

**Submission Date :** 07/02/2023

**Scientist Name :** Tarang Kaneria

**Journal Date :** 25/02/2023

**Team Leader Name :** Tarang Kaneria

**Chemist :**

**Catalogue No. :** SZ-F005010

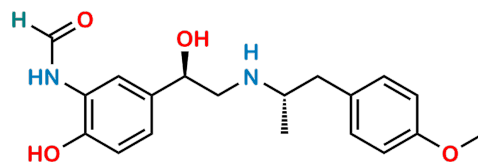
**Project Name :** Formoterol

**Product Name :** Formoterol Fumarate  
Dihydrate EP Impurity I (R,S-isomer) ((R,S)-Formoterol)

**CAS No. :** 67346-51-4

**Mole. Weight :** 344.4

**Mole. Formula :** C<sub>19</sub>H<sub>24</sub>N<sub>2</sub>O<sub>4</sub>



**Batch Code :** TEST-00010

**Quantity Submitted :** 10000

**Ref. 1H/HPLC/MS Code :**

**1H Status :** SER Pending

**HPLC/GC/ELSD Date :** 28/02/2023

**Chromatography :** 465312 %

**MS Analysis :** APCI

**Type Of Compound :** Impurity

**State Of Compound :** Light Pink

**If Salt Mention the Name :** Free

**No Of Steps of Final Route :** 2

**Earlier Synthesized :** Yes

Temp Sensitive

**Additional Analysis :** IR,Mass,HPLC/GC/ELSD,NM  
R,APCI Mass,NMR  
Interpretation

**Remark :** ,

**Stability Related Comment :**

**Stability :**

**Physical State :** Sticky Solid

**Stability data in solution form after 7 days :** Unstable

**Stability data in solid form after 7 days :** Unstable

**Any of last 3 step NMR done ? :** No

**Any of last 2 step crystallization done? :** No

**Purification By :** Preparative HPLC