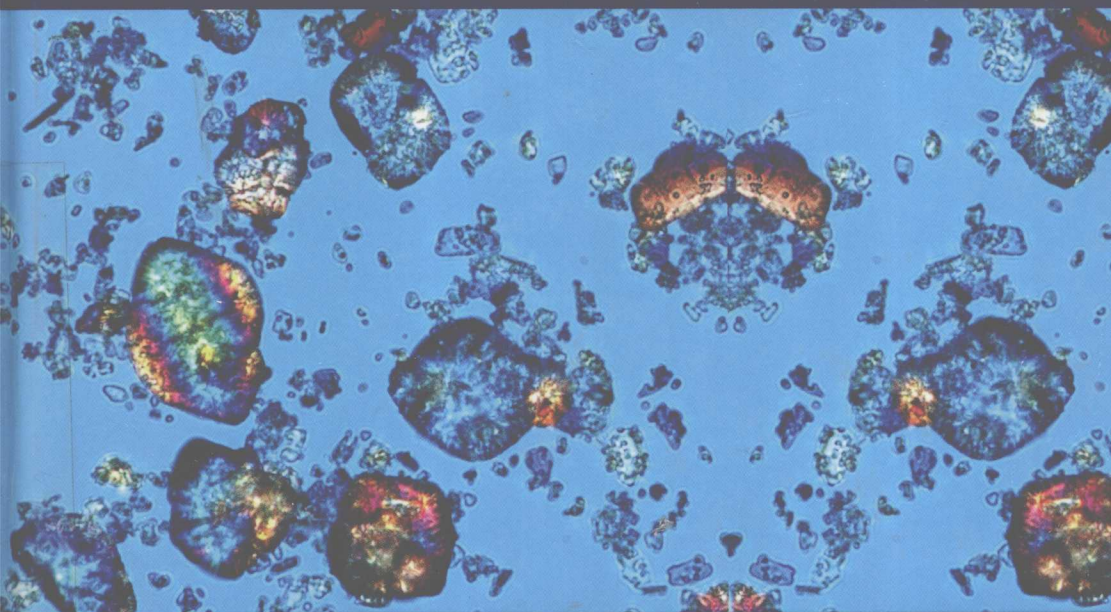


Formulation and Analytical Development for Low-Dose Oral Drug Products

Edited by *Jack Zheng*



FORMULATION AND ANALYTICAL DEVELOPMENT FOR LOW-DOSE ORAL DRUG PRODUCTS

Edited By

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沈阳药科大学图书馆



Y2005549

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Published by John Wiley & Sons, Inc., Hoboken, New Jersey
Published simultaneously in Canada

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Library of Congress Cataloging-in-Publication Data:

Formulation and analytical development for low-dose oral drug products /
[edited by] Jack Zheng.

p. : cm.

Includes bibliographical references and index.

ISBN 978-0-470-05609-7 (cloth)

1. Drugs—Dose-response relationship. 2. Drugs—Dosage. 3. Oral medication. 4. Drug development. I. Zheng, Jack.
[DNLM: 1. Chemistry, Pharmaceutical—methods. 2. Administration, Oral. 3. Drug Evaluation, Preclinical—methods. 4. Drug Industry. QV 744 F726 2008]

RM301.8.F67 2008

615'.1—dc22

2009009573

Printed in the United States of America

10 9 8 7 6 5 4 3 2 1

CNY 875. —

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Opportunities multiply as they are seized

—Sun Tsu

To my wonderful wife Lijuan and my talented children Karen and Allen for
their love, encouragement, and support

PREFACE

In November 2005, I co-chaired a symposium entitled “Analytical and Formulation Development Strategies, Challenges and Regulatory Considerations for Low-dose Drug Products” during the annual meeting of the American Association of Pharmaceutical Scientists. The goal of the symposium was to provide an overview on development of low-dose drug products from the perspective of pharmaceutical, analytical, and regulatory sciences, including formulation design, process development, analytical method development, and regulatory considerations. The presenters included Dr Norm Sesí from Eli Lilly and Company, Dr Ravi Harapanhalli from the U.S. Food and Drug Administration, Dr Mary am Ende from Pfizer Inc., and Dr Keith Hutchison from Capsugel, Division of Pfizer Inc. After the meeting, I was approached by John Wiley & Sons Inc. to discuss the publication of a book on analytical and formulation development of low-dose drug products. As a pharmaceutical scientist who has worked in product development for more than a decade, I know that product development scientists in the pharmaceutical industry and the graduate students in the pharmacy schools will benefit from a book that collects the existing knowledge, techniques, and strategies in development of low-dose drug products. After two years of diligent work, all contributors and the publisher, John Wiley & Sons Inc., have made the book available to our readers.

Formulation and Analytical Development for Low-Dose Oral Drug Products focuses on the key topics involved in the challenges and strategies in analytical, formulation, and regulatory perspectives for development of low-dose drug products. The book begins with eight chapters devoted to aspects of formulation and process

development of low-dose drug products, including theoretical consideration of particle size of drug substance, micronization and physical characterization of drug substance, control of excipients, and different manufacturing platform technologies. Chapter 2 provides an overview of challenges and strategies in formulation development of low-dose drug products. Chapters 4–7 are concerned with formulation and process development of low-dose drug products. Commonly used manufacturing platform technologies for low-dose drug products are discussed, such as high-shear wet granulation, fluid bed granulation, direct compression, and roller compaction. Chapters 3, 8, and 9 deal with drug substance, ranging from theoretical consideration of particle size according dose strengths, the methods for micronization of drug substance, and quality and functionality of pharmaceutical excipients.

Chapters 10–13 focus on challenges in analytical method development for low-dose drug products, including physical characterization of the micronized powder and the solid state of API in dosage forms. Analytical issues related to low-dose assay and impurities are discussed together with some specific case studies. Chapter 11 provides guidance on how to run appropriate dissolution testing so that meaningful data can be obtained. Chapter 14 provides a particularly interesting perspective on how pharmaceutical excipients should be controlled in the development of low-dose drug products and how an excipients library can help formulation scientists select appropriate excipients for better control of product quality. There is also a chapter specifically addressing practical concerns in the pharmaceutical industry with respect to cleaning verification of manufacturing equipment, illuminated by many examples.

The last section of the book is devoted to a few very important topics in development of low-dose drug products, including regulatory perspectives and containment technologies used in analytical laboratories and manufacturing plants. I hope that this combination of topics will enable the readers to obtain a broad overview on development of low-dose drug products.

I sincerely acknowledge the contributing authors of this book and thank them for their cooperation in the timely preparation of their specialized chapters, which allowed me to produce a book that reflects state-of-the-art thinking in analytical and formulation development of low-dose drug products. I would especially like to thank Drs Joe Zhou, Ralph Lipp, and Paul Collins for stepping in at the final hour and writing chapters on the fluid bed granulation technology and micronization of drug substance. Without these chapters, the book would have been incomplete. Also, I give my appreciation to Drs Gus Hartauer, Dave Maclaren, Ralph Lipp, Eugene Inman, Bret Huff, and Tom Verhoeven for their tremendous support and encouragement for my preparing this book. My sincerest thanks to Ms Karen Boleyn, a senior technical writer, for reviewing and making editorial corrections for several chapters in this book. Special thanks are expressed to Drs David Long, Tim Woznik, David Moeckly, Paul Sirois, James Wood, and Thirumala Kommuru for peer review of book chapters. Further, I would like to thank the editors at John Wiley and Sons Inc., in particular Jonathan Rose, for his accessibility and helpfulness

in all aspects of the book's production. Finally, I would like to thank my wife Lijuan (Susan) and my talented children, Karen (a Yale) and Allen, for their love, understanding, and support in the time I have spent editing this book. Now I will have more time for them upon the completion of this project.

JACK ZHENG, Ph.D.

Indianapolis, Indiana

FOREWORD

A few years ago, I sat in my office with Dr Jack Zheng as we discussed a technically challenging chemical stability issue we were having with a very-low-dose formulation of an early-phase clinical compound. There are unique challenges that a development team faces with low-dose compounds delivered orally; in effect, we agreed that it would be extremely useful to generate an internal guidance leveraging our collective in-house knowledge in this area. Jack not only acted on that idea, but has gone one better by recruiting a team of experienced scientists from multiple companies across the industry to author a book on this very topic.

At first glance, the thought of bringing forward a molecule with very low doses can have an appealing upside. One specific benefit is seen in reduced quantities of often very expensive active pharmaceutical ingredient (API) needed during the various stages of the development process, as well as impact on COPS. While this is definitely an advantage, this book clearly demonstrates that the hurdles present in developing a low-dose product can quickly offset that advantage. Time and expense can increase if the team does not robustly plan for and develop a formulation, manufacturing process, and analytical/API physical property control strategy to overcome those challenges. The most effective development plan in these cases arises from a multidisciplinary approach to bring to bear the best science and exploration of appropriate design space. This approach is reflected in the individual chapters of this book, where specific technical areas such as *in vitro* dissolution testing, physical transformation and containment techniques are discussed, but in the context of the ultimate goal of developing a commercial product.

The development of low-dose formulations is certainly not new to the pharmaceutical industry; one obvious example is the long-term clinical use of digoxin tablets. However, with the introduction of new technologies to identify molecular

targets and the use of high-throughput screening techniques to select structures with increased selectivity and activity toward a given target, the trend has been toward an ever-increasing amount of candidates dosed in the submilligram range. The increase in candidates meeting this definition of low-dose, along with the combination of increasing regulatory (e.g., impurity specifications) and technical requirements for such products, makes this book a valuable and timely contribution to pharmaceutical sciences.

Recent estimates have approached \$1.2 billion for the cost of development of a new chemical entity into a commercial drug product (i.e., medicine). This book is a systematic, technical collection on this relevant topic than can help lead to a more effective and efficient drug development process. I consider it to be a welcome addition to the library of all drug product developers involved in bringing new therapies to patients.

KERRY “GUS” HARTAUER, PH.D.

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CONTENTS

PREFACE	xv
FOREWORD	xix
CONTRIBUTORS	xxi
1 AN OVERVIEW	1
<i>Jack Y. Zheng</i>	
1.1 The Drug Discovery and Development Process	2
1.2 Challenges and Strategies in Development of Low-Dose Drug Products	10
1.3 Summary	20
Acknowledgments	20
References	20
I CHALLENGES AND STRATEGIES IN FORMULATION DEVELOPMENT OF ORAL LOW-DOSE DRUG PRODUCTS	23
2 CHALLENGES AND STRATEGIES IN FORMULATION DEVELOPMENT OF ORAL SOLID LOW-DOSE DRUG PRODUCTS	25
<i>Jack Y. Zheng</i>	
2.1 Introduction	25
2.2 Current Regulatory Environment and its Impact on New Drug Product Development	28
2.3 Challenges in Developing Low-Dose Formulations	31

2.4	Manufacturing Platforms for Low-Dose Drug Products	38
2.5	Use of Experimental Design in Formulation and Process Development	42
2.6	Containments	44
2.7	Summary	45
	Acknowledgments	46
	References	46
3	PARTICLE SIZE OF DRUG SUBSTANCE AND PRODUCT CONTENT UNIFORMITY—THEORETICAL CONSIDERATIONS	49
	<i>Kevin C. Johnson</i>	
3.1	Introduction	49
3.2	Concept of Ideal Mixing	50
3.3	Ideal Mixing Model Comparison with the Yalkowsky and Bolton Approach	56
3.4	Experimental Support of Model Assumptions	59
3.5	Analytical and Practical Considerations	61
	References	62
4	DEVELOPMENT OF LOW-DOSE FORMULATIONS USING FLUIDIZED BED GRANULATION	63
	<i>J. Joe Zhou and Ralph Lipp</i>	
4.1	Introduction	63
4.2	Granulation Fundamentals	66
4.3	Theory of Fluidization	68
4.4	Formulation Development	72
4.5	Process Development	77
4.6	Summary	86
	References	86
5	DEVELOPMENT OF LOW-DOSE SOLID ORAL FORMULATIONS USING WET GRANULATION	89
	<i>Ahmad Almaya</i>	
5.1	Introduction	89
5.2	Granulation Mechanisms	91
5.3	General Considerations on Wet Granulation	93
5.4	Advantages and Disadvantages of Wet Granulation	100
5.5	Use of Wet Granulation for Low-Dose Formulations	101
5.6	Process-Induced Form Changes in Wet Granulation	109
5.7	Concluding Remarks	111
	References	112

6	CHALLENGES IN DEVELOPMENT AND SCALE-UP OF LOW-DOSE DRUG PRODUCTS BY DRY GRANULATION: A CASE STUDY	117
	<i>Mary T. Am Ende, Daniel O. Blackwood, Daniel S. Gierer, and Christopher P. Neu</i>	
6.1	Introduction	117
6.2	Dry Granulation Process—Pros and Cons	118
6.3	Overview of Dry Granulation Processes and Equipment Design	119
6.4	Challenges for Low-Dose Product Development and their Assessment Methods	125
6.5	Case Study: Formulation Challenges for Low-Dose Products	128
6.6	Process Challenges During Dry Granulation Optimization for Low-Dose Products	140
6.7	Conclusions	154
	Acknowledgments	155
	References	155
7	DEVELOPMENT OF LOW-DOSE SOLID ORAL TABLETS USING DIRECT COMPRESSION	159
	<i>Jack Y. Zheng and Robert L. Ternik</i>	
7.1	Introduction	159
7.2	Advantages of Direct Compression	160
7.3	Challenges in Low-Dose Tablet Development Using Direct Compression	162
7.4	Formulation Development for Low-Dose Drug Products Using Direct Compression	169
7.5	Manufacturing Process Development for Low-Dose Drug Products	187
7.6	Scale-Up for Blending Operation	196
7.7	Formulation Examples for Direct Compression	197
7.8	Conclusions	199
	Acknowledgments	199
	References	200
8	REDUCTION OF PARTICLE SIZE OF DRUG SUBSTANCE FOR LOW-DOSE DRUG PRODUCTS	205
	<i>Christopher L. Burcham, Paul C. Collins, Daniel J. Jarmer, and Kevin D. Seibert</i>	
8.1	Introduction	205
8.2	Reduction of Particle Size of Drug Substance by Milling Technologies	207
8.3	Reduction of Particle Size of Drug Substance Using Crystallization Technologies	216
8.4	Scale-Up Considerations	218