

CONTENTS

PREFACE	xv
CONTRIBUTORS	xvii
ACRONYMS	xix
PART I METHODOLOGY	
1. Introduction to Mass Spectrometry	3
<i>Scott A. Smith, Ruth Waddell Smith, Yu Xia, and Zheng Ouyang</i>	
1.1. History	3
1.1.1. Atomic Physics	4
1.1.2. Early Applications	7
1.1.3. Organic Structural Analysis	7
1.1.4. The Biological Mass Spectrometry Revolution	8
1.2. Ionization Methods	9
1.3. Mass Spectrometer Types	10
1.3.1. Magnetic Sector Mass Spectrometers	10
1.3.2. Quadrupole Mass Filter and Quadrupole Ion Trap Mass Spectrometers	14
1.3.3. Time-of-Flight Mass Spectrometers	19
1.3.4. Fourier Transform Ion Cyclotron Resonance Mass Spectrometers	22
1.3.5. Orbitrap Mass Spectrometers	25
1.4. Tandem Mass Spectrometry	28
1.4.1. Ion Isolation	29
1.4.2. Ion-Molecule Collisions and Collision-Induced Dissociation	30
1.4.3. Electron Capture Dissociation and Electron Transfer Dissociation	32
1.5. Separation Techniques Coupled to Mass Spectrometry	35
1.5.1. Gas Chromatography–Mass Spectrometry	35
1.5.2. Liquid Chromatography–Mass Spectrometry	37
1.5.3. Capillary Electrophoresis–Mass Spectrometry	42
1.5.4. Ion Mobility Spectrometry–Mass Spectrometry	45

1.6. Prospects for Mass Spectrometry	48
References	51
2. LC Method Development and Strategies	59
<i>Gang Xue and Yining Zhao</i>	
2.1. Introduction	59
2.2. Column, pH, and Solvent Screening	60
2.2.1. Resolution: Goal of Separation	60
2.2.2. Screening: Systematic Approach to Seeking Selectivity	60
2.2.3. Screening Instrumentation and Controlling Software	67
2.3. Gradient and Temperature Optimization	69
2.4. Orthogonal Screening	70
2.4.1. Method Orthogonality	71
2.4.2. Selection of Orthogonal Methods	72
2.4.3. Impurity Orthogonal Screening	74
2.5. High-Efficiency Separation	76
2.6. Conclusions	78
References	78
3. Rapid Analysis of Drug-Related Substances using Desorption Electrospray Ionization and Direct Analysis in Real Time Ionization Mass Spectrometry	81
<i>Hao Chen and Jiwen Li</i>	
3.1. Introduction	81
3.2. Ionization Apparatus, Mechanisms, and General Performance	83
3.2.1. Desorption Electrospray Ionization (DESI)	83
3.2.2. Direct Analysis in Real Time (DART)	85
3.3. Drug Analysis in Biological Matrices using DESI and DART	87
3.3.1. DESI Application	88
3.3.2. DART Application	89
3.4. High-Throughput Analysis	92
3.5. Chemical Imaging and Profiling	94
3.6. Future Perspectives	101
References	101
4. Orbitrap High-Resolution Applications	109
<i>Robert J. Strife</i>	
4.1. Historical Anecdote	109
4.2. General Description of Orbitrap Operating Principles	110
4.3. The Orbitrap is a “Fourier Transform” Device	112

4.4.	Performing Experiments in Trapping Devices	113
4.4.1.	“Raw” HPLC Data Look Like Infusion Data	114
4.4.2.	How Much Mass Resolution Should Be Used During HPLC	114
4.5.	Determining Elemental Compositions of “Unknowns” Using an Orbitrap	115
4.6.	Orbitrap Figures of Merit in Mass Measurement	117
4.6.1.	Accuracy	117
4.6.2.	Precision	118
4.6.3.	Discussion	118
4.7.	HPLC Orbitrap MS: Accurate Mass Demonstration and Differentiation of Small Molecule Formulas Very Proximate in Mass/Charge Ratio Space	121
4.8.	Determination of Trace Contaminant Compositions by Simple Screening HPLC-MS and Infusion Orbitrap MS	122
4.9.	Determining Substructures: Orbitrap Tandem Mass Spectrometry (MS ⁿ)	124
4.10.	Multianalyzer (Hybridized) System: The Linear Ion Trap/Orbitrap for MS/MS and Higher-Order MS ⁿ , $n > 2$	127
4.11.	Mass Mapping to Discover Impurities	129
4.12.	The Current Practice of Orbitrap Mass Spectrometry	131
4.13.	Conclusion	132
	References	132
5.	Structural Characterization of Impurities and Degradation Products in Pharmaceuticals Using High-Resolution LC-MS and Online Hydrogen/Deuterium Exchange Mass Spectrometry	135
	<i>Guodong Chen and Birendra N. Pramanik</i>	
5.1.	Introduction	135
5.2.	Characterization of Impurities	137
5.2.1.	Mometasone Furoate	137
5.2.2.	Enol Tautomer Impurity in Hepatitis C Virus (HCV) Protease Inhibitor	152
5.3.	Characterization of Degradation Products	155
5.3.1.	Everninomicin	156
5.3.2.	Posaconazole	164
5.4.	Conclusions	176
	References	177

6. Isotope Pattern Recognition on Molecular Formula Determination for Structural Identification of Impurities	183
<i>Ming Gu</i>	
6.1. Introduction	183
6.2. Three Basic Approaches to Isotope Pattern Recognition	184
6.2.1. With Centroid Data	185
6.2.2. With Profile Data without Peak Shape Calibration	187
6.2.3. With Profile Data with Peak Shape Calibration	189
6.3. The Importance of Lineshape Calibration	190
6.3.1. Lineshape Calibration Using Standards	191
6.3.2. Lineshape Self-Calibration	193
6.4. Spectral Accuracy	194
6.5. Formula Determination with Quadrupole MS	194
6.5.1. Impurity Identification with LC-MS	195
6.5.2. Impurity Identification with GC-MS	200
6.5.3. Pros and Cons of Determination of Elemental Decomposition (DEC) with Quadrupole MS	201
6.6. Formula Determination with High-Resolution MS	203
6.7. Conclusions and Future Directions	208
References	208

PART II APPLICATION

7. Practical Application of Very High-Pressure Liquid Chromatography Across the Pharmaceutical Development–Manufacturing Continuum	215
<i>Brent Kleintop and Qinggang Wang</i>	
7.1. Introduction	215
7.2. Theory and Benefits of VHPLC	217
7.3. VHPLC Method Development	220
7.3.1. Adapting Existing HPLC Methods to VHPLC	220
7.3.2. Developing New VHPLC Methods	224
7.4. Other Practical Considerations	226
7.5. VHPLC Method Validation	227
7.6. Summary	229
References	229
8. Impurity Identification for Drug Substances	231
<i>David W. Berberich, Tao Jiang, Joseph McClurg, Frank Moser, and R. Randy Wilhelm</i>	
8.1. Introduction	231

8.2. Case Studies	232
8.2.1. Identification of Impurities in Each Synthetic Step of Drug Substance during Process Development	232
8.2.2. Impurity ID by LC/MS during Exploratory Chemistry: Evaluation of New Raw Materials	237
8.2.3. Impurity Identification during Accelerated Stability Studies	243
8.3. Conclusions	249
References	250
9. Impurity Identification in Process Chemistry by Mass Spectrometry	251
<i>David Q. Liu, Mingjiang Sun, and Lianming Wu</i>	
9.1. Introduction	251
9.2. Experimentation	252
9.2.1. Liquid Chromatography Conditions	252
9.2.2. LC-MS Systems	253
9.2.3. GC-MS System	253
9.2.4. Accurate Mass	253
9.2.5. Online H/D Exchange LC-MS	254
9.3. Applications	254
9.3.1. Identification of Reaction Byproducts by Data-Dependent LC/MS ⁿ	254
9.3.2. Online H/D Exchange Aids Structural Elucidation of Process Impurities	257
9.3.3. LC-MS for Chemical Reaction Impurity Fate Mapping	260
9.3.4. GC-MS for Impurity Profiling of Small-Molecule Starting Materials	262
9.3.5. Identification of a Process Impurity that Impacts Downstream Formulation	265
9.3.6. Differential Fragmentation between Sodiated and Protonated Molecules as a Means of Structural Elucidation	267
9.4. Concluding Remarks	275
Acknowledgments	275
References	276
10. Structure Elucidation of Pharmaceutical Impurities and Degradants in Drug Formulation Development	279
<i>Changkang Pan, Frances Liu, and Michael Motto</i>	
10.1. Importance of Drug Degradation Studies in Drug Development	279
10.2. Drug Degradation Studies in Formulation Development	281

10.2.1.	Drug Substance–Excipient Interaction	281
10.2.2.	Small Unknown Peaks (~0.1%) (Low-Dose Drugs <1 mg per Dose)	282
10.2.3.	“Busy” LC Chromatogram with Multiple Peaks (Combination Drug Products)	282
10.2.4.	Modification of Non-MS-Compatible LC Methods	282
10.2.5.	Uncontrollable Multiple Chemical Reactions in Stability Samples	283
10.2.6.	Separation Interference and Contamination Induced by Excipients	283
10.2.7.	Peak Isolation and NMR Confirmation for Late-Phase Projects	284
10.3.	Complexity of Impurity Identification in Drug Development	284
10.3.1.	Drug Substance (DS) Degradation	284
10.3.2.	DS–Excipient Interaction	285
10.3.3.	DS–Residual Solvent Interaction	287
10.3.4.	DS–Solvent Impurity Interaction	287
10.3.5.	Metal Ion–Catalyzed Reaction	289
10.3.6.	DS–Excipient Impurity Interaction	289
10.3.7.	DS–Salt Interaction	291
10.3.8.	DS–Preservative Interaction	291
10.3.9.	Preservative–Excipient Interaction	292
10.3.10.	Excipient Degradation	292
10.3.11.	Leachables and Extractables	293
10.4.	Strategy for Structure Elucidation of Unknowns	295
10.4.1.	Non-MS-Compatible Method versus MS-Compatible Method	295
10.4.2.	Selection of Ionization Mode (ESI or APCI, Positive or Negative)	298
10.4.3.	Multiple Approaches for Structure Elucidation	298
10.4.4.	Structure Confirmation	299
10.5.	Hyphenated Analytical Techniques Used in Drug Development	300
10.5.1.	LC-MS/MS for Fragmentation Pathways	302
10.5.2.	High-Resolution MS for Chemical Formula/Elemental Composition	302
10.5.3.	SEC/CLND or HPLC/CLND: Nitrogen-Specific Detection	304
10.5.4.	GC-MS with EI-CI Combination	305
10.5.5.	Headspace GC-MS: Volatile Compounds	305
10.5.6.	NMR and LC-NMR	306
10.5.7.	TD-GC/MS: Chemical Reactions Attributing to Weight Loss in TGA	307
10.6.	Case Studies	307

10.6.1.	LC-MS, GC-MS, and LC-NMR Studies of a Drug Degradation Product	307
	10.6.1.1. LC-MS Analysis	308
	10.6.1.2. GC-MS Analysis	308
	10.6.1.3. LC-NMR Analysis	308
10.6.2.	Strategy for Identification of Leachables in Packaged Liquid Formulation	313
10.6.3.	Characterization of Methionine Oxidation in Parathyroid Hormone Formulation	316
	10.6.3.1. Oxidation, Isolation, and Digestion of PTH1-34	316
	10.6.3.2. Mass Assignment of PTH1-34 Oxidized Variants	317
	10.6.3.3. Mass Assignment of CNBr Digested Peptide Fragments	318
	10.6.3.4. LC-MS/MS Studies of Ion Fragments from Oxidized Peptides	322
	Acknowledgment	326
	References	326
11.	Investigation of Degradation Products and Extractables in Developing Topical OTC (Over the Counter) and NCE (New Chemical Entity) Consumer Healthcare Medication Products	337
	<i>Fa Zhang</i>	
11.1.	Introduction	337
11.2.	Oxidatively Induced Coupling of Miconazole Nitrate with Butylated Hydroxytoluene in a Topical Ointment	338
	11.2.1. HPLC-MS Screening	339
	11.2.2. Organic Synthesis	341
	11.2.3. Degradation Mechanism	344
11.3.	Extractables from Rubber Closures of a Prefilled Semisolid Drug Applicator	347
	11.3.1. Isolation of the Extractables	348
	11.3.2. Structural Identification of Extractables 5 and 6	348
	11.3.3. Structural Identification of Extractables 7 and 8	349
	11.3.4. Structural Identification of Extractable 9	351
11.4.	New Degradation Products and Pathways of Vitamin D and Its Analogs	352
	11.4.1. Thermal Isomerization of Vitamin D ₃ in DMSO	355
	11.4.2. Autoxidation of Isotachysterol	356

11.4.2.1.	<i>Mechanism of Isotachysterol Autoxidation</i>	362
11.4.3.	Thermal Degradation of Ecalcidene	364
11.4.4.	Acid-Induced Degradation of Ecalcidene	368
11.4.5.	Iodine-Induced Degradation of Ecalcidene	370
11.4.5.1.	<i>cis/trans-Isomerization of Ecalcidene</i>	371
11.4.5.2.	<i>cis/trans-Isomerization of Previtamin D₃-Type Isomer 24</i>	372
11.5.	Reductive Degradation of a 1,2,4-Thiadiazolium Derivative	376
11.6.	Conclusions	382
	References	383
12.	Characterization of Impurities and Degradants in Protein Therapeutics by Mass Spectrometry	391
	<i>Li Tao, Michael Ackerman, Wei Wu, Peiran Liu, and Reb Russell</i>	
12.1.	Introduction to Therapeutic Proteins	391
12.2.	Recent Advances in Mass Spectrometry	392
12.3.	Impurities	393
12.3.1.	Endotoxin	394
12.3.2.	Residual DNA	394
12.3.3.	Residual HCP	395
12.4.	Degradation Products	395
12.4.1.	Chemical Degradation	396
12.4.1.1.	<i>Deamidation/Isomerization</i>	396
12.4.1.2.	<i>Protein Fragmentation</i>	400
12.4.1.3.	<i>Oxidation</i>	401
12.4.2.	Variants Caused by Posttranslational Modification	404
12.4.2.1.	<i>Case Study: Characterization of S-Thiolation on Secreted Proteins from E. coli</i>	406
12.4.2.2.	<i>TM307</i>	408
12.4.2.3.	<i>TM485</i>	408
12.4.2.4.	<i>TM358 and TM687</i>	410
12.5.	Conclusions	413
	References	413
13.	Identification and Quantification of Degradants and Impurities in Antibodies	427
	<i>David M. Hambly and Himanshu S. Gadgil</i>	
13.1.	Introduction to Antibodies and Protein Drugs	427

13.1.1.	Antibody Classification and Subtypes	427
13.1.2.	Antibody Structure	428
13.1.3.	Antibody-Domain Structure	429
13.1.4.	Recombinant Antibody Production	429
13.1.5.	Methods for Characterizing Antibody Degradation and Impurity	430
13.2.	Overview of Degradations and Impurities in Protein Drugs and Antibodies	431
13.2.1.	Chemical Degradations and Impurities	431
13.2.1.1.	<i>Methionine Oxidation</i>	431
13.2.1.2.	<i>Disulfide Bonds or Reduced Cysteine</i>	432
13.2.1.3.	<i>Deamidation of Asparagine and Glutamine</i>	432
13.2.1.4.	<i>Isomerization of Aspartic Acid and Glutamic Acid</i>	433
13.2.1.5.	<i>Amide Backbone Hydrolysis Reactions</i>	433
13.2.1.6.	<i>Glycation of Lysine Residues</i>	433
13.2.1.7.	<i>C-Terminal Lysine Variants</i>	434
13.2.1.8.	<i>Carbohydrate Variants</i>	434
13.3.	Methods Used to Identify and Quantitate Degradations and Impurities	435
13.3.1.	Whole-Protein Mass Analysis Methods	435
13.3.1.1.	<i>Carbohydrate Variation</i>	435
13.3.1.2.	<i>Detection of Lysine C-terminal Variants and Glycated Lysine</i>	437
13.3.1.3.	<i>Detection of Disulfide Bond Variants in IgG2 Antibodies</i>	437
13.3.2.	Methods for Evaluating the Mass of Protein Fragments	438
13.3.2.1.	<i>Limited Digestion Method for Antibodies</i>	438
13.3.2.2.	<i>Limited and Reduced Method for Antibodies</i>	440
13.3.2.3.	<i>Reduced Protein Mass Analysis</i>	441
13.3.3.	Methods for Evaluating Peptides for Impurities and Degradations	443
13.3.3.1.	<i>Reduced and Alkylated Peptide Mapping</i>	443
13.4.	Conclusions	450
	Appendix	450
	References	453
	INDEX	461