Production of $^{177}$Lu and formulation of Ethylene diamine tetramethylene phosphonate (EDTMP) kits as a bone-seeking radiopharmaceutical

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**INTRODUCTION**

Radionuclide therapy (RNT) employing open sources of radiotherapeutic agents is fast emerging as an important part of nuclear medicine, primarily due to the development of sophisticated molecular carriers. In order to develop effective radiopharmaceuticals for therapy, it is essential to carefully consider the choice of appropriate radionuclides as well as the carrier moiety with suitable pharmacokinetic properties that could result in good in vivo localization and desired excretion. The major criteria for the choice of a radionuclide for radiotherapy are suitable decay characteristics, ease of production and amenable chemistry. As regards the decay characteristics, physical half-life of the radionuclide should match with the biological half-life of the radiopharmaceutical. The energy of the particulate emission should be compatible to the volume of lesion to be irradiated and at the same time should result in minimal dose delivery to the tissues surrounding the site of localization (1-6). The high-energy beta-particle emitter $^{177}$Lu is candidate for use as therapeutic radiopharmaceuticals. It gives a high local dose for radioimmunotherapy, synovectomy and bone-palliation.

The radionuclide $^{177}$Lu disintegrates by beta ($\beta^-$) decay to three excited levels which are depopulated by six gamma transitions with energies from 71 to 312 KeV and, to an important extent, to the ground state of $^{177}$Hf. The energies of $\beta^-$ particles from $^{177}$Lu being adequately low, it is expected to have minimum bone marrow suppression on...
accumulation in skeletal lesions while simultaneously delivering the appropriate dose (9-11).

Emissions of adequate energy gamma photons in low abundance are suitable for carrying out simultaneous scintigraphic studies and dosimetric evaluation (11). Several classes of structurally different phosphonate ligands chelated to different radionuclides emitting moderate energy β particles have been extensively studied for their bone uptake characteristics. The affinity of the coordinated phosphonate ligands for calcium in activity growing bones is considered to be the factor responsible for their selective localization into metastatic lesions. Complexation of radiometals with diphosphonate ligands in aqueous medium produces multiple chelate entities which are not desirable from stability consideration and formulation.

Ethylene diamine tetramethylene phosphonate (EDTMP) is one of the most widely used ligands which forms stable complexes with various radionuclides and all the complexes showed high bone uptake in biodistribution studies (12-17).

EDTMP has a high affinity to skeleton and osteoblastic bone metastases and many EDTMP chelates possess a considerably high stability. This stimulated application of the ligand as the in-vivo carrier of various radionuclides, intended for both therapy and diagnosis of osteoblastic lesions.

The present study intends to produce $^{177}$Lu in Tehran Research Reactor (TRR) and to formulate EDTMP kits, labeling them with $^{177}$Lu, quality control and biodistribution of it in healthy mice.

**MATERIALS AND METHODS**

**Chemicals and radionuclides**

All chemicals were obtained from commercial sources and used without further purification. Enriched $^{176}$Lu$_2$O$_3$ (74.1%) was purchased of Campro Scientific Company. EDTMP (Ethylene diamine tetramethylene phosphonic acid) was purchased of Tokyo Kasei. Lutetium Oxide, Lu$_2$O$_3$ (1.25x10$^{-3}$ mmole, 0.5 mg) was dissolved in 10 ml 0.1 N HCl, by gentle warming. The resultant solution was evaporated near dryness and redissolved in 10 ml of 0.1 N HCl several times. The $^{176}$LuCl$_3$ was dispensed in quartz capsules and the solvent was evaporated, each capsule contains 10 µg of $^{176}$LuCl$_3$ and was flame sealed under vacuum and cold welded in aluminum can. $^{177}$LuCl$_3$ was produced by thermal neutron bombardment of it via a (n, γ) reaction in TRR at a flux of 2.6x10$^{13}$ n.Cm$^{-2}$.S$^{-1}$ for 14 days. Then the can was opened inside a lead shielded plant and the product was dissolved in 2 ml 1M HCl by gentle warming.

Ethylene diamine tetramethylene phosphonic acid (EDTMP) was dissolved in distilled water (10 mg/ml), after adjustment of the pH to 7.5-8.5, the mixture was dispensed to 10 ml sterile vials, lyophilized and finally sealed under nitrogen atmosphere. The kits containing 15mg of EDTMP was stored in dark at 2-8°C.

**Radionuclide purity, quality control and stability of radiolabeled EDTMP**

Radioactivity assay was carried out by measuring the activity in an ISMED 1010 Dose Calibrator (Nuklear-Medizintechnik Dresden GmbH, Dresden, Germany). Radionuclide purity was determined by recording γ-ray spectrum of the appropriately diluted solution of the irradiated target using a multi channel analyzer with high HPGe detector (Silena 2000). A $^{152}$Eu source (Amersham.Inc.) was used for both energy and efficiency calibration.

Radiochemical purity of $^{177}$LuCl$_3$ was determined by paper chromatography (Whatman 1mm, Normal saline, Rf $\approx 1$). The EDTMP freeze-dried kits were labeled with 50 mCi of $^{177}$LuCl$_3$, the final volume was 2 ml, after 30 minutes incubation at room temperature the labeling was completed. The labeling yield and stability of the radiopharmaceutical were assessed using paper chromatography (Whatman 1
Production of $^{177}$Lu and formulation of EDTMP kits

Biodistribution studies of $^{177}$LuCl$_3$

Biodistribution studies were done in the normal mice (20-25 g) 0.1 ml of $^{177}$LuCl$_3$ (100 µCi), pH = 5.5 administered to mice via the tail vein. The animals were killed by CO$_2$ 24, 48, 120, 144, 168 hours post-injection and blood, kidney, liver, spleen, bone, intestine, colon, muscle, lung were taken out. The radioactivity of the blood pool and samples of weighted tissues and the whole body was measured by a gamma counter. The percentage of the dose per gram of tissue was calculated (%ID/g).

Biodistribution studies of $^{177}$Lu-EDTMP

Biodistribution studies for $^{177}$Lu-EDTMP (pH= 7.5-8.5) was done the same as $^{177}$LuCl$_3$ and the results were calculated as a percentage of the dose per gram of tissue (%ID/g).

In-vitro stability studies

The stability of $^{177}$Lu-EDTMP complex which was diluted in human serum (5 µg/ml) was studied at pH= 7.5-8.5 at 37°C for a period of 72 hours after preparation. The radiochemical purity of the complex was assessed at 1, 3, 24, 48, 72 hours by employing paper chromatography using Whatman 1 mm and normal saline as the eluting solvent.

RESULTS

$^{177}$LuCl$_3$ production

The yield of $^{177}$Lu from enriched $^{176}$Lu$_2$O$_3$ after 14 days irradiation in Tehran Research Reactor ($2.6 \times 10^{15}$ n. Cm$^{-2}$.S$^{-1}$) was ~220 TBq/g (6000 Ci/g). The radionuclidic purity of $^{177}$Lu was ~99% as estimated by analyzing the γ-ray spectrum (figure 1), the major γ peaks observed were 113, 208, 250 and 321 keV, all of which correspond to the photopeaks of $^{177}$Lu. The radioactivity due to $^{177m}$Lu (414,418 keV) was insignificant. Table 1 shows the target-material composition, irradiation conditions, resulting specific activities, and radionuclide impurity.

Kit labeling

The kit was labeled with 50 mCi of $^{177}$LuCl$_3$ in 2 ml volume and pH=7.5-8.5. The labeling yield after 30 min was 98±0.5

Table 1. Characteristics of the $^{177}$Lu produced for formulation of EDTMP-based radiopharmaceuticals.

<table>
<thead>
<tr>
<th>Radionuclide</th>
<th>Target material</th>
<th>Irradiation conditions</th>
<th>Specific activity</th>
<th>Radionuclidic impurities</th>
</tr>
</thead>
<tbody>
<tr>
<td>$^{177}$Lu</td>
<td>Lu$_2$O$_3$, isotopic enrichment, % $^{176}$Lu(74.1%)</td>
<td>Flux $2.6 \times 10^{15}$ n. Cm$^{-2}$.S$^{-1}$ Duration 2 weeks</td>
<td>6000 Ci/g Lu</td>
<td>$^{177m}$Lu 0.2 %</td>
</tr>
</tbody>
</table>
The 177Lu-EDTMP preparations stored for 24 hrs showed radiochemical purity 95±1.2%. The stability of radiolabeled kit in human serum for 72 hours post labeling was acceptable (90±2.1%).

**Biodistribution studies of 177LuCl₃**

The biodistribution studies of 177LuCl₃ in normal mice are shown in figure 2. It demonstrates skeleton uptake and remaining the activity there and low soft-tissue concentration of 177LuCl₃.

**Biodistribution studies of 177Lu-EDTMP**

Figure 3 shows the biodistribution studies of the 177Lu-EDTMP in normal mice. It revealed skeleton uptake, remaining and low soft-tissue concentration of 177Lu-EDTMP.

**In-vitro stability studies**

177Lu-EDTMP exhibited *in vitro* stability (90±2.1%) at pH=7.5-8.5 when stored at 37°C for 72 hours post preparation. The complex was found to retain its radiochemical purity to the extent of 85±1.8% 72 hours after labeling (figure 4).

**DISCUSSION**

The 176LuCl₃ was irradiated at 2.6×10¹³ n.Cm⁻².S⁻¹ neutron flux for 7 and 14 days,

![Figure 2. Biodistribution of 177LuCl₃ in normal mice 24, 48, 120, 144, 168 hours post injection.](image)

![Figure 3. Biodistribution of 177Lu-EDTMP in healthy mice at 24, 48, 120, 144, 168 hours post injection.](image)
and irradiation for 14 days shows better specific activity. Deionized water was used for preparing freeze-dried kit and radio-labeling because of the competition of metal ions with $^{177}$Lu$^{3+}$ in chelating complexation and decreasing the yield of labeling.

For labeling the EDTMP kit different activities of $^{177}$LuCl$_3$ (10, 20, 40, 50, 100 mCi) were used, radiolabeling with 50 mCi showed the best radiolabeling yield and stability of all.

The bone uptake of $^{177}$Lu-EDTMP in mice was found to be high and selective as compared with other tissues. Moreover, $^{177}$Lu-EDTMP was retained in bone throughout the 7-day experimental period. The clearance of $^{177}$Lu-EDTMP from soft tissues was rapid compared with its physical half-life. $^{177}$Lu-EDTMP would bind to bone by bridging of $^{177}$Lu to hydroxyapatite by multidentate phosphate chelate system. EDTMP chelate has at least eight protonation sites and it binds readily with bi- and trivalent metal radioisotopes, such as $^{177}$Lu, $^{227}$Th, $^{154}$Sm, $^{186}$Re, which were thought to have potential for use in treatment of bone metastases. The femur to other tissue uptake ratios of $^{177}$Lu-EDTMP was high. The clearance of $^{177}$Lu-EDTMP from soft tissues was done by kidney. Our results using $^{177}$LuCl$_3$ also indicated that the %ID/g of $^{177}$Lu retained in the kidney, liver, spleen, and other tissues was low. The difference in biodistribution between $^{177}$Lu-EDTMP and $^{177}$LuCl$_3$ was due to differences in the bioavailability of these complexes. $^{177}$LuCl$_3$ would initially bind to bone according to the chemical absorption of Lu (III) to hydroxyapatite, while $^{177}$Lu-EDTMP would bind to bone by bridging of $^{177}$Lu to hydroxyapatite by the multidentate phosphate chelate system. Therefore, our comparative study of $^{177}$Lu-EDTMP and $^{177}$LuCl$_3$ demonstrated the efficacy of $^{177}$Lu-EDTMP for bone-affinity radiopharmaceuticals (18-20). All of characteristics were made $^{177}$Lu-EDTMP an ideal radiopharmaceutical for pain palliation in bone metastases.

**CONCLUSION**

$^{177}$Lu has got very good potential as a therapeutic radionuclide. The high thermal neutron cross-section of $^{176}$Lu (n, γ) $^{177}$Lu reaction facilitates large-scale production. The present study shows 6000Ci/g of $^{177}$Lu activity could be produced by thermal neutron bombardment at a flux of 2.6×10$^{13}$ n.Cm$^{-2}$.S$^{-1}$ for a period of 14 days using enriched $^{176}$Lu$_2$O$_3$ (74.1%). Our results showed that freeze-dried kit developed can be used for preparation of $^{177}$Lu-EDTMP reveals skeleton uptake and low soft-tissue concentration. Due to its suitable nuclear characteristics $^{177}$Lu appears to be worthwhile for palliative therapy of bone metastasis.
REFERENCES


