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(54) Titre : PROCEDE DE PREPARATION D'UN DERIVE SULFATE DE 3,5-DIIODO-O-[3-IODOPHENYL]-L-TYROSINE
(54) Title: PROCESS FOR THE PREPARATION OF A SULFATED DERIVATIVE OF 3,5-DIIODO-O-[3-IODOPHENYL]-L-TYROSINE

(57) **Abrégé/Abstract:**

The present invention relates to a process for the preparation of the mono sodium salt of the derivative 3,5-diiodo-O-[3-iodo-4-(sulphooxy)phenyl]-L- tyrosine (T3S) by starting from the corresponding phenolic compound, in the presence of chlorosulfonic acid and dimethylacetamide as a solvent. The so obtained T3S compound may conveniently be isolated in a pure form as a solid in good yields. The present invention further relates to the process for T3S preparation, wherein the starting reagent is T2 and further comprising the formulation of such compound in tablets. Furthermore, the invention discloses non-radioactive immunoassays based on T3S derivatives.

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(54) Title: PROCESS FOR THE PREPARATION OF A SULFATED DERIVATIVE OF 3,5-DIIODO-O-[3-IODOPHENYL]-L-TYROSINE

(57) Abstract: The present invention relates to a process for the preparation of the mono sodium salt of the derivative 3,5-diiodo-O-[3-iodo-4-(sulphooxy)phenyl]-L-tyrosine (T3S) by starting from the corresponding phenolic compound, in the presence of chlorosulfonic acid and dimethylacetamide as a solvent. The so obtained T3S compound may conveniently be isolated in a pure form as a solid in good yields. The present invention further relates to the process for T3S preparation, wherein the starting reagent is T2 and further comprising the formulation of such compound in tablets. Furthermore, the invention discloses non-radioactive immunoassays based on T3S derivatives.



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**PROCESS FOR THE PREPARATION OF A SULFATED DERIVATIVE OF
3,5-DIIODO-O-[3-IODOPHENYL]-L-TYROSINE
FIELD OF THE INVENTION**

The field of the present invention relates to a process for the preparation of
5 sulfated derivatives of thyroid hormones or salts thereof.

BACKGROUND OF THE INVENTION

Thyroid hormone tri-iodothyronine (3,5-diiodo-O-[3-iodophenyl]-L-tyrosine
or T3) is the metabolically most active thyroid hormone. Like thyroxine (T4)
it is physiologically produced by thyroid and stored together with it, under
10 the form of a thyroglobulin, a glycoprotein precursor. On average, one
thyroglobulin molecule contains three or four T4 residues and, at the most,
one T3 residue. TSH production activates thyroglobulin proteolysis through
the enzymes cathepsin D, B and L with the release of thyroid hormones T3
and T4. However, T3 generation is not limited to this mechanism: actually,
15 in the peripheral tissues, thyroxine is transformed into tri-iodothyronine
(80% of tri-iodothyronine is periferally produced by thyroxine and 20% is
produced inside thyroid gland).

The importance of T3 is not only the one due to the fact of being the most
active thyroid hormone. Actually, in this respect, various pathological
20 conditions are known that are caused by its deficiency. In particular, e.g., in
nervous tissue during embryonal development and childhood, T3 deficiency
gives rise to a reduction in cerebral and cerebellar cortex growth, axons
proliferation, cell migration, myelinization, dendrite branching and synapse
genesis. As a result of T3 deficiency in the initial stages of life, a delay in
25 the nervous system development is observed followed by a cognitive and
motor deficit, that may cause a clinical picture referred to as cretinism. Also
in adults it has been demonstrated by cerebral PET that, when the tri-
iodothyronine levels are reduced, the blood flow inside the brain and
glucose cerebral metabolism are lower. These data may explain the
30 psycomotor deficit in the hypothyroid individuals.

In addition to the effects observed in the nervous tissue, also the ones in
the bone tissue are known where the endochondral ossification is stimulated
by tri-iodothyronine, thus rendering the bone linearly longer through

maturation of the epiphysis bone centers. Even if not necessary after birth for the bone linear growth, tri-iodothyronine is essential for the proper fetus bones development.

Furthermore, T3 effects in the epidermis tissues have been substantiated, where tri-iodothyronine not only takes part in its maturation and of skin adnexa, but also in degradation thereof thus promoting cell regeneration. Therefore, both the excess and the deficiency of this hormone can cause dermatological problems.

Therefore, T3 thyroid hormone may definitely be considered as a pleiotropic hormone, with well documented effects, in addition to the ones above mentioned, in the blood tissue, where it increases erythropoietin production and, consequently, haemopoiesis; in fat tissues, where it promotes maturation of pre-adipocytes to adipocytes, increases the fatty acids lipolysis and finally also regulating cholesterol metabolism.

Hypothyroidism, very frequently generated by autoimmune pathologies, is rather common: actually, prevalence in Italian people is about 1.5% among females and 1% among males. It is pharmacologically treated in a satisfactory way through substitutive therapies, mainly based on synthetic levo-thyroxine (T4), drug of choice because of the very short half-life of the more active form, i.e. T3, which, for this reason, cannot be routinely used.

However, also the therapy with levo-thyroxine shows some disadvantages connected to the fact that while plasmatic euthyroidism is restored, the tissutal one not always does. The study of pharmacological alternatives, such as the ones proposable on the basis of the thyromimetic T3 activity described in EP 1560575 B, might represent a desirable alternative to the present treatments of choice.

However, as far as T3S is involved, the major obstacle seems to be represented by the difficulties met by a large scale synthesis. Actually, until now it has been possible to produce T3S only on a laboratory scale.

In this respect, the preparation of T3S from T3 by means of sulphating agents e.g. concentrated sulphuric acid (H₂SO₄) or chlorosulfonic acid (CSA) in large excess has been described, for example in US2970165 and *Biochim. Biophys. Acta*, 33, 461 (1959), that describe the preparation of T3S from T3

in solid form, by means of the direct addition of concentrated sulfuric acid, at low temperatures.

Endocrinology, Vol.117, No.1, 1-7 (1985) and *Endocrinology*, Vol.117, No.1, 8-12 (1985) envisage the synthesis of T3S from T3 by means of the addition under cooling of a chlorosulfonic acid (CSA) solution in dimethylformamide, followed by a purification step through Sephadex LH-20.

Up to now however, none of the prior art processes can be scaled up for grams production of the final product in a pure form, mainly because the reported purification procedures need extremely high volumes.

Advantageously, it has now been found that the sulfation reaction starting from tri-iodothyronine with chlorosulfonic acid (CSA) as a sulfating agent, in the presence of DMAC, offers high conversion rates. Moreover the purification can be carried out with smaller volumes than the ones reported in the known prior-art processes. Eventually, the product T3S can be purified up to the required levels for its clinical use both for the necessary quality and quantity (hundreds of grams), also under conditions applicable on an industrial scale.

Furthermore, since only radioactive assays to detect T3S levels in serum, such as the RIA described in Chopra et al. (J. Clin. Endocrinol. Metab., 1992, 75: 189-194), have been described until now, the need exists for safer immunoassays based, for example, on non-radioactive reagents. The use of such reagents would also allow clinical and/or research structures to carry out these measures. To this aim, non radioactive immuno-assays have been developed and are part of the present invention.

BRIEF DESCRIPTION OF THE DRAWINGS

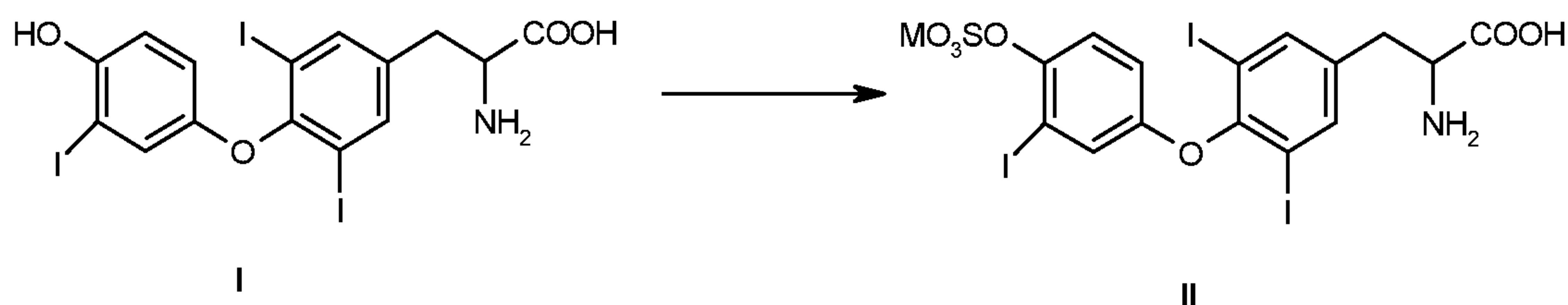
Figure 1. Panel a) T3S calibration curve by competitive ELISA; Panel b) DELFIA calibration curve. T3S was assayed at 33.6, 56, 93.3, 155.5, 259, 432, 720, 1200, 2000 pg/mL.

Figure 2. Schematic of DTPA-T3S monoamide synthesis.

SUMMARY OF THE INVENTION

The present invention relates to a process for the preparation of a mono-cationic salt of 3,5-diiodo-O-[3-iodo-4-(sulfooxy)phenyl]-L-tyrosine of

formula II (T3S), by starting from 3,5-diiodo-O-(4-hydroxy-3-iodophenyl)-L-tyrosine of formula I or a salt thereof, according to the scheme:



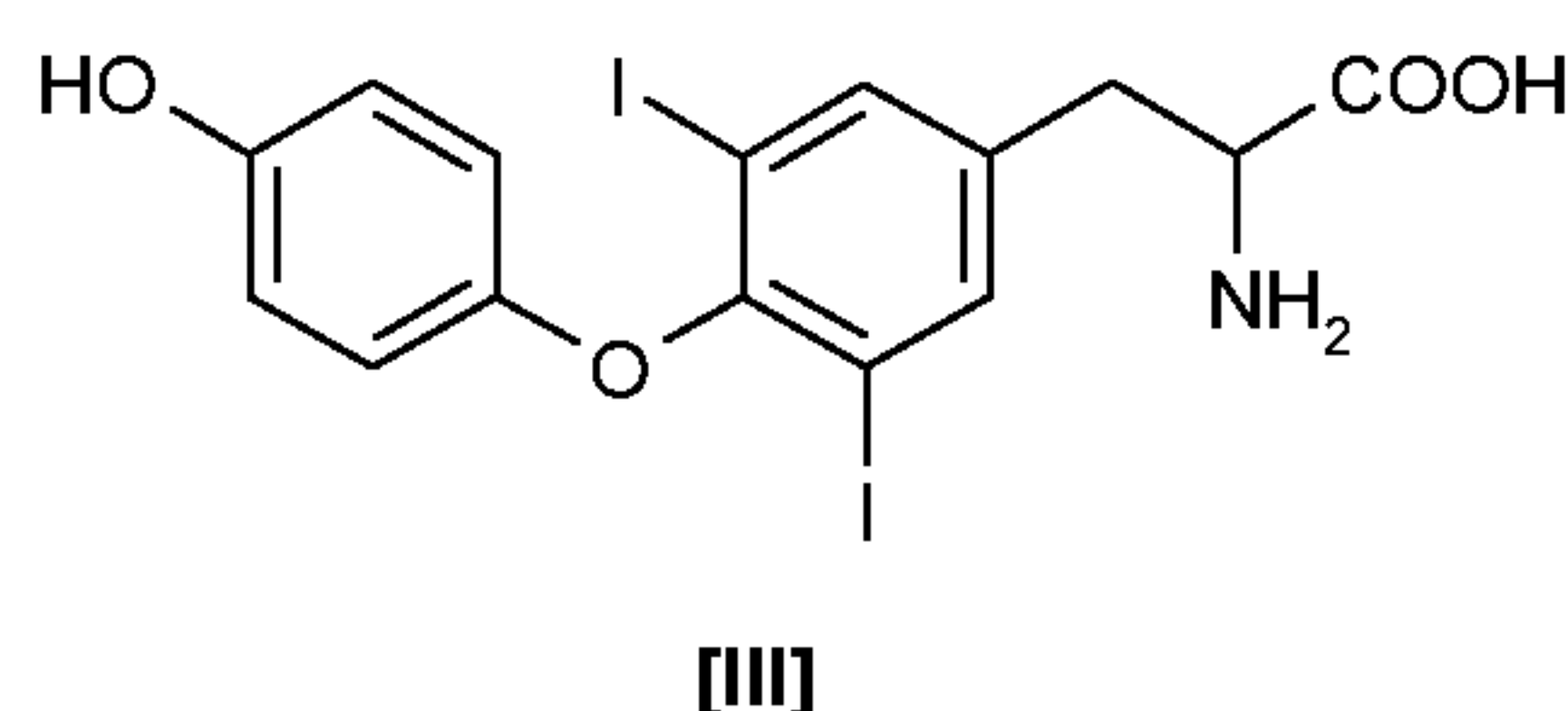
5

wherein M is an alkali metal, preferably Na,
comprising the steps of:

a) sulfation of the compound of formula I or of the salts thereof
with chlorosulfonic acid (CSA) in the presence of dimethylacetamide
10 (DMAC) as a solvent;

b) salification of the sulfated derivative obtained in a) to give the
compound of Formula II (T3S) by adding the reaction mixture obtained in a)
to an aqueous solution of an alkali metal inorganic salt, preferably a mono-
cationic sodium, even more preferably NaHCO₃.

15 According to a particularly preferred embodiment, the compound of formula
I (T3) is obtained by means of the iodination of a compound of formula III
(T2):



with an iodinating agent, preferably with NaI and I₂, in the presence of an
20 aliphatic amine, preferably selected from linear mono alkyl (C₁-C₄) aliphatic
amines, among which, ethylamine is preferred.

The addition of the iodinating agent is carried out in the presence of an
aqueous solvent, preferably water, at a temperature preferably lower than
25°C. Preferably, the iodinating agent is present at a molar ratio comprised
25 between 0.9 and 1.1 mol/mol of compound III (T2).

Thus the process for the preparation of T3S comprises the preparation of T3
by means of the iodination of T2 under the conditions above described and

then its sulfation with chlorosulfonic acid in dimethylacetamide, as better described in the detailed description.

Moreover, according to a further aspect, the invention also comprises the formulation of the active principle, T3S, into pharmaceutical compositions, preferably solid, wherein T3S, preferably under a powder form, is mixed with a diluting agent and then a flowing agent, a lubricating agent, preferably glycerol dibehenate, and a disaggregating agent, preferably croscarmellose or the derivatives thereof, are added to the mixture their sieving and their further mixing with the diluting mixture comprising the active principle.

Thus according to this realization, the process comprises a step where the diluent, for example microcrystalline cellulose, is added in one or more fractions, their mixing, then the preparation of a mixture comprising a flowing agent, preferably glycerol dibehenate, a lubricating agent, preferably magnesium or zinc stearate, hydrated colloidal silica, colloidal silicon dioxide and preferably also a disintegrating agent, preferably croscarmellose or the derivatives thereof; then their sieving and their further mixing with the mixture comprising the active principle together with the diluent. Further excipients, stabilizers and diluents (such as for example calcium carbonate) may then be added and mixed for a variable time.

According to a particularly preferred aspect, the invention further discloses a tablet prepared by the process above described, comprising T3S as the active principle in a quantity comprised from 1 to 1000 μg and comprising the following diluents, excipients, glidants and lubricants: calcium carbonate, glycerol dibehenate, croscarmellose sodium salt, hydrate colloidal silica, magnesium stearate, microcrystalline cellulose. Preferred quantities for a single dosage are given in the table below:

	Amount per Tablet
Calcium carbonate	20-40 mg
Glycerol dibehenate	2-15 mg
Croscarmellose sodium salt	1-10 mg
Hydrate colloidal silica	0.1-5 mg
Magnesium stearate	0.01-2 mg
Microcrystalline cellulose	At least 30 mg

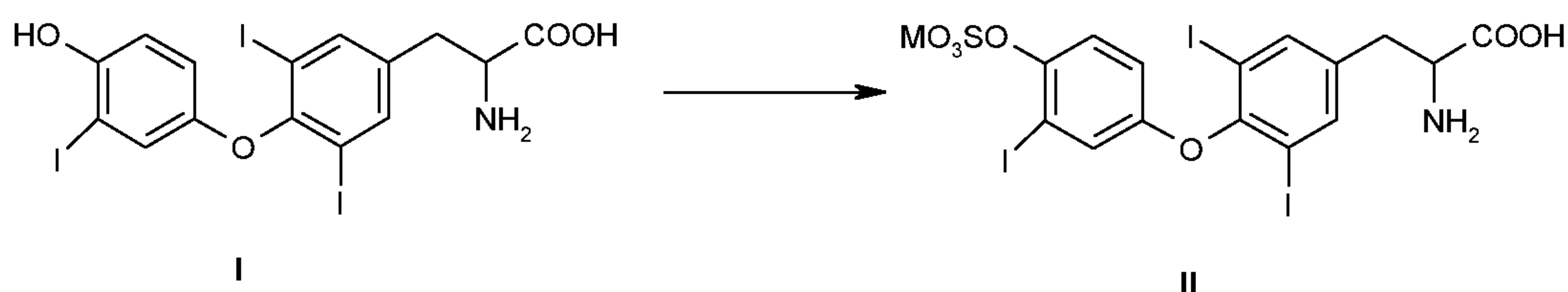
A further embodiment of the invention is represented by non radioactive immunoassays.

Preferably the immunoassay is an Enzyme Linked Immuno Assay (ELISA),
 5 more preferably a competitive ELISA, more preferably carried out in a multi-well plate, using as detectable moiety a fluorescent group or an enzyme (e.g., horseradish peroxidase, alkaline phosphatase, etc.) or an avidin-derivative detectable moiety (i.e. biotin).

As a further development of the T3S non-radioactive detection assays,
 10 reagents have been developed for the Lanthanide Fluorescence Immuno-Assay. This assay, the synthesized reagents, and kits for T3S quantitation based on the new reagents, represent a further object of the invention.

DETAILED DESCRIPTION OF THE INVENTION

Object of the present invention is a process for the preparation of a sulfated
 15 form of the thyroid hormone T3, 3,5-diiodo-O-[3-iodo-4-(sulfooxy)phenyl]-L-tyrosine (T3S) having formula II as a mono-cationic salt, by starting from 3,5-diiodo-O-[4-hydroxy-3-iodophenyl]-L-tyrosine of formula I or from a salified derivative thereof:



wherein M is an alkali metal, preferably Na, which comprises the steps of:

a) sulfation of the compound of formula I (T3) with chlorosulfonic acid (CSA) in the presence of dimethylacetamide (DMAC) as a solvent,

5 b) salification of the sulfated derivative obtained in a) to give the compound of formula II. Salification is generally obtained by means of the addition of the reaction mixture obtained in a) to an aqueous solution of an alkali metal inorganic salt, preferably a sodium salt, even more preferably Na_2CO_3 or NaHCO_3 .

10 For the purpose of the present invention by T3S is meant the compound of Formula II comprising either the sulfated form of tri-iodothyronine or the mono-cationic salts thereof (Formula II compound).

Step a) is carried out by adding CSA to a suspension of T3 in DMAC under cooling, while keeping the solution under a vigorous stirring.

15 Temperature is kept at values lower than about 10°C , more preferably comprised between -10°C and 8°C , more preferably between -8°C and 6°C , even more preferably between -5°C and 5°C .

The addition of CSA to the suspension is made slowly, preferably in a period of time comprised from 30 to 60 min depending on the amount of the reagents employed and preferably under an inert atmosphere, for example under a nitrogen or argon atmosphere.

According to a preferred embodiment, the molar ratio between CSA and T3 is greater than 4, preferably comprised from 4.5 to 10, even more preferably comprised from 7 to 9. Even more preferably comprised from 7.5 to 8.5 mol of CSA/mol of T3. The concentration of T3 in DMAC, expressed as mol of T3/L of DMAC, is comprised from 0.06 to 0.15 mol/L, more preferably from 0.12 to 0.14 mol/L. It follows that, the ratio between CSA and solvent may be comprised from 0.35 to 1.28 mol of CSA/L of DMAC, preferably from about 0.8 to 1.15 mol/L, even more preferably from about 0.96 to 1.1 mol of CSA/L of DMAC.

30 After adding CSA, the mixture is allowed to react for a period of time not higher than 4-5 hours, generally without cooling, allowing the temperature to reach room temperature ($20-25^\circ\text{C}$).

Sulfation is generally completed, under the described conditions, when more than 85%, preferably more than 90%, even more preferably more than 95% T3 has been converted to T3S.

According to a particularly preferred embodiment, step a) of the process
5 foresees the addition of CSA to a T3 solution in DMAC at a concentration of 0.12-0.14 mol of T3/L of DMAC, with a preferred ratio of about 8 moles of CSA per mole of T3, at a temperature comprised from about -5°C to about 5°C, in a period of time of 30-40 min. At the end of the addition, cooling is generally stopped and the temperature is allowed to rise to room
10 temperature (comprised from about 15 to 25°C), for not more than 4-5 hours, preferably not more than 2-3 hours.

The sulfation mixture is then added according to salification step b), to an aqueous solution of an inorganic alkali salt, preferably mono-cationic, wherein Na is particularly preferred cation, in such an amount as to
15 neutralize the present chlorosulfonic acid.

Salification is preferably carried out with an aqueous solution of sodium carbonate (Na_2CO_3) or sodium hydrogen carbonate (NaHCO_3), in amounts function of the amount of chlorosulfonic acid used in the former step, and at least sufficient to neutralize the pH of the resulting solution. In general,
20 when Na_2CO_3 is used, an amount of about 1.5 moles per mole of CSA is sufficient. According to this embodiment, the Na_2CO_3 solution concentration is about 0.7 mol/L of solution. Under such conditions a solution pH after quenching comprised between 6.5 and 7.5 is obtained.

According to this embodiment, the corresponding mono-cationic salt of the
25 T3S compound obtained, has formula II, wherein M is preferably Na.

The addition of the reaction mixture according to step b) is carried out in a period of time which is variable, typically comprised from 1 h and 3h, while keeping a temperature lower than 30°C.

The T3S compound of formula II, obtained in solution as a mono-cationic
30 salt according to the step b) above described, is purified by chromatography, in accordance to a further step c). Chromatography is previously and optionally preceded by precipitation and/or filtration, for example gravimetical or under vacuum, of the reaction mixture obtained in

b), with the aim of reducing part of the inorganic salts that are formed as by-products.

Chromatography (c) is carried out on an adsorbent resin, of the polymer type. Preferably, such a resin is constituted by a macro reticular aromatic
5 polymeric matrix. Examples of preferred resins are XADTM AmberlitesTM, even more preferably AmberliteTM XADTM 1600.

As well known, before its use, the resin is activated by means of procedures known in the art, such as, for example, washings with water, acetone or the like (for a general reference, see Rohm and Haas in "*Laboratory Column*
10 *Procedures and Testing of Amberlite and Duolite Polymeric Adsorbents*", section "*Preparation of Resins*"). In accordance with the process of the invention the resin is preferably activated with the solvent selected for the next elution (i.e. acetone or a water/acetone mixture).

T3S is preferably eluted from the resin by an elution mixture of solvents
15 with a decreasing gradient of polarity, starting from the mixture having higher polarity. According to a preferred embodiment, said elution mixture is at first water, followed by successive dilutions with a suitable polar organic solvent, in suitable reciprocal ratios.

Preferred elution mixtures are represented by water/acetonitrile and
20 water/acetone in ratios comprised from 1:0 to 0.7:0.3. Preferably the elution mixture is represented by a mixture of water and acetone in a ratio comprised from 1:0 to 0.85:0.15 and the elution rate through the column is generally comprised from 0.9 to 1.1 volumes of column/h.

The fractions eluted from the column and containing the final product with a
25 purity level higher than 95%, more preferably higher than 96%, 98%, 99% (measured by analytical methods well known in the art, such as for example UV detection and analysed by HPLC analysis) are collected together and the active principle can be isolated by evaporating the solvent, i.e. under vacuum by freeze-drying or by other known methods.

30 However, according to a preferred embodiment, the eluted fractions are concentrated for example by partial evaporation under vacuum up to a concentration of about 10 g/kg of solution.

At this concentration, the pH of the solution is adjusted to values lower than 6.5, preferably comprised from 5.5 to 6.5, by adding a diluted strong inorganic acid solution, preferably one acid selected between sulfuric acid and hydrochloric acid, being hydrochloric acid particularly preferred, and
5 utilized in diluted form at a concentration comprised from 0.9 to 1.1 N.

The solution is further concentrated about 10-15 times and T3S can be isolated as a solid for example by freeze-drying, spray-drying, or, preferably treated with an organic solvent, preferably of a polar type to be isolated in solid form and then optionally further micronized.

10 Thus, according to this preferred embodiment, the Formula II compound is isolated in a solid form by treatment with a solvent selected from the group consisting of: acetone, acetonitrile and C₁-C₄ alcohols. However other solvents may be employed, which are selected among: aromatic alkanes, ethers, chlorinated solvents, esters, dimethylformamide, nitromethane,
15 dimethylsulfoxide, 2-methoxyethanol, or mixtures thereof, that allow to obtain a salt in solid form, and isolable.

Thus, in detail, after chromatography and concentration of the T3S containing fractions up to a concentration of about 10 g/kg of solution, pH adjustment to values lower than 6.5, preferably comprised from 5.5 to 6.5,
20 and further evaporation up to a concentration of the Formula II compound comprised from 170 to 500 g/kg of suspension or gel, the concentrated solution is treated with an organic solvent. Preferably, said solvent is a polar organic solvent selected among: acetone, lower alcohols, such as for example, ethanol, propanol, isopropanol, and the like, and acetonitrile,
25 being acetone particularly preferred.

The addition of acetone to the concentrated T3S solution occurs at a temperature comprised from 20 to 25°C, preferably leaving the mixture under stirring for 1-3 h at a temperature comprised from 0 to 25°C, in order to let the solid form of the mono-cationic T3S salt precipitate completely.

30 The addition of the solvent to the suspension occurs according to known proportions: when acetone is used, it's added in an amount comprised between 1-11 g acetone/g T3S, at a temperature comprised from 20-25°C.

The mono-cationic derivative of formula II, or more preferably the sodium salt thereof, is thus obtained in solid form after separation of the liquid phase from the solid one, for example by filtration, with a HPLC purity higher than 95%, more preferably, higher than 96%, 98% or even >99%.

5 Thus, taken as a whole, the process according to the invention allows to obtain isolation of the final product (T3S) in high yields (overall yield: $\geq 60\%$) and with a high purity level (HPLC >99%).

Actually, advantageously with prior art processes, already in the sulfation mixture a) in the presence of DMAC, the amount of by-products is lower
10 than 10%, generally lower than 7%.

The high conversion percentage in the sulfation reaction and the following salification allow then to obtain a product in pure form by an industrially applicable chromatographic step and with limited volumes.

T3S is efficiently separated from the other by-products and has high purity
15 (>99%) even when it is prepared in hundreds of grams thus rendering the use of this tri-iodothyronine derivative in clinical practice possible.

In order to prepare formulations for clinical use, T3S, in solid form and with a purity up to 99%, is preferably further micronized, for example under nitrogen pressure, to reduce the particle size.

20 Particularly preferred is a particle size smaller than 25 μm (at least 90%, more preferably at least 95% of the particles with dimensions lower than 25 μm) resulting stable for at least one month when submitted to accelerated stability trials in a climatic chamber.

Therefore, according to a preferred aspect of the invention, the process
25 comprises micronization of the solid T3S in a pure form, to give particles of the above defined size and the use thereof to prepare solid formulations, for oral administration.

According to this aspect, after micronization, T3S is formulated together with suitable additional components in powder mixtures, optionally also
30 under granular or microgranular form, preferably formulated as tablets or pills obtained through direct compression of the powder mixture.

The T3S formulation in solid form or more preferably into tablets, provides to add, to the micronized active principle (or principles when preferably in

combination with levo-thyroxine), firstly a part of the amount of the necessary final diluent, preferably 30, 40, or preferably at least 50% of the diluent, and mixing them to give mixture a).

Preferred diluent is cellulose or the derivatives thereof for example microcrystalline cellulose. Other suitable diluting agents are caolin, starch or
5 alkali inorganic salts such as magnesium or calcium carbonate. Particularly preferred is calcium carbonate, more preferably in association with microcrystalline cellulose.

Mixture a) is then mixed with a mixture b) comprising further components,
10 in general: a glidant agent, a lubricating agent and a disaggregating agent, their sieving and their successive mixing with mixture a) comprising the active principle.

Among the disintegrating agents, particularly preferred is croscarmellose or its derivatives. Other usable agents to this aim are crospovidone,
15 polymethacrylates, maltodestrines, starch sodium glicolate, pre-gelatinized starch, sodium alginate.

Among glidant agents, particularly preferred is glycerol dibehenate. Other usable glidants are: tribasic calcium phosphate, talc, starch or derivatives thereof.

20 Among the lubricating agents particularly preferred are magnesium or zinc stearate, colloidal hydrated silica, colloidal silicon dioxide. Further excipients, stabilizers and diluents (such as for example calcium carbonate) may be successively added and mixed for a variable time. The final mixture is then measured out and the tablets are preferably prepared by direct
25 compression.

T3S is present in the solid dosage units in amounts comprised from 1 and 1000 µg, more preferably from 2.5 to 500 µg, even more preferably from 5 to 250 µg, as the only active principle, or in combination with other active principles, preferably T4 (levo-thyroxine). According to this embodiment T4
30 is present in amounts comprised from 1 to 800 µg, or from 5-400 µg, more preferably from 10-200 µg. Accordingly then, in the preparation process of tablets comprising both T3 and T4 as active principles, these are mixed with

the preferred diluent(s) in mixture a) and further mixed with the other components, in their turn pre-mixed, as above described.

Therefore according to a preferred aspect the invention discloses a tablet prepared by the process above described, comprising T3S as the active principle, in a quantity comprised from 1 to 1000 µg together with the following additional components:

- the diluent, selected from cellulose or derivatives thereof, preferably together with a second diluent, preferably calcium carbonate, up to 35% of the total diluent (w/w);
- 10 - the glidant, selected from glycerol dibehenate (most preferred), talc, silica derivatives among which magnesium trisilicate, amides, tribasic calcium phosphate, are usually present in the composition in a quantity range from 1 to 10 %, most preferably 4 to 6% (w/w);
- the disintegrant selected from starch, croscarmellose sodium and crospovidone. Preferred is croscarmellose sodium salt in a quantity ranging from 0.5 to 10% even more preferably comprised from 1-5 %, most preferably comprised from 2-to 4% (w/w);
- 15 - the lubricant selected from magnesium stearate, hydrate colloidal silica and talc, more preferably magnesium stearate and colloidal silica, in a total quantity range comprised from 0.1 to 7% even more preferably the first one comprised from 0.1 to 2% and the second comprised from 0.5 to 5% (w/w).

Particularly preferred as excipients are the following ingredients: calcium carbonate, glycerol dibehenate, croscarmellose sodium salt, hydrate colloidal silica, magnesium stearate, microcrystalline cellulose, according to the following preferred quantities:

	Amount per Tablet
Calcium carbonate	20-40 mg, preferably 25-35 mg, more preferably 30 mg
Glycerol dibehenate	2-15 mg, preferably 4-8 mg, more preferably 5 mg
Croscarmellose sodium salt	1-10 mg, preferably 2-6 mg, more preferably 3.5 mg
Hydrate colloidal silica	0.1-5 mg, preferably 0.5-4, more preferably 2 mg
Magnesium stearate	0.01-2 mg, preferably 0.1-1 mg, more preferably 0.5 mg
Microcrystalline cellulose	At least 30 mg

In a more preferred embodiment, the composition comprises 2.5 to 500 μg T₃S or more preferably 5-250 μg T₃S.

For combination compositions where also T₄ is present, T₃S is preferably present in a quantity of from 2.5-500 μg and T₄ of from 1 to 800 μg , or, even more preferably: T₃S: 5-250 μg and T₄: 5-400 μg , or T₃S: 10-100 μg and T₄ 10-200 μg .

It is intended that the above quantities refer to single dosage units, preferably tablets of about 110 mg, preferably for daily single dosage administration, even though the skilled artisan may envisage adjustments due to alternative composition forms, tablet weight and/or therapeutic treatment protocols.

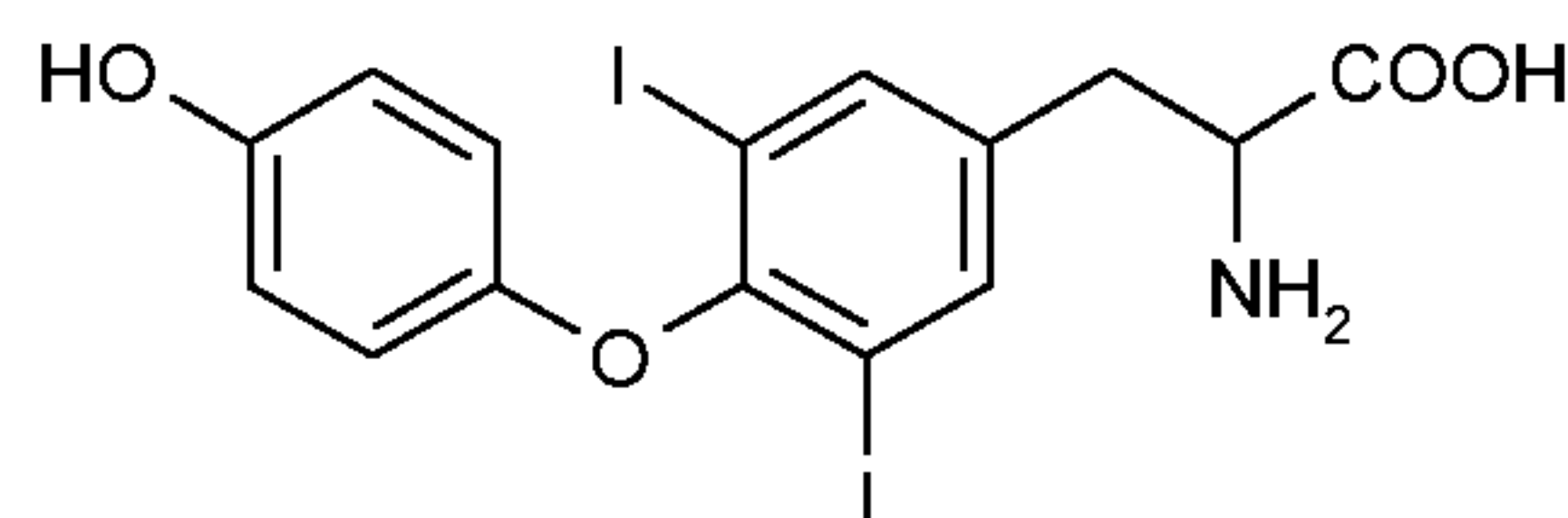
The tablets according to the preferred embodiment show optimal dissolution rates (see table below) and an optimal stability of the active principle(s) (at least 24 months).

The following properties measured in conditions according to ICH Guidelines:

Dissolution test	$\geq 75 \%$ after 45'
Moisture content	$\leq 10 \%$
Resistance to crushing	$\geq 20 \text{ N}$
HPLC Title T3S	90-110 %
HPLC Title T4 (when present)	90-110 %

In the process according to the invention all the reagents including T₃ (compound of formula I), are commercially available.

However, according to a particularly preferred embodiment, T3 is prepared by iodination of a compound of formula III (3,5-diiodo-thyronine, Levoditi, or T2):



[III]

with an iodinating agent, preferably NaI and I₂, in the presence of an aliphatic amine, preferably selected among the mono-alkyl (C₁-C₄) linear aliphatic amines, among which the preferred is ethylamine. T2 is preferably prepared as described.

The addition of the iodinating agent is carried out in the presence of an aqueous solvent, preferably water, at a temperature preferably lower than 25°C.

Preferably the iodinating agent is present at a molar ratio comprised from 0.9 to 1.1 mol/mol of compound III (T2).

After iodination, T3 is isolated, preferably by filtration, as sodium salt, then converted in acid form by re-suspension in water and acidification with an acid, preferably acetic acid or sulfuric acid.

The acid form is isolated, preferably by filtration, again re-suspended in water to remove salts and filtered.

T3, as a wet solid, is suspended in N,N-dimethylacetamide, the suspension is anhydried and submitted to sulfation reaction.

According to a preferred realization, the molar ratio between CSA and T3 is greater than 4, preferably comprised from 4.5 to 10, even more preferably comprised from 7 to 9. Even more preferably comprised from 7.5 to 8.5 mol of CSA/mol of T3. The concentration of T3 in DMAC, expressed as mol of T3/L of DMAC, is comprised from 0.10 to 0.15 mol/L, more preferably from 0.12 to 0.14 mol/L. It follows that, the ratio between CSA and solvent may be comprised from 0.58 to 1.28 mol of CSA/L of DMAC, preferably from 0.89 to 1.15 mol/L, even more preferably from 0.96 to 1.09 mol of CSA/L of DMAC.

After adding CSA, the mixture is allowed to react for a period of time not higher than 4-5 hours, generally without cooling, allowing the temperature to rise to room temperature.

Sulfation is generally completed, under the described conditions, when
5 more than 85%, preferably more than 90%, even more preferably more than 95% T3 has been converted to T3S.

According to a particularly preferred embodiment, step a) of the process foresees the addition of CSA to a T3 solution in DMAC at a concentration of 0.12-0.14 mol of T3/L of DMAC, with a preferred ratio of about 8 moles of
10 CSA per mole of T3, at a temperature comprised from about -5°C to about 10°C, in a period of time of 30-40 min. At the end of the addition, the cooling is generally stopped and the temperature is allowed to rise to room temperature (comprised from about 15 to 25°C), for not more than 4-5 hours, preferably not more than 2-3 hours.

15 The sulfation mixture is then added according to salification step b), to an aqueous solution of an inorganic alkali salt, preferably di-cationic, wherein Na is a particularly preferred cation, in such an amount as to neutralize the present chlorosulfonic acid.

Salification is preferably carried out with an aqueous solution of Na_2CO_3 or
20 NaHCO_3 , in amounts function of the amount of chlorosulfonic acid used, at least sufficient to neutralize the pH of the resulting solution. In general, when Na_2CO_3 is used, an amount of salt of at least 1.5 moles per mole of CSA is sufficient. When, according to a particularly preferred aspect, the inorganic alkali metal salt is Na_2CO_3 , its final concentration is at least 0.7
25 mol/L solution. Under such conditions, after quenching, a pH of the solution comprised from 6.5 to 7.5 is obtained.

According to this embodiment, the corresponding mono-cationic salt of the T3S compound obtained, has formula II, wherein M is preferably Na.

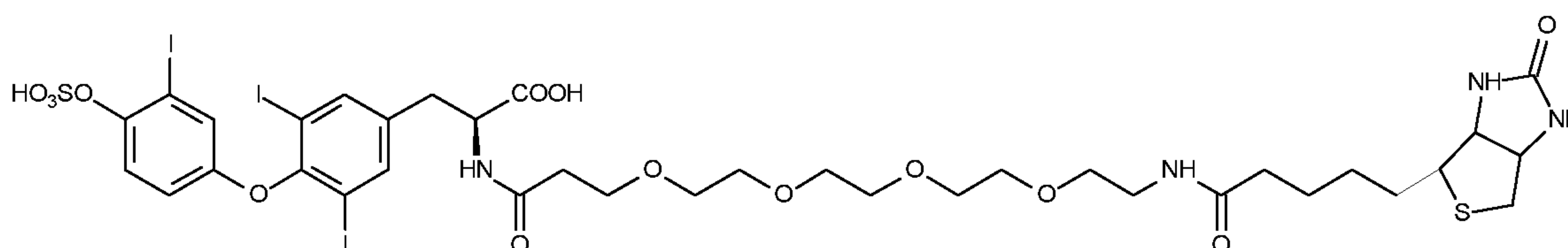
The addition of the reaction mixture according to step b) is carried out in a
30 period of time which is variable, typically comprised from 1 h and 3h, while keeping a temperature lower than 30°C.

The T3S compound of formula II, obtained in solution as a mono-cationic salt according to steps b) and c) as above described.

The process according to the invention describes for the first time, according to the Applicant's best knowledge, the preparation of T₃S from either T₃ or T₂, at a purity of at least 95%, more preferably, of at least 96%, 98% or >99%, for clinical use.

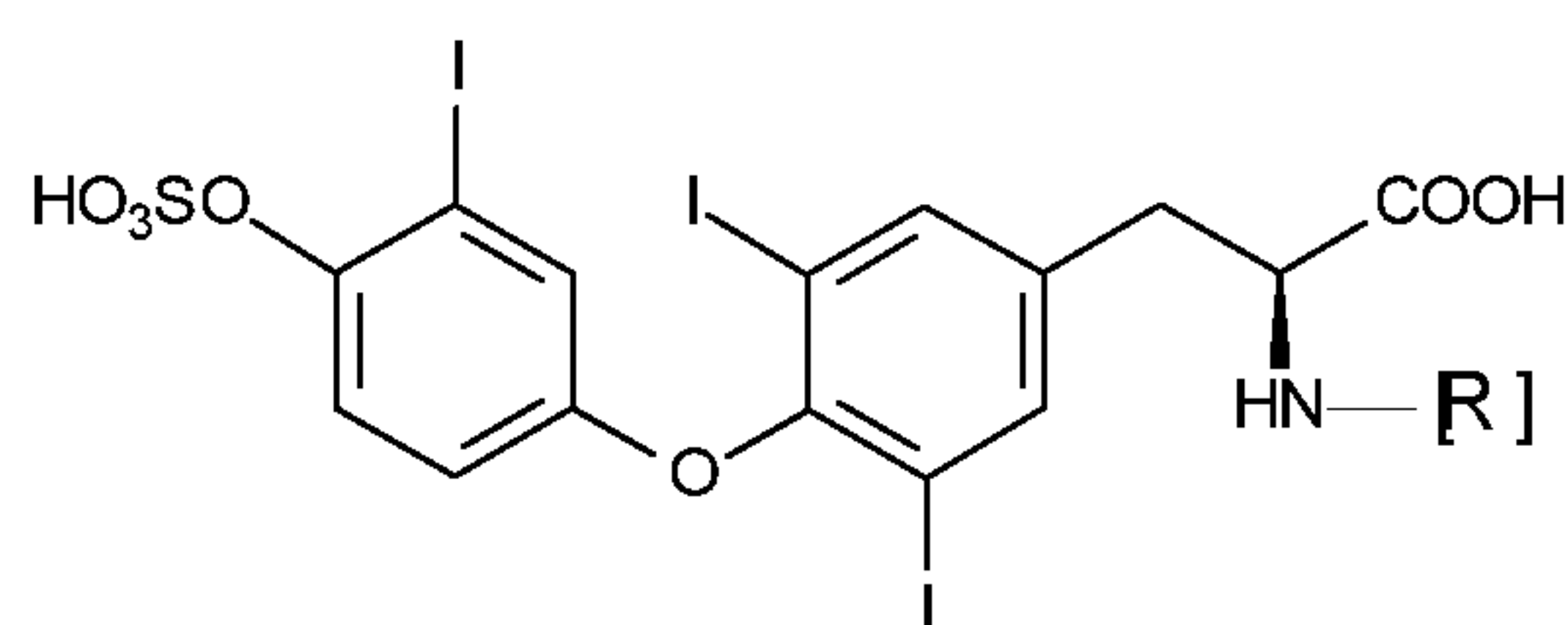
- 5 According to a further embodiment, the invention also relates to a non-radioactive T₃S immunoassay, either based on colorimetric, fluorescent or chemiluminescent detection.

Preferably the immunoassay is an Enzyme Linked Immuno Assay (ELISA), more preferably is a competitive ELISA where increasing amounts of
 10 T₃S compete for the binding to a solid phase bound anti-T₃S antibody, (e.g. the polyclonal disclosed in Chopra et al., J. Clin. Endocrinol. Metab., 1992, 75: 189-194) with a fixed amount of T₃S conjugated with a detectable moiety, such as a fluorescent group or an enzyme (e.g. horseradish peroxidase, alkaline phosphatase, etc.) or an avidin binding-derivative (i.e.
 15 biotin) optionally linked to a detectable moiety.



Formula A'

The T₃S derivatives useful for the non radioactive assays are generally
 20 comprised in the general Formula A:



Formula A

wherein R is selected from the group consisting of:

- a) a detectable moiety, selected from the group consisting of: a
 25 fluorescent group or an enzyme selected from the group consisting of: horseradish peroxidase, alkaline phosphatase,

- c) an avidin-binding derivative optionally linked to a detectable moiety,
- d) a lanthanide chelating agent.

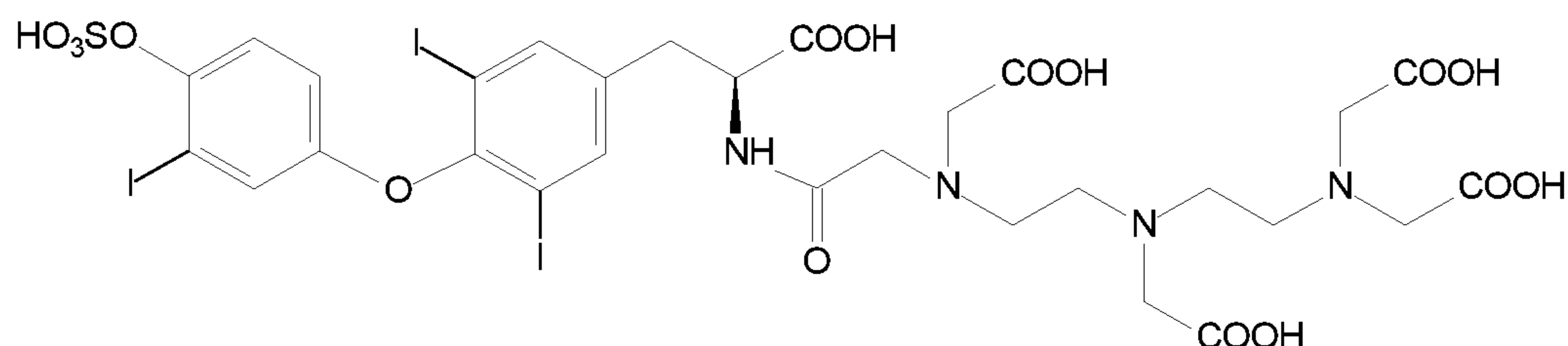
When R is a lanthanide chelating agent the T₃S derivative is preferably the compound of Formula IV.

The assay is preferably carried out in a multi-well plate. Preferably, the detectable moiety is a fluorescent group or an enzyme (e.g., horseradish peroxidase, alkaline phosphatase, etc.) or an avidin-binding -derivative (i.e. biotin). According to the latter embodiment, detection is preferably carried out with an avidin-derivative, preferably streptavidin comprising an enzyme such as Alkaline Phosphatase or Horseradish Peroxidase, preferably HRP, which converts specific substrates into coloured, fluorescent or chemiluminescent products. The use of biotin-avidin interaction, combined with the various detection luminescence as techniques for signal development, allows signal amplification and increased sensitivity comparable to a RIA test (see i.e. Chopra et al., J. Clin. Endocrinol. Metab., 1992, 75: 189-194) but without the need for radioactivity, a clear advantage over the prior art.

The ELISA assay, the T₃S -derivatives, such as the biotin derivative their synthesis and kits for T₃S quantitation comprising such reagents, represent a further objects of the present invention.

As an alternative embodiment the non-radioactive T₃S immunoassay is developed for a fluorescence technique, called Lanthanide Fluorescence Immuno-Assay, described in Hemmilä I et al. Anal Biochem. 1984 Mar;137(2): 335-43, by which a sensitivity from 1-1000 pg/ml T₃S is obtained. This assay developed for T₃S detection, the synthesized reagents, and kits for T₃S quantitation comprising said reagents, represent a further object of the invention.

Thus, accordingly, a DTPA- T₃S monoamide (3,5-Diiodo-N-[[[(carboxymethyl)[2-[(carboxymethyl)[2-[bis(carboxymethyl)amino]ethyl]amino]ethyl]amino]acetyl]-O-[3-iodo-4-(sulfooxy)phenyl]-L-tyrosine) of Formula IV, represents a chelating compound according to a preferred embodiment:

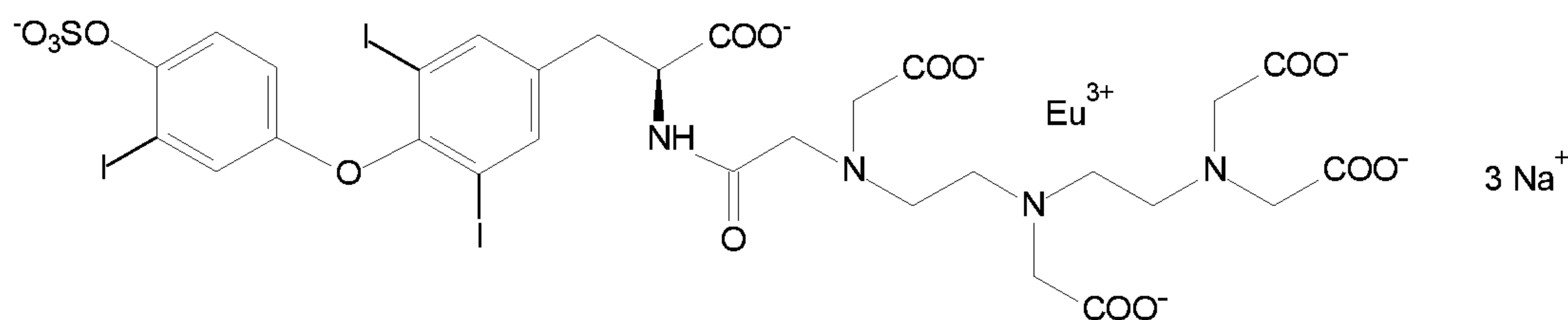


Formula IV

Other molecules can be designed and synthesized by an expert in the field, through conjugation of T₃S with a variety of chelating moieties, among those suitable for complexation of lanthanide ions, e.g., nitrilotriacetic acid (NTA), ethylenediaminetetraacetic acid (EDTA), ethylenediamine-N,N'-bis(2-hydroxyphenylacetic acid) (EDDHA), ethylenediaminedisuccinic acid (EDDS), propanediaminetetraacetic acid (PDTA), diethylenetriaminetetraacetic acid (DTTA), diethylenetriaminepentaacetic acid (DTPA), and similar molecules. Conjugation between the chelating agent and T₃S can be obtained by a variety of methods known to the expert in the field, including a direct amide bond formation, as exemplified in Experimental Part, or the use of bifunctional chelating agents, that may even be commercial products, such as (S)-1-p-isothiocyanatobenzyl diethylenetriaminepentaacetic acid (DTPA isothiocyanate – Invitrogen cat. I24221), or similar products.

Suitable lanthanide metals to be used as chelate labels are selected in the group consisting of: samarium, terbium, dysprosium and europium.

Particularly preferred is the Europium chelate 3,5-Diiodo-N-[[[(carboxymethyl)[2-[(carboxymethyl)[2-[bis(carboxymethyl)amino]ethyl]amino]ethyl]amino]acetyl]-O-[3-iodo-4-(sulfooxy)phenyl]-L-tyrosine (Formula V).



Formula V

A schematic of its synthesis is shown in Figure 2. The process can be summarized as follows: DTPA di-anhydride is partially hydrolysed by adding

an approximately equimolar amount of water dissolved in a suitable organic solvent, then the product, mainly composed of DTPA mono-anhydride is reacted with T_3S , in the presence of a suitable organic or inorganic base. After solvent evaporation, the oily residue is diluted with water. The
5 resulting precipitate is collected, washed with water and dissolved in a water/acetone mixture. This crude reaction product is purified on a column of Amberlite XAD1600, or similar resin, developed with mixtures or gradients of water/acetone. The product containing fractions are collected and evaporated to dryness, yielding the desired DTPA- T_3S monoamide.

10 Lanthanide complexation is obtained according to known procedures by adding an equimolar amount of a lanthanide salt to the monoamide water solution and adjusting the pH at 7 with a suitable base (e.g. NaOH). Optionally, the lanthanide chelated product can be desalted by adsorption on a resin column (e.g. Amberlite XAD1600) and elution with water/solvent
15 mixtures.

Also in this case, a sensitivity comparable to the known RIA test (see Chopra et al., ibidem) is obtained while avoiding the use of radioactive isotopes which represents a clear advantage over the prior art assay.

From the above teachings the skilled man may envisage alternative formats
20 of the ELISA which are nevertheless comprised in the present invention. For instance, the target hormone T_3S can be covalently bound to the plate and the antibody, optionally linked to a tracer enzyme or used in combination with an antibody linked to a tracer enzyme, used to competitively measure T_3S level in an unknown sample. According to a further embodiment, the
25 tracer is the antigen itself (T_3S) directly bound to a detectable enzyme (e.g., Alkaline Phosphatase or Horseradish Peroxidase) according to procedures known to the skilled man, also available in ready-to-use conjugation kit.

According to a further embodiment, the invention comprises a kit for T_3S
30 administration and dosage in serum, wherein said kit comprises a dosage kit for T_3S immunodetection by the above disclosed non-radioactive assays and an administration/therapeutic kit with a number of T_3S or T_3S and T_4

composition daily doses (i.e. the weekly, bi-weekly, monthly or bi-monthly need), preferably in the form of tablets as described above.

The dosage kit for T₃S non radioactive immunodetection may comprise according to a first preferred embodiment, polyclonal antibodies, the avidin-binding T₃S derivative, wherein preferably the conjugate is T₃S -biotin and the avidin-derivative detectable moiety is i.e. streptavidin. More preferably, the avidin-derivative is streptavidin and the detectable moiety comprises an enzyme chemiluminescent moiety (such as Alkaline Phosphatase or Horseradish Peroxidase), preferably HRP.

According to the lanthanide fluorescence immunoassay derived embodiment, the kit may comprise, together with antibodies, reagents specifically developed for such a detection, such as a lanthanide metals chelated complex T₃S derivatives, wherein the metal is selected in the group consisting of: samarium, terbium, dysprosium and europium. Particularly preferred is the Europium chelate 3,5-Diiodo-N-[[[(carboxymethyl)[2-[(carboxymethyl)[2-[bis(carboxymethyl)amino]ethyl]amino]ethyl]amino]acetyl]-O-[3-iodo-4-(sulfooxy)phenyl]-L-tyrosine (Formula V compound).

The kit may also comprise T₃S standards for the preparation of a calibration curve. The standard may be pre-diluted and ready for use as a solution at the correct concentration or for solubilisation in a suitable solvent. The kit may also comprise other reagents selected from the group consisting of: a diluent, a dye-molecule, a buffer, a preservative, an anti- T₃S antibody, an instruction leaflet.

The invention is now described by the following examples which are only explanatory and must not be construed as limitative of the scope of the invention.

EXPERIMENTAL SECTION

Example 1. Preparation of T₃S in DMAC

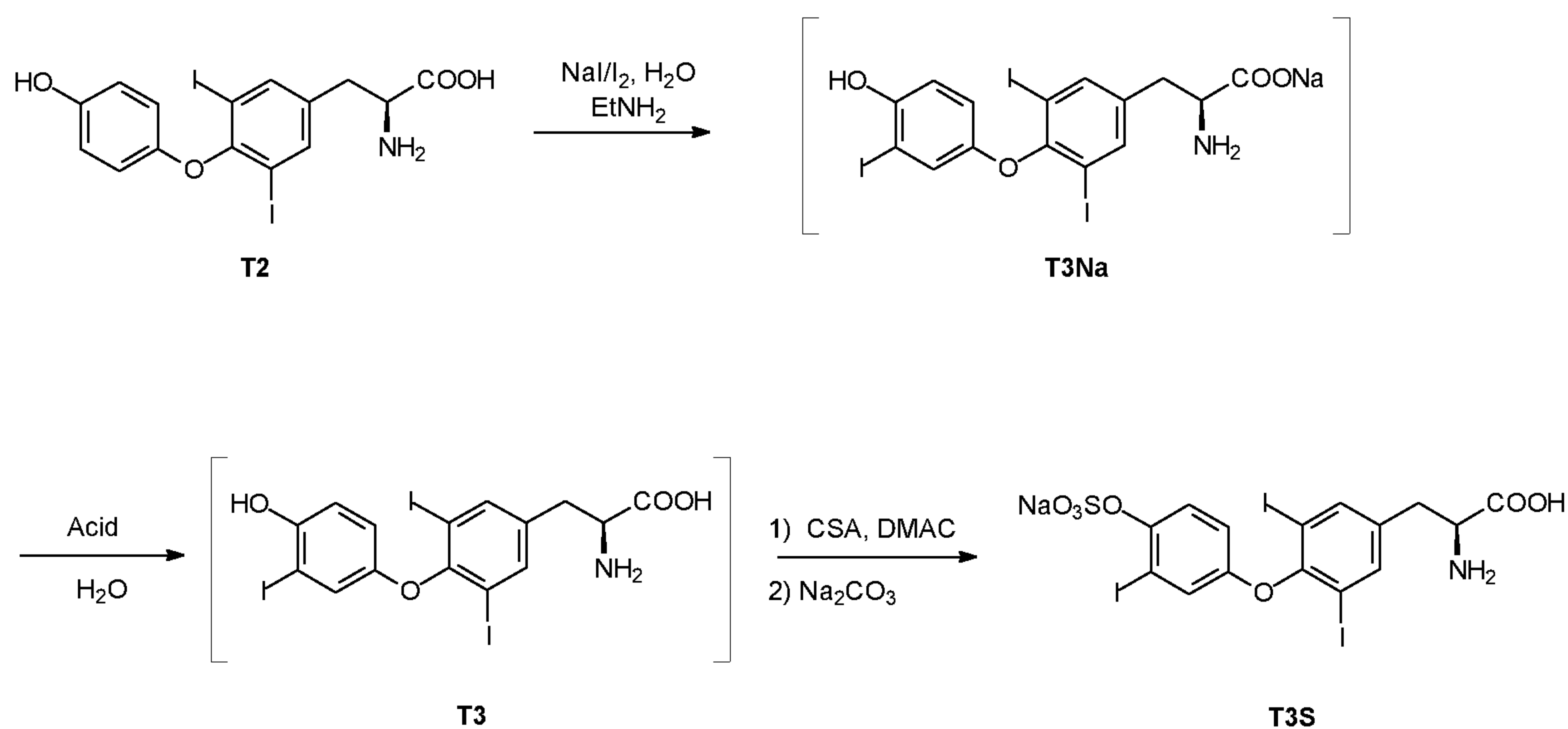
All the amounts of the raw materials are expressed with reference to 100 g of T₃.

3,5-diiodo-O-(4-hydroxy-3-iodophenyl)-L-tyrosine (100 g; 0.154 mol) was suspended in DMAC (2.0 L) under nitrogen atmosphere and vigorously

stirred in order to avoid solid precipitation. After cooling to -5°C , CSA (142.2 g; 1.229 mol) was added dropwise in 40 min while keeping the temperature between $-5 \div 5^{\circ}\text{C}$. At the end of the addition, cooling was stopped and the reaction mixture was left under stirring for about 4 h. The reaction mixture was added dropwise in 1.5 h, into a stirred aqueous solution of sodium bicarbonate (335.5 g; 3.994 mol in water, 4.5 L). At the end of the addition, from the so obtained solution with time it was observed the precipitation of a crystalline solid as a mixture of inorganic salts. Such a solid was filtered off, then the obtained solution was purified on Amberlite™ XAD™1600 by means of elution with water/acetone mixtures having decreasing polarity collecting the eluate into fractions. The fractions containing the product having an appropriate purity level were evaporated under vacuum up to a concentration of 10 g/kg. The pH of such suspension was adjusted to 6.2 with HCl 1N. The suspension was further concentrated up to a ratio of about 1:3 solid and residual water. Such a residue was treated with acetone under cooling for 2 h, then filtered off and washed with acetone. The product was dried at 40°C under vacuum. 74 g of T₃S were obtained as a white solid. Yield on the anhydrous base: 62%.

Example 2. Preparation of T₃S from T₂ (Levoditi)

The reaction schematic is presented below:



All quantities of raw materials are expressed for 1 kg of Levoditi.

Iodine (approx. 0.48 kg, source: SQM), NaI (approx. 0.65 kg, source: Ajay - SQM) and water were charged in a reactor 18-22°C and stirred until complete dissolution. The resulting iodinating mixture was maintained under stirring at room temperature until use.

- 5 Levoditi obtained from L-thyrosine according to the process described in: Chalmers, J. R. et al. A. J. Chem. Soc. 1949, 3424-3433), NaI (approx. 0.32 kg) and water were charged in another reactor and 70% monoethylamine was added.

The iodinating mixture was added to the reaction mixture.

- 10 The suspension obtained was stirred for at least 6 h at 18-22°C, then was cooled to 0°C in 1h, stirred for 3-4 h and filtered. The cake was washed with water.

The wet solid was suspended in water and acetic acid was added to the mixture and stirred. The suspension was filtered and the cake washed with

15 water.

The wet solid was re-suspended in water stirred, filtered and washed with water.

The cake was then suspended in DMAC (approx. 12.15 kg) and the suspension was anhydriified distilling under vacuum.

- 20 The suspension was cooled to 5-10°C and, in nitrogen atmosphere, CSA (approx. 1.54 kg) was slowly added and the temperature maintained below 15°C.

- The solution was heated to 18-22°C in 1 h and maintained for another hour, then was added in a reactor containing a solution of Na₂CO₃ (approx. 2.27
- 25 kg) in water (approx. 29.02 kg), previously prepared, maintaining the temperature under 30°C.

- The solution was purified onto a column of Amberlite XAD 1600 (12.5 L) by elution of water (87.5 L) and water/acetone mixtures (125 L) with decreasing polarity starting from 95:5 to 70:30. The fractions with high
- 30 HPLC purity were collected and distilled under vacuum until the desired composition was achieved (approx. 0.04 kg T₃S /L suspension).

The suspension was cooled to 40°C and Ethanol (approx. 5.22 kg) was added, obtaining a solution.

The mixture was cooled to 0°C in 2h, causing precipitation, stirred for another hour and then filtered. The cake was washed with Ethanol/water mixture at room temperature.

Wet solid was dried at approximately 40°C under vacuum.

- 5 0.98 kg of pure T3-Sulfate sodium salt (HPLC Area % > 99%) were obtained as a white solid.

Overall yield from T2 (on the anhydrous base): 68.5%.

Example 3. Preparation of T₃S tablets

- 10 The active principle, also in combination with different amounts of levo-thyroxine, was pre-mixed for fifteen minutes with 50% of the content of the microcrystalline cellulose.

- To this pre-mixture the following ingredients were added in this order: glycerol dibehenate, colloidal hydrated silica, sodium croscarmellose, magnesium stearate and calcium carbonate (previously sieved through a
15 0.6 mm clean light/mesh sieve), together with the remaining 50% of the microcrystalline cellulose, mixing for further 20 minutes.

- The uniformity of distribution of active principle in the mixture was checked by sampling from six points of the mixer; the text showed that the active principle (or the active principles) uniformly distribute within the mixture,
20 also in the case of formulation with levo-thyroxine.

The powders mixture was then compressed by means of a rotary tablet press equipped with a round flat punch and the tablets were submitted to tests for friability, disaggregation times and the active principle or principles distribution.

- 25 The results of the texts performed on the mixing and pressing process confirmed reproducibility of both of them, for T₃S dosages comprised from 25 to 200 µg. Moreover they showed that the tablets so obtained had parameters corresponding to the requirements provided for by the official European Pharmacopoeia (VI Ed.).

- 30 Tablet Composition

T ₃ S Na salt	20.6 µg (corresp. to 20 µg T ₃ S)
Calcium carbonate	30 mg
Glycerol dibehenate	5 mg
Croscarmellose sodium salt	3.5 mg
Hydrate colloidal silica	2 mg
Magnesium stearate	0.5 mg
Microcrystalline cellulose	Up to 110 mg

The tablets prepared as above described were used in clinical trials Phase I on thyroidectomised individuals, showing that they can be used as a thyroid hormone replacement therapy (see US 2011/0245342).

- 5 In fact, T₃S was shown to be absorbed (crossing the Gastrointestinal Barrier), was found in serum after oral administration and was converted to the clinically active T₃ in a dose-related fashion. T₃ levels in serum were still detectable 48 hrs after single dose administration.

Example 4. Quantitation of T₃S by immunoassay with chemiluminescence detection.

Synthesis of T3S biotin derivative

Briefly, T3S biotin derivative was synthesized as follows: N-hydroxysuccinimidyl d-biotin-15-amido-4,7,10,13-tetraoxapentadecylate A (50 mg; 0.0849 mmol) was solubilized in DMAC (2 mL), to which DIPEA (14.5 µL; 0.0866 mmol) was added, while maintaining the reaction mixture under continuous stirring at 0°C. T3S (68.4 mg; 0.0908 mmol, prepared as described in Mol & Visser, Endocrinology 1985, 117:1-7) was then added and after a few minutes the suspension was left to heat up to room temperature to give a clear solution. It was allowed to stir for 2 h, then kept overnight at the same temperature. DMAC was evaporated under reduced pressure (10 mbar; 40°C) to give a colourless oil. The crude so obtained was dissolved in H₂O and purified by Semi-preparative HPLC. The fractions containing the product were collected, concentrated and finally lyophilized to give T3S-biotin as a white solid (59.6 mg; 0.0495 mmol). Yield 58 %.

A polyclonal anti-T3S antiserum was obtained in rabbits as described in Chopra et al., J. Clin. Endocrinol. Metab., 1992, 75: 189-194.

The assay was based on a competitive ELISA in which increasing amounts of T3S competed for antibody binding with a fixed amount of T₃S conjugated with biotin, in a white 96 well plate. The employment of the biotin-avidin interaction, which allows signal amplification, combined with
 5 luminescence as technique for signal development allowed for a sensibility comparable to the RIA test (described in Chopra et al., J. Clin. Endocrinol. Metab., 1992, 75: 189-194).

Standard solutions of T3S were prepared at the following concentrations: 1000, 200, 40, 8, 1.6 pg/mL in Diluent Buffer: PBS, 0.05% Tween, 0.3%
 10 BSA

The tracer solution (T3S-Biotin, 180.6 μ M) was prepared in the above diluent buffer. Antibody solution: T3S rabbit antiserum was diluted 1:50000 in Diluent Buffer plus 8 mM ANS (1-anilino-8-naphthalene sulfonate), 1.2 mg/mL Sodium Salicylate.

15 A 96 well white plate was coated over night at 4 °C with 100 μ L/well of 2 μ g/mL anti Rabbit IgG diluted in phosphate buffer pH 7.8. At the same time, Standard solutions of biotin labelled T3S were combined with the diluted antiserum and the T3S-biotin solution as reported in Table Table A. The mixed samples were incubated at room temperature in the dark, over-night.

20 The day after, the plate was washed four times with Washing Buffer (0.05% Tween 20 in PBS), then incubated in Blocking Buffer (2% BSA in Washing Buffer) for 1 h at room temperature.

Afterwards, the plate was rinsed four times with Washing Buffer, 100 μ L/well of the mixed samples were added in triplicate and the plate was
 25 incubated 3 h at room temperature.

Then, the plate was rinsed three times with Washing Buffer and incubated with Streptavidin Poly-HRP (10 ng/mL in RASA, 100 μ L/well) for 1 h at room temperature.

After additional six washes, the plate was incubated with SuperSignal ELISA
 30 Femto Maximum Sensitivity Substrate (100 μ L/well) for 5 min in the dark and the emitted light was read as counts per second (CPS) with a luminescence plate reader.

Table A: Calibration Curve Preparation

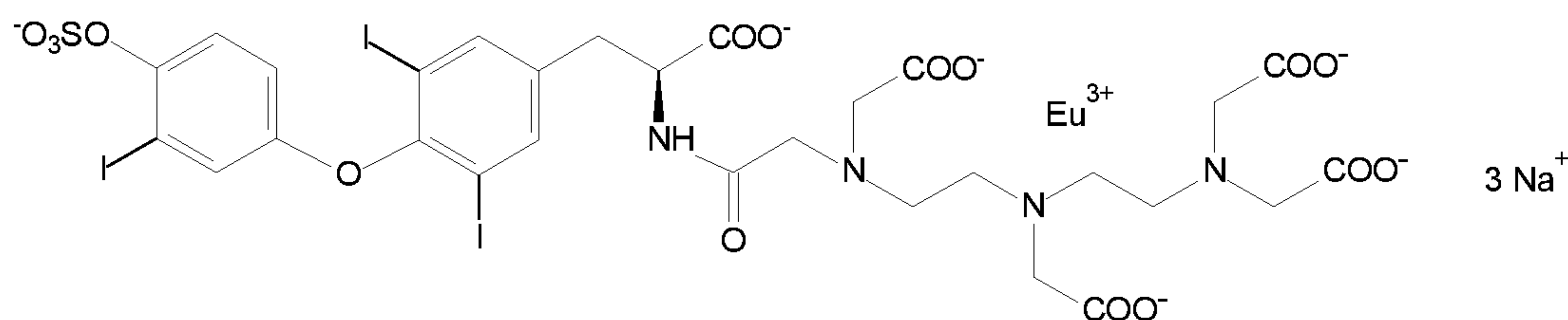
	T3S/1 (μL)	T3S/1 Antiserum (μL)	T3S-biotin (μL)
CS 5 (1000 pg/mL)	250	125	50
CS 4 (200 pg/mL)	250	125	50
CS 3 (40 pg/mL)	250	125	50
CS 2 (8 pg/mL)	250	125	50
CS 1 (1.6 pg/mL)	250	125	50
B0	-	125	50
NSB	-	-	50

The calibration curve was prepared in buffer using five concentrations of the test item in the range 1.6 - 1000 pg/mL. The curve is shown in Fig. 1, panel a).

5 **Example 5. Quantitation of T3S by the lanthanide fluorescence immunoassay.**

Preparation of Formula V compound:

[[3,5-Diiodo-N-[[[(carboxymethyl)[2-[(carboxymethyl)[2-
[bis(carboxymethyl) amino]ethyl]amino]ethyl]amino]acetyl]-O-[3-iodo-4-
10 (sulfooxy)phenyl]-L-tyrosinate(6-)]europate(3-)]trisodium (Formula V).



Synthesis of Eu-DTPA-T3S monoamide

The reaction scheme of the synthesis of 3,5-Diiodo-N-[[[(carboxymethyl)[2-
15 [(carboxymethyl)[2-[bis(carboxymethyl) amino]ethyl]amino]ethyl]
amino]acetyl]-O-[3-iodo-4-(sulfooxy)phenyl]-L-tyrosine (DTPA-T3S
monoamide) is shown in Figure 2.

A solution of H₂O (0.282 ml; 15.64 mmol) in DMAC (43 mL) was added
dropwise to a suspension of N,N-bis[2-(2,6-dioxymethyl) orange-4-
20 morpholinyl]ethyl]glycine A (4.27 g; 11.94 mmol) in DMAC (85 mL) at room
temperature. At the end of the addition the mixture was heated to 80°C.
After 4.5 h the reaction mixture was cooled to 25°C and a solution of T3S/1
(3 g; 3.98 mmol) and DIPEA (2.71 mL; 15.92 mmol) in DMAC (85 mL) was

added dropwise over 20 min. DMAC was evaporated under reduced pressure (10 mbar; 40°C). The oily residue was diluted with H₂O (200 mL), obtaining precipitation of a yellowish solid that was filtered washed with H₂O and dried. The crude so obtained was dissolved in Acetone/H₂O 20:80 (v/v), the solution (pH = 2,97) was loaded on an Amberlite® XAD-1600 resin column (200 mL; diam. 6 cm) and eluted with a Acetone/ H₂O gradient. The fractions containing the product having similar composition were collected and evaporated to give the ligand DTPA-T3S as a solid (1.27 g; 1.15 mmol). Yield 26 %.

Europium chloride hexahydrate (0.17 g, 0.46 mmol) was added in portions to a solution of the ligand DTPA-T3S (0.51 g; 0.46 mmol) in H₂O (50 mL) at 20°C (pH 2.93); after each addition the suspension was stirred until complete dissolution. Once the complexation was complete the pH was adjusted to 7 with 0.1 N NaOH and the solution was desalted by elution with water/acetone from a column of Amberlite® XAD-1600 resin (100 mL; diam. 3 cm) . The fractions containing the desired product and free from salts were collected and evaporated to give the compound of Formula IV (0.37 g, 0.28 mmol) a yellow solid. Yield: 61%.

The immunoassay method was designed according to: Hemmilä I et al. Anal Biochem. 1984 Mar;137(2): 335-43. The solutions used were as described in the Example 4 with the following exceptions: a DELFIA® Wash (Perkin Elmer) was used instead of the above Washing buffer. The Tracer stock solution contained the Europium 100 µM and it was stored at +4°C, protected from light. Just before use it was diluted 1:300000 in Assay Buffer to obtain a final concentration of 440 pg/mL.

The assay was performed in DELFIA® Yellow plates (Perkin Elmer).

After the 3-h incubation with the mixed samples, the Formula V diluted compound solution was added (50 µL per well) to all wells. The plates were then sealed with plastic adhesive sheets and incubated under agitation for 1 h at 37°C.

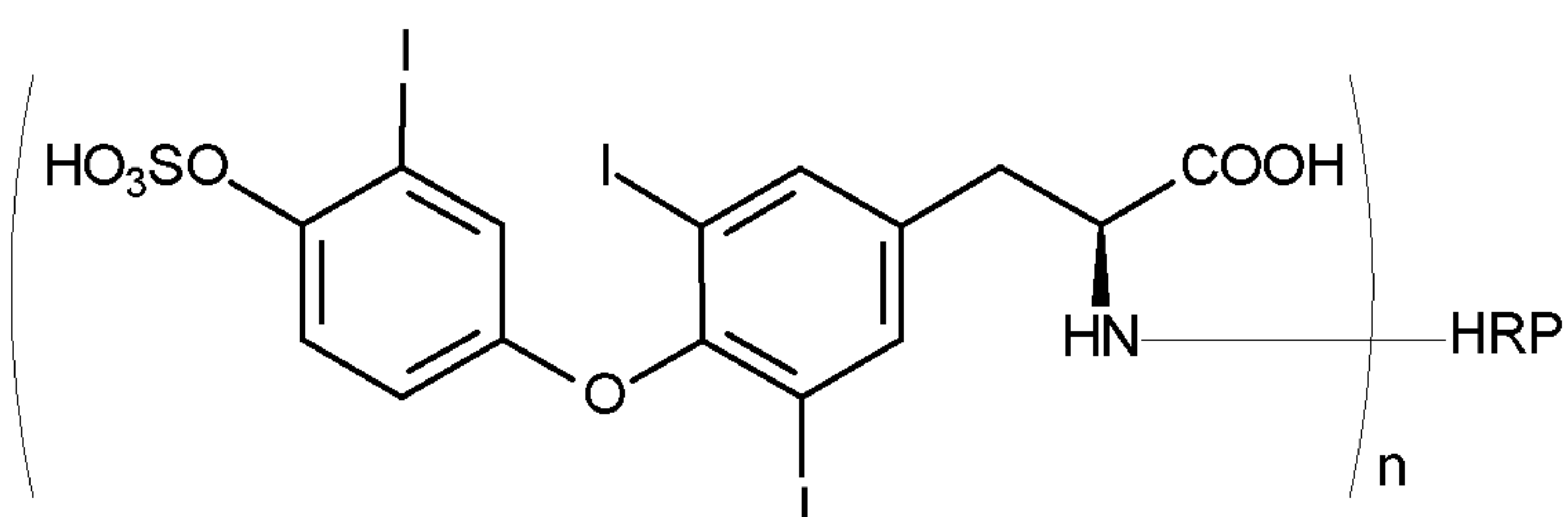
After three washes, the plates were tapped dry on absorbent paper, and Delfia Enhancement Solution (Perkin Elmer) was added (200 µL) After 1 h

at 25°C, the plates were read in a Victor3 instrument according to the "Europium" manufacturer protocol.

A calibration curve was prepared using nine concentrations of the test item in the range 30 - 2000 pg/mL. The curve is shown in Fig. 1, panel b).

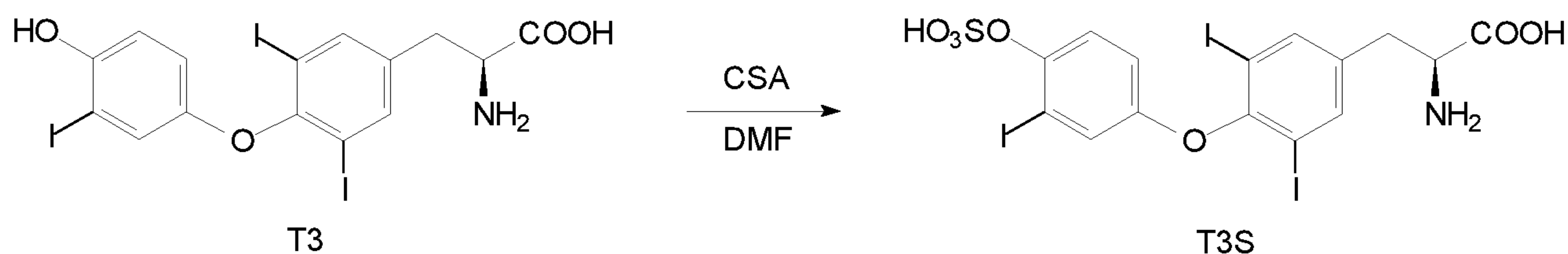
5 **Example 6. Synthesis of HRP-T3S monoamide**

The conjugate was prepared directly using a commercial kit containing activated HRP (e.g., HOOK™ HRP PLUS Labeling Kit – G-Biosciences). 1-2 mg of T3S was dissolved in 1 mL of the supplied carbonate buffer, then this solution was dispensed in a vial containing the lyophilized activated HRP, mixing gently by repeated pipetting in order to reconstitute the activated enzyme. After about 1 hour at room temperature, 20 µL of the supplied Sodium Cyanoborohydride (NaCNBH₃) solution was added, then allowing to react for about 15 min at room temperature. Finally, 50µL of quenching buffer was added, then incubating with gentle tumbling or shaking for 15 min. The final conjugate was desalted and buffer exchanged in PBS by either dialysis or column desalting. Appropriate dilutions of the T3S-HRP conjugate were prepared and used as a tracer in a single-step ELISA, as described in Example 4, omitting the Streptavidin-HRP incubation step.



20

Comparative example: T3S synthesis in DMF and elution trials.



25 The reaction was carried out according to the scheme above, in DMF. Briefly: T3 (40 mg) was dissolved in ammoniacal ethanol. This solution was evaporated under a stream of nitrogen.

To the residual, 2 ml of a hot solution of Chlorosulfonic acid (obtained by mixing 2.5 mL of 99% Chlorosulfonic acid and 8 ml of N,N-DMF) was added. Subsequently, the mixture was allowed to reach room temperature under stirring and the reaction was continued overnight.

- 5 The mixture was diluted with water (5 mL) and then was eluted on a column of Sephadex LH-20 (5 mL), obtaining fraction A. The elution was continued with 0.1 N HCl (5 mL), obtaining fraction B.

These fractions were re-loaded on column and purified by serial elution of 0.1 N HCl (approx. 4 mL), water and absolute Ethanol.

- 10 However, five different water and absolute ethanol quantities were used for purification. The T3S yields and purities obtained by these five conditions have been summarized in Table B.

Table B: Purification trials

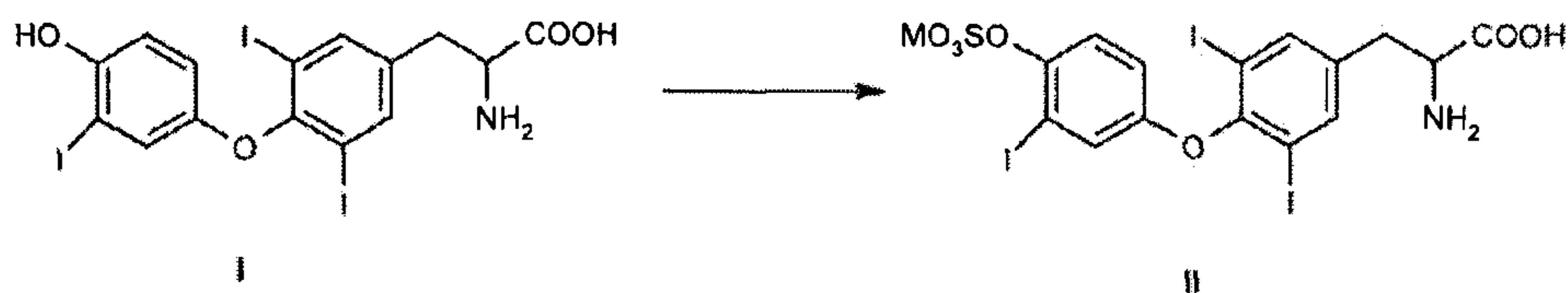
Trial	H ₂ O	abs. EtOH	T3-Sulfate from aqueous fractions			T3-Sulfate from alcoholic fractions		
	(mL)	(mL)	Amount (mg)	Purity ^(a) (%)	Yield (%)	Amount (mg)	Purity ^{(a)(b)} (%)	Yield ^(c) (%)
1	5	10	1.0	100	2.2	35	80	62.3
2	50	100	2.5	100	5.6	30	80	53.4
3	125	125	8.0	100	17.8	30	75	50.1
4	Not registered	100	Not registered	Not registered	-	30	75	50.1
5	40	10	Not registered	Not registered	-	10	50	11.1
		20	Not registered	Not registered	-	20	70	31.2
(a) ¹ H-NMR purity.								
(b) From the analyses, the product is a mixture of T3S and T3.								
(c) Yields are calculated on the content of T3-Sulfate.								

Table B shows that when the synthesis is carried out in the conditions described above and DMF is used as the solvent, high conversion may be achieved, but the overall yield is quite low.

5

CLAIMS

1. A process for the preparation of a sulfated form of a thyroid hormone having formula II (T₃S) according to the following reaction:



wherein:

M is an alkaline metal;

comprising the steps of:

- a) sulfation of a compound of formula I with chlorosulfonic acid (CSA) in the presence of dimethylacetamide (DMAC);
 - b) salification to give a compound of formula II, in an aqueous solution of an alkaline metal inorganic salt;
 - c) purification of the formula II compound by chromatography on macroreticular aromatic polymeric matrix and elution with a decreasing polarity mixture of water and an organic solvent.
2. The process according to claim 1, wherein M is Na.
3. The process according to claim 1 or claim 2, wherein said inorganic salt is a sodium salt.
4. The process according to any one of claims 1-3, wherein the molar ratio between CSA and the compound of formula I is comprised from 4 to 10.
5. The process according to claim 4, wherein the molar ratio between CSA and the compound of formula I is comprised from 7 to 9.
6. The process according to any one of claims 1-5 wherein in step a) the concentration of the compound of formula I in DMAC is comprised from 0.060 and 0.090 mol/L of DMAC.
7. The process according to any one of claims 1-6 wherein the sulfation reaction in step a) is carried out at a temperature below 10° C.
8. The process according to claim 7 wherein the sulfation reaction in step a) is carried out at a temperature of from -10° C to 8° C.
9. The process according to claim 7 or claim 8, wherein the sulphatation in step a) is left to occur for at least 2 hours.
10. The process according to any one of claims 1-9, wherein the salification according to step b) is carried out in an aqueous solution of NaHCO₃.

11. The process according to any one of claims 1-10, wherein said step c) is optionally preceded by a filtration step.
12. The process according to any one of claims 1-11, wherein said decreasing polarity mixture is a mixture of water and a polar solvent in a ratio comprised from
5 1.0:0 and 0.7:0.3 of water to polar solvent.
13. The process according to claim 11 or claim 12, wherein after elution, the solution is concentrated up to at least 10g of Formula II compound/kg, and the solution is brought to pH values of from 5.5 to 6.5.
14. The process according to any one of claims 1-13, wherein the compound of
10 formula II is obtained as a solid after treatment with an organic polar solvent.
15. The process according to claim 14, wherein said polar organic solvent is selected from: acetone, ethanol, isopropanol and acetonitrile.
16. The process according to claim 14 or claim 15, wherein the compound of formula II in the solid form is further micronized.
- 15 17. The process according to any one of claims 14-16, which comprises further admixing the solid and/or micronized form of the compound of formula II, optionally in combination with levo-thyroxine (T4), with at least one diluent selected from the group consisting of: cellulose or a derivative thereof, kaolin, starch and inorganic alkaline salts selected from: calcium and magnesium
20 carbonate.
18. The process according to claim 17, wherein the mixture of the compound of formula II and the diluent, wherein the diluent is microcrystalline cellulose, is further admixed with at least one glidant agent selected from the group consisting of: glycerol dibehenate, tribasic calcium phosphate, talc, starch and derivatives
25 thereof, at least one disintegrant selected from the group consisting of: croscarmellose or derivatives thereof, crospovidone, polymethylacrylates, maltodextrin, sodium glycolate starch, pre-gelatinized starch, sodium alginate, and optionally, a lubricating agent selected from the group consisting of: magnesium stearate, zinc stearate, colloidal hydrated silica and colloidal silicon dioxide, and
30 then formulated in tablets by direct compression of the mixture.
19. The process according to any one of claims 1-18, wherein the reagent of formula I is obtained by iodinating a 3',5 di-iodothyronine (T2) with an iodinating agent in an aqueous media and in the presence of an aliphatic amine.
20. The process according to claim 19, wherein the iodinating agent is a mixture
35 comprising I₂/NaI.

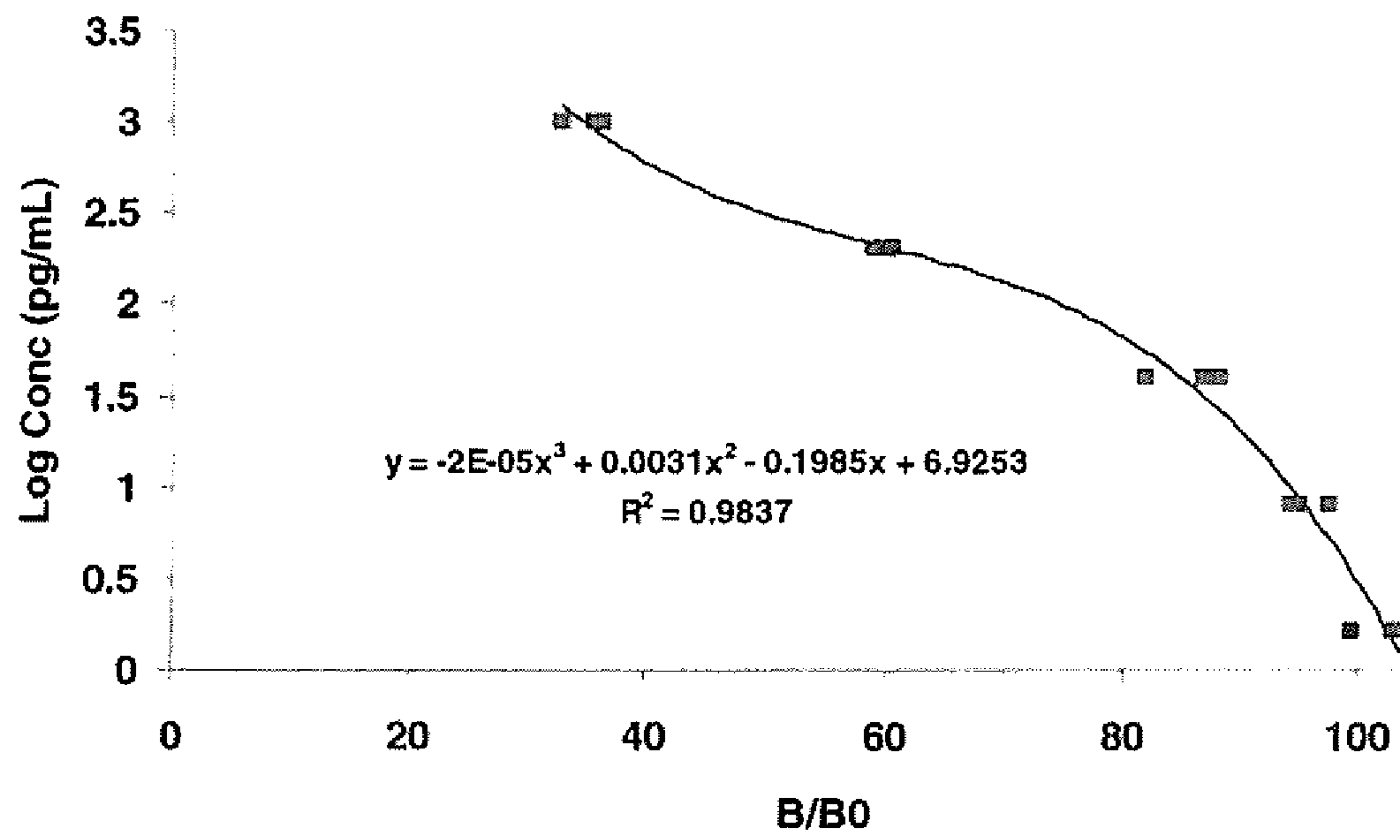


Figure 1 Panel a)

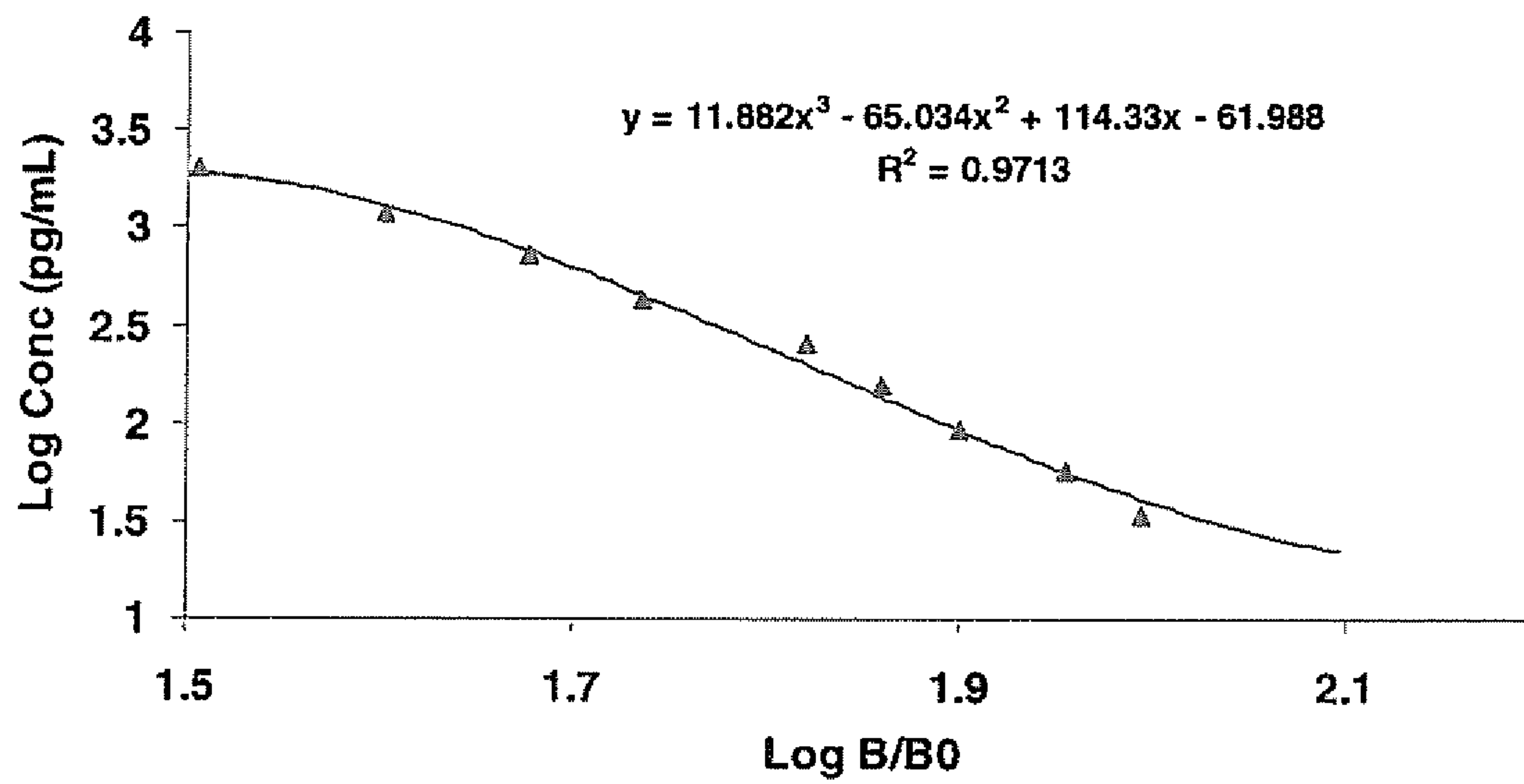


Figure 1 Panel b)

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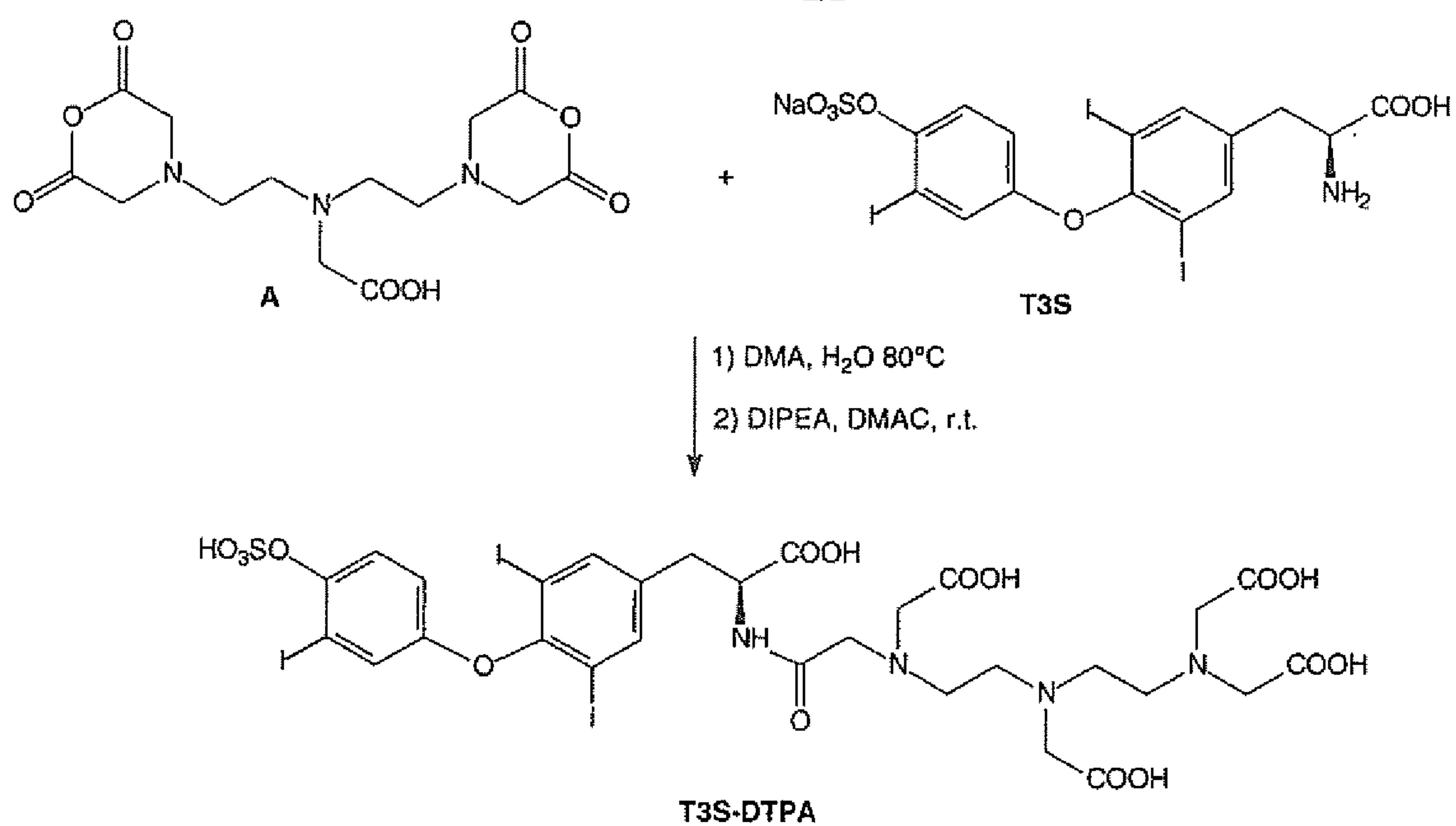


Figure 2