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Title: Analytical procedures for the quality control of pharmaceuticals in terms of residual solvents content – challenges and recent developments

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## ACCEPTED MANUSCRIPT

1	Analytical procedures for the quality control of pharmaceuticals in terms of residual
2	solvents content – challenges and recent developments
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13	
14	Highlights
15	<ul> <li>residual solvents in pharmaceuticals – problems and challenges</li> </ul>
16	<ul> <li>overview of regulatory and general methods</li> </ul>
17	<ul> <li>sample preparation techniques for analysis</li> </ul>
18	• final determination methods
19	<ul> <li>recent developments in the determination of residual solvents</li> </ul>
20	XO
21	Abstract
22	
23	Residual solvents play an important role in the synthesis of drug substances and in product
24	formulations. At the same time they pose a problem and must be removed, because many of
25	them have toxic or environmentally hazardous properties. Therefore, constant monitoring of
26	quality control is needed. In this paper, we present an overview of regulatory and general
27	methods described by various Pharmacopoeias. Next, the most commonly used
28	methodologies for the determination of residual solvents in different pharmaceutical samples
29	are reviewed to demonstrate their limitations, which form the basis for discussion about new
30	methods. Several interesting new alternatives for sample preparation and gas chromatography
31	(GC) separation are presented using examples from recent literature. The techniques
32	described are direct injection, headspace analysis with different modifications and variations,

liquid extraction, single-drop microextraction, solid-phase microextraction. Various GC

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