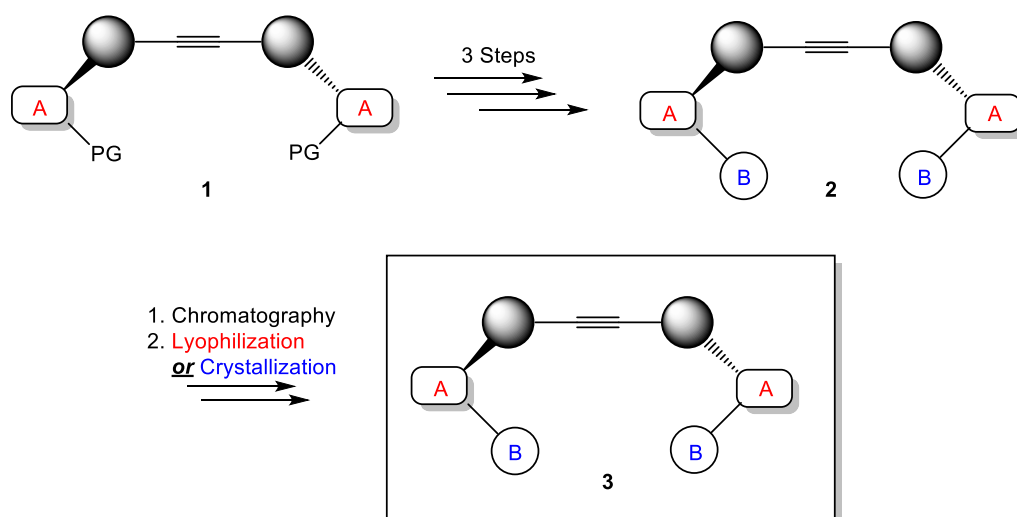


From Catastrophy to Success

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The target molecule (compound **3**) was manufactured under cGMP conditions (2.5 – 3.0 kg) in five steps starting from a C_2 -symmetric molecule (compound **1**). After deprotection, purification via crystallization and coupling, compound **2** was obtained in good yields. The process was followed by a purification step via preparative HPLC chromatography, as seen in the scheme below.



Due to the lack of a crystallization method for the final purification and isolation of the target molecule (compound **3**), a lyophilization was originally planned. Due to an unforeseen event [1] during the preparation of the lyophilization mixture, unexpectedly a crystallization method was discovered and developed. The incident will be presented and how the key crystallization was stumbled on.

[1] Unpublished results, *Project Report No. RDE3173 2014*