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(19) **United States**(12) **Patent Application Publication**
Sundaram(10) **Pub. No.: US 2018/0185488 A1**(43) **Pub. Date: Jul. 5, 2018**(54) **FORMULATIONS OF BENDAMUSTINE****Publication Classification**(71) Applicant: **Eagle Pharmaceuticals, Inc.**, Woodcliff Lake, NJ (US)(72) Inventor: **Srikanth Sundaram**, Somerset, NJ (US)(21) Appl. No.: **15/908,075**(22) Filed: **Feb. 28, 2018**(51) **Int. Cl.***A61K 47/10* (2006.01)*A61K 31/4184* (2006.01)*A61K 47/20* (2006.01)*A61K 9/00* (2006.01)*A61K 47/02* (2006.01)*A61K 47/22* (2006.01)(52) **U.S. Cl.**CPC *A61K 47/10* (2013.01); *A61K 31/4184*(2013.01); *A61K 47/22* (2013.01); *A61K**9/0019* (2013.01); *A61K 47/02* (2013.01);*A61K 47/20* (2013.01)**Related U.S. Application Data**

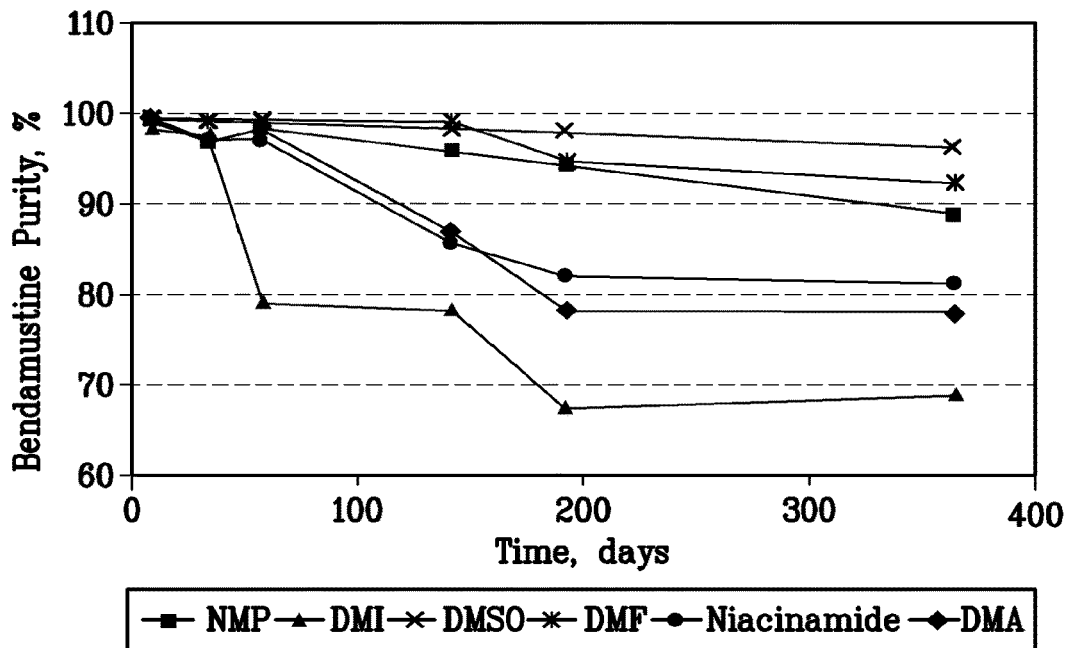
(63) Continuation of application No. 15/432,378, filed on Feb. 14, 2017, which is a continuation of application No. 14/857,064, filed on Sep. 17, 2015, now Pat. No. 9,597,397, which is a continuation of application No. 14/714,578, filed on May 18, 2015, now Pat. No. 9,144,568, which is a continuation of application No. 13/838,090, filed on Mar. 15, 2013, now Pat. No. 9,034,908.

(60) Provisional application No. 61/613,173, filed on Mar. 20, 2012, provisional application No. 61/669,889, filed on Jul. 10, 2012.

(57)

ABSTRACT

Methods of treatment using bendamustine formulations designed for small volume intravenous administration are disclosed. The methods conveniently allow shorter administration time without the active ingredient coming out of solution as compared to presently available formulations.

Bendamustine Purity at 25°C

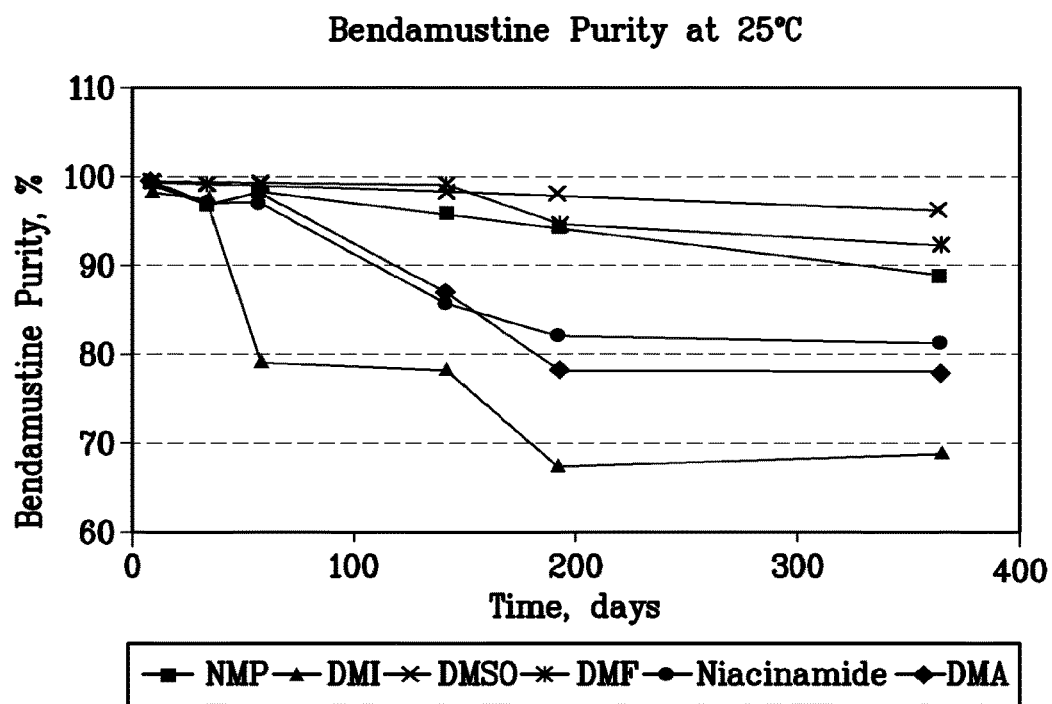
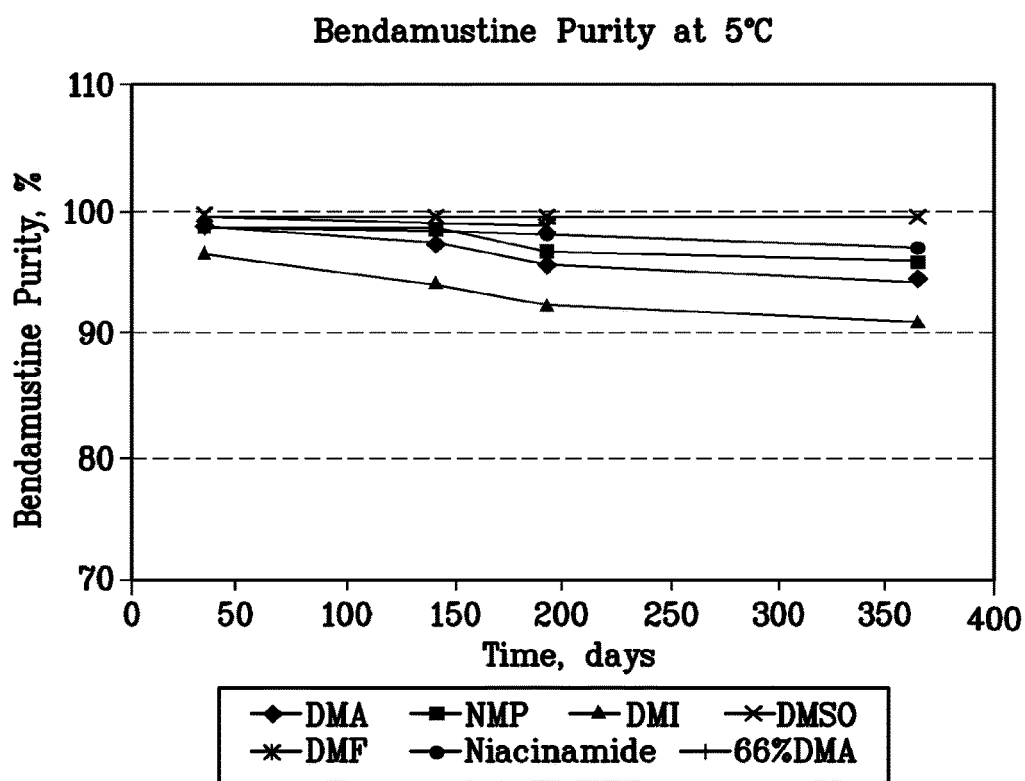
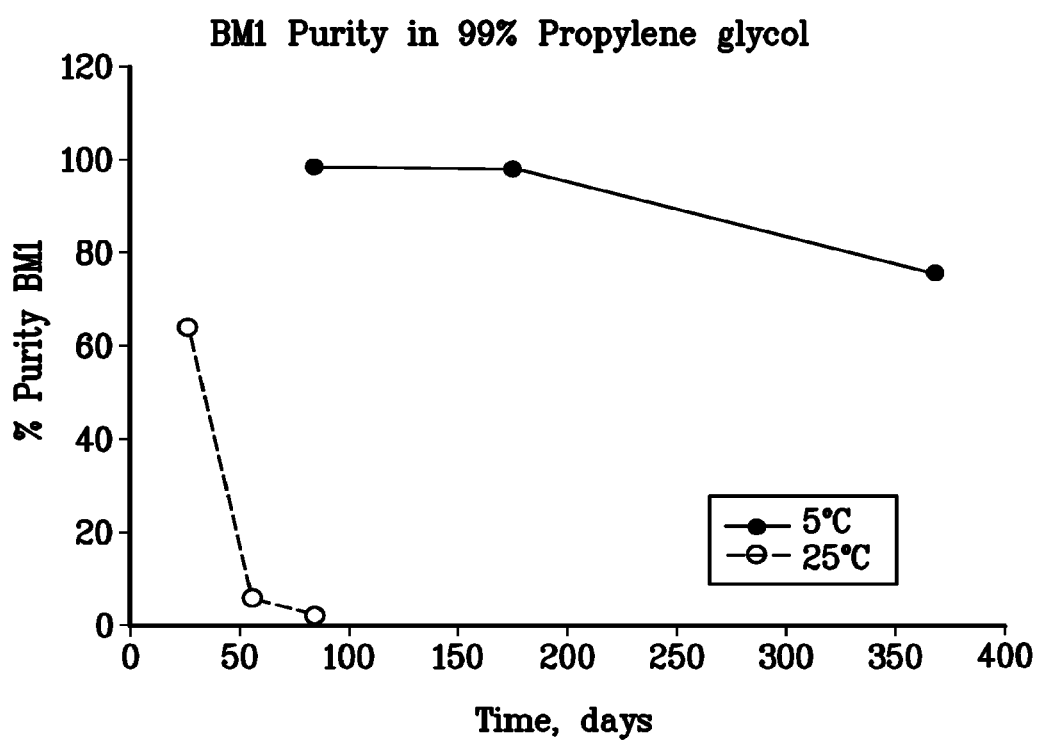
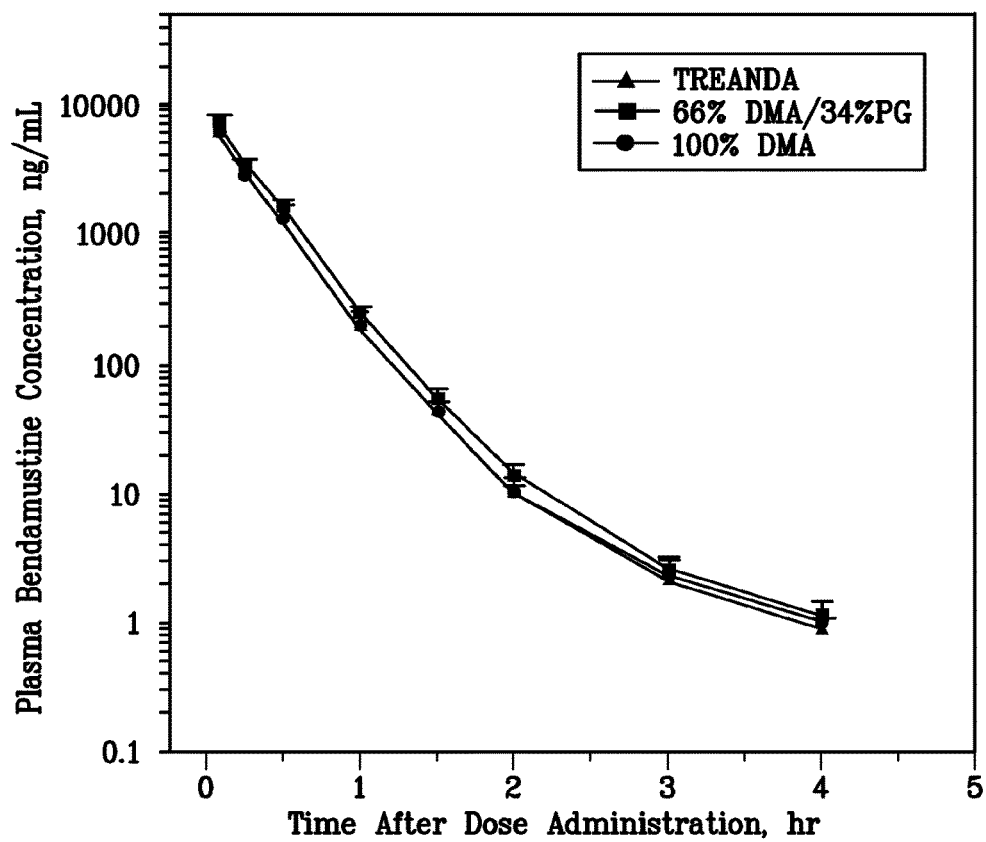


FIG. 1

*FIG. 2*

*FIG. 3*

*FIG. 4*

FORMULATIONS OF BENDAMUSTINE

CROSS-REFERENCE TO RELATED APPLICATIONS

[0001] This application is a continuation of copending U.S. application Ser. No. 15/432,378, filed Feb. 14, 2017, which is a continuation of U.S. application Ser. No. 14/857,064, filed Sep. 17, 2015, now U.S. Pat. No. 9,597,397, which is a continuation of U.S. application Ser. No. 14/714,578, filed May 18, 2015, now U.S. Pat. No. 9,144,568, which is a continuation of U.S. application Ser. No. 13/838,090, filed Mar. 15, 2013, now U.S. Pat. No. 9,034,908, which claims the benefit of priority from U.S. Provisional Patent Application Nos. 61/613,173, filed Mar. 20, 2012, and 61/669,889, filed Jul. 10, 2012, the disclosures of which are incorporated herein by reference.

BACKGROUND OF THE INVENTION

[0002] Bendamustine is used in the treatment of a number of cancers including leukemias, Hodgkin's disease and multiple myelomas. Bendamustine (present as the HCl salt) is the active ingredient of the commercial product Treanda™, a lyophilized powder for reconstitution. Current labeling requirements call for the reconstituted product to be immediately (within 30 minutes) diluted into 500 mL of parenterally acceptable diluents such as 0.9% saline (normal saline) or 2.5% dextrose/0.45% saline and administered as part of an intravenous infusion delivering 100 mg/m² over 30 minutes or 120 mg/m² over 60 minutes. The diluted admixture may be stored at 2-8° C. for up to 24 hours, or 3 hours at room temperature (15-30° C.); administration must be completed within this period due to limited chemical stability in aqueous solutions.

[0003] Solubility limitations at 2-8° C. with currently approved and/or available formulations are believed to prevent current formulations from being administered in smaller more concentrated infusion volumes up to about 150 ml; at volumes below 150 ml, solubility is not sufficient even at 25° C. Side effects associated with extravasation and local erythema, swelling and pain at the injection site also dictate that the infusion be as dilute as possible. Therefore, precautions are taken to avoid extravasation, including monitoring of the intravenous infusion site for redness, swelling, pain, infection, and necrosis during and after administration of bendamustine. Higher infusion volume and longer infusion times, however, are associated with many drawbacks. For example, after reconstitution, the current product has a short period of stability, degradation of the drug occurs from the time of reconstitution until the entire large volume infusion has been completely administered. The current label for Treanda™ therefore instructs that the admixture should be prepared as close as possible to the time of patient administration, and that administration of Treanda™ must be completed within the durations indicated above. From patient comfort and nursing administration points of view, higher infusion volumes and long infusion times are undesirable. Higher infusion volumes may be associated with higher likelihood of weight gain and edema. Shorter infusion times and smaller infusion volumes result in a better quality of life experience for the patient by reducing the overall "stress" to the patient and reducing the time spent in the infusion clinic. Shorter infusion times (and smaller volumes) also reduce the potential extravasation (and

shorten the patient monitoring time required). It would be advantageous if the drug could be administered in smaller volumes and over shorter times. The present invention addresses these needs.

SUMMARY OF THE INVENTION

[0004] In a first aspect of the invention there are provided methods of treating or preventing cancer or malignant disease in a subject such as a human. The methods include parenterally administering a volume of about 325 ml or less of a liquid composition containing:

[0005] a) from about 0.05 to about 12.5 mg/ml of bendamustine or a pharmaceutically acceptable salt thereof;

[0006] b) a solubilizer comprising polyethylene glycol and propylene glycol; and

optionally

[0007] c) a parenterally acceptable diluent;

over a substantially continuous period of less than or equal to about 30 minutes to a subject in need thereof.

[0008] In alternative aspects of the invention there are provided methods of treating or preventing a bendamustine-responsive condition in a subject such as a human. In a first embodiment the methods include administering less than or equal to 325 ml of a liquid composition which contains

Ingredient	Concentration Range (mg/ml)
Bendamustine HCl	0.05 to 1.6
Solubilizer 1 propylene glycol	0.30 to 6.5
Solubilizer 2 PEG 400	3.3 to 65
Monothioglycerol	0.02 to 0.35
NaOH	0.0 to 0.01

over a substantially continuous period of less than or equal to about 30 minutes to a subject in need thereof.

[0009] In a related second embodiment of this aspect of the invention, the methods include administering less than or equal to 325 ml of a liquid composition which contains

Ingredient	Concentration Range (mg/ml)
Bendamustine HCl	1.1 to 12.5
Solubilizer 1 propylene glycol	4.5 to 51
Solubilizer 2 PEG 400	45 to 500
Monothioglycerol	0.2 to 2.5
NaOH	0.0 to 0.04

over a substantially continuous period of less than or equal to about 30 minutes to a subject in need thereof.

[0010] The methods of the present invention take advantage of the fact that the concentration of the bendamustine HCl is below the room temperature solubility limit of the vehicle into which it is placed. As a result, the bendamustine does not precipitate during administration to the patient thereby substantially avoiding the side effects which would otherwise occur during small volume administration of therapeutic doses of the drug. In addition, patients or subjects with bendamustine-responsive conditions can be treated using substantially smaller parenteral volumes which are well below the standard 500 ml administration volume.

BRIEF DESCRIPTION OF THE DRAWINGS

[0011] FIG. 1 is a graph of a stability analysis of bendamustine in various solvents at 25° C.

[0012] FIG. 2 is a graph of a stability analysis of bendamustine in various solvents at 5° C.

[0013] FIG. 3 is a graph of bendamustine purity, over time, in 99% propylene glycol, at 5° C. and at 25° C.

[0014] FIG. 4 shows the mean±standard deviation concentration-versus-time profiles of bendamustine in male Cynomolgus monkeys (N=4) administered single 3 mg/kg bolus intravenous doses of bendamustine hydrochloride in 3 different formulations.

DETAILED DESCRIPTION OF THE INVENTION

[0015] Unless defined otherwise, all technical and scientific terms used herein have the same meaning as is commonly understood by one of ordinary skill in the art to which this invention belongs. In the event that there is a plurality of definitions for a term herein, those in this section prevail unless stated otherwise.

[0016] In a first aspect of the invention there are provided methods of treating or preventing cancer or malignant disease in a subject or patient who is preferably a human. The methods generally include parenterally administering a volume of about 325 ml or less of a liquid composition containing:

[0017] a) from about 0.05 to about 12.5 mg/ml of bendamustine HCl or a pharmaceutically acceptable salt thereof, the HCl salt being preferred;

[0018] b) a solubilizer comprising polyethylene glycol and propylene glycol; and optionally

[0019] c) a parenterally acceptable diluent; over a substantially continuous period of less than or equal to about 30 minutes to a subject in need thereof.

[0020] The solubilizer portion of the formulation preferably includes from about 0.3 to about 45% volume polyethylene glycol (PEG) and from about 0.03 to about 5% volume propylene glycol (PG), as calculated on the basis of the total or final volume administered. Stated alternatively, the final concentration of the PEG generally ranges from about 3 to about 500 mg/ml, while the final concentration of the PG generally ranges from about 0.5 to about 51 mg/ml. Within these general ranges, certain aspects of the invention include concentration ranges for the PEG of from about 45 to about 500 mg/ml or from about 3.3 to about 63.3 mg/ml; and for the PG ranges of from about 4.7 to about 50.6; or from about 0.02 to about 6.5 mg/ml.

[0021] In some aspects of the invention, the bendamustine is administered intravenously as part of an intravenous infusion. Contemplated infusion volumes are preferably less than 325 ml with volumes such as about 250 ml, 100 ml, and 50 ml, with each volume varying about +/−10% or +/−15% being preferred in some embodiments. In alternative aspects of the invention, the intravenous administration volume is suitable for IV bolus administration and may also include an amount of pharmaceutically acceptable diluent such as normal saline or one of the other diluents described herein which does not cause the solubility of the vehicle to fall below the concentration of the bendamustine. Stated alternatively, the final concentration of the bendamustine will be below the solubility of the combination vehicle containing

the mixture of propylene glycol and PEG and diluent. While most aspects of the invention are described in the context of administering less than about 325 ml including all vehicle ingredients, excipients, etc., it should be appreciated that volumes as low as a few milliliters, e.g. about 2, can be used so long as the vehicle includes sufficient solubilizers to preserve the solubility of the bendamustine therein during administration to the patient.

[0022] For purposes of the present invention, the word “about” when used to modify infusion volumes or concentrations shall be understood to include values which may vary by amounts of about +/−10% or 15%. In certain embodiments where the infusion volume is about 50 ml, the concentration of the bendamustine HCl or other pharmaceutically acceptable salt thereof is preferably from about 0.5 to about 5.6 mg/ml. In embodiments where the infusion volume is about 100 ml, the concentration of the bendamustine HCl or other pharmaceutically acceptable salt thereof can be preferably from about 0.1 to about 3.2 mg/ml. Similarly, in some aspects of the invention where the infusion volume is about 250 ml, the concentration of the bendamustine HCl or other pharmaceutically acceptable salt thereof is from about 0.05 to about 1.4 mg/ml.

[0023] The solubilizer is preferably a mixture of polyethylene glycol, hereinafter “PEG” and propylene glycol, hereinafter “PG”. The solubilizer can also optionally include an antioxidant such as monothioglycerol. The amount of antioxidant included is a formulation stabilizing amount, which, in the case of monothioglycerol ranges from about 2 to about 10 mg/ml. The PEG preferably has a molecular weight of about 400, i.e. PEG 400. Other molecular weight PEG’s known to those of ordinary skill can be included if desired in alternative embodiments.

[0024] Certain aspects of the invention call for the ratio of the PEG to PG found in the solubilizer to be about 90:10. In alternative aspects, the ratio of the PEG to PG is about 85:15.

[0025] In some aspects of the invention, the total amount of solubilizer, i.e. blend of PEG and PG, included in infusion volumes of about 100-115 ml is from about 0.5 to about 26.5% vol.; while amounts of from about 0.2 to about 5% vol. for the solubilizer are preferably included in infusion volumes of about 250-265 ml; with solubilizer amounts of from about 2.0 to about 22.4% vol. included in infusion volumes of about 50-65 ml.

[0026] Since the solubilizer is a blend, the amount of PEG and PG in various volumes (calculated as % vol.) can be as follows:

Solubilizer	50 ml	100 ml	250 ml
PEG	20.12	11.33	4.9
PG	2.24	1.26	0.54

[0027] In some preferred embodiments, the methods of the invention are advantageously carried out using bendamustine HCl containing compositions administered as small volume infusions with volumes of about 50 ml or about 100 ml or about 250 ml. Such smaller volumes allow the drug to be administered over a time period of about 10 minutes or less as part of an intravenous infusions containing a volume of about 50 ml; about 15 minutes or less as part of an intravenous infusions containing a volume of about 100 ml or when volumes of about 250 ml are infused, the IV

infusion is administered over a time period of about 30 minutes or less. Depending upon the amount of drug administered, the IV bolus volumes containing sufficient amount of the drug will be less than 50 ml, with amounts of about 10 or 15 to 30 ml being sufficient.

[0028] The infusible compositions in many aspects of the invention will also preferably include the parenterally acceptable diluents such as water for injection (WFI), 0.9% saline (normal saline, preferred), 0.45% saline (half normal saline) or 2.5% dextrose/0.45% saline. Formulations well suited for carrying out the methods described herein are also described in commonly assigned U.S. patent application Ser. No. 13/016,473, filed Jan. 28, 2011, and Ser. No. 13/767,672 filed Feb. 14, 2013, the contents of which are incorporated herein by reference. As reviewed in the '672 patent application, some preferred bendamustine formulations can also include a minor amount of a pH adjuster such as sodium formate, sodium phosphate, potassium hydroxide, phosphoric acid or, preferably, sodium hydroxide.

[0029] In an alternative embodiment of the invention, the bendamustine formulations used in the methods described herein can be one or more of those described in U.S. Pat. Nos. 8,344,006 and 8,076,366; and US Published Patent Application Nos. 2013/0041004; 2012/0071532; 2010/0216858; 2006/0159713; and 2013/0041003, the contents of each of which are incorporated herein by reference. It being understood that the vehicle into which the bendamustine HCl is placed will have sufficient bendamustine solubility which exceeds the concentration of the drug included therein.

[0030] For example, U.S. Published Patent Application No. 2010/0216858 discloses a composition comprising: (a) bendamustine, (b) a charged cyclopolysaccharide, and (c) a stabilizing agent having a charge opposite to that of the cyclopolysaccharide.

[0031] Preferably, the proportion of active ingredient to cyclopolysaccharide, by weight, is between about 1:12,500 and about 1:25; is more preferably between about 1:5,000 and about 1:50; is even more preferably between about 1:2,500 and about 1:75 and most preferably between about 1:1,500 and 1:100.

[0032] The stabilizing agent is typically present in a weight ratio to the cyclopolysaccharide of between about 5:1 and about 1:1000; preferably of between about 2:1 and about 1:200.

Cyclopolysaccharides

[0033] The cyclopolysaccharides which may be employed in the practice of this invention include cyclodextrins, cyclomannins, cycloaltrins, cyclofructins and the like. In general, cyclopolysaccharides comprising between 6 and 8 sugar units are preferred.

[0034] Among the preferred cyclopolysaccharides which may be employed are cyclodextrins.

[0035] Cyclodextrins are cyclic oligo-1-4- α -D-glucopyranoses comprising at least 6 sugar units. The most widely known are cyclodextrins containing six, seven or eight sugar units. Cyclodextrins containing six sugar units are known as α -cyclodextrins, those containing seven sugar units are known as β -cyclodextrins and those consisting of eight sugar units are known as γ -cyclodextrins. Particularly preferred cyclopolysaccharides are β -cyclodextrins.

[0036] The cyclopolysaccharides employed are modified with one or more chargeable groups. Such chargeable groups may be anionic, in which case the stabilizing agent is cationic; or such charged groups may be cationic, in which case the stabilizing agent is anionic. Preferred anionic groups include carboxyl, sulfonyl and sulphate groups; while preferred cationic groups include quarternary ammonium groups.

[0037] As employed herein the term "charged cyclopolysaccharide" refers to a cyclopolysaccharide having one or more of its hydroxyl groups substituted or replaced with a chargeable moiety. Such moiety may itself be a chargeable group (e.g., such as a sulfonyl group) or it may comprise an organic moiety (e.g., a C_1 - C_6 alkyl or C_1 - C_6 alkyl ether moiety) substituted with one or more chargeable moieties. Preferred substituted cyclopolysaccharides include, but are not limited to, sulfobutyl ether β -cyclodextrin, β -cyclodextrin substituted with 2-hydroxy-N,N,N-trimethylpropanammonium, carboxymethylated- β -cyclodextrin, O-phosphated- β -cyclodextrin, succinyl-(2-hydroxy)propyl- β -cyclodextrin, sulfopropylated- β -cyclodextrin, heptakis(6-amino-6-deoxy) β -cyclodextrin, O-sulfated- β -cyclodextrin, and 6-monodeoxy-6-mono(3-hydroxy)propylamino- β -cyclodextrin; with sulfobutyl ether β -cyclodextrin being particularly preferred.

Cationic Stabilizing Agents

[0038] In those embodiments wherein the cyclopolysaccharide is modified with anionic groups, the stabilizing agent is selected from cationic agents, or from polycationic compounds. Cationic agents which may be employed include primary amines, secondary amines, tertiary amines or quaternary ammonium compounds, such as N-alkyl-N,N-dimethylamines, N-alkyl-N,N-diethylamines, N-alkyl-N,N-diethanolamines, N-alkylmorpholine, N-alkylpiperidine, N-alkylpyrrolidine, N-alkyl-N,N,N-trimethylammonium, N,N-dialkyl-N,N-dimethylammonium, N-alkyl-N-benzyl-N,N-dimethylammonium, N-alkyl-pyridinium, N-alkyl-picolinium, alkylamidomethylpyridinium, carbalkoxy-pyridinium, N-alkylquinolinium, N-alkylisoquinolinium, N,N-alkylmethylpyrrolidinium, and 1-alkyl-2,3-dimethylimidazolium. Particularly preferred cationic adjuvants include sterically hindered tertiary amines, such as N-alkyl-N,N-diisopropylamine, N-alkylmorpholine, N-alkylpiperidine, and N-alkylpyrrolidine; and quaternary ammonium compounds such as cetylpyridinium chloride, benzyltrimethyldecylammonium chloride, dodecylpyridinium chloride, hexadecyltrimethylammonium chloride, benzyltrimethyltetradecylammonium chloride, octadecyltrimethylbenzylammonium chloride, and domiphen bromide.

[0039] Polycationic compounds such as oligo- or polyamines, or pegylated oligo- or polyamines may also be employed as the stabilizing agent. Preferred polycationic compounds include oligoamines such as spermine, spermidin, putrescine, and cadaverine; polyamines: such as polyethyleneimine, polyspermine, polyputrescine, and polycadaverine; and pegylated oligoamines and polyamines of the group listed above. Particularly preferred is PI2080, polyethyleneimine 2000 conjugated with PEG 8000.

[0040] One preferred class of cationic stabilizing agents are polypeptides comprising from about 5 to about 50, more preferably between about 6 and about 20, amino acids;

wherein at least about 50% of such amino acids contain a positive charge. Most preferably, such charged amino acid is arginine. Particularly preferred members of this class of peptides include arginine rich peptides comprising at least one block sequence of 4 arginines. Another particularly preferred member of this class of peptides is protamine which has been digested with thermolysin (hereinafter referred to as Low Molecular Weight Protamine or "LMWP").

[0041] Hydrophobically modified oligo- or polyamines may also be employed. Preferred stabilizing agent of this type include acetyl spermine, acetyl polyspermine, acetyl polyethyleneimine, butyryl spermine, butyryl polyspermine, butyryl polyethyleneimine, lauroyl spermine, lauroyl polyspermine, lauroyl polyethyleneimine, stearyl spermine, stearyl polyspermine, and stearyl polyethyleneimine,

[0042] In addition, cationic polysaccharides and synthetic polycationic polymers may also be employed. Illustrative of such cationic polysaccharides are chitosan, deacetylated chitosan, quaternized cellulose, quaternized amylose, quaternized amylopectine, quaternized partially hydrolyzed cellulose, quaternized partially hydrolyzed amylose and quaternized partially hydrolyzed amylopectine. Illustrative of such synthetic polycationic polymers are Polyquaternium 2 (poly[bis(2-chloroethyl)ether-alt-1,3-bis[3-dimethylamino)propyl]-urea quaternized); Polyquaternium 11 (poly(l-vinylpyrrolidone-co-dimethylammonioethyl methacrylate) quaternized); Polyquaternium 16 and 44 (copolymer of vinylpyrrolidone and quaternized vinylimidazole); and Polyquaternium 46 (copolymer of vinylcaprolactam, vinylpyrrolidone and quaternized vinylimidazole).

Anionic Stabilizing Agents

[0043] In those embodiments wherein the cyclopolysaccharide is modified with cationic groups, the stabilizing agent is selected from anionic agents, or from polyanionic polymers.

[0044] Preferably, such anionic agent is selected from compounds comprising a carboxy-, sulfate-, sulfono-, phosphate-, or phosphono-group.

[0045] One class of anionic agents that may be employed are anionic surfactants such as sodium 3-[(3-cholamidopropyl)dimethylammonio]-1-propanesulfonate, sodium N-lauroylsarcosinate, sodium dodecyl sulfate, sodium dodecylbenzylsulfonate and the like.

[0046] Cationic polysaccharides may also be employed as the stabilizing agent. Illustrative of such compounds are chondroitin sulfate, dermatan sulphate, kappa-carrageenan, iota-carrageenan, lambda-carrageenan, mu-carrageenan, xi-carrageenan, psi-carrageenan, tau-carrageenan, fucellaran, heparan sulphate, keratin, fucoidan, hyaluronic acid, alginic acid, poly(sulfonylbutylo)cellulose, poly(sulfonylpropylo)cellulose, poly(sulfonylpropylo)dextran, poly(sulfonylbutylo)dextran, poly(sulfonylbutylo)amylase and poly(sulfonylpropylo)amylase.

[0047] The stabilizing agent may also be a polyanionic polymer selected from polyacrylates, polymethacrylates, and their copolymers.

Excipients

[0048] The compositions of this invention may further contain pharmaceutically acceptable excipients, such as sugars, polyalcohols, soluble polymers, salts and lipids.

[0049] Sugars and polyalcohols which may be employed include, without limitation, lactose, sucrose, mannitol, and sorbitol.

[0050] Illustrative of the soluble polymers which may be employed are polyoxyethylene, poloxamers, polyvinylpyrrolidone, and dextran.

[0051] Useful salts include, without limitation, sodium chloride, magnesium chloride, and calcium chloride.

[0052] Lipids which may be employed include, without limitation, fatty acids, glycerol fatty acid esters, glycolipids, and phospholipids.

Preparation

[0053] The composition of the invention may be prepared by the dissolution of solid bendamustine in an aqueous solution of the cyclopolysaccharide; or by mixing an aqueous solution of the cyclopolysaccharide with an aqueous stock solution of bendamustine. Such resulting mixture is vigorously mixed and optionally subjected to the action of ultrasound waves to obtain an homogenous and equilibrated aqueous solution. When the cyclopolysaccharide is a cyclodextrin, it is preferred that the aqueous solution of cyclodextrin used for the preparation of composition contains at least 4% of cyclodextrin; more preferably such solution contains at least 10% of cyclodextrin.

[0054] The stabilizing agent and excipient (if present) are preferably introduced to the composition by their addition to a pre-prepared aqueous homogenous and equilibrated solution of bendamustine with the cyclopolysaccharide. Such agents may be added either as pure substances or as aqueous solutions and are preferably mixed employing gentle agitation.

[0055] Preferably, the final composition is filtered before use for injection.

[0056] The composition may be optionally freeze-dried to produce a solid material suitable for dissolution in injection media before its use. It is preferred that compositions comprising amines as stabilizing agents are freeze dried prior to the addition of such stabilizing agent, with such agent being introduced into the composition after reconstitution, shortly before use.

[0057] In one embodiment the composition of this invention is prepared by mixing the components and incubation.

[0058] In another embodiment the composition of this invention is prepared by mixing the components and applying ultrasound to the mixture.

[0059] In another embodiment the composition of this invention is prepared by mixing the components, incubation, and freeze-drying the product.

[0060] In a preferred embodiment the composition of this invention is prepared by mixing the components, applying ultrasound to the mixture, and freeze-drying the product.

[0061] The compositions of this invention demonstrate enhanced stability in aqueous solution and when introduced into plasma, both under in vitro and under in vivo conditions. Thus, such formulations will exhibit a half-life in plasma which is greater than that of non-formulated bendamustine; which half-life may be extended by more than 50% and preferably more than 100%.

[0062] In addition, the compositions of this invention exhibit unexpectedly improved activity against tumors relative to compositions comprising bendamustine and a cyclopolysaccharide; as well as relative to bendamustine alone.

[0063] In other aspects, U.S. Pat. No. 8,344,006 discloses that pharmaceutically acceptable liquid formulations of bendamustine, and the pharmaceutically acceptable salts thereof, in particular the hydrochloride salt, can be prepared by combining bendamustine, or the pharmaceutically acceptable salt thereof, with a polar aprotic solvent or mixture of polar aprotic solvents. Polar, aprotic solvents are known in the art and include, for example, 1-methyl-2-pyrrolidone, 1,3-dimethyl-2-imidazolidinone, dimethylacetamide, dimethyl sulfoxide, acetone, tetrahydrofuran, 1,4-dioxane, acetonitrile, dimethyl formamide, propylene carbonate. See also, e.g., Florence Mottu, et al. *Organic solvents for pharmaceutical parenterals and embolic liquids: A review of toxicity data*, PDA J. Pharma. Sci. & Tech. vol 54, no. 6, 456-469 (November-December 2000). Particularly preferred polar aprotic solvents include dimethylacetamide, dimethyl sulfoxide, and mixtures thereof.

[0064] Without wishing to be held to any particular theory, it is believed that polar, aprotic solvents are sufficiently non-nucleophilic towards bendamustine such that polar aprotic solvent-bendamustine adducts do not form over the course of typical commercial storage conditions. Typical commercial storage conditions include time periods of, for example, about 30 days, about 90 days, about 180 days, and about 365 days (about 1 month, about 3 months, about 6 months, and about 1 year). Typical commercial storage conditions also include temperatures of about 23° C. (ambient room temperature) and refrigerated temperatures below ambient room temperature, for example, about 5° C. Preferably, the liquid formulations of the present invention are stored at refrigerated temperatures.

[0065] It has also been discovered that stable formulations of bendamustine can be obtained by mixing a polar aprotic solvent, or a mixture of polar aprotic solvents, with a non-aqueous polar protic solvent or mixture of nonaqueous polar protic solvents. Pharmaceutically acceptable nonaqueous polar protic solvents are known in the art and include alkyl alcohols, for example, ethanol, ethylene glycol, propylene glycol, butylene glycol, glycerin, polysorbates, for example TWEEN 20, TWEEN 40, and TWEEN 80, and cyclodextrins (such as hydroxypropyl- β -cyclodextrin), polyalkylene glycols, such as polyethylene glycol, polypropylene glycol, and polybutylene glycol, and primary amides such as niacinamide.

[0066] Such formulations will typically comprise 90% or less, by volume of the formulation, of the nonaqueous polar protic solvent. In other preferred embodiments, formulations will comprise between about 20% and about 85%, by volume of the formulation, of the nonaqueous polar protic solvent. In still other embodiments, formulations will comprise between about 30% and about 70%, by volume of the

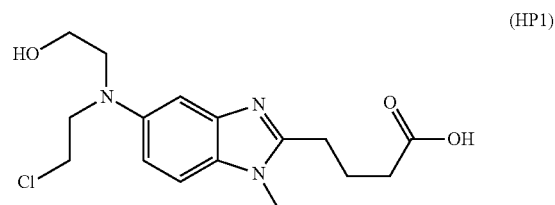
formulation, of the nonaqueous polar protic solvent. In most preferred embodiments, formulations will comprise about 80%, about 67% or about 34%, by volume of the formulation, of the nonaqueous polar protic solvent.

[0067] Alternatively, formulations of the present invention will comprise 10 moles per liter, or less, of the nonaqueous polar protic solvent. Preferably, formulations of the present invention will comprise between about 4 moles per liter to about 9.5 moles per liter, of the nonaqueous polar protic solvent. In certain embodiments, formulations will comprise about 9.1 moles per liter of the nonaqueous polar protic solvent. In other embodiments, formulations will comprise about 4.6 moles per liter, of the nonaqueous polar protic solvent.

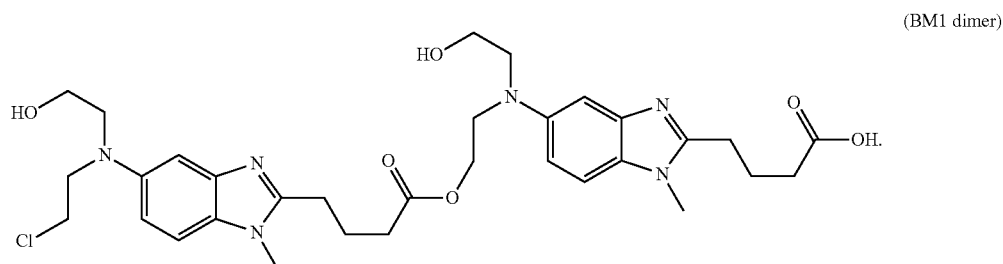
[0068] While not wishing to be held to any particular theory, it is believed that while nonaqueous polar protic solvents are of sufficient nucleophilicity to form potentially undesirable polar protic solvent-bendamustine adducts, such adducts will not form during typical commercial storage if the concentration of the polar protic solvent is kept within the scope of the present invention.

[0069] Liquid formulations of the present invention are stable over the course of a typical commercial storage period. As used herein, “stable” is defined as no more than about a 10% loss of bendamustine under typical commercial storage conditions. Preferably, formulations of the present inventions will have no more than about a 10% loss of bendamustine, more preferably, no more than about a 5% loss of bendamustine, under typical commercial storage conditions.

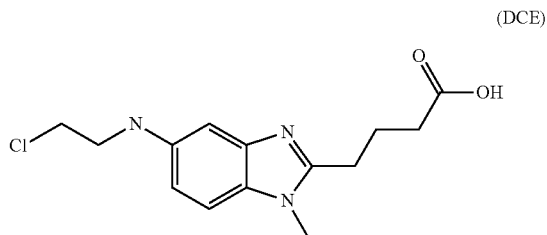
[0070] Bendamustine converts to non-bendamustine products (i.e., “degrades”) upon exposure to certain nucleophiles, for example, water and alkylene glycols such as propylene glycol. Exposure of bendamustine to water can produce “HP1,” which is undesirable.



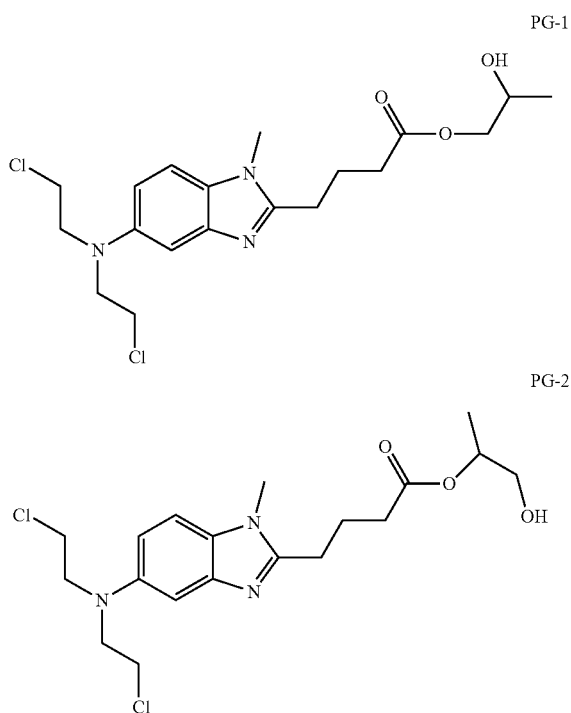
Another undesirable compound that bendamustine can convert to over time is “BM1 dimer.”



Still another undesirable compound that bendamustine can convert to over time is "DCE."



Upon exposure to an alkylene glycol, for example, propylene glycol, esters of bendamustine can form, e.g., PG-1 and PG-2.



[0071] In preferred embodiments of the present invention, analysis of formulations of the present invention will exhibit 1.50% or less of DCE, as determined by HPLC analysis, after about 1 year (about 365 days) at about 5° C. More preferably, the formulations will exhibit 1.0% or less of DCE, as determined by HPLC analysis, after about 1 year (about 365 days) at about 5° C. Even more preferably, the formulations will exhibit 0.5% or less of DCE, as determined by HPLC analysis, after about 1 year (about 365 days) at about 5° C. Most preferably, the formulations will exhibit about 0.1% or less of DCE, as determined by HPLC analysis, after about 1 year (about 365 days) at about 5° C.

[0072] In other embodiments of the present invention, analysis of the formulations will exhibit about 0.4% or less of HP1, as determined by HPLC analysis, after about 1 year (about 365 days) at about 5° C. Preferably, the formulations

will exhibit about 0.10% or less of HP1, as determined by HPLC analysis, after about 1 year (about 365 days) at about 5° C.

[0073] In certain other embodiments of the present invention, analysis of the formulations will exhibit about 0.70% or less of BM1 dimer, as determined by HPLC analysis, after about 1 year (about 365 days) at about 5° C. Preferably, the formulations will exhibit about 0.30% or less of dimer, as determined by HPLC analysis, after about 1 year (about 365 days) at about 5° C. In most preferred embodiments, the formulations will exhibit about 0.10% or less of BM1 dimer, as determined by HPLC analysis, after about 1 year (about 365 days) at about 5° C.

[0074] In those embodiments of the present invention comprising alkylene glycol as the nonaqueous polar protic solvent, analysis of those formulations will exhibit 1.5% or less of alkylene glycol esters of bendamustine, as determined by HPLC analysis, after about 1 year (about 365 days) at about 5° C. For example, in those embodiments comprising propylene glycol, analysis of those formulations will exhibit 1.5% or less of propylene glycol esters PG-1 and PG-2, as determined by HPLC analysis, after about 1 year (about 365 days) at about 5° C.

[0075] Analysis of the liquid formulations of the present invention can be performed using techniques known in the art, including, for example, HPLC, gas chromatography, and NMR. After exposure to typical commercial storage conditions, analysis of the formulations of the present invention will indicate that the formulation contains no less than about 90% of the amount of bendamustine present prior to exposure to the storage conditions. Preferably, analysis will indicate that the formulation contains no less than about 95% of the amount of bendamustine present prior to exposure to the storage conditions.

[0076] In preferred embodiments of the present invention, analysis of the formulations of the present invention will indicate that the formulation contains no less than about 90% of the amount of bendamustine present prior to exposure to storage conditions that include temperatures of about 5° C. and time periods of about 30 days (about 1 month) to about 365 days (about 1 year). Preferably, analysis of the formulations of the present invention will indicate that the formulation contains no less than about 90% of the amount of bendamustine present prior to exposure to storage conditions that include temperatures of about 5° C. and time periods of about 30 days (about 1 month), about 90 days (about 3 months), and about 180 days (about 6 months). Preferably, analysis will indicate that the formulation contains no less than about 95% of the amount of bendamustine present prior to exposure to storage conditions that include temperatures of about 5° C. and time periods of about 30 days (about 1 month) to about 365 days (about 1 year). More preferably, analysis will indicate that the formulation contains no less than about 95% of the amount of bendamustine present prior to exposure to storage conditions that include temperatures of about 5° C. and time periods of about 30 days (about 1 month), about 90 days (about 3 months), and about 180 days (about 6 months).

[0077] Formulations of the present invention can comprise pharmaceutically useful concentrations of bendamustine, or a pharmaceutically acceptable salt thereof. Useful concentrations include concentrations ranging from about 5 mg/mL to about 200 mg/mL. Preferably, the concentration of bendamustine, or a pharmaceutically acceptable salt thereof,

ranges from about 5 mg/mL to about 120 mg/mL. Preferred concentrations include about 5 mg/mL, about 10 mg/mL, about 20 mg/mL, about 30 mg/mL, about 40 mg/mL, about 50 mg/mL, about 60 mg/mL, about 100 mg/mL and about 200 mg/mL of bendamustine, or a pharmaceutically acceptable salt thereof. Greater than 200 mg/ml of bendamustine, or a pharmaceutically acceptable salt thereof, for example, greater than about 300 mg/mL, are also within the scope of the present invention, as are saturated solutions of bendamustine, or a pharmaceutically acceptable salt thereof.

[0078] In addition to comprising a polar aprotic solvent, or mixture of polar aprotic solvents, and optionally, a nonaqueous polar protic solvent, or mixture of solvents, formulations of the present invention may further comprise other pharmaceutically acceptable excipients. Pharmaceutically acceptable excipients are known in the art and include, for example, antioxidants (e.g., tocopherol (Vitamin E), ascorbic acid, methyl paraben, butylhydroxyanisole (BHA), butylhydroxytoluene (BHT), and propyl gallate), surfactants, (e.g., polysorbates (TWEEN 20, TWEEN 40, TWEEN 80)), lipids (e.g., dimyristoylphosphatidylcholine (DMPC), Dimyristoylphosphatidylglycerol (DMPG), distearoylphosphatidylglycerol (DSPG)), fillers (e.g., mannitol), organic acids (e.g., citric acid, lactic acid, benzoic acid), hydrophilic polymers (e.g., polyethylene glycols (PEG 300, PEG 400)), complexing agents (e.g., niacinamide, nicotinic acid, creatine, cyclodextrins), and preservatives (e.g., benzyl alcohol).

[0079] If desired, a sufficient amount of a concentrated, ready to use liquid formulation such one containing 25 mg/ml bendamustine HCl and already admixed with sufficient solubilizers can be transferred to a suitable fixed volume diluent container such as a bag containing 50, 100, 250 ml normal saline or the like. Alternatively, lyophilized bendamustine HCl can be reconstituted, combined with sufficient solubilizer blends as described herein and administered in accordance with the inventive methods. In such embodiments, the actual amount delivered to the patient will be slightly more than the diluent amount so as to allow for the addition of the drug/solubilizer vehicle.

[0080] In some aspects of the invention, there are provided methods of treating or preventing chronic lymphocytic leukemia (CLL). The small volume infusions can be given as part of any treatment protocol for which bendamustine is included. Thus, the compositions described herein can be administered as part of a poly-pharmaceutical treatment regimen according to known protocols with the exception that the concentrated bendamustine compositions described herein are administered in smaller infusion volumes over significantly shorter administration periods. For example, some CLL treatment regimens can include administering the compositions described herein intravenously as part of about 100 ml infusions in about 20 minutes or less and more preferably in about 15 minutes or less on days 1 and 2 of a 28 day cycle and repeating the cycle up to 6 times or longer if clinically appropriate. If 250 ml volumes are used to deliver the bendamustine, the time of administration is preferably about 30 minutes or less. If 50 ml volumes are used to deliver the bendamustine, the time of administration is preferably about 10 minutes or less.

[0081] In spite of the smaller volumes, the amount of bendamustine HCl administered to the patient in need thereof per dose (infusion or otherwise) in some preferred embodiments is about 100 mg/m². In some alternative

aspects of the invention, the amount of bendamustine HCl administered to the patient in need thereof as part of the 50, 100 or 250 ml infusion is an amount sufficient to provide a dosage of 50 or 25 mg/m². Additional administration dosages will be apparent to those of ordinary skill based upon clinical experience, patient need without undue experimentation.

[0082] In other aspects of the invention, there are methods of treating or preventing the malignant disease of indolent B-cell non-Hodgkin's lymphoma. In these aspects, the composition is administered intravenously as a 100 ml infusion in less than 20 minutes and more preferably in about 15 minutes or less on days 1 and 2 of a 21 day cycle for up to 8 cycles or longer if clinically appropriate. If 250 ml volumes are used to deliver the bendamustine, the time of administration is preferably about 30 minutes or less. If 50 ml volumes are used to deliver the bendamustine, the time of administration is preferably about 10 minutes or less. The amount of bendamustine administered to the subject is preferably about 120 mg/m², although in alternative embodiments, the amount administered ranges from about 90 or 60 mg/m². As will be appreciated, further alternative dosage amounts will be apparent to those of ordinary skill based upon clinical experience, patient need without undue experimentation.

[0083] It will be appreciated by those skilled in the art that the above-mentioned dosages calculated in mg/m² for purposes of body surface area (BSA) are consistent with the bendamustine HCl concentrations also described herein, e.g. 0.5 to 5.6 mg/ml. In the alternative, the invention also contemplates IV bolus administration of bendamustine-containing formulations in volumes which can be administered via syringe, e.g. from a few milliliters up to about 50 milliliters, with therapeutic amounts of the drug in a concentration which does not exceed the vehicle solubility for the drug therein.

[0084] Further embodiments of the invention include methods of treating or preventing a bendamustine-responsive condition in a subject such as a human. In a first embodiment, the methods include administering less than or equal to 325 ml of a liquid composition which contains

Ingredient	Concentration Range (mg/ml)
Bendamustine HCl	0.05 to 1.6
Solubilizer 1 propylene glycol	0.30 to 6.5
Solubilizer 2 PEG 400	3.3 to 65
Monothioglycerol	0.02 to 0.35
NaOH	0.0 to 0.01

over a substantially continuous period of less than or equal to about 30 minutes to a subject in need thereof. More preferably, the administration time is well below 30 minutes and the administration time will decrease as the volume administered decreases.

[0085] Bendamustine formulations containing the above ingredients are capable of delivering approximately 25 mg of the drug as the HCl salt in volumes of pharmaceutically acceptable diluent ranging from about 325 ml down to about 15 ml. For example, 1 ml of a bendamustine HCl ready to use liquid available from Eagle Pharmaceuticals containing

Ingredient	Concentration (mg/ml)
Bendamustine HCl	25
PG	103.2
PEG 400	1013.4
Monothioglycerol	5
NaOH	0.08

is combined with 300 ml of a normal saline diluent to provide a final IV infusion containing 301 ml and a bendamustine final concentration of 0.08 mg/ml.

[0086] One ml of the 25 mg/ml Eagle bendamustine HCl is diluted into additional diluent volumes as shown below:

Diluent Volume (ml)	Final Volume (ml)	Final Bendamustine Conc. (mg/ml)
200	201	0.12
100	101	0.25
50	51	0.49
30	31	0.81
15	16	1.56

[0087] The measured solubility of the bendamustine HCl in the diluent/solubilizer combination (50 ml diluent plus 1 ml of 25 mg/ml bendamustine HCl and solubilizers, etc.) at room temperature was 10.5 mg/ml using normal saline and 14.2 mg/ml using half normal saline/dextrose. The solubility of the diluent/solubilizer combination far exceeded the bendamustine concentration, thus assuring the avoidance of precipitated drug prior to or during administration. As will be appreciated by those of ordinary skill, as the concentration of solubilizers increases with respect to the total volume in small administration doses, the solubility of the bendamustine is maintained.

[0088] In a related second embodiment of this aspect of the invention, the methods include administering less than or equal to 325 ml of a liquid composition which contains

Ingredient	Concentration Range (mg/ml)
Bendamustine HCl	1.1 to 12.5
Solubilizer 1 propylene glycol	4.5 to 51
Solubilizer 2 PEG 400	45 to 500
Monothioglycerol	0.2 to 2.5
NaOH	0.0 to 0.04

over a substantially continuous period of less than or equal to about 30 minutes to a subject in need thereof. As was the case above, the administration time will decrease with the decrease in volume administered.

[0089] Bendamustine formulations containing the above ingredients are capable of delivering approximately 360 mg of the drug as the HCl salt in volumes of pharmaceutically acceptable diluent ranging from about 325 ml down to about 15 ml. As was the case above, the measured solubility of the bendamustine HCl in the diluent/solubilizer combination (1 ml drug+solubilizers, etc. and 50 ml diluent) at room temperature was 10.5 mg/ml using normal saline and 14.2 mg/ml using half normal saline/dextrose.

[0090] Instead of using only 1 ml of the above described Eagle 25 mg/ml bendamustine HCl ready to use liquid, 14.4 ml is combined with various amounts of diluent.

Diluent Volume (ml)	Final Volume (ml)	Final Bendamustine Conc. (mg/ml)
300	314.4	1.15
200	214.4	1.68
100	114.4	3.15
50	64.4	5.59
30	44.4	8.11
15	29.4	12.24

[0091] In each case, the solubility of the diluent/solubilizer combination exceeds the bendamustine concentration, thus assuring the avoidance of precipitated drug prior to or during administration.

EXAMPLES

[0092] The following examples serve to provide further appreciation of the invention but are not meant in any way to restrict the effective scope of the invention.

Example 1

[0093] The solubility of bendamustine HCl, obtained from two different sources, in 0.9% saline and 0.9% saline containing from different amounts of a non-aqueous solubilizer comprising a mixture of polyethylene glycol 400 and propylene glycol (in the volume proportion of 90:10) with and without 5 mg/ml monothioglycerol was determined at both room temperature (22-23° C.) and at refrigerated temperature (5° C.). Essentially, an excess of bendamustine HCl was added to solvents comprising of various volume percent of the non-aqueous solubilizer in 0.9% saline, and allowed to equilibrate with shaking for 30 minutes at room temperature, or for 24 hours at refrigerated temperature. At the end of the equilibration step, the suspensions were filtered through a 0.2 micron filter to remove undissolved bendamustine, and the filtrate solutions analyzed for bendamustine HCl content using a HPLC assay; quantification was performed against a bendamustine HCl reference standard. The solubility data are presented in Table 1.

TABLE 1

Solubility of bendamustine HCl in 0.9% saline with various amounts of non-aqueous solubilizer (90:10 PEG400:PG with and without 5 mg/mL monothioglycerol (MTG))					
Dilution Fold	Volume % of Normal Saline	Volume % of Non-aqueous Solubilizer	Solubility of bendamustine HCl (mg/mL) in 90:10 PEG 400/PG		
			Room temperature		
			API Source A	API Source B* B	5° C. API Source A
n/a	100.0	0.0	3.461	3.304	1.175
40	97.5	2.5	3.987	3.889	nd
20	95.0	5.0	4.429	4.204	2.022
13.3	92.5	7.5	nd	4.742	nd
10	90.0	10.0	5.626	5.351	2.431
8	87.5	12.5	nd	5.825	nd
6.7	85.0	15.0	7.012	6.554	2.900
5.7	82.5	17.5	nd	7.641	3.328
5	80.0	20.0	8.642	8.492	3.824
3.3	70.0	30.0	12.006	11.407	nd

*solvent also contained 5 mg/ml monothioglycerol

nd = not determined;

API = active pharmaceutical ingredient

Example 2

[0094] Bendamustine-containing compositions are prepared by adding 5 mg/ml of thioglycerol to a mixture containing 90% polyethylene glycol 400 and 10% propylene glycol. As indicated in the Table 2 below, NaOH may be added to the PEG in an amount sufficient to get apparent pH of greater than or equal to 6.5 as measured using the pH method outlined in the USP monograph for polyethylene glycol (PEG). Bendamustine (BDM) is then added to the sample to a concentration of 10 mg/ml.

TABLE 2

Formulation
BDM - 10 mg/mL
Thioglycerol - 5 mg/mL
PEG 400:PG (90:10)
qs to 1 mL
BDM - 10 mg/mL
Thioglycerol - 5 mg/mL
PEG 400:PG (90:10)
qs to 1 mL
(PEG 400 Treated with NaOH)

[0095] The compositions are then admixed with normal saline based on the total dose of bendamustine HCl, which in turn is based on the patient body surface area (BSA) and the dosing regimen (100 mg/m² for CLL and 120 mg/m² for NLL; although dose modifications of 90, 60, 50, and 25 mg/m² are possible, only the highest two dosing regimens are considered for illustrative purposes, as these result in the highest concentration of bendamustine during infusion). The 100 ml infusion is then made by admixing the dose appropriate volume of the 10 mg/ml solution with a 100 ml portion of normal saline to provide an infusible composition containing the appropriate dose of bendamustine (as the HCl

salt) in the final admixture, which can be administered intravenously over about 15 minutes to a patient in need thereof.

[0096] As seen in Table 3, the concentrations of bendamustine (as HCl salt) and the corresponding volume percent of non-aqueous component are well below the corresponding solubilities at both room temperature and refrigerated temperature as detailed in Table 1. For example, for a 2.0 m² (average) patient dosed at 120 mg/m², the final concentration of bendamustine HCl in a 100 ml admixture is 1.94 mg/mL. This is above the solubility of bendamustine HCl at refrigerated storage conditions in the absence of any non-aqueous components (1.175 mg/ml as shown in Table 1 for 100% normal saline), as would be the case with the currently approved Treanda™ product, thereby precluding preparation and storage of a 100 ml admixture volume at refrigerated conditions. However, the use of the non-aqueous bendamustine formulation described in this example results in the presence of 19.4% of the non-aqueous component in the final admixture, which improves the solubility to about 3.8 mg/mL (solubility of 3.824 mg/mL at 2-8° C. with 20% non-aqueous component, as shown in Table 1). Therefore, the solubility with the non-aqueous formulation is well above the final concentration (of bendamustine HCl) of 1.94 mg/mL, allowing preparation and storage of the 100 ml admixture at refrigerated conditions. In this example, the room temperature solubilities in 100% normal saline and 80% normal saline (with 20% non-aqueous component) are about 3.3 mg/ml and 8.5 mg/ml, respectively (see Table 1), which are also well above the final concentration of 1.94 mg/ml. Therefore, 100 ml admixtures of the non-aqueous formulation described in the example may also be prepared and stored at room temperature. In addition, the non-aqueous formulation of bendamustine described in this example at Table 2 may be diluted into smaller infusion volumes ranging from 250 ml or less, and stored at either room temperature or refrigerated temperature, with bendamustine continuing to remain in solution for extended periods of time as compared to currently available formulations.

TABLE 3

Concentrations of bendamustine (BDM, as HCl salt) and corresponding volume % of non-aqueous (NA) component in the final admixture, for volumes ranging from 100 ml to 250 ml For 10 mg/mL Formulation								
BSA (m ²)	Admix. Volume 250 mL					Admix. Volume 200 mL		
	100 mg/m ² dose			120 mg/m ² dose		100 mg/m ² dose		120 mg/m ² dose
	BDM Conc (mg/ml)	% NA comp.	BDM Conc (mg/ml)	% NA comp.	BDM Conc (mg/ml)	% NA comp.	BDM Conc (mg/ml)	% NA comp.
1.00	0.38	3.8	0.46	4.6	0.48	4.8	0.57	5.7
1.25	0.48	4.8	0.57	5.7	0.59	5.9	0.70	7.0
1.50	0.57	5.7	0.67	6.7	0.70	7.0	0.83	8.3
1.75	0.65	6.5	0.77	7.7	0.80	8.0	0.95	9.5
2.00	0.74	7.4	0.88	8.8	0.91	9.1	1.07	10.7
2.25	0.83	8.3	0.97	9.7	1.01	10.1	1.19	11.9
2.50	0.91	9.1	1.07	10.7	1.11	11.1	1.30	13.0
2.75	0.99	9.9	1.17	11.7	1.21	12.1	1.42	14.2
3.00	1.07	10.7	1.26	12.6	1.30	13.0	1.53	15.3

TABLE 3-continued

Concentrations of bendamustine (BDM, as HCl salt) and corresponding volume % of non-aqueous (NA) component in the final admixture, for volumes ranging from 100 ml to 250 ml For 10 mg/mL Formulation								
Admix. Volume 150 mL					Admix. Volume 100 mL			
100 mg/m ² dose			120 mg/m ² dose		100 mg/m ² dose		120 mg/m ² dose	
BSA (m ²)	BDM Conc (mg/ml)	% NA comp.	BDM Conc (mg/ml)	% NA comp.	BDM Conc (mg/ml)	% NA comp.	BDM Conc (mg/ml)	% NA comp.
1.00	0.63	6.3	0.74	7.4	0.91	9.1	1.07	10.7
1.25	0.77	7.7	0.91	9.1	1.11	11.1	1.30	13.0
1.50	0.91	9.1	1.07	10.7	1.30	13.0	1.53	15.3
1.75	1.04	10.4	1.23	12.3	1.49	14.9	1.74	17.4
2.00	1.18	11.8	1.38	13.8	1.67	16.7	1.94	19.4
2.25	1.30	13.0	1.53	15.3	1.84	18.4	2.13	21.3
2.50	1.43	14.3	1.67	16.7	2.00	20.0	2.31	23.1
2.75	1.55	15.5	1.80	18.0	2.16	21.6	2.48	24.8
3.00	1.67	16.7	1.94	19.4	2.31	23.1	2.65	26.5

Example 3

[0097] The procedures of Example 2 are repeated except that the dose appropriate volume of the 10 mg/ml bendamustine solution is diluted into 250 ml of normal saline. The final concentration of bendamustine in the 250 ml volume container ranges from about 0.05 mg/ml to about 1.3 mg/ml.

Example 4

[0098] The approximately 100 ml bendamustine HCl infusion of Example 2 is administered to a patient in about 15 minutes.

Example 5

[0099] Bendamustine-containing compositions may be prepared by adding 5 mg/ml of thioglycerol to 90% polyethylene glycol 400 and 10% propylene glycol. As indicated in the Table 4 below, NaOH may be added in an amount sufficient to get apparent pH of greater than or equal to 6.5 as measured using the pH method outlined in the USP monograph for polyethylene glycol (PEG). Bendamustine is then added to the sample to a concentration of 25 mg/ml as indicated in Table 4 below.

TABLE 4

Formulation
BDM - 25 mg/mL
Thioglycerol - 5 mg/mL
PEG 400:PG (90:10)
qs to 1 mL
BDM - 25 mg/mL
Thioglycerol - 5 mg/mL
PEG 400:PG (90:10)
qs to 1 mL
(PEG 400 Treated with NaOH)

[0100] The compositions are then admixed with normal saline based on the total dose of bendamustine HCl, which in turn is based on the patient body surface area (BSA) and the dosing regimen (100 mg/m² for CLL and 120 mg/m² for NLL; although dose modifications of 90, 60, 50, and 25 mg/m² are possible, only the highest two dosing regimens

are considered for illustrative purposes, as these result in the highest concentration of bendamustine during infusion). Table 5 below provides the final concentration of bendamustine (as the HCl salt) in the final admixture, for volumes ranging from 250 ml to 50 ml.

[0101] As seen in Table 5, the concentrations of bendamustine (as HCl salt) and the corresponding volume percent of non-aqueous component are well below the corresponding solubilities at room temperature as detailed in Table 1, for all admixture volumes up to 50 ml. For example, for a 2.0 m² (average) patient dosed at 120 mg/m², the final concentration of bendamustine HCl in a 50 ml admixture is 4.03 mg/ml. This is above the solubility of bendamustine HCl at both refrigerated and room temperature conditions in the absence of any non-aqueous components (1.175 mg/ml at 2-8° C. and 3.304-3.461 mg/ml at room temperature, as shown in Table 1 for 100% normal saline), as would be the case with the currently approved Treanda product, thereby precluding preparation and storage of a 50 ml admixture volume. However, the use of the non-aqueous bendamustine formulation described in this example results in the presence of 16.1% of the non-aqueous component in the final admixture, which improves the room temperature solubility to about 6.5 mg/ml (solubility of 6.554 mg/ml and 7.012 mg/ml with 15% non-aqueous component, as shown in Table 1). Therefore, the solubility with the non-aqueous formulation is well above the final concentration (of bendamustine HCl) of 4.03 mg/mL, allowing preparation and storage of the 100 ml admixture at room temperature conditions. Therefore, the non-aqueous formulation of bendamustine described in this example may be diluted into smaller infusion volumes ranging from 250 ml or less, with bendamustine continuing to remain in solution if maintained at room temperature. However, at refrigerated temperatures, the concentrations of bendamustine (as HCl salt) and the corresponding volume percent of non-aqueous component exceed the corresponding solubilities as detailed in Table 1, for all admixture volumes equal to or below 150 ml. In the scenario above, the solubility at refrigerated conditions with 15% non-aqueous component has improved to 2.9 mg/ml but is still below the final concentration of 4.03 mg/ml. Therefore, 50 ml admixtures of the non-aqueous formulation described in the example cannot be prepared and stored at refrigerated tem-

peratures. However, for a 150 ml admixture, the final concentration of bendamustine HCl in this scenario is 1.5 mg/ml with about 6.0% non-aqueous component, which is below the solubility limit (of 2.022 mg/ml at 5% non-aqueous at 2-8° C.). Therefore, the non-aqueous formulation of bendamustine described in this example may be diluted into smaller infusion volumes ranging from 250 ml to 50 ml, and stored at only room temperature (but not refrigerated temperature), with bendamustine continuing to remain in solution. For storage at refrigerated temperatures, the minimum admixture volume that can be used is 150 ml or higher.

when admixed with 250 ml and 100 ml of normal saline, was assessed. The hemolysis study was conducted at the highest final bendamustine HCl concentrations expected at these admixture volumes, namely, for a 3.0 m² patient dosed at 120 mg/m². At this dosing, the final bendamustine HCl concentration for 250 ml and 100 ml admixture volumes is 1.36 mg/ml and 3.15 mg/ml, respectively (Table 5). Human whole blood (1 ml) was incubated at 37° C. for approximately 30 minutes with admixed bendamustine HCl solutions at 1.4 mg/ml or 3.2 mg/ml at blood to drug solution volumetric ratios of 1:2 and 1:1, respectively. These volu-

TABLE 5

Concentrations of bendamustine (BDM, as HCl salt) and corresponding volume % of non-aqueous (NA) component in the final admixture, for volumes ranging from 100 ml to 250 ml For 25 mg/mL Formulation								
Admix. Volume 250 mL					Admix. Volume 200 mL			
100 mg/m ² dose			120 mg/m ² dose		100 mg/m ² dose		120 mg/m ² dose	
BSA (m ²)	BDM Conc (mg/ml)	% NA comp.	BDM Conc (mg/ml)	% NA comp.	BDM Conc (mg/ml)	% NA comp.	BDM Conc (mg/ml)	% NA comp.
1.00	0.39	1.6	0.47	1.9	0.49	2.0	0.59	2.3
1.25	0.49	2.0	0.59	2.3	0.61	2.4	0.73	2.9
1.50	0.59	2.3	0.70	2.8	0.73	2.9	0.87	3.5
1.75	0.68	2.7	0.81	3.3	0.85	3.4	1.01	4.0
2.00	0.78	3.1	0.92	3.7	0.96	3.8	1.15	4.6
2.25	0.87	3.5	1.04	4.1	1.08	4.3	1.28	5.1
2.50	0.96	3.8	1.15	4.6	1.19	4.8	1.42	5.7
2.75	1.05	4.2	1.25	5.0	1.30	5.2	1.55	6.2
3.00	1.15	4.6	1.36	5.4	1.42	5.7	1.68	6.7
Admix. Volume 150 mL					Admix. Volume 100 mL			
100 mg/m ² dose			120 mg/m ² dose		100 mg/m ² dose		120 mg/m ² dose	
BSA (m ²)	BDM Conc (mg/ml)	% NA comp.	BDM Conc (mg/ml)	% NA comp.	BDM Conc (mg/ml)	% NA comp.	BDM Conc (mg/ml)	% NA comp.
1.00	0.65	2.6	0.78	3.1	0.96	3.8	1.15	4.6
1.25	0.81	3.2	0.96	3.8	1.19	4.8	1.42	5.7
1.50	0.96	3.8	1.15	4.6	1.42	5.7	1.68	6.7
1.75	1.11	4.5	1.33	5.3	1.64	6.5	1.94	7.7
2.00	1.27	5.1	1.50	6.0	1.85	7.4	2.19	8.8
2.25	1.42	5.7	1.68	6.7	2.06	8.3	2.44	9.7
2.50	1.56	6.3	1.85	7.4	2.27	9.1	2.68	10.7
2.75	1.71	6.8	2.02	8.1	2.48	9.9	2.92	11.7
3.00	1.85	7.4	2.19	8.8	2.68	10.7	3.15	12.6
Admix. Volume 50 mL								
100 mg/m ² dose			120 mg/m ² dose					
BSA (m ²)	BDM Conc (mg/ml)	% NA comp.	BDM Conc (mg/ml)	% NA comp.				
1.00	1.85	7.4	2.19	8.8				
1.25	2.27	9.1	2.68	10.7				
1.50	2.68	10.7	3.15	12.6				
1.75	3.07	12.3	3.60	14.4				
2.00	3.45	13.8	4.03	16.1				
2.25	3.81	15.3	4.44	17.8				
2.50	4.17	16.7	4.84	19.4				
2.75	4.51	18.0	5.22	20.9				
3.00	4.84	19.4	5.59	22.4				

Example 6

[0102] The hemolytic potential of the non-aqueous bendamustine formulation indicated in Table 4 (Example 5),

metric ratios correspond to infusion times of 15 minutes and 10 minutes, respectively, for the 250 ml and 100 ml admixture volumes. A placebo of the bendamustine formulation

(without the active ingredient) was also evaluated at these concentrations and volumetric ratios. A positive control (1% saponin solution), a negative control (normal saline), and Treanda™ diluted in normal saline to the highest concentration stated in the prescribing information (0.6 mg/ml) were included in the study. Following incubation and centrifugation of the samples, the plasma was harvested and hemolysis was evaluated by spectrophotometric analysis for hemoglobin in the supernatant. The results are summarized in Table 6. No hemolysis was observed with the non-aqueous bendamustine formulation when diluted with saline at either concentration or volumetric (blood:drug solution) ratios, or with the corresponding placebo at comparable sample volumes; supernatants from all samples were light yellow. In conclusion, no hemolytic effects are observed with non-aqueous bendamustine formulations when diluted to smaller volumes (100 to 250 ml) and infused in shorter times (10-15 minutes) than current practice.

TABLE 6

Hemolytic Potential test results				
Mixture	Hemoglobin ^a (mg/dL)	Test Result	Supernatant Color ^b	Tube No.
Human blood plus:				
Test Article A (25 mg/mL, diluted to 3.2 mg/mL with saline) - 100 ml admixture				
	1	N	Light yellow	1
	0	N	Light yellow	2
	1	N	Light yellow	3
Test Article A (25 mg/mL, diluted to 1.4 mg/mL with saline) - 250 ml admixture				
	2	N	Light yellow	4
	1	N	Light yellow	5
	1	N	Light yellow	6
Test Article A Vehicle (Placebo, diluted with 100 ml saline)				
	0	N	Light yellow	7
	1	N	Light yellow	8
	0	N	Light yellow	9
Test Article A Vehicle (Placebo, diluted with 250 ml saline)				
	1	N	Light yellow	10
	4	N	Light yellow	11
	1	N	Light yellow	12
Treanda™ (5 mg/mL, diluted to 0.6 mg/mL with saline)				
	3	N	Light yellow	43
	4	N	Light yellow	44
	2	N	Light yellow	45
Negative Control (normal saline)				
	9	N	Yellow	55
	5	N	Yellow	56
	3	N	Yellow	57
Positive Control (1% Saponin) ^c				
	5949	P	Red	58
	5974	P	Red	59
	6386	P	Red	60

N = Negative, no hemolysis.

NA = Not applicable.

P = Positive, hemolysis.

^aHemoglobin index of the mixture supernatants.

^bPlasma separated from whole blood plasma.

^c1% Saponin. Saponin is a hemolytic agent used to lyse erythrocytes.

Example 7

[0103] The local tolerance (intravenous (IV) and perivascular (PV)) of the non-aqueous bendamustine-containing composition indicated in Table 4 (Example 5), when admixed with 100 ml of normal saline and infused over 10 minutes, was assessed. New Zealand White rabbits (3 males [IV] and 2 males [PV]) received a single dose of bendamustine formulation (admixed with 100 ml saline to a final concentration of 3.2 mg/ml bendamustine HCl) and corresponding placebo in the left and right ear, respectively. The formulation was administered as either intravenous infusion (5 mg/kg in 10 minutes), or perivascular injection (250 µl) to determine local tolerance. Treanda™ reconstituted and admixed with normal saline to a final concentration of 0.6 mg/ml (the highest concentration stated in the label) was also studied either as a 30 minute IV infusion (the shortest infusion time stated in the label), as well as perivascular injection (250 µl). Animals were held for a 96 hour (post-dose) observation period. During the observation period, dermal scores were recorded for all administration sites. At the end of the observation periods, animals were euthanized and a macroscopic and microscopic examination of both ears was performed. Parameters evaluated during the study were: viability, clinical observations, body weights, macroscopic observations and microscopic pathology.

[0104] The results of the local tolerance study are summarized in Table 7 (in life dermal observations) and Table 8 (microscopic pathology for perivascular administration).

[0105] In Life Dermal Observations:

[0106] As seen in Table 7, there was transient, dermal irritation in the form of slight to moderate erythema and moderate edema noted between 24 and 72 hours post dose, in each of the groups receiving either bendamustine-containing formulations or placebo material intravenously. At 96 hours, irritation was limited to a few individual sites treated with test or placebo articles. Only a limited number of animals were affected, and there was no consistent pattern of irritation within a dose group (either for test article or placebo). The bendamustine formulations were considered not to produce dermal irritation when administered intravenously.

[0107] Perivascular administration of bendamustine formulations (0.25 ml injection volume) produced dermal irritation in all groups. Local signs of dermal irritation following perivascular administration were mostly characterized by slight (group 6—Treanda™) or slight to moderate (group 7—non aqueous bendamustine formulation of example 5) erythema, and slight edema (groups 7). The severity of the irritation observed correlated with the dose and/or concentration of the test article administered, with placebo groups generally showing a lesser level of irritation than the corresponding test-article formulation.

TABLE 7

Summary of in life dermal observations		
Dermal observations during 96 hour post dose period (incidence and most severe level of erythema and edema noted)		
Material - Left ear/Right ear	Left ear (Bendamustine-containing formulation)	Right ear (Placebo material)
Intravenous administration		
Group 1: Treanda™ diluted to 0.6 mg/ml in saline/Treanda Placebo - 500 ml admixture	—	(2/3) Slight
Group 2: Non-aqueous bendamustine formulation 25 mg/ml diluted to 3.2 mg/ml in saline/placebo (+saline) - 100 ml admixture	—	(1/3) Moderate
Perivascular administration		
Group 6: Treanda™ diluted to 0.6 mg/ml in saline/Treanda™ Placebo - 500 ml admixture	(1/2) Slight	(1/2) Slight
Group 7: Non-aqueous bendamustine formulation 25 mg/ml diluted to 3.2 mg/ml in saline/placebo (+saline) - 100 ml admixture	(2/2) Moderate	(2/2) Slight

[0108] Microscopic Pathology:

[0109] Intravenous administration of test articles/placebos was generally well tolerated; no test article related effects were observed. Perivascular administration of bendamustine-containing formulations (including Treanda™) was associated with dose and/or concentration related minimal to marked edema/collagen degeneration and mixed inflammation in perivascular tissues. The non-aqueous formulation of bendamustine (Group 7) was nominally more severe in grade than Treanda™ (Group 6).

TABLE 8

Incidence and Average Severity of Microscopic Findings at Perivascular Sites		
Formulation	Treanda™ (diluted to 0.6 mg/ml)/ Treanda™ Placebo	Non Aqueous Bendamustine (diluted to 3.2 mg/ml)/ Placebo
Group number	6	7
No. Animals examined	2	2
Incidence (Average Severity)*		
RIGHT EAR (RE) - Placebo		
RE Injection site		
Hemorrhage	0 (0.0)	0 (0.0)
Mixed Inflammation	0 (0.0)	0 (0.0)
Edema/Collagen Degeneration	1 (0.5)	0 (0.0)
Degeneration/Inflammation, Vascular	0 (0.0)	0 (0.0)
RE 2 cm distal		
Edema/Collagen Degeneration	0 (0.0)	0 (0.0)
Degeneration/Inflammation, Vascular	0 (0.0)	0 (0.0)

TABLE 8-continued

Incidence and Average Severity of Microscopic Findings at Perivascular Sites		
Formulation	Treanda™ (diluted to 0.6 mg/ml)/ Treanda™ Placebo	Non Aqueous Bendamustine (diluted to 3.2 mg/ml)/ Placebo
RE 4 cm distal		
Degeneration/Inflammation, Vascular	0 (0.0)	0 (0.0)
Incidence (Average Severity)		
LE Injection site		
Hemorrhage	0 (0.0)	0 (0.0)
Mixed inflammation	0 (0.0)	2 (2.0)
Edema/Collagen Degeneration	1 (1.0)	2 (1.5)
Epidermis, Crust/Pustule, Erosion/Ulceration	0 (0.0)	0 (0.0)
Degeneration/Inflammation, Vascular	1 (1.5)	1 (1.5)
LE 2 cm distal		
Hemorrhage	0 (0.0)	0 (0.0)
Mixed Inflammation	1 (0.5)	1 (1.0)
Edema/Collagen Degeneration	0 (0.0)	2 (2.0)
Epidermis, Crust/Pustule, Erosion/Ulceration	0 (0.0)	0 (0.0)
Degeneration/Inflammation, Vascular	0 (0.0)	0 (0.0)
LE 4 cm distal		
Hemorrhage	0 (0.0)	0 (0.0)
Mixed inflammation	0 (0.0)	1 (1.5)
Edema/Collagen Degeneration	0 (0.0)	1 (2.0)
Epidermis, Crust/Pustule, Erosion/Ulceration	0 (0.0)	0 (0.0)
Degeneration/Inflammation, Vascular	0 (0.0)	0 (0.0)

*The number in parentheses represents the average severity score; the total of severity scores of the findings divided by the number of animals in the group.

[0110] Conclusion:

[0111] No test-article related irritation effects were observed for the non-aqueous formulation of bendamustine via the IV route, indicating that proper administration of this formulation did not result in any adverse local reaction. Perivascular administration of the non-aqueous bendamustine formulation, which is primarily related to effects that may occur if extravasation should occur, resulted in irritation that was generally comparable to Treanda. Therefore, the non-aqueous formulation of bendamustine described herein is well tolerated, despite the higher concentration of the smaller infusion volume preparation.

Example 8

[0112] The chemical stability of the non-aqueous bendamustine formulation (25 mg/ml) indicated in Table 4 (Example 5), when admixed with 50 ml and 100 ml of normal saline, was assessed. For each admixture volume, the admixture solutions were prepared at the expected lowest concentration (corresponding to a 1.0 m² patient dosed at 25 mg/m²) and the highest concentration (corresponding to a 3.0 m² patient dosed at 120 mg/m²) of bendamustine HCl in the final admixture. For the 50 ml admixture volume, the tested minimum and maximum concentrations are about 0.5 mg/ml and 6.0 mg/ml, respectively. For the 100 ml admixture volume, the tested minimum and maximum concentrations are about 0.25 mg/ml and 3.2 mg/ml, respectively. The chemical stability of Treanda™ was also determined at the lowest (0.2 mg/ml) and the highest (0.6 mg/ml) admixed concentrations stated in the label. The chemical stability was

monitored at room temperature at periodic intervals up to 24 hours using a validated HPLC assay. The results are summarized in Table 9.

aqueous formulations of bendamustine thus offer better chemical stability than Treanda™ when admixed into smaller volumes.

TABLE 9

Dilution (Admixed) Stability of Bendamustine Formulations in Normal Saline at Room Temperature										
Formulation	Attribute									
	Highest Concentration (3.2 mg/ml)					Lowest Concentration (0.25 mg/ml)				
	Time									
	Initial	1 hr	3 hrs	6 hrs	24 hrs	Initial	1 hr	3 hrs	6 hrs	24 hrs
Non Aqueous Bendamustine Formulation 25 mg/ml admixed with 100 ml normal saline										
Assay (mg/ml)	3.155	3.090	3.060	3.085	2.895	0.240	0.234	0.229	0.224	0.196
Assay (% Initial)	100.0	97.9	97.0	97.8	91.8	100.0	97.5	95.4	93.3	81.7
Impurity - MCE (%)	BLQ	BLQ	BLQ	BLQ	BLQ	ND	ND	ND	ND	ND
Impurity - HP1 (%)	0.244	0.606	1.237	2.236	6.707	0.525	1.449	3.495	5.529	13.424
Impurity - Dimer (%)	BLQ	BLQ	BLQ	0.068	0.158	ND	ND	ND	BLQ	0.063
Single unknown (%)	0.086	0.061	BLQ	BLQ	0.098	ND	ND	ND	ND	BLQ
Total (%)	0.33	0.67	1.24	2.30	6.96	0.58	1.45	3.50	5.53	13.49
Formulation	Attribute									
	Highest Concentration (6.4 mg/ml)					Lowest Concentration (0.5 mg/ml)				
	Time									
	Initial	1 hr	hrs	6 hrs	24 hrs	Initial	1 hr	3 hrs	6 hrs	24 hrs
Non Aqueous Bendamustine Formulation 25 mg/ml admixed with 50 ml normal saline										
Assay (mg/ml)	6.62	6.60	6.60	6.54	6.46	0.475	0.470	0.455	0.445	0.394
Assay (% Initial)	100.0	99.7	99.7	98.8	97.8	100.0	98.9	95.8	93.7	82.9
Impurity - MCE (%)	BLQ	BLQ	BLQ	BLQ	0.074	BLQ	BLQ	BLQ	BLQ	BLQ
Impurity - HP1 (%)	0.137	0.265	0.528	0.945	2.967	0.567	1.618	3.719	5.892	14.427
Impurity - Dimer (%)	BLQ	BLQ	BLQ	0.050	0.110	BLQ	BLQ	BLQ	0.065	0.115
Single unknown (%)	0.112	0.105	0.086	0.054	0.112	0.057	BLQ	ND	ND	ND
Total (%)	0.25	0.37	0.61	1.05	3.36	0.67	1.62	3.72	5.96	14.54
Formulation	Attribute									
	Highest Concentration (0.6 mg/ml)					Lowest Concentration (0.2 mg/ml)				
	Time									
	Initial	1 hr	3 hrs	6 hrs	24 hrs	Initial	1 hr	3 hrs	6 hrs	24 hrs
Treanda™ 5 mg/ml admixed with 500 ml normal saline										
Assay (mg/ml)	0.566	0.558	0.544	0.527	0.454	0.193	0.191	0.185	0.178	0.154
Assay (% Initial)	100.0	98.6	96.1	93.1	80.2	100.0	99.0	95.9	92.2	79.8
Impurity - MCE (%)	0.263	0.261	0.268	0.262	0.263	0.261	0.288	0.277	0.250	0.276
Impurity - HP1 (%)	1.250	2.248	4.730	7.287	16.887	1.231	2.241	4.770	7.462	17.504
Impurity - Dimer (%)	0.223	0.229	0.269	0.279	0.326	0.188	0.185	0.178	0.176	0.252
Single unknown (%)	0.103	0.103	0.101	0.097	0.081	0.077	0.079	0.103	0.083	0.066
Total (%)	1.97	2.97	5.50	8.04	17.66	1.85	3.01	5.41	8.07	18.27

MCE—monochloroethyl derivative;
HP1—mono hydroxyl bendamustine

[0113] As shown in Table 9, Treanda™ when prepared as directed in the label (final concentration between 0.2-0.6 mg/ml) shows total degradation of about 5-6% in 3 hours at room temperature (corresponding to the room temperature stability claim in the label); monohydroxy bendamustine is the main degradant. In contrast, the non-aqueous bendamustine formulations admixed in either 50 ml or 100 ml saline show total degradation of less than 5-6% over 6 hours at the lowest concentrations tested, indicating that these admixtures are significantly less prone to degradation. This stabilizing effect is particularly pronounced at the higher concentrations (which are more typical), with chemical stability evident for 24 hours at these concentrations. The non-

Example 9

Solubility and Stability of Bendamustine Hydrochloride in Polar Aprotic Solvents

[0114] Equilibrium solubility was determined for solvents including 1-methyl-2-pyrrolidone (NMP), 1,3-dimethyl-2-imidazolidinone (DMI), dimethylacetamide (DMA), dimethyl sulfoxide (DMSO), acetone, tetrahydrofuran (THF), dimethylformamide (DMF), and propylene carbonate (PC). The solubility of bendamustine hydrochloride was also determined for two solutions, 25 mg/mL niacinamide in DMA and 66% DMA/34% propylene glycol (PG). A saturated solution of bendamustine hydrochloride was made in

triplicate for each solvent or solution and mixed on a Lab-Quake with gentle mixing and low shear for 3 days at room temperature. A sample of each suspension was put into a microcentrifuge tube and spun at 10,000 rpm for 5 min on an Eppendorf microcentrifuge. The supernatant was removed and put into a clean vial. Each solution was diluted with sample solvent: 50% NMP/50% 0.1% trifluoroacetic acid in water. A reverse phase method for bendamustine hydrochloride was used to determine the concentration of each sample calculated from a standard. Analysis was performed within 18 hours of preparation of the diluted sample. The solubilities are listed in Table 10 below. Each value is an average of three samples.

TABLE 10

Sample*	% Purity	Assay (mg/mL)
NMP	99.1	104.0
DMI	98.5	75.8
DMSO	99.5	311.7
DMF	99.6	71.8
66% DMA/34% PG	99.5	110.1
DMA	99.4	56.2
PC	98.7	7.7
Niacinamide/DMA	99.2	61.3

*acetone and THF have no measurable solubility of bendamustine.

[0115] The three replicates were combined and mixed well and then pipetted into amber HPLC vials and placed in stability chambers at 25° C. and 5° C. All the samples were clear and colorless except for the DMI sample which was clear and yellow. The 25° C. stability leveled out from about 180 days (about 6 months) to about 365 days (about 12 months, about 1 year). At 5° C., all solutions had a purity greater than 90%. The analysis of stability samples can be seen in the graphs of FIGS. 1 and 2.

TABLE 11

Impurity profile of certain liquid formulations of Bendamustine HCl after storage at 5° C. for about 12 months					
Formulation	DCE (Area %)	HP1 (Area %)	BM1 dimer (Area %)	PG-1 (Area %)	PG-2 (Area %)
Niacinamide/DMA	1.40	0.08	0.06	ND	ND
DMA	1.10	0.08	0.05	ND	ND
66% DMA/34% PG	0.12	0.08	0.06	1.09	0.27
DMF	0.07	0.11	0.07	ND	ND
NMP	0.90	0.10	ND	ND	ND
DMSO	0.04	0.38	0.70	ND	ND

ND = not detected

Analysis conducted using reverse phase HPLC with 50% NMP/50% 0.1% trifluoroacetic acid in water as the running solvent.

[0116] As can be seen in FIG. 3, bendamustine (BM1) in 99% propylene glycol degrades significantly when stored at 25° C. for less than 100 days. After storage at 5° C. for about 365 days, the purity of the bendamustine is about 80% or less.

Pharmacokinetic Study of Formulations in Monkey

[0117] 4 fasted (18 to 23 hr), drug-naive male cynomolgus monkeys consecutively received single 3-mg/kg bolus intra-

venous doses of bendamustine hydrochloride prepared from 3 different formulations. The formulations evaluated in the study included:

1) TREANDA (lyophilized mixture of bendamustine hydrochloride and mannitol; 25 mg (bendamustine hydrochloride) vials; 2) a 66% dimethylacetamide (DMA)/34% propylene glycol (PG) (w/w) solution (90 mg (bendamustine hydrochloride)/mL stock); and 3) a 100% DMA solution (45 mg (bendamustine hydrochloride)/mL stock). The lyophilized powder and stock solutions of bendamustine hydrochloride were constituted or diluted with 0.9% saline, as appropriate, to give solutions of 3 mg bendamustine hydrochloride/mL, just prior to dose administration. The resulting solutions were administered as a bolus via a saphenous vein at a fixed volume of 1.0 mL/kg. There was at least a 7-day washout period separating successive doses. During all 3 phases of dosing, blood samples for pharmacokinetic profiling of bendamustine and its 2 active circulating metabolites, γ -hydroxybendamustine (M3) and N-des-methylbendamustine (M4), were collected via a femoral vein immediately prior to dosing and at preselected timepoints through 12 hr postdose. Concentrations of bendamustine, M3 and M4 in plasma samples were determined using a validated high-performance liquid chromatography method with tandem mass spectrometric detection (LC-MS/MS) as follows. Bendamustine and the M3 and M4 metabolites are extracted from plasma by protein precipitation using acetonitrile. After the extraction, the aliquoted sample is acidified with 1% formic acid and bendamustine with an added carbon in the carboxylic acid chain is added as an internal standard. The samples are evaporated to dryness and the residue is reconstituted with an acetonitrile/water/formic acid/ammonium formate mixture. The sample is injected into an HPLC system with LC/MS/MS detection using a Phenomenex Synergi Max-RP column with an acetonitrile/water/formic acid/ammonium formate mobile phase. Pharmacokinetic analyses were performed using noncompartmental methods.

[0118] After single bolus intravenous doses of bendamustine hydrochloride to male cynomolgus monkeys, the shapes of the mean plasma concentration-versus-time profiles of bendamustine were similar in each of the 3 formulations (See FIG. 4). In all cases, the highest observed plasma levels of bendamustine were achieved at 0.083 hr postdose (ie, the first sampling time after dose administration) and subsequent removal of the compound from plasma occurred in a bi-phasic manner that was characterized by an initial rapid distribution phase and a somewhat slower terminal phase of drug elimination. The harmonic mean $t_{1/2}$ of the terminal phase was approximately 0.6 hr for each formulation (See Table 12).

[0119] In addition to the similarities in the shapes of the mean plasma concentration-versus-time profiles, the 3 formulations were also similar with respect to bendamustine systemic exposure (i.e., C_{max} and AUC). Specifically, the respective mean values of C_{max} and AUC_{0-∞} for bendamustine were 6037 ng/mL and 2314 ng·hr/mL for the TREANDA formulation, 7380 ng/mL and 2854 ng·hr/mL for the 66% DMA/34% PG formulation and 6209 ng/mL and 2372 ng·hr/mL for the 100% DMA formulation. Plasma clearance (CL) and volume of distribution (V_z and V_{ss}) for bendamustine were also comparable between each of the 3 formulations (See Table 12). In Table 12, t_{max} , hr is given as Median [range], $t_{1/2}$, hr is given as the Harmonic Mean, λ_z , hr⁻¹ is the

slope of line in elimination phase used to calculate half-life, and $MRT_{0-\infty}$ is the mean residence time.

[0120] In summary, the pharmacokinetic profiles of bendamustine, M3 and M4 for the 2 liquid formulations of bendamustine hydrochloride were qualitatively and quantitatively similar to those obtained for the TREANDA formulation after single bolus intravenous doses to monkeys.

[0121] Table 12 shows the mean \pm Standard Deviation pharmacokinetic parameters of bendamustine in male Cynomolgus monkeys (N=4) administered single 3 mg/kg bolus intravenous doses of bendamustine hydrochloride in the three different formulations.

TABLE 12

Parameter	Formulation		
	TREANDA	66% DMA/34% PG	100% DMA
C_0 , ng/mL	8664 \pm 3841	10716 \pm 2033	8956 \pm 1965
C_{max} , ng/mL	6037 \pm 2456	7380 \pm 1170	6209 \pm 1300
t_{max} , hr	0.083 [0.083 for all]	0.083 [0.083 for all]	0.083 [0.083 for all]
AUC_{0-r} , ng \cdot hr/mL	2313 \pm 800	2853 \pm 398	2371 \pm 535
$AUC_{0-\infty}$, ng \cdot hr/mL	2314 \pm 800	2854 \pm 398	2372 \pm 535
λ_{z1} , hr $^{-1}$	1.220 \pm 0.111	1.295 \pm 0.108	1.092 \pm 0.219
$t_{1/2}$, hr	0.57	0.54	0.63
CL, L/hr/kg	1.27 \pm 0.40	0.96 \pm 0.14	1.18 \pm 0.27
V_z , L/kg	1.04 \pm 0.36	0.74 \pm 0.05	1.17 \pm 0.44
V_{ss} , L/kg	0.34 \pm 0.11	0.26 \pm 0.05	0.30 \pm 0.04
$MRT_{0-\infty}$, hr	0.26 \pm 0.02	0.27 \pm 0.02	0.26 \pm 0.03

In-Use Studies of Formulations

[0122] Admixtures in 0.9% sodium chloride (500 mL bag) were prepared at a high dose (360 mg bendamustine hydrochloride) and purity was determined over time at room temperature for up to 8 hours using HPLC, using a Zorbax Bonus-RP column with a gradient from 93% 0.1% trifluoroacetic acid in water (Mobile Phase A)/7% 0.1% trifluoroacetic acid in acetonitrile (Mobile Phase B) to 10% Mobile Phase A/90% Mobile Phase B.

[0123] The 66% DMA/34% PG formulation had a concentration of bendamustine hydrochloride of 90 mg/g, so 4 mL was injected into a 500 mL bag of saline, inverted 10 times and sampled at room temperature for 8 hours. After 8 hours the purity was 95.4%. This is within the label requirements for dosing Treanda. This formulation of the present invention could be used for up to 8 hours at room temperature. By way of contrast, reconstituted Treanda can only be stored at room temperature for up to 3 hours.

[0124] The 100% DMA formulation had a concentration of 45 mg/g, so 8 mL was injected into a 500 mL bag of saline, inverted 10 times, and sampled at room temperature for 4 hours. After 4 hours the purity was 97.9%. This formulation of the present invention could be used for more than 4 hours at room temperature.

[0125] The comparative Treanda admixture purity was 95.0% after 4 hours at 25° C.

Example 10

[0126] Preparation of a Bendamustine Composition with Sodium Sulfobutyl Ether β -Cyclodextrin and Chondroitin
[0127] 6 mg of bendamustine hydrochloride were dissolved in 1 mL of 20% w/w solution of sodium sulfobutyl ether β -cyclodextrin. The solution was incubated at 20° C. for 15 minutes on ultrasonic bath and mixed with 1 mL of 25% solution of chondroitin sulfate.

Example 11

[0128] Preparation of a Bendamustine Composition with Sodium Sulfobutyl Ether β -Cyclodextrin and Poly(Sulfobutyl)Cellulose

[0129] 6 mg of bendamustine hydrochloride are dissolved in 1 mL of 30% w/w solution of sodium sulfobutyl ether β -cyclodextrin. The solution is preincubated at 10° C. for 15 minutes on ultrasonic bath. After that the solution is mixed with 1 mL of 2% solution of poly(sulfobutyl)cellulose sodium salt. The sample is incubated on ultrasonic bath for 30 minutes at 10° C.

Example 12

[0130] Preparation of a Bendamustine Composition with Sodium Sulfobutyl Ether β -Cyclodextrin and Hyaluronic Acid

[0131] 6 mg of bendamustine hydrochloride were dissolved in 1 mL of 30% w/w solution of sodium sulfobutyl ether β -cyclodextrin. The solution was preincubated at 10° C. for 15 minutes on ultrasonic bath. After that the solution was mixed with 1 mL of 0.1% solution of hyaluronic acid sodium salt. The sample was incubated on ultrasonic bath for 30 minutes at 10° C.

Example 13

[0132] Preparation of a Bendamustine Composition with Sodium Sulfobutyl Ether β -Cyclodextrin and Dextran

[0133] 6 mg of bendamustine hydrochloride were dissolved in 1 mL of 20% w/w solution of sodium sulfobutyl ether β -cyclodextrin. The solution was incubated at 20° C. for 15 minutes on ultrasonic bath and then mixed with 1 mL of 50% solution of dextran 40 (MW 40000) and sonicated for another 15 minutes.

Example 14

[0134] Preparation of a Bendamustine Composition with 2-Hydroxypropyl- β -Cyclodextrin and Dextran

[0135] 6 mg of bendamustine hydrochloride were dissolved in 1 mL of 20% w/w solution of 2-hydroxypropyl- β -cyclodextrin. The solution was incubated at 20° C. for 15 minutes on ultrasonic bath and then mixed with 1 mL of 50% solution of dextran 40 (MW 40000) and was sonicated for another 15 minutes.

Example 15

[0136] Preparation of a Bendamustine Composition with Sodium Sulfobutyl Ether β -Cyclodextrin and Quaternized Cellulose

[0137] 2 mg of quaternized cellulose (hydrochloride salt) were dissolved in 1 mL of water. After 4 hours of preincubation on an ultrasonic bath (at room temperature), the solution was mixed with a solution of 6 mg of bendamustine hydrochloride in 1 mL of 20% w/w solution of sodium sulfobutyl ether β -cyclodextrin. The solution was well mixed and incubated for 15 minutes on ultrasonic bath.

Example 16

[0138] Preparation of a Bendamustine Composition with Sodium Sulfobutyl Ether β -Cyclodextrin and Polyvinylpyrrolidone

[0139] 6 mg of bendamustine hydrochloride were dissolved in 1 mL of 30% w/w solution of sodium sulfobutyl ether β -cyclodextrin. The solution was incubated at 20° C. for 15 minutes on an ultrasonic bath and then mixed with 1 mL of 20% solution of PVP (MW=10000) and sonicated for 20 minutes.

Example 17

[0140] Preparation of a Bendamustine Composition with Sodium Sulfobutyl Ether β -Cyclodextrin and Cetylpyridinium Chloride

[0141] 6 mg of bendamustine hydrochloride and 8.5 mg of mannitol were dissolved in 0.8 g of 50% w/w solution of sodium sulfobutyl ether β -cyclodextrin. The solution was incubated at 20° C. for 15 minutes on ultrasonic bath and then mixed with 0.2 mL of 2.5% solution of cetylpyridinium chloride.

Example 18

[0142] Preparation of Bendamustine Composition with Sodium Sulfobutyl Ether β -Cyclodextrin and PI2080 Preparation of PI2080

[0143] Polyethyleneimine (PEI, MW 2000) was purchased from Aldrich. Poly(ethylene glycol) monomethyl ether (PEG, MW 8500) was purchased from Polymer Sources Inc. PI2080, a conjugate of PEG and PEI, was prepared following the procedure described by Vinogradov S. V. et al. in Bioconjugate Chem. 1998, 9, 805-812. 4 g of PEG was reacted with 1,1'-carbonyldiimidazole in 20 mL anhydrous acetonitrile. The product of the reaction was dialysed twice against water using SpectraPor 3 membrane, MWCO 3500, and freeze-dried. The freeze-dried material was dissolved in 32 mL of methanol, mixed with 2.9 g of PEI and incubated for 24 hours at 25° C. The product was dialysed twice against water using SpectraPor 3 membrane, MWCO 3500, and the product PI2080 was freeze-dried.

Example 19

[0144] Preparation of Bendamustine Composition with Sodium Sulfobutyl Ether β -Cyclodextrin and PI2080

[0145] 2.5 mg of bendamustine hydrochloride and 4.3 mg of mannitol were dissolved in 0.8 g of 50% w/w solution of sodium sulfobutyl ether β -cyclodextrin. The solution was incubated at 20° C. for 15 minutes on ultrasonic bath and then mixed with 0.2 mL of 5% solution of PI2080.

Example 20

[0146] Preparation of Bendamustine Composition with Sodium Sulfobutyl Ether β -Cyclodextrin and with Protamine Sulphate

[0147] 2.5 mg of bendamustine hydrochloride and 4.3 mg of mannitol were dissolved in 0.800 g of 50% w/w solution of Sodium sulfobutyl ether β -cyclodextrin. Solution was shaken at 20° C. for 90 minutes and then incubated for 30 minutes in an ultrasonic bath. Then the mixture was transferred into a suspension of 30 mg of protamine sulfate in 0.163 g of water and vigorously mixed for 15 minutes.

Example 21

[0148] Pharmacokinetics of Bendamustine Dosed to Rats in Composition with Sodium Sulfobutyl Ether β -Cyclodextrin and Cetylpyridinium Chloride

The Tested Compositions:

[0149] Control: 6 mg/mL bendamustine hydrochloride, 10.2 mg/mL of mannitol in 0.9% NaCl; dose of 20 mg/kg
[0150] Inventive Composition: 5 mg/g bendamustine hydrochloride, 40% w/w sodium sulfobutyl ether β -cyclodextrin, 0.5% cetylpyridinium chloride, 8.5 mg/g mannitol in water (produced following the procedure of Example 17); dose of 20 mg/kg.

We claim:

1. A method of treating chronic lymphocytic leukemia or indolent B cell non-Hodgkin's lymphoma in a subject comprising parenterally administering to the subject a volume of about 100 mL or less of a liquid composition comprising: bendamustine; a charged cyclopolysaccharide; and a parenterally acceptable diluent; over a period of less than or equal to about 15 minutes.
2. The method of claim 1, wherein the subject is human.
3. The method of claim 1, wherein the concentration of the bendamustine or pharmaceutically acceptable salt thereof is from about 0.05 to about 12.5 mg/mL.
4. The method of claim 1, wherein the concentration of the bendamustine or pharmaceutically acceptable salt thereof is from about 0.1 to about 6.0 mg/mL.
5. The method of claim 1, wherein the concentration of the bendamustine or pharmaceutically acceptable salt thereof is from about 0.05 to about 3.2 mg/mL.
6. The method of claim 1, wherein the concentration of the bendamustine or pharmaceutically acceptable salt thereof is from about 0.5 to about 5.6 mg/mL.
7. The method of claim 1, wherein the volume administered is about 100 mL, about 50 mL, about 30 mL, or about 5 mL.
8. The method of claim 1, wherein the volume administered is about 50 mL.
9. The method of claim 1, wherein the bendamustine is administered to treat chronic lymphocytic leukemia.
10. The method of claim 9, wherein the composition is administered intravenously in a volume of about 50 mL in about 10 minutes or less on days 1 and 2 of a 28 day cycle.
11. The method of claim 10, wherein the composition is administered in about 10 minutes.
12. The method of claim 10, wherein the composition is administered for up to 6 cycles.
13. The method of claim 9, wherein the volume of the composition administered to the subject provides a benda-

mustine dosage amount ranging from about 25 mg/m² to about 100 mg/m² to the subject.

14. The method of claim 13, wherein the composition provides a bendamustine dosage of about 100 mg/m².

15. The method of claim 9, wherein the liquid composition comprises from about 1.85 mg/mL to about 4.84 mg/mL of bendamustine or a pharmaceutically acceptable salt thereof.

16. The method of claim 1, wherein the bendamustine is administered to treat indolent B cell non-Hodgkin's lymphoma.

17. The method of claim 16, wherein the composition is administered intravenously in a volume of about 50 mL in about 10 minutes or less on days 1 and 2 of a 21 day cycle.

18. The method of claim 17, wherein the composition is administered in about 10 minutes.

19. The method of claim 17, wherein the composition is administered for up to 8 cycles.

20. The method of claim 16, wherein the volume of the composition administered to the subject provides a bendamustine dosage amount ranging from about 60 mg/m² to about 120 mg/m² to the subject.

21. The method of claim 20, wherein the composition provides a bendamustine dosage of about 120 mg/m².

22. The method of claim 16, wherein the liquid composition comprises from about 2.19 mg/mL to about 5.59 mg/mL of bendamustine or a pharmaceutically acceptable salt thereof.

23. The method of claim 1, wherein the cyclopolysaccharide is a beta-cyclodextrin.

24. The method of claim 1, wherein the charged cyclopolysaccharide has one or more anionic groups.

25. The method of claim 24, wherein the anionic group is a sulfate, sulfonyl, or carbonyl group.

26. The method of claim 24, wherein the anionic group is a sulfate or sulfonyl group.

27. The method of claim 24, wherein the cyclopolysaccharide is sulfobutyl ether beta-cyclodextrin.

28. The method of claim 1, wherein the proportion of bendamustine to cyclopolysaccharide is between about 1:12, 500 and about 1:25, by weight.

29. The method of claim 1, wherein the composition further comprises a stabilizing agent.

30. The method of claim 29, wherein the stabilizing agent is a polypeptide comprising from about 5 to about 50 amino acids, wherein at least about 50% of the amino acids have a positive charge.

31. The method of claim 29, wherein the stabilizing agent is a polypeptide comprising between about 6 and about 20 amino acids, wherein at least about 50% of the amino acids have a positive charge.

32. The method of claim 30, wherein the polypeptide comprises at least one block sequence of 4 arginines.

33. The method of claim 32, wherein the stabilizing agent is polyarginine.

34. The method of claim 30, wherein the stabilizing agent is low molecular weight protamine.

35. The method of claim 1, wherein the charged group on the cyclopolysaccharide is a cationic group.

36. The composition of claim 35, wherein the cationic group is a quaternary ammonium group.

37. The method of claim 1, wherein the bendamustine is present as the hydrochloride salt.

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