thereof, which comprises administering an effective amount of the pharmaceutical composition according to claim 38.

65. A method of delivering carvedilol to lower gastrointestinal tract of a subject in need thereof, which comprises administering an effective amount of the pharmaceutical composition according to claim 39.

66. A method of delivering carvedilol to lower gastrointestinal tract of a subject in need thereof, which comprises administering an effective amount of the pharmaceutical composition according to claim 40.
FIG. 10

6.123% WT LOSS (0.3419mg)

64.93°C
90.73°C
123.79°C

59.29°C
3925. J/g
\[ ^{13}\text{C} \text{ CP-TOSQ spectrum of Carvedilol phosphate} \]

C2  C7
C14  C19
C18  C21
C8  C12  C13
C9  C11

**= unassigned

13C chemical shift (ppm from TMS)

160 150 140 130 120 110 100 90 80 70 60 50 40

FIG. 26
P MAS (with $^1$H decoupling)
spectrum of Carvedilol phosphate

phosphate

*=spinning sidebands

$^{31}$P chemical shift (ppm from 85% phosphoric acid)

FIG. 27
FIG. 76

Heat Flow

Temperature (°C)

Temperature (%)

Weight (mg)

Exo Down

128.8°C

4.677% Wt. loss
(0.1047 mg)

114.02°C

5.937% Wt. loss
(0.1329 mg)

123.34°C

26.57 J/g

103.74°C

16.73 J/g

2.0

1.5

1.0

0.5

0.0

-0.5

300

250

200

150

100

50

0
FIG. 87
Figure 113
FT-IR Spectrum of Carvedilol Mandelate

Figure 114
FT-Raman Spectrum of Carvedilol Mandelate
FT-IR Spectrum of Carvedilol Lactate

Figure 116
FT-Raman Spectrum of Carvedilol Laetate

Figure 117
FT-IR Spectrum of Carvedilol Maleate
FT-Raman Spectrum of Carvedilol Maleate

Figure 119
120/130

FT-IR Spectrum of Carvedilol Sulfate

Figure 120
FT-Raman Spectrum of Carvedilol Sulfate

Figure 121
FT-IR Spectrum of Carvedilol Glutarate

Figure 122
FT-Raman Spectrum of Carvedilol Glutarate
Figure 124

Carvedilol Benzoate: FT-IR Spectrum of Polymorphic Form 1
Carvedilol Benzoate: FT-Raman Spectrum of Polymorphic Form 1; Reference
pH-solubility profile for carvedolol.

Figure 126
Mean plasma profiles in beagle dogs following intra-colonic administration of a carvedilol solution containing Captisol or carvedilol in aqueous suspension.

Figure 127
Dissolution/Solubility profile of carvedilol phosphate in pH 7.1 Tris buffer.
(For comparison, carvedilol free base has a solubility of ~20-30 μg/mL at this pH.)

Figure 128
Mean plasma profiles in beagle dogs following oral administration of the formulations listed in Table 16.

Figure 129
Figure 130

Mean plasma profiles following oral administration of Companion capsules filled with four formulations at 10 mg strength to Beagle dogs.
INTERNATIONAL SEARCH REPORT

A. CLASSIFICATION OF SUBJECT MATTER
   IPC(7) : A61K 31/403; C07D 209/82
   US CL : 514/411; 548/444

   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)
   U.S. : 514/411; 548/444

   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)
   EAST; WEST; STN CAS Online: FILE REGISTRY, FILE CAPLUS

C. DOCUMENTS CONSIDERED TO BE RELEVANT

<table>
<thead>
<tr>
<th>Category</th>
<th>Citation of document, with indication, where appropriate, of the relevant passages</th>
<th>Relevant to claim No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Y</td>
<td>U.S. 2001/0036960 A1 (DECKER et al.) 1 November 2001 (01.11.2001), see entire document.</td>
<td>3</td>
</tr>
</tbody>
</table>

   □ Further documents are listed in the continuation of Box C.  □ See patent family annex.

   “A” – document defining the general state of the art which is not considered to be of particular relevance
   “E” – earlier application or patent 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

   Date of the actual completion of the international search: 15 March 2005 (15.03.2005)
   Date of mailing of the international search report: 31 MAR 2005

   Name and mailing address of the ISA/US
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   Authorized officer:
   Janet L. Coppens
   Telephone No. 703.272.0680

Form PCT/ISA/210 (second sheet) (January 2004)
INTERNATIONAL SEARCH REPORT

PCT/US04/39528

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.: 1-2 and 4-66
   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:
   Please See Continuation Sheet

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:

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 fee, this Authority did not invite payment of any additional fee.

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.:

Remark on Protest  
☐ The additional search fees were accompanied by the applicant's protest.
☐ No protest accompanied the payment of additional search fees.

Form PCT/ISA/210 (continuation of first sheet(2)) (January 2004)
Continuation of Box II  Reason 2:
In these claims, the numerous compounds, their anhydrous forms, their solvates, and their numerous crystalline salt forms and combinations make it virtually impossible to determine the full scope and complete meaning of the claimed subject matter. As presented, the claimed subject matter cannot be regarded as being a clear and concise description for which protection is sought and as such the listed claims do not comply with the requirements of PCT article 6. Thus it is impossible to carry out a meaningful search on the same. A search will be made on the first discernable invention in the claims, which is the first recited compound of claim 3.