



## BDG SYNTHESIS

### Certificate of Analysis

BDG Synthesis certifies that this reference material meets or exceeds the specifications stated herein.

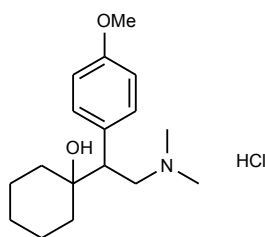
*Barry Dent*

Barry R. Dent, PhD, Director  
6 December 2012

**Name:** Venlafaxine HCl

**CAS Number:** 99300-78-4

**Structure:**



**Molecular Weight:**  $C_{17}H_{27}NO_2 \cdot HCl = 313.86$

**Lot Number:** BDG 5422

**Appearance:** White, crystalline solid

**Purity By HPLC:** 100.0 %

**Re-test Date:** 6 December 2017

**Storage and Handling:**

|              |   |
|--------------|---|
| Temperature: | refrigerate for prolonged storage; may be handled and shipped at ambient temperature. |
| Humidity:    | not believed to be hygroscopic; may be handled in normal laboratory atmosphere.       |
| Light:       | protect from strong sunlight.   |
| Caution:     | only experienced laboratory personnel should handle the material.                     |

## Identity and Purity

### Proton NMR Spectrum

Identity: the signals are consistent with the proposed structure and in accord with literature where available.

Residual Solvents: no residual solvents are observed.

Impurities: no significant impurities are evident in the spectrum.

### Carbon-13 NMR Spectrum

Identity: the signals are consistent with the proposed structure and in accord with literature where available.

### High-resolution Mass Spectrum (ESI+)

Found  $m/z$  278.2093.  $C_{17}H_{28}NO_2$   $[M+H]^+$  requires  $m/z$  278.2115. The deviation of 7.6 ppm is somewhat outside normally accepted limits for the establishment of identity by HRMS, and the mass spectral data should be considered in conjunction with other identity criteria.

### HPLC

A sharp, slightly tailing peak is observed (100.0 %). Note: in the absence of reference materials for preparing calibration curves, it is assumed that all peaks have the same detector response. Where possible, the conditions of analysis follow a pharmacopeial or literature method, or have been adapted from same.

### Elemental Analysis

|                              |           |                           |
|------------------------------|-----------|---------------------------|
| $C_{17}H_{27}NO_2 \cdot HCl$ | Found:    | C 65.25, H 8.48, N 4.46 % |
|                              | Requires: | C 65.05, H 8.99, N 4.46 % |

The elemental analyses fall within generally accepted limits ( $\pm 0.4$  %) for establishing the molecular formula given, except the result for hydrogen. The results may also be taken to imply the absence of significant quantities of water or inorganic salts (which have not been elsewhere tested for because of sample size limitations).

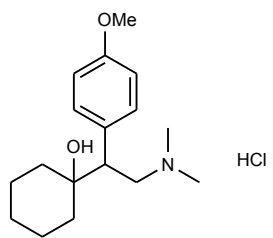
The available quantity of custom-synthesised material is always small, and this limits the extent and type of analytical data which can be obtained. This Certificate is presented in descriptive format for use by analytical chemists who are trained in the use of custom-synthesised materials. Custom materials often contain higher levels of residual solvents and/or water, and we urge you to use the corrected purity where needed rather than the raw HPLC purity. This compound is intended for use as an analytical reference material and it is not for human administration. Structures are shown with relative stereochemistry unless otherwise specified.

The re-test date is assigned from experience gained with the material in the laboratory and/or on storage. It is not possible to perform formal storage studies because of the small amount of material available.

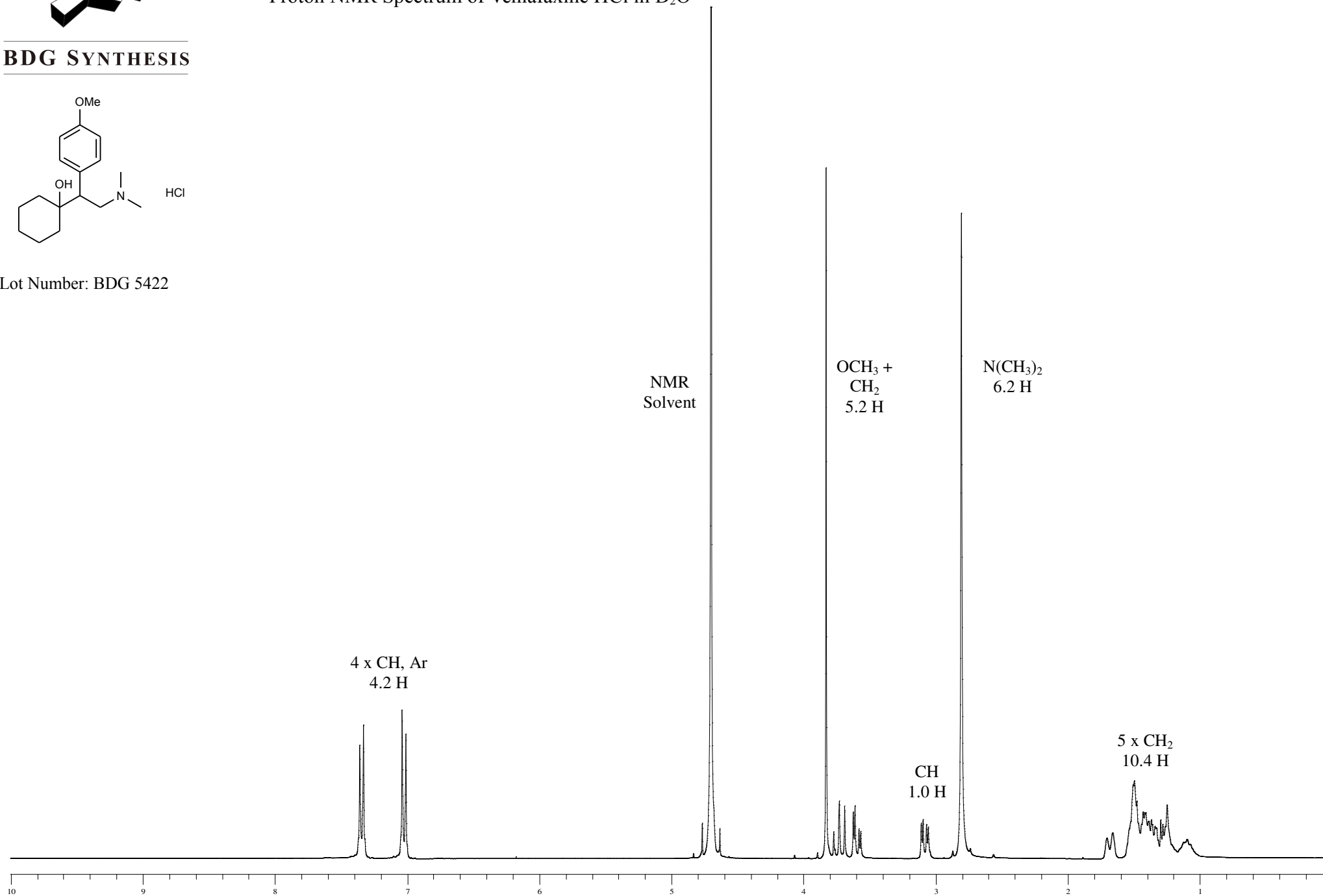


# Proton NMR Spectrum of Venlafaxine HCl in D<sub>2</sub>O

## BDG SYNTHESIS



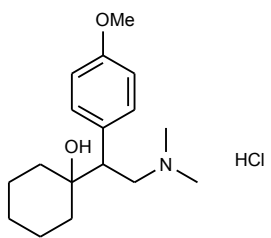
Lot Number: BDG 5422



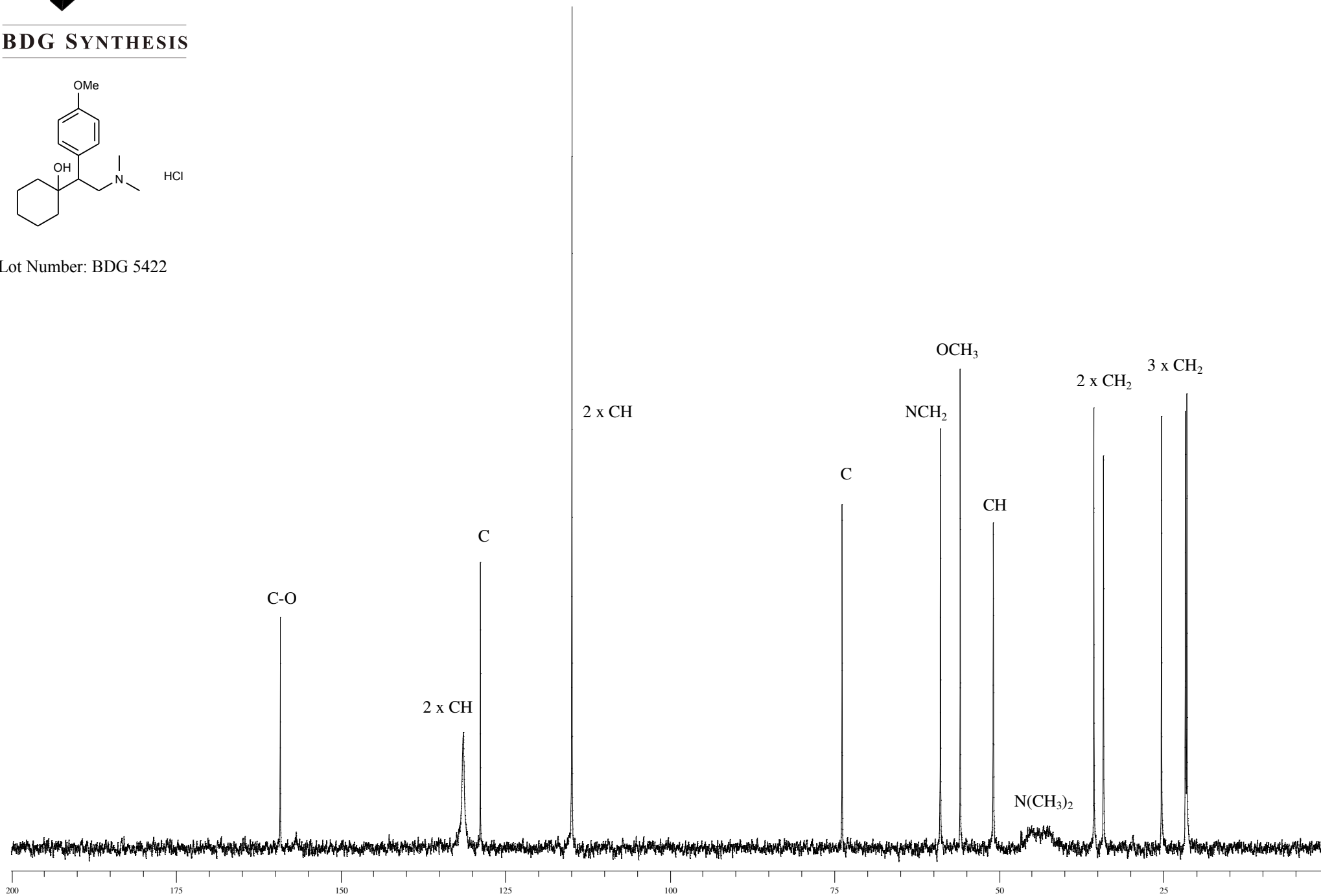


# Carbon-13 NMR Spectrum of Venlafaxine HCl in D<sub>2</sub>O

**BDG SYNTHESIS**



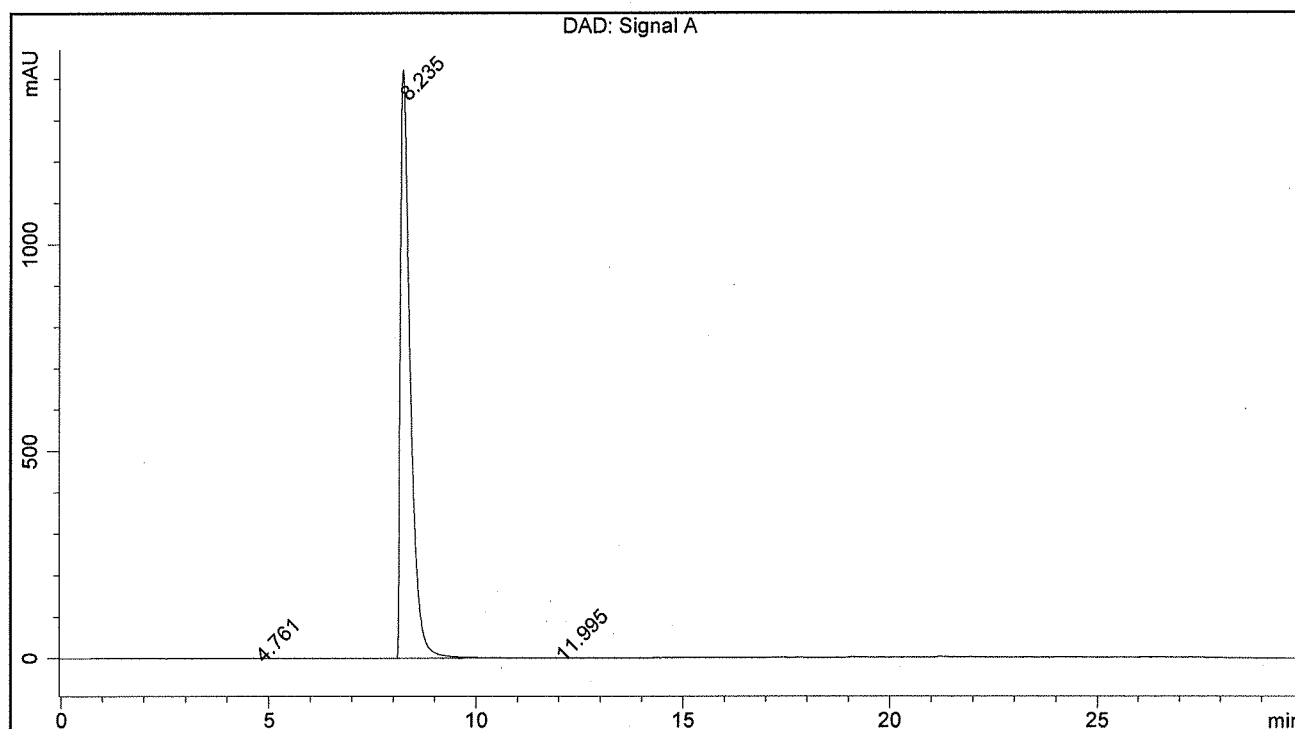
Lot Number: BDG 5422



BDG - Analysis of Venlafaxine

Column : Phenomenex Luna C18(2) 5um 250 x 4.6 mm  
 Guard : Phenomenex Security Guard C18 RP 4 x 3 mm  
 Mobile Phase A: 70:30 20 mM diPotassium Hydrogen Phosphate pH=7.0 : Acetonitrile  
 Mobile Phase B: 25:75 20 mM diPotassium Hydrogen Phosphate pH=7.0 : Acetonitrile  
 Gradient (A:B) : T0=100:0, T20=0:100, T24=0:100, T26=100:0, T30=100:0  
 Flow Rate : 1.0 mL/min  
 Sample Solvent : Initial Mobile Phase  
 Injection Volume : 10 uL  
 Column Temperature : 20C  
 Detection : UV at 230 nm

|                    |                              |                      |                |
|--------------------|------------------------------|----------------------|----------------|
| <b>Sample Name</b> | BDG 5422                     | <b>Instrument</b>    | AnalyticalLC01 |
| <b>Acquisition</b> | 06/12/2012, 18:37:34         | <b>Method (rev.)</b> | LC10030a ( 3)  |
| <b>Sequence</b>    | BDG_06Dec2012c - Reprocessed | <b>Vial Position</b> | 1              |
| <b>Operator</b>    | solvation010\cerityadmin     | <b>Injection</b>     | 1 of 2         |



Area Percent Report

| Peak# | RT        | Peak Height | Peak Area  | Width      | Area %   |
|-------|-----------|-------------|------------|------------|----------|
| 1     | 4.76 min  | 0.4203      | 4.1799     | 0.1460 min | 0.018 %  |
| 2     | 8.24 min  | 1419.7038   | 23435.4912 | 0.2426 min | 99.958 % |
| 3     | 12.00 min | 0.2941      | 5.7378     | 0.2396 min | 0.024 %  |