



(22) Date de dépôt/Filing Date: 2008/12/30

(41) Mise à la disp. pub./Open to Public Insp.: 2009/07/16

(62) Demande originale/Original Application: 2 676 477

(30) Priorité/Priority: 2007/12/31 (US61/018,021)

(51) Cl.Int./Int.Cl. *C07D 401/12* (2006.01),
A61K 31/4439 (2006.01), *A61K 9/52* (2006.01),
A61P 1/00 (2006.01)

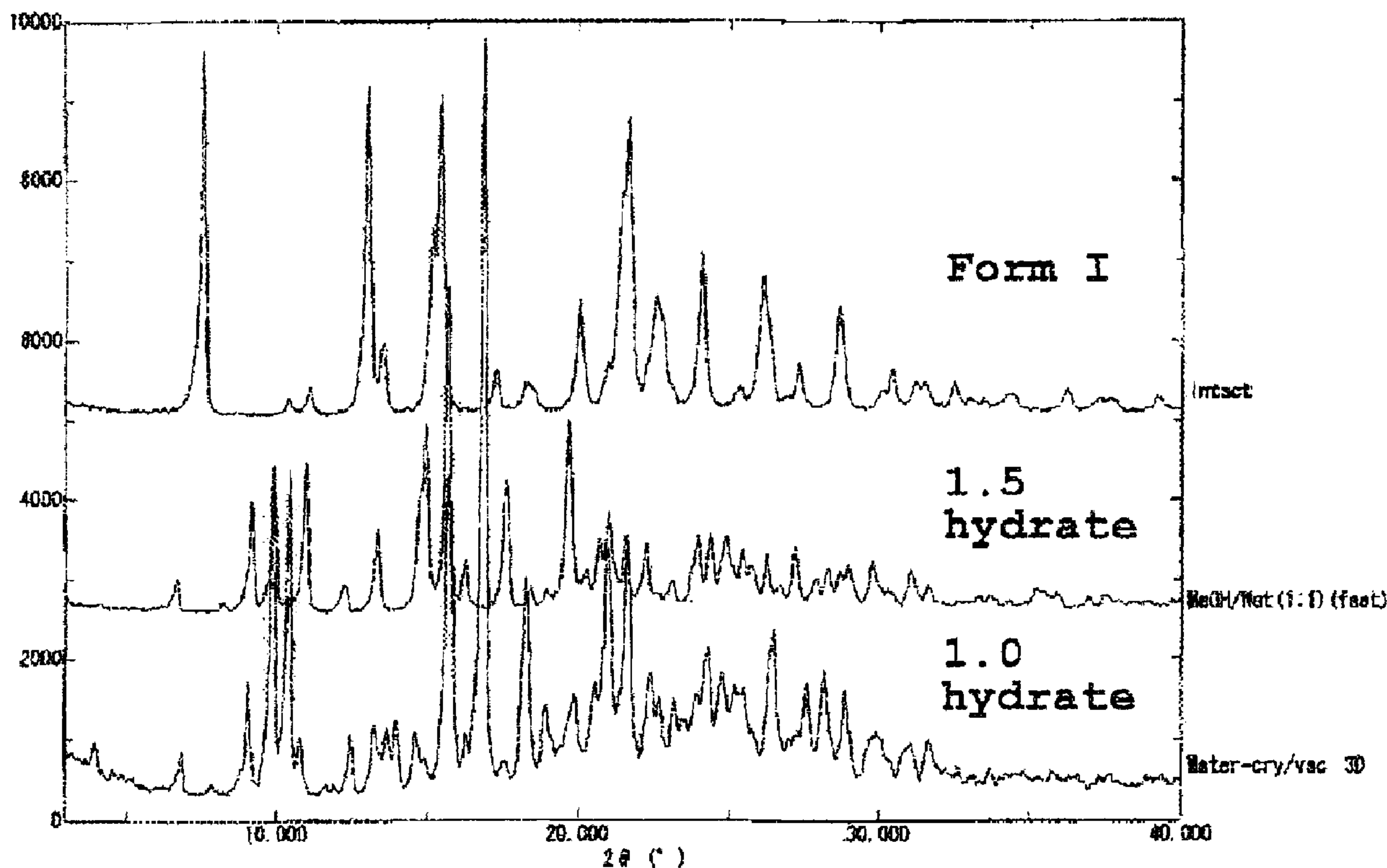
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(54) Titre : FORMES SOLVATEES DE CRISTAUX DE (R)-2-[[[3-METHYL-4-(2,2,2-TRIFLUOROETHOXY)-2-PYRIDINYL] METHYL] SULFINYL]-1H-BENZIMIDAZOLE

(54) Title: CRYSTALLINE SOLVATED FORMS OF (R)-2-[[[3-METHYL-4-(2,2,2-TRIFLUOROETHOXY)-2-PYRIDINYL]METHYL]SULFINYL]-1H-BENZIMIDAZOLE



(57) Abrégé/Abstract:

The present invention relates to crystals of (R)-2-[[[3-methyl-4-(2,2,2-trifluoromethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole of the present invention, which are useful as antiulcer agents.

27103-625D

Abstract:

The present invention relates to crystals of
(*R*)-2-[[[3-methyl-4-(2,2,2-trifluoromethoxy)-2-pyridinyl]methyl]sulfinyl]-
1H-benzimidazole of the present invention, which are useful as antiulcer agents.

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DESCRIPTION

CRYSTALLINE SOLVATED FORMS OF (R)-2-[[[3-METHYL-
4-(2,2,2-TRIFLUOROETHOXY)-2-PYRIDINYL]METHYL]SULFINYL]-1H-BENZIMIDAZOLE

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This application is a divisional of application No. 2,676,477
filed on December 30, 2008.

TECHNICAL FIELD OF THE INVENTION

10 The present invention relates to a crystal of a
benzimidazole compound showing an antiulcer action.

BACKGROUND OF THE INVENTION

2-[[[3-Methyl-4-(2,2,2-trifluoroethoxy)-2-
pyridinyl]methyl]sulfinyl]-1H-benzimidazole or a salt thereof
15 having an antiulcer action has been reported in JP-A-61-50978,
etc.

An anhydrous or hydrate crystal of optically active (R)-
2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-
pyridinyl]methyl]sulfinyl]-1H-benzimidazole has been reported
20 in JP-A-2001-058990, JP-A-2002-037783, JP-A-2002-226478 and
the like.

SUMMARY OF THE INVENTION

The present inventors have conducted intensive studies of
a novel crystal of (R)-2-[[[3-methyl-4-(2,2,2-
25 trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole
currently sold all over the world as a pharmaceutical product
having a superior antiulcer activity, and found a novel
hydrate crystal, a novel methanol solvate crystal, a novel
ethanol solvate crystal, a novel ethanol·hydrate crystal, and a
30 novel isopropanol·hydrate crystal, and also found that these
crystals unexpectedly show different physical properties
(solubility, transfer stability), particularly properties of
solubility, although they contain the same drug ingredient as
the conventional crystals of optically active forms. Since the
35 solubility of a drug may influence the bioavailability due to
the pharmaceutical agent side during the gastrointestinal
absorption process, the crystals of the present invention can
be designed differently as a preparation from the conventional
crystals. Moreover, these crystals can be synthetic
intermediates for crystals of a pharmaceutical product having
superior antiulcer activity, (R)-2-[[[3-methyl-4-(2,2,2-

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trifluoroethoxy)-2-pyridinyl)methyl]sulfinyl]-1H-benzimidazole.
They have found that these crystals serve satisfactorily as
pharmaceuticals or synthetic intermediates for pharmaceuticals.
Based on these findings, they have completed the present
5 invention.

Accordingly, the present invention relates to:

- [1] a hydrate crystal of (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl)methyl]sulfinyl]-1H-benzimidazole wherein the X-ray powder diffraction analysis pattern has
10 characteristic peaks at interplanar spacings (d) of 9.62 ± 0.2 , 8.90 ± 0.2 , 5.93 ± 0.2 , 5.66 ± 0.2 and 5.04 ± 0.2 Angstrom; (Form II crystal)
- [2] an ethanol·hydrate crystal of (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl)methyl]sulfinyl]-1H-benzimidazole
15 wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar spacings (d) of 13.23 ± 0.2 , 6.21 ± 0.2 , 4.75 ± 0.2 , 4.51 ± 0.2 and 4.41 ± 0.2 Angstrom; (Form III crystal)
- [3] an isopropanol·hydrate crystal of (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl)methyl]sulfinyl]-1H-benzimidazole wherein the X-ray powder diffraction analysis
20 pattern has characteristic peaks at interplanar spacings (d) of 14.90 ± 0.2 , 5.01 ± 0.2 , 4.56 ± 0.2 , 4.26 ± 0.2 and 3.50 ± 0.2 Angstrom; (Form IV crystal)
- [4] a hydrate crystal of (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl)methyl]sulfinyl]-1H-benzimidazole wherein the X-ray powder diffraction analysis pattern has
25 characteristic peaks at interplanar spacings (d) of 9.21 ± 0.2 , 6.70 ± 0.2 , 5.88 ± 0.2 , 4.83 ± 0.2 and 4.40 ± 0.2 Angstrom; (Pattern V
30 crystal)
- [5] a hydrate crystal of (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl)methyl]sulfinyl]-1H-benzimidazole wherein the X-ray powder diffraction analysis pattern has
characteristic peaks at interplanar spacings (d) of 8.86 ± 0.2 ,
35 8.43 ± 0.2 , 5.60 ± 0.2 , 5.22 ± 0.2 and 4.83 ± 0.2 Angstrom; (Form VI

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crystal);

[6] a methanol solvate crystal of (*R*)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar spacings (*d*) of 13.42±0.2, 5 13.22±0.2, 6.21±0.2, 6.16±0.2, 4.51±0.2 and 4.32±0.2 Angstrom;

[7] an ethanol solvate crystal of (*R*)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar spacings (*d*) of 13.71±0.2, 13.50±0.2, 13.22±0.2, 13.06±0.2 and 6.16±0.2 Angstrom;

10 [8] a 1.0 hydrate crystal of (*R*)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar spacings (*d*) of 8.93±0.2, 8.47±0.2, 5.65±0.2, 5.63±0.2 and 5.25±0.2 Angstrom;

15 [9] a 1.5 hydrate crystal of (*R*)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar spacings (*d*) of 5.95±0.2, 5.91±0.2, 5.65±0.2, 4.51±0.2 and 4.50±0.2 Angstrom;

[10] a 1.5 hydrate crystal of (*R*)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole, which has a powder X-ray diffraction 20 pattern shown in Form II of Fig. 1;

[11] a 1.5 hydrate crystal of (*R*)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole, which is produced by a process comprising agitating a mixture of (*R*)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole, and water and another solvent (e.g. 25 acetone or ethanol) at a mixing ratio of 1:1 to 100:1.

[12] a pharmaceutical agent which comprises the crystal of any of the above-mentioned [1] to [11];

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[13] a pharmaceutical agent according to the above [12], which is an agent for the prophylaxis or treatment of digestive ulcer, reflux esophagitis, symptomatic gastroesophageal reflux disease (GERD); and so forth;

[14] a pharmaceutical formulation comprising the crystal of any of the above-
5 mentioned [1] to [11] and a pharmacologically acceptable carrier; and which may be an oral dosage form;

[15] use of a crystal of any of the above-mentioned [1] to [11] for the prophylaxis or treatment of digestive ulcer, reflux esophagitis, symptomatic gastroesophageal reflux disease (GERD); and so forth; and

10 [16] use of a crystal of any of the above-mentioned [1] to [11] for the manufacture of a pharmaceutical agent.

BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1 shows X-ray powder diffraction patterns of solvate crystals of (*R*)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-
15 benzimidazole.

Figure 2 shows FT-Raman spectrums of solvate crystals of (*R*)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole.

Figure 3 shows solid ¹³C-NMR spectrums of solvate crystals of
20 (*R*)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-

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pyridinyl)methyl)sulfinyl]-1H-benzimidazole.

Figure 4 shows X-ray powder diffraction patterns of methanol solvate crystal and ethanol solvate crystal of (R)-2-
 5 [[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl)methyl)sulfinyl]-1H-benzimidazole.

Figure 5 shows X-ray powder diffraction patterns of hydrate crystals of (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl)methyl)sulfinyl]-1H-benzimidazole.

Figure 6 is a chart showing concentration vs. time for
 10 Forms I, II, III, IV and VI of R(+)-lansoprazole in water under constant agitation at up to 25°C.

Figure 7 is a scheme showing the relationships among Forms I, II, III, IV and VI of R(+)-lansoprazole.

DETAILED DESCRIPTION OF THE INVENTION

15 A hydrate crystal of (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl)methyl)sulfinyl]-1H-benzimidazole includes 0.5 hydrate to 5.0 hydrate. Among others, 0.5 hydrate, 1.0 hydrate, 1.5 hydrate, 2.0 hydrate and 2.5 hydrate are preferred. More preferred is 0.5 hydrate, 1.0 hydrate or 1.5
 20 hydrate. In addition, a hydrate of (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl)methyl)sulfinyl]-1H-benzimidazole may be deuterium substituted.

As an alcohol solvate crystal of (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl)methyl)sulfinyl]-1H-
 25 benzimidazole, for example, methanol solvate crystal, ethanol solvate crystal, propanol solvate crystal, isopropanol solvate crystal and the like can be mentioned, and methanol solvate crystal, ethanol solvate crystal, isopropanol solvate crystal and the like are preferable, and methanol solvate crystal and
 30 ethanol solvate crystal are particularly preferable.

An alcohol solvate crystal of (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl)methyl)sulfinyl]-1H-benzimidazole includes 0.1 alcohol solvate to 3.0 alcohol solvate.

Specific examples of the methanol solvate crystal and
 35 ethanol solvate crystal include 0.4 to 0.6 methanol solvate,

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0.5 to 0.7 ethanol solvate and the like, and 0.5 methanol solvate and 0.6 ethanol solvate are particularly preferable.

A solvate crystal of (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole
5 may be formed using two or more kinds of solvents, and an embodiment wherein the crystal is formed using two kinds of solvents is preferable.

When a solvate crystal is formed using two or more kinds of solvents, the solvents are selected from alcohol (methanol,
10 ethanol, propanol, isopropanol and the like), water and the like. Preferably, a solvate crystal is formed using alcohol and water, more preferably ethanol and water, or isopropanol and water. In the present invention, for example, "a solvate crystal formed using ethanol and water" is indicated as an
15 "ethanol·hydrate crystal".

When a solvate crystal is formed using two or more kinds of solvents, the molar ratio of the total amount of solvents used relative to (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole is generally
20 selected from the range of 0.1 mol to 3.0 mol.

When a solvate crystal is formed using two or more kinds of solvents, while the constitution ratio of the solvent is not particularly limited, it is selected from the range of alcohol:water = 1:0.5 to 1:3.0, in the case of, for example,
25 an alcohol·hydrate crystal.

As a solvate crystal formed using two or more kinds of solvents, an ethanol·hydrate crystal or an isopropanol·hydrate crystal is preferable. Specific examples include a 0.5 to 0.9 ethanol·0.8 to 1.2 hydrate crystal and a 0.5 to 0.9
30 isopropanol·1.0 to 1.4 hydrate crystal, with particular preference given to a 0.7 ethanol·1 hydrate crystal and a 0.7 isopropanol·1.2 hydrate crystal.

The hydrate crystal, methanol solvate crystal, ethanol solvate crystal, ethanol·hydrate crystal and isopropanol·
35 hydrate crystal of (R)-2-[[[3-methyl-4-(2,2,2-

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trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole of the present invention can be produced by subjecting 2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole or a salt thereof to an optical resolution or
 5 subjecting 2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]thio]-1H-benzimidazole to an asymmetrical oxidization to obtain the (R)-isomer, followed by crystallizing the resultant isomer, or transforming the known crystal of the (R)-isomer.

10 Methods of optical resolution include per se known methods, for example, a fractional recrystallization method, a chiral column method, a diastereomer method, and so forth. Asymmetric oxidation includes per se known method.

The "fractional recrystallization method" includes a
 15 method in which a salt is formed between a racemate and an optically active compound [e.g., (+)-mandelic acid, (-)-mandelic acid, (+)-tartaric acid, (-)-tartaric acid, (+)-1-phenethylamine, (-)-1-phenethylamine, cinchonine, (-)-cinchonidine, brucine, etc.], which salt is separated by
 20 fractional recrystallization etc., and, if desired, subjected to a neutralization process, to give a free optical isomer.

The "chiral column method" includes a method in which a racemate or a salt thereof is applied to a column for optical isomer separation (chiral column). In the case of liquid
 25 chromatography, for example, optical isomers are separated by adding a racemate to a chiral column such as ENANTIO-OVMTM (produced by Tosoh Corporation) or the DAICEL CHIRALTM series (produced by Daicel Corporation), and developing the racemate in water, a buffer (e.g., phosphate buffer), an organic
 30 solvent (e.g., hexane, ethanol, methanol, isopropanol, acetonitrile, trifluoroacetic acid, diethylamine, triethylamine, etc.), or a solvent mixture thereof. In the case of gas chromatography, for example, a chiral column such as CP-Chirasil-DeX CBTM (produced by GL Science) is used to
 35 separate optical isomers.

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The "diastereomer method" includes a method in which a racemate and an optically active reagent are reacted (preferably, an optically active reagent is reacted to the 1-position of the benzimidazole group) to give a diastereomer mixture, which is then subjected to ordinary separation means (e.g., fractional recrystallization, chromatography, etc.) to obtain either diastereomer, which is subjected to a chemical reaction (e.g., acid hydrolysis, base hydrolysis, hydrogenolysis, etc.) to cut off the optically active reagent moiety, whereby the desired optical isomer is obtained. Said "optically active reagent" includes, for example, an optically active organic acids such as MTPA [α -methoxy- α -(trifluoromethyl)phenylacetic acid] and (-)-menthoxyacetic acid; and an optically active alkoxymethyl halides such as (1R-endo)-2-(chloromethoxy)-1,3,3-trimethylbicyclo[2.2.1]heptane, etc.

2-[[[3-Methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole or a salt thereof is produced by the methods described in JP-A-61-50978, USP 4,628,098 etc. or analogous methods thereto.

Methods of crystallization include per se known methods, for example, a crystallization from solution.

Methods of the "crystallization from solution" include, for example, a concentration method, a slow cooling method, a reaction method (diffusion method, electrolysis method), a hydrothermal growth method, a fusing agent method, and so forth. Solvents to be used include, for example, aromatic hydrocarbons (e.g., benzene, toluene, xylene, etc.), halogenated hydrocarbons (e.g., dichloromethane, chloroform, etc.), saturated hydrocarbons (e.g., hexane, heptane, cyclohexane, etc.), ethers (e.g., diethyl ether, diisopropyl ether, tetrahydrofuran, dioxane, etc.), nitriles (e.g., acetonitrile, etc.), ketones (e.g., acetone, etc.), sulfoxides (e.g., dimethylsulfoxide, etc.), acid amides (e.g., N,N-dimethylformamide, etc.), esters (e.g., ethyl acetate, etc.),

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alcohols (e.g., methanol, ethanol, isopropyl alcohol, etc.), water, and so forth. When a hydrate crystal is to be obtained, water, a mixture of water and other solvent, and the like are used; when an alcohol solvate crystal is to be obtained, 5 alcohol or a mixture of alcohol and other solvent is used; and when an alcohol·hydrate crystal is to be obtained, a mixture of alcohol and water or a mixture of alcohol, water and other solvent is used.

When a mixed solvent of two or more kinds is to be used, 10 they are mixed at a suitable ratio (e.g., 1:1 to 1:100) and used. Preferably, two or more kinds of solvents are mixed at a ratio of 1:1 to 1:20, more preferably the ratio of water:other solvent is 1:1, 1:9 or 9:1 (e.g., the ratio of water:methanol is 1:1, the ratio of water:ethanol is 1:9, the ratio of 15 water:acetone is 9:1, the ratio of water:ethanol is 9:1).

Known crystals to be used for transformation from known crystals include the anhydrous crystal and hydrate crystal described in JP-A-2001-058990, hydrate crystal described in JP-A-2002-037783, anhydrous crystal described in JP-A-2002- 20 226478 and the like.

(R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole 1.5 hydrate crystal (after-mentioned Form II) can be produced by a production method characterized by a process of agitating a mixture of (R)-2-[[[3- 25 methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole (preferably, anhydrous crystal of (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole), and water and other solvent (e.g., acetone, ethanol etc.) at a mixing ratio of 1:1 to 100:1 (preferably, 1:1 30 to 20:1, more preferably, 9:1) at an ambient temperature for 2 to 4 days (preferably, 3days ± 6 to 12 hrs, more preferably, 3 days) by constant rotation. As the "other solvent" in the mixture, acetone is preferable.

As other production method, (R)-2-[[[3-methyl-4-(2,2,2- 35 trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole

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1.5 hydrate crystal (1.5 hydrate crystal of the after-mentioned (2)) can be produced by a production method characterized by a process of crystallization from a mixture of (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole (preferably, anhydrous crystal of (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole), and water and other solvent (e.g., acetone, methanol etc.) at a mixing ratio of 1:1 to 1:20 (preferably, 1:1) by standing the mixture at -25 to -15 °C (preferably, -20 °C ± 1 °C, more preferably, -20 °C ± 0.5 °C, still more preferably, -20 °C). The crystals obtained by the production method are dried under reduced pressure for 2 day to 4 days (preferably, 3 days ± 6 to 12 hrs, more preferably, 3 days) to give (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole 1.0 hydrate crystal (the after-mentioned 1.0 hydrate crystal). As the "other solvent" in the mixture, methanol is preferable.

(R)-2-[[[3-Methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole 0.5 hydrate crystal (the after-mentioned Form VI) can be produced by a production method characterized by drying (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole 1.5 hydrate crystal (the above-mentioned Form II) at an ambient temperature under vacuum. As the "drying" under vacuum, drying for 24 hrs ± 6 to 12 hrs (preferably, overnight) is preferable.

(R)-2-[[[3-Methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole methanol solvate crystal (the after-mentioned methanol solvate crystal) can be produced by a production method characterized by a process of crystallization from a solution obtained by adding methanol to (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole at room temperature (preferably, anhydrous crystal of (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole).

(R)-2-[[[3-Methyl-4-(2,2,2-trifluoroethoxy)-2-

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pyridinyl)methyl)sulfinyl]-1H-benzimidazole ethanol solvate crystal (the after-mentioned ethanol solvate crystal) can be produced by a production method characterized by a process of crystallization from a solution obtained by adding ethanol to
 5 (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl)methyl)sulfinyl]-1H-benzimidazole (preferably, anhydrous crystal of (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl)methyl)sulfinyl]-1H-benzimidazole) at room temperature.

10 (R)-2-[[[3-Methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl)methyl)sulfinyl]-1H-benzimidazole ethanol hydrate crystal (preferably, about 0.7 ethanol · 1 hydrate) (the after-mentioned Form III) can be produced by a production method characterized by a process of dissolving (R)-2-[[[3-methyl-4-
 15 (2,2,2-trifluoroethoxy)-2-pyridinyl)methyl)sulfinyl]-1H-benzimidazole (preferably, anhydrous crystal of (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl)methyl)sulfinyl]-1H-benzimidazole) in a mixture of water and ethanol at a dissolution ratio of 1:1 to 1:20 (preferably, 1:9), and
 20 precipitation from the solution.

(R)-2-[[[3-Methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl)methyl)sulfinyl]-1H-benzimidazole isopropanol hydrate crystal (preferably, about 0.7 isopropanol · 1.2 hydrate) (after-mentioned Form IV) can be produced by a
 25 production method characterized by a process of filtering a solution of (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl)methyl)sulfinyl]-1H-benzimidazole (preferably, anhydrous crystal of (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl)methyl)sulfinyl]-1H-
 30 benzimidazole) in isopropanol and evaporating the filtrate under ambient conditions to allow crystallization. As the "filtering", filtering with a 0.1 to 0.5 μm (preferably, 0.2 μm) filter is preferable.

(R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl)methyl)sulfinyl]-1H-benzimidazole hydrate crystal (the
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after-mentioned Form V) can be produced by a production method characterized by a process of agitating a mixture of (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole (preferably, anhydrous crystal of (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole), and water and other solvent (e.g., acetone, ethanol etc.) at a mixing ratio of 1:1 to 100:1 (preferably, 1:1 to 20:1, more preferably, 9:1) at an ambient temperature for 2 to 4 days (preferably, 3days $\pm$ 6 to 12 hrs, more preferably, 3 to 10 days) by constant rotation. As the "other solvent" in the mixture, ethanol is preferable.

As a method of crystal transformation, crystallization from the above-mentioned solution, as well as, for example, a transpiration method (known crystal is dissolved in a solvent and, after filtration, the solvent is evaporated under ambient conditions), a slurry method (known crystal is added to a solvent such that excess solid remains to give a suspension, the suspension is stirred at ambient temperature or under heating and the solid is collected by filtration), drying under reduced pressure, trituration, pressurization and the like can be mentioned.

For analyzing the crystal obtained, X-ray diffraction crystallographic analysis is commonly used. In addition, crystal orientation can also be determined by a mechanical method, an optical method (e.g., FT-Raman spectrum, solid NMR spectrum), etc.

The peak of the spectrum obtained by the above-mentioned analysis method inevitably contains a certain measurement error by its nature. A crystal with a spectrum peak within the error range is also encompassed in the crystal of the present invention. For example, " ± 0.2 " in the interplanar spacing (d) of powder X-ray diffraction means that the error is tolerable.

As (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole solvate crystal, a 1.5 hydrate crystal wherein the X-ray powder diffraction

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analysis pattern has characteristic peaks at interplanar spacings (d) of 9.62 ± 0.2 , 8.90 ± 0.2 , 5.93 ± 0.2 , 5.66 ± 0.2 and 5.04 ± 0.2 Angstrom, preferably, a 1.5 hydrate crystal wherein the X-ray powder diffraction analysis pattern has

5 characteristic peaks at interplanar spacings (d) of 9.62 ± 0.2 , 8.90 ± 0.2 , 8.07 ± 0.2 , 6.63 ± 0.2 , 6.01 ± 0.2 , 5.93 ± 0.2 , 5.66 ± 0.2 , 5.04 ± 0.2 , 4.50 ± 0.2 and 3.00 ± 0.2 Angstrom, more preferably, a 1.5 hydrate crystal wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar

10 spacings (d) of 9.62 ± 0.2 , 8.90 ± 0.2 , 8.07 ± 0.2 , 6.63 ± 0.2 , 6.01 ± 0.2 , 5.93 ± 0.2 , 5.66 ± 0.2 , 5.04 ± 0.2 , 4.50 ± 0.2 , 3.51 ± 0.2 and 3.00 ± 0.2 Angstrom (hereinafter referred to as Form II crystal), an about 0.7 ethanol·1 hydrate crystal wherein the X-ray powder diffraction analysis pattern has characteristic peaks at

15 interplanar spacings (d) of 13.23 ± 0.2 , 6.21 ± 0.2 , 4.75 ± 0.2 , 4.51 ± 0.2 and 4.41 ± 0.2 Angstrom, preferably, an about 0.7 ethanol·1 hydrate crystal wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar spacings (d) of 13.23 ± 0.2 , 6.21 ± 0.2 , 5.06 ± 0.2 , 4.97 ± 0.2 ,

20 4.75 ± 0.2 , 4.51 ± 0.2 , 4.41 ± 0.2 and 4.32 ± 0.2 Angstrom (hereinafter referred to as Form III crystal), an about 0.7 isopropanol·1.2 hydrate crystal wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar spacings (d) of 14.90 ± 0.2 , 5.01 ± 0.2 , 4.56 ± 0.2 ,

25 4.26 ± 0.2 and 3.50 ± 0.2 Angstrom, preferably an about 0.7 isopropanol·1.2 hydrate crystal wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar spacings (d) of 14.90 ± 0.2 , 6.66 ± 0.2 , 5.01 ± 0.2 , 4.56 ± 0.2 , 4.50 ± 0.2 , 4.36 ± 0.2 , 4.26 ± 0.2 , 3.90 ± 0.2 , 3.63 ± 0.2 and

30 3.50 ± 0.2 Angstrom (hereinafter referred to as Form IV crystal), a hydrate crystal wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar spacings (d) of 9.21 ± 0.2 , 6.70 ± 0.2 , 5.88 ± 0.2 , 4.83 ± 0.2 and 4.40 ± 0.2 Angstrom, preferably a hydrate crystal wherein the X-

35 ray powder diffraction analysis pattern has characteristic

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peaks at interplanar spacings (d) of 9.21 ± 0.2 , 8.30 ± 0.2 , 6.70 ± 0.2 , 6.12 ± 0.2 , 5.88 ± 0.2 , 4.83 ± 0.2 , 4.71 ± 0.2 , 4.66 ± 0.2 , 4.40 ± 0.2 and 3.18 ± 0.2 Angstrom, more preferably, a hydrate crystal wherein the X-ray powder diffraction analysis pattern

5 has characteristic peaks at interplanar spacings (d) of 20.03 ± 0.2 , 13.26 ± 0.2 , 9.50 ± 0.2 , 9.21 ± 0.2 , 8.30 ± 0.2 , 6.80 ± 0.2 , 6.70 ± 0.2 , 6.12 ± 0.2 , 5.88 ± 0.2 , 5.71 ± 0.2 , 5.62 ± 0.2 , 4.88 ± 0.2 , 4.83 ± 0.2 , 4.71 ± 0.2 , 4.66 ± 0.2 , 4.50 ± 0.2 , 4.40 ± 0.2 , 4.15 ± 0.2 , 4.13 ± 0.2 , 4.09 ± 0.2 , 3.93 ± 0.2 , 3.69 ± 0.2 , 3.66 ± 0.2 , 3.62 ± 0.2 ,

10 3.47 ± 0.2 , 3.42 ± 0.2 , 3.39 ± 0.2 , 3.21 ± 0.2 , 3.18 ± 0.2 , 3.14 ± 0.2 , 3.12 ± 0.2 , 3.10 ± 0.2 , 2.77 ± 0.2 , 2.67 ± 0.2 , 2.43 ± 0.2 and 2.42 ± 0.2 Angstrom (hereinafter referred to as Pattern V crystal),

a 0.5 hydrate crystal wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar

15 spacings (d) of 8.86 ± 0.2 , 8.43 ± 0.2 , 5.60 ± 0.2 , 5.22 ± 0.2 and 4.83 ± 0.2 Angstrom, preferably, a 0.5 hydrate crystal wherein the X-ray powder diffraction analysis pattern has

characteristic peaks at interplanar spacings (d) of 8.86 ± 0.2 , 8.43 ± 0.2 , 5.60 ± 0.2 , 5.22 ± 0.2 , 4.83 ± 0.2 and 4.21 ± 0.2 Angstrom

20 (hereinafter referred to as Form VI crystal) and the like can be mentioned, with preference given to Form II crystal, Form III crystal, Form IV crystal, Pattern V crystal and Form VI crystal.

As (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-

25 pyridinyl]methyl]sulfinyl]-1H-benzimidazole methanol solvate crystal, a methanol solvate crystal wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar spacings (d) of 13.42 ± 0.2 , 13.22 ± 0.2 , 6.21 ± 0.2 , 6.16 ± 0.2 , 4.51 ± 0.2 and 4.32 ± 0.2 Angstrom,

30 preferably, a methanol solvate crystal wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar spacings (d) of 13.76 ± 0.2 , 13.42 ± 0.2 , 13.22 ± 0.2 , 6.21 ± 0.2 , 6.16 ± 0.2 , 4.97 ± 0.2 , 4.87 ± 0.2 , 4.74 ± 0.2 , 4.51 ± 0.2 , 4.32 ± 0.2 and 3.98 ± 0.2 Angstrom,

35 more preferably, a methanol solvate crystal wherein the X-ray

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powder diffraction analysis pattern has characteristic peaks at interplanar spacings (d) of 14.24 ± 0.2 , 14.06 ± 0.2 , 13.76 ± 0.2 , 13.42 ± 0.2 , 13.22 ± 0.2 , 10.13 ± 0.2 , 7.32 ± 0.2 , 6.24 ± 0.2 , 6.21 ± 0.2 , 6.16 ± 0.2 , 5.63 ± 0.2 , 5.13 ± 0.2 , 5.06 ± 0.2 , 4.97 ± 0.2 , 4.89 ± 0.2 ,
 5 4.87 ± 0.2 , 4.74 ± 0.2 , 4.53 ± 0.2 , 4.51 ± 0.2 , 4.41 ± 0.2 , 4.32 ± 0.2 , 4.13 ± 0.2 , 4.10 ± 0.2 , 4.08 ± 0.2 , 3.99 ± 0.2 , 3.98 ± 0.2 , 3.73 ± 0.2 , 3.64 ± 0.2 , 3.43 ± 0.2 , 3.41 ± 0.2 , $3.35(3.3533) \pm 0.2$ and $3.35(3.3483) \pm 0.2$ Angstrom can be mentioned.

As (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-
 10 pyridinyl]methyl]sulfinyl]-1H-benzimidazole ethanol solvate crystal, an ethanol solvate crystal wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar spacings (d) of 13.71 ± 0.2 , 13.50 ± 0.2 , 13.22 ± 0.2 , 13.06 ± 0.2 and 6.16 ± 0.2 Angstrom,
 15 preferably, an ethanol solvate crystal wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar spacings (d) of 13.89 ± 0.2 , 13.71 ± 0.2 , 13.50 ± 0.2 , 13.22 ± 0.2 , 13.06 ± 0.2 , 6.22 ± 0.2 , 6.16 ± 0.2 , 4.74 ± 0.2 , 4.32 ± 0.2 and 4.31 ± 0.2 Angstrom,
 20 more preferably, an ethanol solvate crystal wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar spacings (d) of 14.29 ± 0.2 , 13.89 ± 0.2 , 13.71 ± 0.2 , 13.50 ± 0.2 , 13.22 ± 0.2 , 13.06 ± 0.2 , 10.09 ± 0.2 , 7.32 ± 0.2 , 6.22 ± 0.2 , 6.16 ± 0.2 , 5.14 ± 0.2 , 5.09 ± 0.2 , 4.98 ± 0.2 , 4.97 ± 0.2 , 4.88 ± 0.2 ,
 25 4.84 ± 0.2 , 4.78 ± 0.2 , 4.74 ± 0.2 , 4.65 ± 0.2 , 4.62 ± 0.2 , 4.58 ± 0.2 , 4.53 ± 0.2 , 4.52 ± 0.2 , 4.51 ± 0.2 , 4.49 ± 0.2 , 4.44 ± 0.2 , 4.39 ± 0.2 , 4.35 ± 0.2 , 4.33 ± 0.2 , 4.32 ± 0.2 , 4.31 ± 0.2 , 4.09 ± 0.2 , 4.07 ± 0.2 , 3.97 ± 0.2 , 3.95 ± 0.2 , 3.75 ± 0.2 , 3.74 ± 0.2 , 3.63 ± 0.2 , 3.44 ± 0.2 , 3.43 ± 0.2 , 3.42 ± 0.2 , 3.38 ± 0.2 , 3.36 ± 0.2 , $3.35(3.3508) \pm 0.2$,
 30 $3.35(3.3459) \pm 0.2$, 3.34 ± 0.2 and 3.03 ± 0.2 Angstrom can be mentioned.

As (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-
 pyridinyl]methyl]sulfinyl]-1H-benzimidazole hydrate crystal,
 (1) a 1.0 hydrate crystal wherein the X-ray powder diffraction
 35 analysis pattern has characteristic peaks at interplanar

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spacings (d) of 8.93 ± 0.2 , 8.47 ± 0.2 , 5.65 ± 0.2 , 5.63 ± 0.2 and 5.25 ± 0.2 Angstrom,

preferably, a 1.0 hydrate crystal wherein the X-ray powder diffraction analysis pattern has characteristic peaks at
 5 interplanar spacings (d) of 8.93 ± 0.2 , 8.47 ± 0.2 , 5.65 ± 0.2 , 5.63 ± 0.2 , 5.60 ± 0.2 , 5.25 ± 0.2 , 4.86 ± 0.2 , 4.85 ± 0.2 , 4.23 ± 0.2 , 4.11 ± 0.2 and 4.10 ± 0.2 Angstrom,

more preferably, a 1.0 hydrate crystal wherein the X-ray powder diffraction analysis pattern has characteristic peaks
 10 at interplanar spacings (d) of 9.77 ± 0.2 , 9.71 ± 0.2 , 8.93 ± 0.2 , 8.47 ± 0.2 , 5.65 ± 0.2 , 5.63 ± 0.2 , 5.60 ± 0.2 , 5.25 ± 0.2 , 4.86 ± 0.2 , 4.85 ± 0.2 , 4.83 ± 0.2 , 4.81 ± 0.2 , 4.45 ± 0.2 , 4.31 ± 0.2 , 4.25 ± 0.2 , 4.23 ± 0.2 , 4.15 ± 0.2 , 4.14 ± 0.2 , 4.11 ± 0.2 , 4.10 ± 0.2 , 4.08 ± 0.2 , 4.07 ± 0.2 , 3.98 ± 0.2 , 3.95 ± 0.2 , 3.68 ± 0.2 , 3.65 ± 0.2 , 3.53 ± 0.2 ,
 15 3.38 ± 0.2 , 3.36 ± 0.2 , 3.23 ± 0.2 , 3.16 ± 0.2 , 3.09 ± 0.2 and 3.08 ± 0.2 Angstrom and

(2) a 1.5 hydrate crystal wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar spacings (d) of 5.95 ± 0.2 , 5.91 ± 0.2 , 5.65 ± 0.2 , 4.51 ± 0.2 and
 20 4.50 ± 0.2 Angstrom,

preferably, a 1.5 hydrate crystal wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar spacings (d) of 8.87 ± 0.2 , 8.04 ± 0.2 , 6.00 ± 0.2 , 5.97 ± 0.2 , 5.95 ± 0.2 , 5.91 ± 0.2 , 5.65 ± 0.2 , 5.02 ± 0.2 , 4.51 ± 0.2 and
 25 4.50 ± 0.2 Angstrom,

more preferably, a 1.5 hydrate crystal wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar spacings (d) of 13.18 ± 0.2 , 9.60 ± 0.2 , 9.07 ± 0.2 , 9.02 ± 0.2 , 8.87 ± 0.2 , 8.04 ± 0.2 , 6.59 ± 0.2 , 6.00 ± 0.2 , 5.97 ± 0.2 ,
 30 5.95 ± 0.2 , 5.91 ± 0.2 , 5.72 ± 0.2 , 5.65 ± 0.2 , 5.47 ± 0.2 , 5.43 ± 0.2 , 5.05 ± 0.2 , 5.02 ± 0.2 , 5.00 ± 0.2 , 4.51 ± 0.2 , 4.50 ± 0.2 , 4.47 ± 0.2 , 4.46 ± 0.2 , 4.26 ± 0.2 , 4.18 ± 0.2 , 4.13 ± 0.2 , 4.11 ± 0.2 , 3.99 ± 0.2 , 3.98 ± 0.2 , 3.75 ± 0.2 , 3.73 ± 0.2 , 3.72 ± 0.2 , 3.71 ± 0.2 , 3.66 ± 0.2 , 3.65 ± 0.2 , 3.64 ± 0.2 , 3.57 ± 0.2 , $3.51(3.5119) \pm 0.2$,
 35 $3.51(3.5064) \pm 0.2$, 3.49 ± 0.2 , 3.46 ± 0.2 , 3.40 ± 0.2 , 3.28 ± 0.2 ,

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3.28±0.2, 3.16±0.2, 3.08±0.2, 3.00±0.2, 2.99±0.2 and 2.88±0.2 Angstrom can be mentioned.

When the same numerical value is recited twice in a row in the above-mentioned d values, it means that two peaks are present at close positions such that the same numerical value is obtained when rounded to two decimal places.

Thus obtained hydrate crystal, methanol solvate crystal, ethanol solvate crystal, ethanol·hydrate crystal and isopropanol·hydrate crystal of (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole or a salt thereof (hereinafter also referred to as "crystal of the present invention") are useful as a pharmaceutical because they show excellent antiulcer action, gastric acid secretion-inhibiting action, mucosa-protecting action, anti-*Helicobacter pylori* action, etc., and because they are of low toxicity. Since the crystal of the present invention shows different physical properties (e.g., solubility and the like) from those of conventional (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole crystal, a preparation design applying such properties is available. Since the crystal of the present invention has low solubility, preparation, such as a controlled release preparation and the like with sustainability, may be considered. In addition, since the crystal can be a synthetic intermediate for (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole crystal, it is useful as a synthetic intermediate for pharmaceutical agents.

The crystal of the present invention is useful in mammals (e.g., humans, monkeys, sheep, bovines, horses, dogs, cats, rabbits, rats, mice, etc.) for the treatment and prevention of peptic ulcer (e.g., gastric ulcer, gastric ulcer due to postoperative stress, duodenal ulcer, anastomotic ulcer, ulcer caused by non-steroidal antiinflammatory agents etc.); Zollinger-Ellison syndrome; gastritis; erosive esophagitis; reflux esophagitis such as erosive reflux esophagitis and the

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like; symptomatic gastroesophageal reflux disease (symptomatic GERD) such as non-erosive reflux disease or gastroesophageal reflux disease free of esophagitis and the like; functional dyspepsia; gastric cancer (including gastric cancer associated
5 with promoted production of interleukin-1 β due to gene polymorphism of interleukin-1); stomach MALT lymphoma; gastric hyperacidity; upper gastrointestinal hemorrhage due to peptic ulcer, acute stress ulcer, hemorrhagic gastritis or invasive stress (e.g. stress caused by major surgery requiring
10 postoperative intensive management, and cerebrovascular disorder, head trauma, multiple organ failure and extensive burn, each requiring intensive treatment) and the like; pre-anesthetic administration, eradication of *Helicobacter pylori* or eradication assistance and the like.

15 As used herein, the above-mentioned reflux esophagitis and symptomatic gastroesophageal reflux disease (symptomatic GERD) are sometimes collectively referred to simply as GERD.

The crystal of the present invention is of low toxicity and can be safely administered orally or non-orally (e.g.,
20 topical, rectal and intravenous administration, etc.), as such or in the form of pharmaceutical compositions formulated with a pharmacologically acceptable carrier, e.g., tablets (including sugar-coated tablets and film-coated tablets), powders, granules, capsules (including soft capsules), orally
25 disintegrating tablets, orally disintegrating films, liquids, injectable preparations, suppositories, sustained-release preparations and patches, in accordance with a commonly known method.

The content of the crystal of the present invention in
30 the pharmaceutical composition of the present invention is about 0.01 to 100% by weight relative to the entire composition. Varying depending on subject of administration, route of administration, target disease etc., its dose is normally about 0.5 to 1,500 mg/day, preferably about 5 to 150
35 mg/day, based on the active ingredient, for example, when it

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is orally administered as an antiulcer agent to an adult human (60 kg). An exemplary dose in a capsule is 30mg or 60mg of a crystal of the invention. The crystal of the present invention may be administered once daily or in 2 to 3 divided portions per day.

5 Pharmacologically acceptable carriers that may be used to produce the pharmaceutical composition of the present invention include various organic or inorganic carrier substances in common use as pharmaceutical materials, including excipients, lubricants, binders, disintegrants,
10 water-soluble polymers and basic inorganic salts for solid preparations; and solvents, dissolution aids, suspending agents, isotonizing agents, buffers and soothing agents for liquid preparations. Other ordinary pharmaceutical additives such as preservatives, antioxidants, coloring agents,
15 sweetening agents, souring agents, bubbling agents and flavorings may also be used as necessary.

Such "excipients" include, for example, lactose, sucrose, D-mannitol, starch, cornstarch, crystalline cellulose, light silicic anhydride and titanium oxide.

20 Such "lubricants" include, for example, magnesium stearate, sucrose fatty acid esters, polyethylene glycol, talc and stearic acid.

Such "binders" include, for example, hydroxypropyl cellulose, hydroxypropylmethyl cellulose, crystalline
25 cellulose, α -starch, polyvinylpyrrolidone, gum arabic powder, gelatin, pullulan and low-substitutional hydroxypropyl cellulose.

Such "disintegrants" include (1) crosslinked povidone, (2) what is called super-disintegrants such as crosslinked
30 carmellose sodium (FMC-Asahi Chemical) and carmellose calcium (Gotoku Yakuhin), (3) carboxymethyl starch sodium (e.g., product of Matsutani Chemical), (4) low-substituted hydroxypropyl cellulose (e.g., product of Shin-Etsu Chemical), (5) cornstarch, and so forth. Said "crosslinked povidone" may
35 be any crosslinked polymer having the chemical name 1-ethenyl-2-pyrrolidinone homopolymer, including polyvinylpyrrolidone

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(PVPP) and 1-vinyl-2-pyrrolidinone homopolymer, and is exemplified by Colidon CL (produced by BASF), Polyplasdon XL (produced by ISP), Polyplasdon XL-10 (produced by ISP) and Polyplasdon INF-10 (produced by ISP).

5 Such "water-soluble polymers" include, for example, ethanol-soluble water-soluble polymers [e.g., cellulose derivatives such as hydroxypropyl cellulose (hereinafter also referred to as HPC), polyvinylpyrrolidone] and ethanol-insoluble water-soluble polymers [e.g., cellulose derivatives
10 such as hydroxypropylmethyl cellulose (hereinafter also referred to as HPMC), methyl cellulose and carboxymethyl cellulose sodium, sodium polyacrylate, polyvinyl alcohol, sodium alginate, guar gum].

 Such "basic inorganic salts" include, for example, basic
15 inorganic salts of sodium, potassium, magnesium and/or calcium. Preferred are basic inorganic salts of magnesium and/or calcium. More preferred are basic inorganic salts of magnesium. Such basic inorganic salts of sodium include, for example, sodium carbonate, sodium hydrogen carbonate, disodium
20 hydrogenphosphate, etc.

 Such basic inorganic salts of potassium include, for example, potassium carbonate, potassium hydrogen carbonate, etc. Such basic inorganic salts of magnesium include, for example, heavy magnesium carbonate, magnesium carbonate,
25 magnesium oxide, magnesium hydroxide, magnesium metasilicate aluminate, magnesium silicate, magnesium aluminate, synthetic hydrotalcite $[\text{Mg}_6\text{Al}_2(\text{OH})_{16}\cdot\text{CO}_3\cdot 4\text{H}_2\text{O}]$, alumina hydroxide magnesium, and so forth. Among others, preferred is heavy magnesium carbonate, magnesium carbonate, magnesium oxide, magnesium
30 hydroxide, etc. Such basic inorganic salts of calcium include, for example, precipitated calcium carbonate, calcium hydroxide, etc.

 Such "solvents" include, for example, water for injection, alcohol, propylene glycol, macrogol, sesame oil, corn oil and
35 olive oil.

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Such "dissolution aids" include, for example, polyethylene glycol, propylene glycol, D-mannitol, benzyl benzoate, ethanol, trisaminomethane, cholesterol, triethanolamine, sodium carbonate and sodium citrate.

5 Such "suspending agents" include, for example, surfactants such as stearyltriethanolamine, sodium lauryl sulfate, laurylaminopropionic acid, lecithin, benzalkonium chloride, benzethonium chloride and monostearic glycerol; and hydrophilic polymers such as polyvinyl alcohol,
10 polyvinylpyrrolidone, carboxymethyl cellulose sodium, methyl cellulose, hydroxymethyl cellulose, hydroxyethyl cellulose and hydroxypropyl cellulose.

Such "isotonizing agents" include, for example, glucose, D-sorbitol, sodium chloride, glycerol and D-mannitol.

15 Such "buffers" include, for example, buffer solutions of phosphates, acetates, carbonates, citrates etc.

Such "soothing agents" include, for example, benzyl alcohol.

Such "preservatives" include, for example, p-oxybenzoic
20 acid esters, chlorobutanol, benzyl alcohol, phenethyl alcohol, dehydroacetic acid and sorbic acid.

Such "antioxidants" include, for example, sulfites, ascorbic acid and α -tocopherol.

Such "coloring agents" include, for example, food colors
25 such as Food Color Yellow No. 5, Food Color Red No. 2 and Food Color Blue No. 2; and food lake colors and red oxide.

Such "sweetening agents" include, for example, saccharin sodium, dipotassium glycyrrhetinate, AspartameTM, SteviaTM and thaumatin.

30 Such "souring agents" include, for example, citric acid (citric anhydride), tartaric acid and malic acid.

Such "bubbling agents" include, for example, sodium bicarbonate.

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Such "flavorings" may be synthetic substances or naturally occurring substances, and include, for example, lemon, lime, orange, menthol and strawberry.

The crystal of the present invention may be prepared as a preparation for oral administration in accordance with a commonly known method, by, for example, compression-shaping it in the presence of an excipient, a disintegrant, a binder, a lubricant, or the like, and subsequently coating it as necessary by a commonly known method for the purpose of taste masking, enteric dissolution or sustained release. For an enteric preparation, an intermediate layer may be provided by a commonly known method between the enteric layer and the drug-containing layer for the purpose of separation of the two layers.

For preparing the crystal of the present invention as an orally disintegrating tablet, available methods include, for example, a method in which a core containing crystalline cellulose and lactose is coated with the crystal of the present invention and a basic inorganic salt, and is further coated with a coating layer containing a water-soluble polymer, to give a composition, which is coated with an enteric coating layer containing polyethylene glycol, further coated with an enteric coating layer containing triethyl citrate, still further coated with an enteric coating layer containing polyethylene glycol, and still yet further coated with mannitol, to give fine granules, which are mixed with additives and shaped.

The above-mentioned "enteric coating layer" includes, for example, aqueous enteric polymer substrates such as cellulose acetate phthalate (CAP), hydroxypropylmethyl cellulose phthalate, hydroxymethyl cellulose acetate succinate, methacrylic acid copolymers [e.g., Eudragit L30D-55 (trade name; produced by Rohm), Colicoat MAE30DP (trade name; produced by BASF), Polykid PA30 (trade name; produced by Sanyo Chemical)], carboxymethylethyl cellulose and shellac;

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sustained-release substrates such as methacrylic acid polymers [e.g., Eudragit NE30D (trade name), Eudragit RL30D (trade name), Eudragit RS30D (trade name), etc.]; water-soluble polymers; plasticizers such as triethyl citrate, polyethylene glycol, acetylated monoglycerides, triacetine and castor oil; and mixtures thereof.

The above-mentioned "additive" includes, for example, water-soluble sugar alcohols (e.g., sorbitol, mannitol, multitol, reduced starch saccharides, xylitol, reduced paratinose, erythritol, etc.), crystalline cellulose [e.g., CeolasTM KG 801, AvicelTM PH 101, AvicelTM PH 102, AvicelTM PH 301, AvicelTM PH 302, AvicelTM RC-591 (crystalline cellulose·carmellose sodium)], low-substituted hydroxypropyl cellulose [e.g., LH-22, LH-32, LH-23, LH-33 (Shin-Etsu Chemical) and mixtures thereof]; binders, souring agents, bubbling agents, sweetening agents, flavorings, lubricants, coloring agents, stabilizers, excipients, disintegrants etc. are also used.

As a preparation using the crystal of the present invention, for example, a tablet for sustained release of the active ingredient according to WO2004-035020 or a capsule containing granules or fine granules can be employed.

The crystal of the present invention may be used in combination with 1 to 3 other active ingredients.

Such "other active ingredients" include, for example, anti-*Helicobacter pylori* activity substances, imidazole compounds, bismuth salts, quinolone compounds, and so forth. Of these substances, preferred are anti-*Helicobacter pylori* action substances, imidazole compounds etc.

Such "anti-*Helicobacter pylori* action substances" include, for example, antibiotic penicillins (e.g., amoxicillin, benzylpenicillin, piperacillin, mecillinam, etc.), antibiotic cefems (e.g., cefixime, cefaclor, etc.), antibiotic macrolides (e.g., erythromycin, clarithromycin. etc.), antibiotic tetracyclines (e.g., tetracycline, minocycline, streptomycin, etc.), antibiotic aminoglycosides (e.g., gentamicin, amikacin,

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etc.), imipenem, and so forth. Of these substances, preferred are antibiotic penicillins, antibiotic macrolides etc.

Such "imidazole compounds" include, for example, metronidazole, miconazole, etc. Such "bismuth salts" include, for example,
5 bismuth acetate, bismuth citrate, etc. Such "quinolone compounds" include, for example, ofloxacin, ciprofloxacin, etc.

Such "other active ingredients" and the crystal of the present invention may also be used in combination as a mixture prepared as a single pharmaceutical composition [e.g., tablets,
10 powders, granules, capsules (including soft capsules), liquids, injectable preparations, suppositories, sustained-release preparations, etc.], in accordance with a commonly known method, and may also be prepared as separate preparations and administered to the same subject simultaneously or at a time
15 interval.

EXAMPLES

The present invention is hereinafter described in more detail by means of, but is not limited to, the following reference examples, examples and experimental examples.

20 In the following examples, the term "room temperature" and "ambient temperature" indicate about 15 to 30 °C.

Melting points were measured using the Micro Melting Point Apparatus (produced by Yanagimoto Seisakusho), and uncorrected values are shown.

25 X-ray powder diffraction was measured using Shimadzu XRD-6000 (Cu-K α ray: $\lambda=1.5418\text{\AA}$, tube voltage: 40 kV, tube current: 40 mA) or RINT Ultima⁺ 2100U (Cu-K α ray: $\lambda=1.5418\text{\AA}$, tube voltage: 40 kV, tube current: 50 mA). In case of using Shimadzu XRD-6000, the divergence and scattering slits were
30 set at 1° and the receiving slit was set at 0.15 mm. Diffracted radiation was detected by a NaI scintillation detector. A θ -2 θ continuous scan at 3°/min (0.4 sec/0.02°step) from 2.5 to 40° 2 θ was used. A silicon standard was analyzed to check the instrument alignment. Data were collected and analyzed using
35 XRD-6100/7000 v.5.0.

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FT-Raman spectra were measured using Thermo Nicolet FT-Raman 960 spectrometer (pumped laser: 1064 nm, laser power: 0.5 to 1.5 W, spectrum range: 3500 to 100 cm^{-1} , detector: InGaAs).

5 Solid ^{13}C -NMR spectra (CP/MAS method) were measured using Varian Unity-INOVATM 400 NMR spectrometer [^{13}C nuclear resonance frequency: 100.543 MHz, sample container: 4 mm pencil-shaped zirconia rotor, measurement temperature: room temperature, MAS rotation number: 12000 Hz, standard
10 substance: glycine solution (176.5 ppm), cumulated number: 200].

For thermogravimetric analysis, TA Instruments differential scanning calorimeter 2920 or Seiko Instruments TG/DTA 220 was used for the measurement.

15 Amorphous (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole to be used was prepared according to JP-A-2001-058990, Reference Example 1.

Anhydrous crystal of (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole
20 (hereinafter referred to as Form I crystal) to be used as a starting material was prepared according to JP-A-2001-058990, Example 2.

Example 1

(R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole (R(+)-
25 lansoprazole) 1.5 hydrate crystal (Form II crystal)

Sufficient amount of Form I crystal was added to a mixture of water (1.8mL) and acetone (0.2mL) in an amber vial such that excess solid remained. The vial was capped and the
30 mixture was agitated by constant rotation on a slurry wheel for three days at ambient temperature. Solid was then collected by filtration. As a result of thermogravimetric analysis, about 7% of weight decrease was observed at 24 to 84°C, and the crystal was assumed to be 1.5 hydrate crystal
35 (theoretical amount of water: 6.6%).

Table 1: XRPD data (Form II crystal)

2 θ (°)	d-value (Å)	Relative intensity (%)
9.1808	9.62491	41
9.9319	8.89865	42
10.9561	8.06898	34
13.3524	6.62577	28
14.74	6.005	36
14.94	5.92506	49
15.6477	5.65865	100
17.5995	5.03525	64
19.7104	4.5005	30
25.3684	3.50811	24
29.7424	3.0014	32

Example 2

5 (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole (R(+)-lansoprazole) 0.7 ethanol·1 hydrate crystal (Form III crystal)

Form I crystal was added to a mixture of water (0.05mL) and ethanol (0.45mL) in an amber vial and the solid was slowly
 10 dissolved. Addition of Form I crystals was continued until excess solid remained. At this point, a large amount of solid precipitated from solution. Solid was then collected by filtration. As a result of thermogravimetric analysis, about 7% of weight decrease was observed at 25 to 66°C. From the
 15 lattice constant calculated from the crystal structure and the results of gas chromatography analysis and the like, the crystal was assumed to be 0.7 ethanol·1 hydrate crystal (theoretical amount of ethanol: 8.1%, theoretical amount of water: 4.7%).

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Table 2: XRPD data (Form III crystal)

2 θ (°)	d-value (Å)	Relative intensity (%)
6.6746	13.23223	100
14.2592	6.20639	53
17.5	5.06365	17
17.82	4.97344	22
18.6484	4.75433	31
19.6535	4.5134	41
20.12	4.40979	25
20.52	4.32473	19

Example 3

(R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole (R(+)-lansoprazole) 0.7 isopropanol·1.2 hydrate crystal (Form IV crystal)

Form I crystal (28.8mg) was added to isopropanol (0.75mL) and the mixture was sonicated to aid dissolution. The solid was dissolved to form a clear yellow solution, which was filtered through a 0.2 μ m nylon filter into a clean vial. The uncovered vial was left to evaporate the filtrate under ambient condition. White needles were collected after four days. As a result of thermogravimetric analysis, about 7% of weight decrease was observed at 25 to 71°C. From the lattice constant calculated from the crystal structure and the results of gas chromatography analysis and the like, the crystal was assumed to be 0.7 isopropanol·1.2 hydrate crystal (theoretical amount of isopropanol: 9.9%, theoretical amount of water: 5.6%).

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Table 3: XRPD data (Form IV crystal)

2 θ (°)	d-value (Å)	Relative intensity (%)
5.9277	14.89773	81
13.2833	6.66008	21
17.6762	5.01357	100
19.4312	4.56453	51
19.72	4.49833	20
20.3666	4.35695	34
20.85	4.25702	49
22.7916	3.89857	22
24.51	3.62899	22
25.4232	3.50067	41

Example 4

(R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole (R(+)-lansoprazole) hydrate crystal (Pattern V crystal)

Sufficient amount of Form I crystal was added to a mixture of water (1.8mL) and ethanol (0.2mL) in an amber vial such that excess solid remained. The vial was capped and the mixture was agitated by constant rotation on a slurry wheel at ambient temperature for three days. Solid was then collected by filtration. As a result of thermogravimetric analysis, about 6% of weight decrease was observed at 17 to 62°C and as a result of thermogravimetry-infrared spectrum analysis, the presence of water was confirmed. However, a sample necessary for identification could not be obtained (theoretically-estimated amount of water: 6.8%).

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Table 4: XRPD data (Pattern V crystal)

2- θ (°)	d-value (Å)	Relative intensity (%)	2- θ (°)	d-value (Å)	Relative intensity (%)
4.4079	20.03032	40	21.5	4.12976	41
6.6585	13.26418	20	21.72	4.08843	41
9.3	9.50181	21	22.5991	3.93134	26
9.5977	9.20774	92	24.12	3.68678	32
10.6447	8.30432	51	24.32	3.65691	48
13	6.80458	26	24.56	3.62171	39
13.2025	6.70066	67	25.66	3.4689	31
14.4698	6.11652	62	26.06	3.41655	43
15.0576	5.87905	87	26.24	3.39352	41
15.5133	5.70737	50	27.76	3.21107	22
15.76	5.61858	25	28.0247	3.18134	52
18.18	4.87576	29	28.36	3.14448	32
18.3622	4.82779	100	28.6	3.11864	23
18.84	4.70641	52	28.82	3.09533	24
19.02	4.66228	64	32.351	2.76509	21
19.716	4.49923	24	33.55	2.66896	32
20.1575	4.40167	72	36.92	2.43271	21
21.42	4.14501	43	37.06	2.42384	23

Example 5

(R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole (R(+)-lansoprazole) 0.5 hydrate crystal (Form VI crystal)

Form II crystal (Example 1) was placed in a vacuum oven and dried overnight at ambient temperature under oil-pump vacuum. The solid was then removed from the oven. As a result of thermogravimetric analysis, about 3% of weight decrease was observed at 25 to 55°C, and the crystal was assumed to be 0.5 hydrate crystal (theoretical amount of water: 3.1%).

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Table 5: XRPD data (Form VI crystal)

2- θ (°)	d-value (Å)	Relative intensity (%)
9.9762	8.85923	60
10.4902	8.42627	30
15.81	5.60092	32
16.9644	5.2223	100
18.3461	4.83199	28
21.0793	4.21122	25

The X-ray powder diffraction patterns of Form II crystal, Form III crystal, Form IV crystal, Pattern V crystal and Form VI crystal are shown in Figure 1 along with the patterns of Form I crystal and amorphous form thereof.

The FT-Raman spectrums of Form II crystal, Form III crystal, Form IV crystal and Pattern V crystal are shown in Figure 2 along with the spectrum of Form I crystal.

The solid ^{13}C -NMR spectrums of Form II crystal, Form III crystal, Form IV crystal and Pattern V crystal are shown in Figure 3 along with the spectrum of Form I crystal.

Example 6

(R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole (R(+)-lansoprazole) methanol solvate crystal

Form I crystal (100ml) was placed in a test tube, methanol was added at room temperature and the crystal was dissolved in an essentially minimum amount and diluted about 3-fold. The solution (2mL) was spread thin in a weighing bottle (diameter about 30mm), and left standing without capping at -20°C to allow gradual crystallization. Thereafter, the solid was collected by filtration. As a result of thermogravimetric analysis, weight decrease was observed from immediately after temperature rise. However, since the decreased weight was not clear, the crystal was assumed to be methanol solvate but not a clear solvate containing methanol in a given mol number.

Table 6: XRPD data (methanol solvate crystal)

2 θ (°)	d-value (Å)	Relative intensity (%)	2 θ (°)	d-value (Å)	Relative intensity (%)
6.200	14.2437	12	18.700	4.7412	29
6.280	14.0624	20	19.580	4.5301	21
6.420	13.7561	29	19.680	4.5073	35
6.580	13.4219	80	20.140	4.4054	22
6.680	13.2212	100	20.560	4.3163	42
8.720	10.1322	13	21.500	4.1297	15
12.080	7.3205	15	21.660	4.0995	21
14.180	6.2407	20	21.760	4.0809	18
14.240	6.2146	35	22.240	3.9939	19
14.360	6.1629	50	22.340	3.9762	23
15.720	5.6326	13	23.860	3.7263	18
17.280	5.1275	16	24.440	3.6391	19
17.520	5.0578	19	25.920	3.4346	15
17.820	4.9733	23	26.120	3.4088	19
18.140	4.8863	19	26.560	3.3533	22
18.240	4.8697	33	26.600	3.3483	17

Example 7

5 (R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole (R(+)-lansoprazole) ethanol solvate crystal

Form I crystal (100ml) was placed in a test tube, methanol was added at room temperature and the crystal was
 10 dissolved in an essentially minimum amount and diluted about 3-fold. The solution (2mL) was spread thin in a weighing bottle (diameter about 30mm), and left standing without capping at -20°C to allow gradual crystallization. Thereafter, the solid was collected by filtration. As a result of
 15 thermogravimetric analysis, weight decrease was observed from immediately after temperature rise. However, since the decreased weight was not clear, the crystal was assumed to be

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ethanol solvate but not a clear solvate containing ethanol in a given mol number.

Table 7: XRPD data (ethanol solvate crystal)

2 θ (°)	d-value (Å)	Relative intensity (%)	2 θ (°)	d-value (Å)	Relative intensity (%)
6.180	14.2897	17	19.680	4.5073	24
6.360	13.8857	26	19.740	4.4937	25
6.440	13.7134	36	19.960	4.4447	15
6.540	13.5039	58	20.220	4.3881	19
6.680	13.2212	100	20.380	4.3540	16
6.760	13.0649	40	20.480	4.3330	25
8.760	10.0860	13	20.540	4.3205	30
12.080	7.3205	15	20.600	4.3080	30
14.220	6.2233	31	21.720	4.0883	19
14.360	6.1629	37	21.800	4.0735	20
17.240	5.1393	15	22.380	3.9692	17
17.400	5.0924	19	22.480	3.9518	14
17.780	4.9844	24	23.680	3.7542	22
17.840	4.9678	21	23.740	3.7448	21
18.180	4.8756	16	24.500	3.6304	14
18.300	4.8439	24	25.860	3.4424	14
18.540	4.7818	23	25.940	3.4320	14
18.720	4.7362	30	26.020	3.4216	14
19.080	4.6476	16	26.320	3.3833	14
19.200	4.6189	22	26.520	3.3582	21
19.360	4.5810	17	26.580	3.3508	19
19.580	4.5301	19	26.620	3.3459	15
19.640	4.5164	25	26.700	3.3360	13
			29.460	3.0294	13

5

The X-ray powder diffraction patterns of methanol solvate crystal and ethanol solvate crystal are shown in Figure 4 along with the pattern of Form I crystal.

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Example 8

(R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole (R(+)-lansoprazole) 1.0 hydrate crystal

5 Form I crystal (100ml) was placed in a test tube, a mixed solvent of water and methanol (1:1) was added at room temperature and the crystal was dissolved in an essentially minimum amount. The solution was left standing as it was at - 20°C to allow crystallization. Thereafter, the solid was
10 collected by filtration. As a result of thermogravimetric analysis, about 6.5% of weight decrease was observed at about 40°C to 80°C, and the crystal was assumed to be 1.5 hydrate. This was dried under reduced pressure for 3 days using a rotary pump. The resulting sample was subjected to
15 thermogravimetric analysis. As a result, the weight decrease at about 40°C to 80°C decreased to 4.4%, and the crystal was assumed to have changed from 1.5 hydrate to 1.0 hydrate.

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Table 8: XRPD data (1.0 hydrate crystal)

2 θ (°)	d-value (Å)	Relative intensity (%)	2 θ (°)	d-value (Å)	Relative intensity (%)
9.040	9.7743	17	21.460	4.1373	18
9.100	9.7100	18	21.620	4.1070	34
9.900	8.9270	46	21.680	4.0958	36
10.440	8.4665	47	21.760	4.0809	27
15.680	5.6469	45	21.820	4.0698	19
15.740	5.6255	41	22.340	3.9762	17
15.800	5.6043	33	22.480	3.9518	19
16.800	5.2481	100	24.180	3.6777	21
18.240	4.8597	31	24.400	3.5450	17
18.280	4.8492	31	25.180	3.5338	18
18.360	4.8282	28	26.320	3.3833	20
18.420	4.8126	18	26.480	3.3632	25
19.920	4.4535	16	27.580	3.2315	17
20.600	4.3080	18	28.240	3.1575	18
20.900	4.2468	29	28.900	3.0869	17
20.980	4.2308	36	28.940	3.0827	16
21.380	4.1526	17			

Example 9

(R)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole (R(+)-lansoprazole) 1.5 hydrate crystal

Form I crystal (100ml) was placed in a test tube, a mixed solvent of water and methanol (1:1) was added at room temperature and the crystal was dissolved in an essentially minimum amount. The solution was left standing as it was at -20°C to allow crystallization. Thereafter, the solid was collected by filtration. As a result of thermogravimetric analysis, about 6.5% of weight decrease was observed at about 40°C to 80°C, and the crystal was assumed to be 1.5 hydrate.

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Table 9: XRPD data (1.5 hydrate crystal)

2 θ (°)	d-value (Å)	Relative intensity (%)	2 θ (°)	d-value (Å)	Relative intensity (%)
6.700	13.1818	13	21.480	4.1335	17
9.200	9.6046	38	21.580	4.1145	28
9.740	9.0733	14	22.260	3.9904	26
9.800	9.0179	23	22.320	3.9798	20
9.960	8.8734	40	23.720	3.7479	17
11.000	8.0367	46	23.820	3.7324	20
13.420	6.5924	28	23.900	3.7201	25
14.760	5.9968	41	23.960	3.7109	27
14.820	5.9726	43	24.300	3.6598	25
14.880	5.9487	47	24.380	3.6480	27
14.980	5.9092	60	24.460	3.6362	19
15.480	5.7194	28	24.940	3.5673	25
15.680	5.6469	100	25.340	3.5119	18
16.200	5.4668	17	25.380	3.5064	21
16.320	5.4269	15	25.480	3.4929	18
17.540	5.0521	32	25.720	3.4609	17
17.640	5.0237	44	26.180	3.4011	17
17.720	5.0012	29	27.140	3.2829	22
19.660	4.5118	58	27.200	3.2758	24
19.700	4.5027	63	28.260	3.1553	16
19.840	4.4713	28	28.960	3.0806	18
19.900	4.4579	16	29.740	3.0016	18
20.840	4.2589	19	29.840	2.9917	17
21.240	4.1796	18	31.080	2.8751	17

The X-ray powder diffraction patterns of 1.0 hydrate crystal and 1.5 hydrate crystal are shown in Figure 5 along with the pattern of Form I crystal.

Experimental Example 1: Solubility

The solubilities of Forms I, II, III, IV and VI of (R)-lansoprazole obtained in the above-mentioned Reference Example

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1 and Examples were tested as a suspension of power in water
at 25°C for 5 days. The solid samples of each form were tested
as-is by HPLC and XRPD without particle size determination.
Forms II, III, IV and VI exhibited similar solubility, and
5 were chemically degraded over time (see the solubility chart
below Figure 6). The extent of chemical degradation as a
function of time was similar for all forms. After the
solubility study, the residual solids were analyzed by XRPD,
and showed that all converted to Form II except for the Form
10 I sample. The Form I sample from the solubility study analyzed
by XRPD was a mixture consisting of Form I (major component)
and Form II.

Experimental Example 2: Relationships among Forms of R(+)-
15 **lansoprazole**

The relationships among Forms of R(+)-lansoprazole were
studied under various conditions. The results are shown in
Figure 7. The conditions are shown in Table 10.

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Table 10

Reaction	Conditions ^a
1	Form I (180.6 mg) was dissolved upon sonication in 18 mL of t-BuOH and filtered through a 0.2 mm nylon filter into a flask. The solution was frozen in a dry ice/acetone bath and lyophilized for 1 day.
2	Amorphous (R)-lansoprazole (from lyophilization) was placed into a vial. The uncapped vial was then placed inside a larger amber vial containing 1 mL IPOAc. The larger vial was capped and left for one day at RT.
3	Amorphous (R)-lansoprazole (from lyophilization) was placed into a vial. The uncapped vial was placed into an 85%RH chamber. The chamber was placed in a 40°C oven for 4 days.
4	20 mL of water was added to Form I (19.7 mg) and the mixture was sonicated. Solids remained after sonication. The vial was capped and wrapped in aluminum foil, and placed on rotating wheel and slurried at RT for 4 days.
5	1.8 mL (2×0.9 mL) of water and 0.2 mL of acetone (water/acetone (9:1)) were added to Form I. Solids remained and slurried on a rotating wheel at RT for 3 days.
	Form I was placed into a ceramic milling jar. 10 µL of water and a ceramic ball were added, and the jar was capped. The sample was milled for a total of nine minutes (3×3 min cycle). Solids were scraped and allowed to cool between cycles. Solids were collected in a vial and refrigerated.
6	8 ml (2×4 ml) of IPA/water (9:1) was added to Form I (2.54489 g). Solids remained, capped with PTFE cap and slurried on a rotating wheel for 4 days. Solids were vacuum filtered and spread onto a petri dish, covered with kimwipe paper, and allowed to dry for 1 day. Solids were collected in a vial after 1 day and capped.

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Table 10 (continued)

Reaction	Conditions ^a
7	5 ml of EtOH/water (95:5) was added to Form I (2.45288 g). Solids remained, capped with PTFE cap and slurried on a rotating wheel for 1 day. Sample appeared as a deep red/purple paste. Sample was spread onto a petri dish, covered and allowed to dry in a hood.
8	Form III post DVS. Moisture sorption/desorption data were collected on a VTI SGA-100 Vapor Sorption Analyzer. Sorption and desorption data were collected over a range of 5% to 95% relative humidity (RH) at 10% RH intervals under a nitrogen purge. Samples were not dried prior to analysis. Equilibrium criteria used for analysis were less than 0.0100% weight change in 5 minutes, with a maximum equilibration time of 3 hours if the weight criterion was not met. Data were not corrected for the initial moisture content of the samples. NaCl and PVP were used as calibration standards. Starting amount of Form III was 11.9 mg.
9	Form II was placed into a vial. The vial was purged with nitrogen and heated to 93°C in an oil bath. Sample had turned brown in up to 45 seconds, removed from oil bath after up to 1 min.
10	Form II was vacuum dried in an open vial at RT for up to 2.5 hours.

Table 10 (continued)

Reaction	Conditions ^a
11	Form VI was placed into a vial. The uncapped vial was placed into an 87% RH chamber at RT for 6 days. Form VI post DVS. Moisture sorption/desorption data were collected on a VTI SGA-100 Vapor Sorption Analyzer. Sorption and desorption data were collected over a range of 5% to 95% relative humidity (RH) at 10% RH intervals under a nitrogen purge. Samples were not dried prior to analysis. Equilibrium criteria used for analysis were less than 0.0100% weight change in 5 minutes, with a maximum equilibration time of 3 hours if the weight criterion was not met. Data were not corrected for the initial moisture content of the samples. NaCl and PVP were used as calibration standards. Starting amount of Form VI was 6.6 mg.
12	Form IV post DVS. Moisture sorption/desorption data were collected on a VTI SGA-100 Vapor Sorption Analyzer. Sorption and desorption data were collected over a range of 5% to 95% relative humidity (RH) at 10% RH intervals under a nitrogen purge. Samples were not dried prior to analysis. Equilibrium criteria used for analysis were less than 0.0100% weight change in 5 minutes, with a maximum equilibration time of 3 hours if the weight criterion was not met. Data were not corrected for the initial moisture content of the samples. NaCl and PVP were used as calibration standards. Starting amount of Form IV was 9.4 mg.

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Table 10 (continued)

Reaction	Conditions ^a
13	Form III was placed into a vial. The uncapped vial was placed into a vacuum oven (at RT) for 1 day.
14	Form IV was placed into a vial. The uncapped vial was placed into a vacuum oven (at RT) for 1 day.
15	Pattern V was placed into a vial. The uncapped vial was placed into a vacuum oven (at RT) for 1 day.

^a EtOH = ethanol, IPA = isopropanol, IPOAc = isopropyl acetate, DVS = dynamic vapor sorption, RH = relative humidity, RT = room temperature, t-BuOH = tert-butanol, NaCl = sodium chloride, PVP = polyvinylpyrrolidone.

Experimental Example 3 Interconversion Slurries

Mixtures of Forms I, II, III, IV and VI were slurried in aqueous saturated solutions at ambient temperature and up to 40°C. Table 11 summarizes the results.

A mixture of Form II and Pattern V material was obtained when the mixture of forms was slurried at ambient temperature for 5 days, despite the absence of Pattern V material as starting material. However, additional slurry time under the same conditions produced Form II exclusively, suggesting that Pattern V material converted to Form II. However, data presented in Table 12 associated with the preparation of Forms suggests that Pattern V material can be present as a mixture with Form II over a long period of time.

Form II was obtained exclusively when the mixture of Forms I, II, III, IV and VI was slurried at up to 40°C for 5 days.

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Table 11: Interconversion Slurries

Starting Forms present	Conditions	Slurry time	XRPD Result
I, II, III, IV, VI	Slurry in water, ambient	5 days	II+V
I, II, III, IV, VI	Slurry in water, ambient	9 days	II
I, II, III, IV, VI	Slurry in water, ambient	13 days	II
I, II, III, IV, VI	Slurry in water, up to 40°C	5 days	II

Table 12: Preparation of Large Scale Samples

Intended Form	Conditions	XRPD Result
II	Slurry in water:acetone 9:1, 4 days	II
III	Slurry in ethanol:water 95:5, 1 day	III
	Spontaneous precipitation from ethanol:water 95:5	
IV	Slurry in isopropanol:water 9:1, 4 days	IV
	Slurry in isopropanol:water 9:1, 1 day	
V	Slurry in water:ethanol 9:1, 4 days	II
	Slurry of Form II in water:ethanol 9:1, 5 days	II
	Slurry of Form II in water: ethanol 9:1, up to 1 month	II
	Slurry of Form II in water:ethanol 9:1, up to 1 month	-
	Slurry in water, 1 day	II
	Slurry in water, 5 days	I + II
	Slurry in water, up to 1 month	II + V
	Slurry in water, 51 days	-
VI	Drying of Form II under vacuum at ambient, 1 day	VI

5

According to Experimental Example 2 and 3, it is suggested that stable crystals in transfer are Form II, Form VI, Form III, Form IV, and Form V, in that order.

Since the crystal of the present invention has excellent

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antiulcer action, gastric acid secretion-inhibiting action, mucosa-protecting action, anti-*Helicobacter pylori* action, etc., and shows low toxicity, it is useful as a pharmaceutical product. Moreover, the crystal of the present invention shows different physical properties, particularly solubility, from those of conventional (R)-lansoprazole crystal. Solubility can markedly influence the bioavailability of pharmaceutical products. Hence, using the crystal of the present invention, a preparation design different from that of conventional crystal in solubility and the like is available, and the crystal is useful, for example, for the invention of controlled release dosage form and the like.

10 Although the present invention have been presented or described by referring to preferred embodiments of this invention, it will, however, be understood by those of ordinary skill in the art that various modifications may be made to the forms and details without departing from the scope of the invention as set forth in the appended claims.

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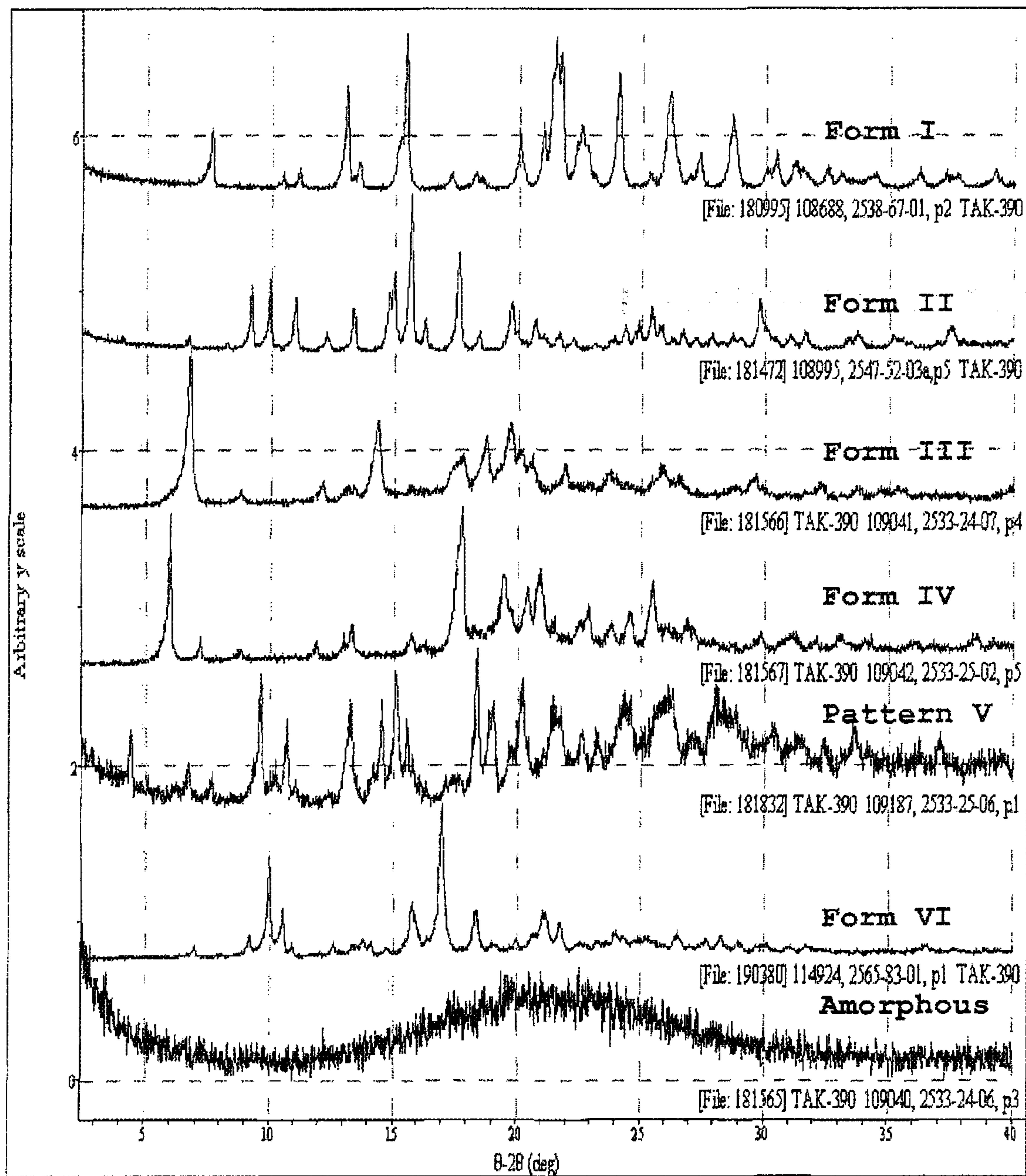
CLAIMS:

1. A 1.0 hydrate crystal of (*R*)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar spacings (*d*) of 8.93 ± 0.2 ,
5 8.47 ± 0.2 , 5.65 ± 0.2 , 5.63 ± 0.2 and 5.25 ± 0.2 Angstrom.
2. An ethanol hydrate crystal of (*R*)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar spacings (*d*) of 13.23 ± 0.2 ,
 6.21 ± 0.2 , 4.75 ± 0.2 , 4.51 ± 0.2 and 4.41 ± 0.2 Angstrom.
- 10 3. An isopropanol hydrate crystal of (*R*)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar spacings (*d*) of 14.90 ± 0.2 , 5.01 ± 0.2 , 4.56 ± 0.2 , 4.26 ± 0.2 and 3.50 ± 0.2 Angstrom.
4. A hydrate crystal of (*R*)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar spacings (*d*) of 9.21 ± 0.2 ,
15 6.70 ± 0.2 , 5.88 ± 0.2 , 4.83 ± 0.2 and 4.40 ± 0.2 Angstrom.
5. A methanol solvate crystal of (*R*)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar spacings (*d*) of 13.42 ± 0.2 ,
20 13.22 ± 0.2 , 6.21 ± 0.2 , 6.16 ± 0.2 , 4.51 ± 0.2 and 4.32 ± 0.2 Angstrom.
6. An ethanol solvate crystal of (*R*)-2-[[[3-methyl-4-(2,2,2-trifluoroethoxy)-2-pyridinyl]methyl]sulfinyl]-1H-benzimidazole wherein the X-ray powder diffraction analysis pattern has characteristic peaks at interplanar spacings (*d*) of 13.71 ± 0.2 ,
25 13.50 ± 0.2 , 13.22 ± 0.2 , 13.06 ± 0.2 and 6.16 ± 0.2 Angstrom.

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7. Use of a crystal as defined in claim 1 for the prophylaxis or treatment of digestive ulcer.
8. Use of a crystal as defined in claim 1, 2, 3, 4, 5 or 6 for the prophylaxis or treatment of reflux esophagitis.
- 5 9. Use of a crystal as defined in claim 1, 2, 3, 4, 5 or 6 for the prophylaxis or treatment of symptomatic gastroesophageal reflux disease (symptomatic GERD).
10. A pharmaceutical formulation comprising a crystal as defined in claim 1, 2, 3, 4, 5 or 6, and a pharmacologically acceptable carrier; and which is an oral dosage form.
- 10 11. The pharmaceutical formulation according to claim 10, which is a capsule or tablet.
12. The pharmaceutical formulation according to claim 10 or 11, for use in the prophylaxis or treatment of digestive ulcer.
13. The pharmaceutical formulation according to claim 10 or 11, for use in
15 the prophylaxis or treatment of reflux esophagitis.
14. The pharmaceutical formulation according to claim 10 or 11, for use in the symptomatic gastroesophageal reflux disease (symptomatic GERD).
15. A sustained-release capsule comprising a crystal as defined in claim 1, 2, 3, 4, 5 or 6, and a pharmacologically acceptable carrier.
- 20 16. The sustained-release capsule according to claim 15, containing 30 mg of the crystal.
17. The sustained-release capsule according to claim 15, containing 60 mg of crystal.

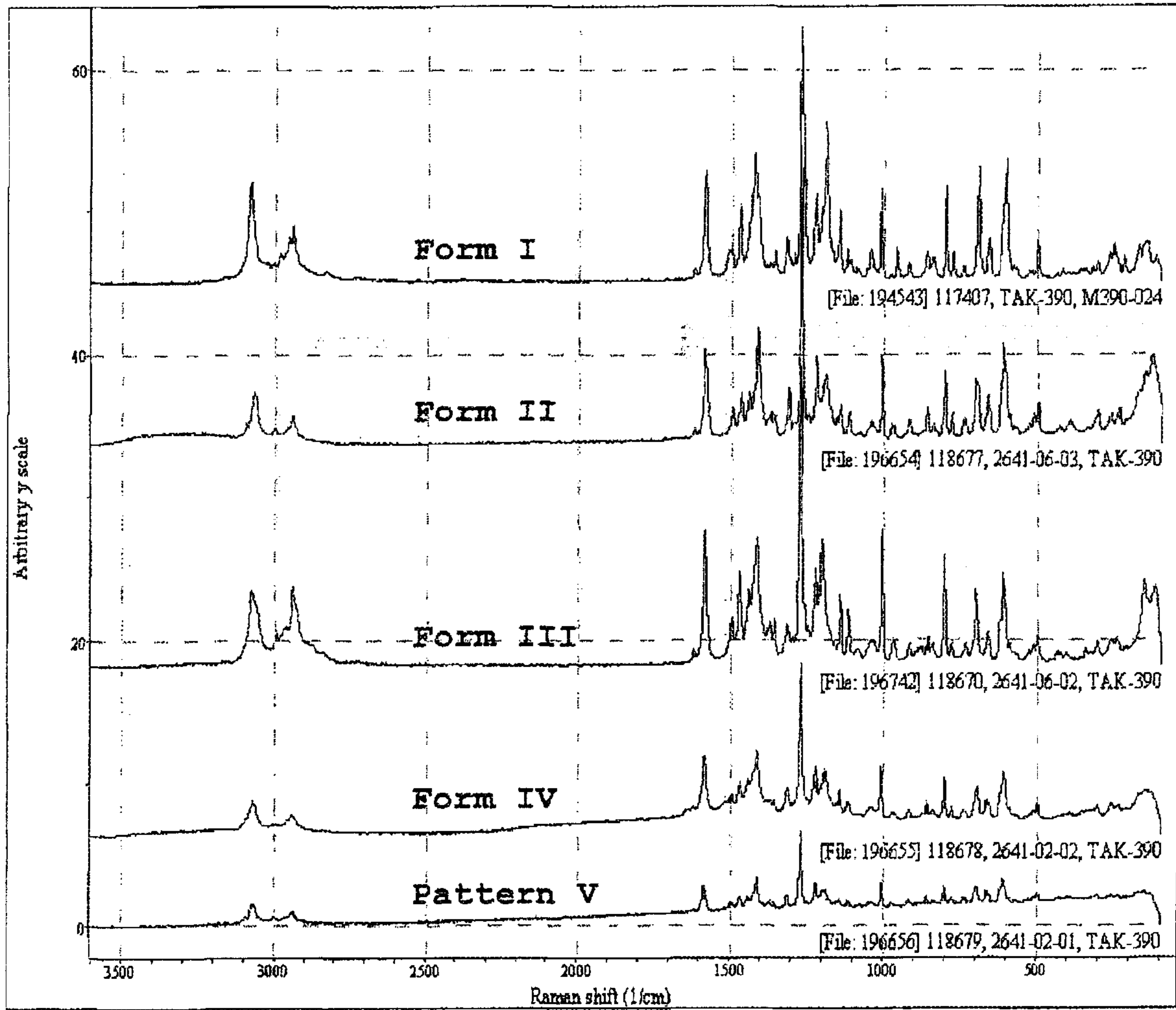
Fig. 1



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Fig. 2



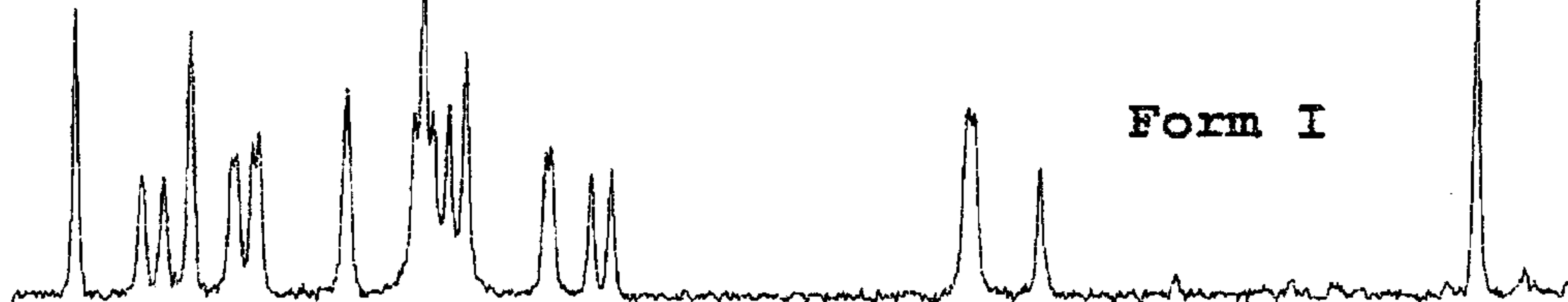
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Fig. 3

118802, 2609-02-01, TAK-390, ^{13}C CP/MAS NMR, externally referenced to glycine at 176.5 ppm

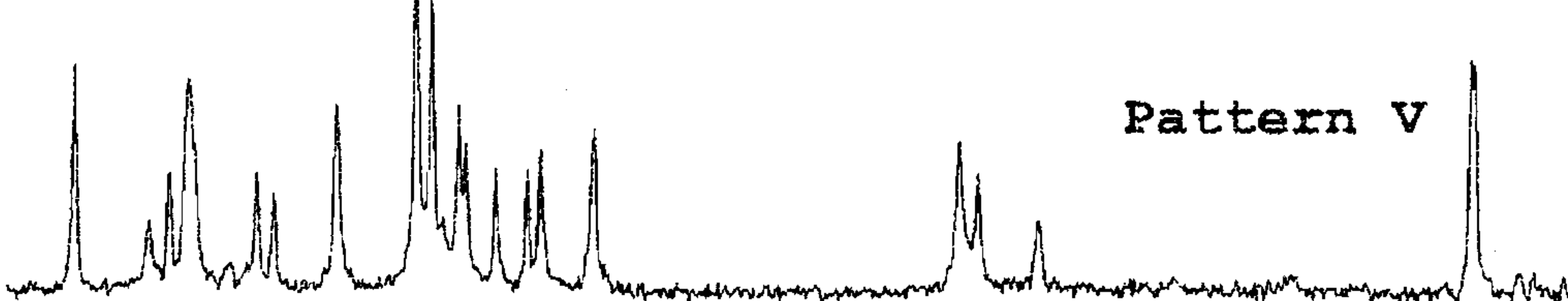
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118679, 2641-02-01, TAK-390, ^{13}C CP/MAS NMR, externally referenced to glycine at 176.5 ppm

File: 196823

118678, 2641-02-02, TAK-390, ^{13}C CP/MAS NMR, externally referenced to glycine at 176.5 ppm

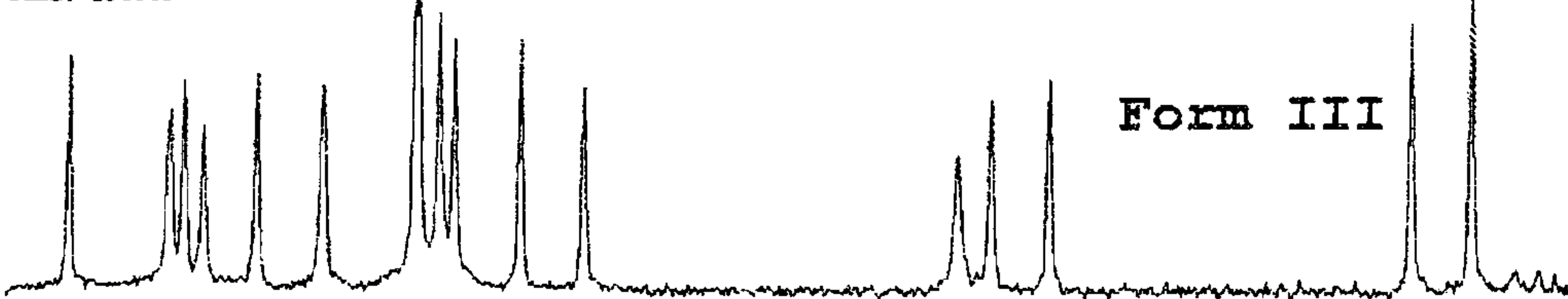
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118677, 2641-06-03, TAK-390, ^{13}C CP/MAS NMR, externally referenced to glycine at 176.5 ppm

File: 196821

118670, 2641-06-02, TAK-390, ^{13}C CP/MAS NMR, externally referenced to glycine at 176.5 ppm

File: 196820



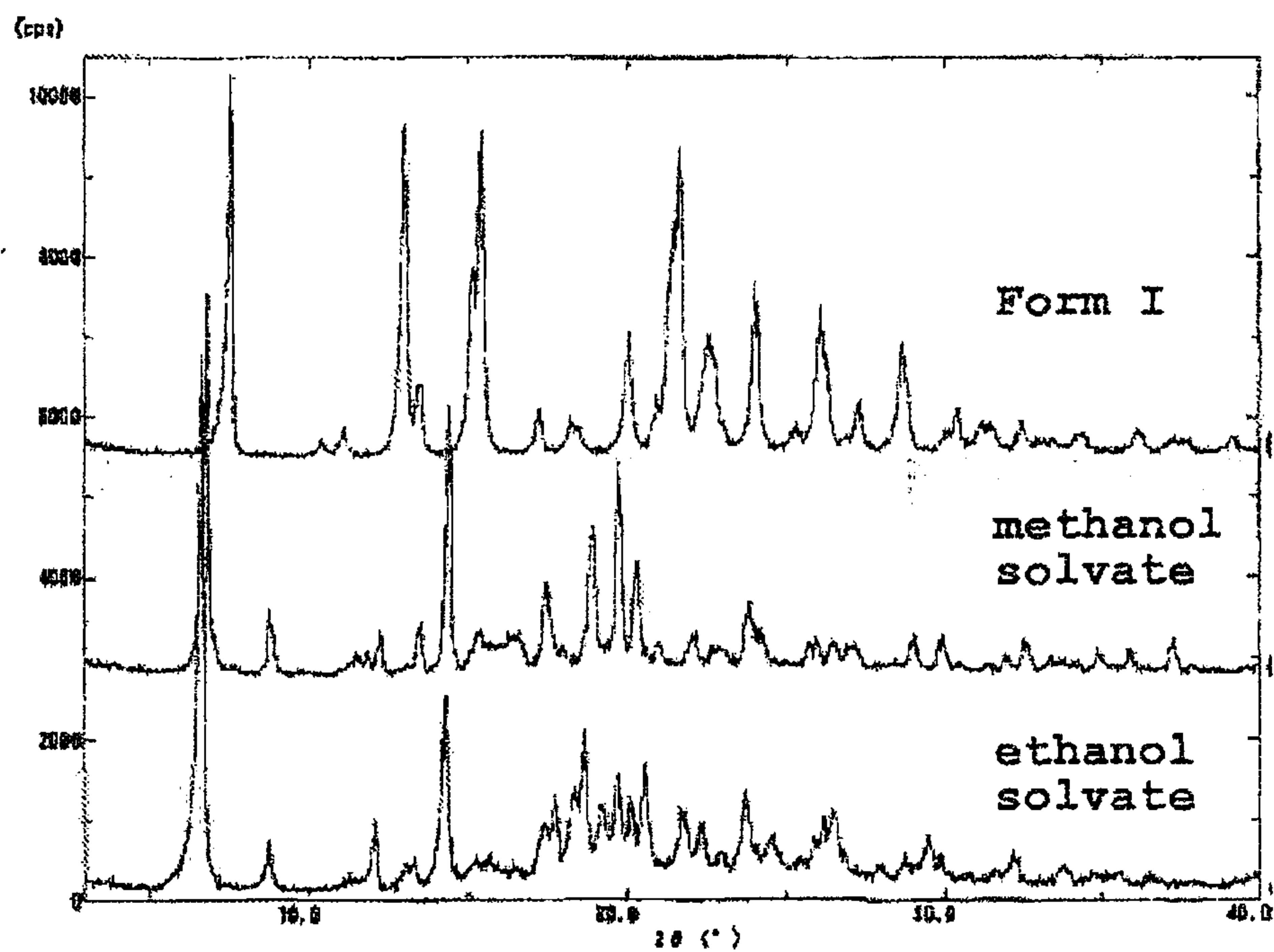
160 140 120 100 80 60 40 20 ppm

Plot file: stack1

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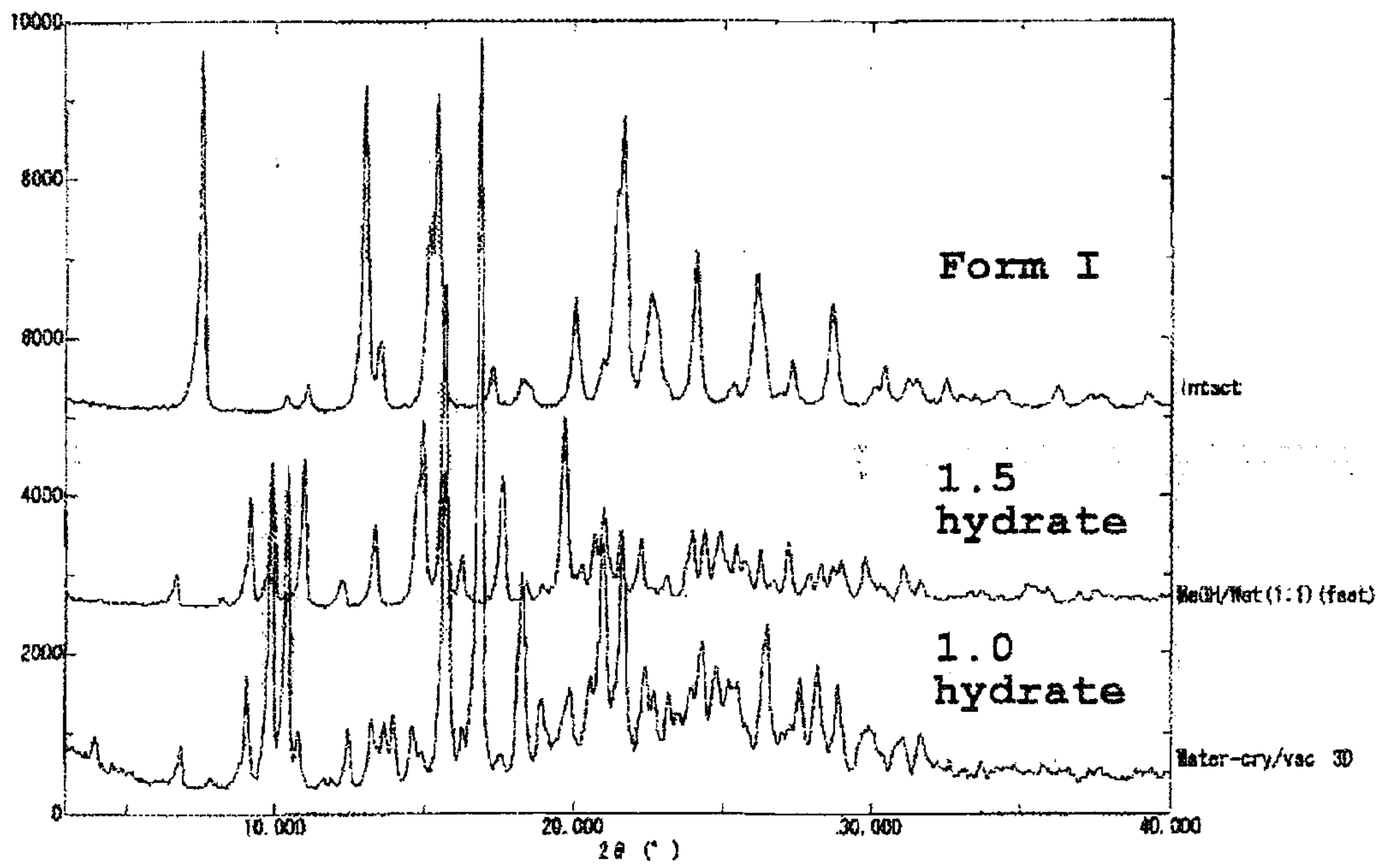
Fig. 4



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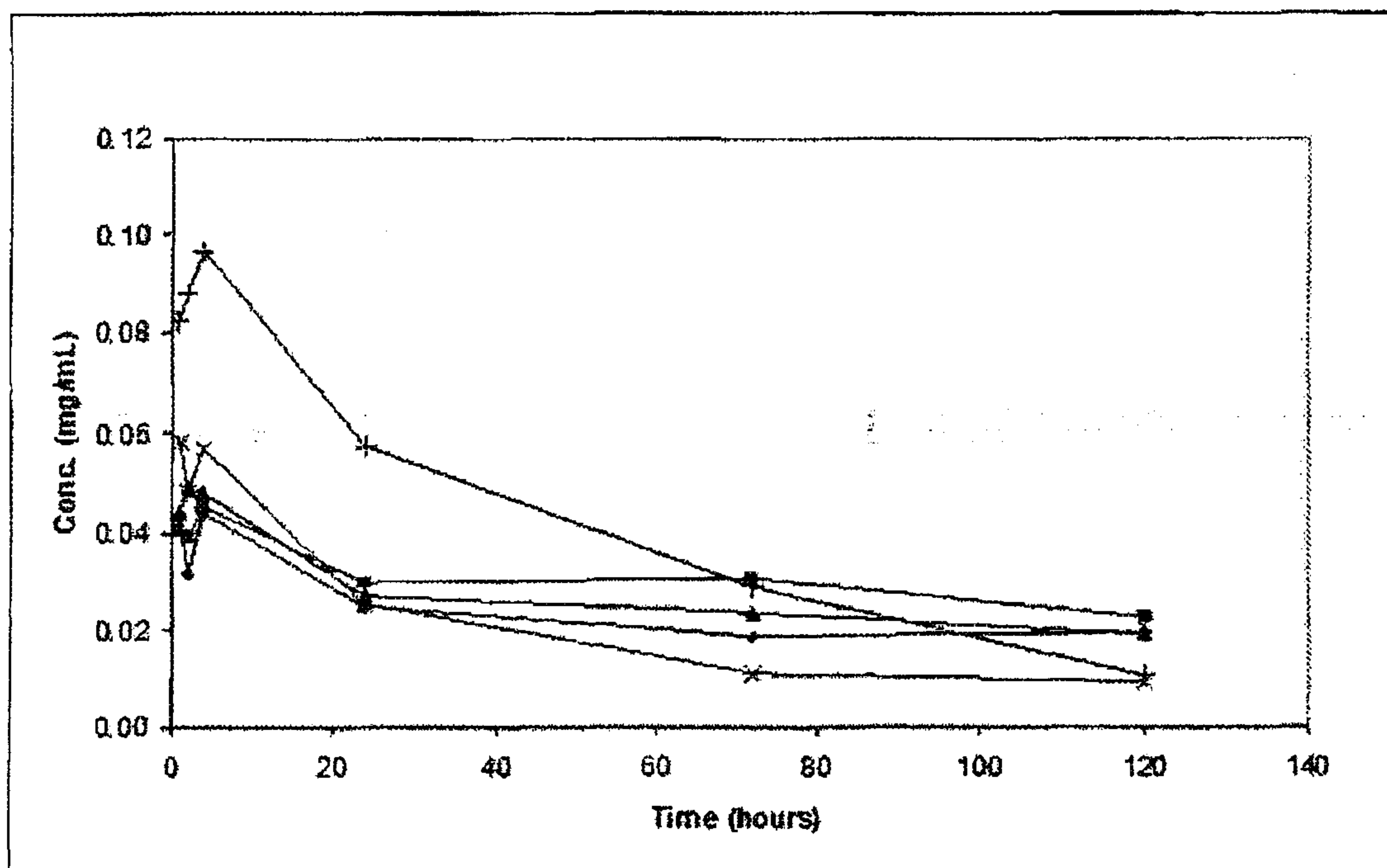
Fig. 5



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Fig. 6



—+— Form I ; —■— Form II ; —▲— Form III ; —x— Form IV ; —◆— Form VI

Fig. 7

