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The salt formulation of drug molecules is often a primary step in developing new pharmaceuticals. In order to aid medicinal chemists who may not be well versed in salt formulations, this work describes the preparation, significance, structures, and selection of pharmaceutically active salts. Chapters cover dissociation and ionic equilibria, solubility, and dissolution; basics and evaluation of solid state properties, safety and biopharmaceutical aspects; salt selection strategies, industrial large scale aspects of salt production, and the significance of salt formation in industrial processing; patent and regulatory issues; and model procedures. A final chapter provides an annotated compilation of the individual salt-forming acids and bases with their relevant properties.