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(54) Titre : LIBERATION REGULIERE DE MEDICAMENTS COMBINES DE GUAIFENESIN
(54) Title: SUSTAINED RELEASE OF GUAIFENESIN COMBINATION DRUGS

(57) **Abrégé/Abstract:**

The invention relates to a novel pharmaceutical modified release formulation of guaifenesin and optionally a second drug which is preferably selected from dextromethorphan and pseudoephedrine. The formulation may comprise a hydrophilic polymer, preferably a hydroxypropyl methylcellulose, and a water-insoluble polymer, preferably an acrylic resin, in a ratio range of about one-to-one (1:1) to about nine-to-one (9:1), more preferably a range of about three-to-two (3:2) to about six-to-one (6:1), and most preferably in a range of about two-to-one (2:1) to about four-to-one (4:1) by weight. This formulation capable of providing therapeutically effective bioavailability of guaifenesin for at least twelve hours after dosing in a human subject. The invention also relates to a modified release product which has two portions: a first portion having an immediate release formulation of guaifenesin and a second portion having a sustained release formulation of guaifenesin, wherein one or both portions further comprises dextromethorphan. The modified release product has a maximum guaifenesin serum concentration equivalent to that of an immediate release guaifenesin tablet, and is capable of providing therapeutically effective bioavailability of guaifenesin for at least twelve hours after dosing in a human subject.

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(54) Title: SUSTAINED RELEASE OF GUAIFENESIN COMBINATION DRUGS

(57) Abstract: The invention relates to a novel pharmaceutical modified release formulation of guaifenesin and optionally a second drug which is preferably selected from dextromethorphan and pseudoephedrine. The formulation may comprise a hydrophilic polymer, preferably a hydroxypropyl methylcellulose, and a waterinsoluble polymer, preferably an acrylic resin, in a ratio range of about one-to-one (1:1) to about nine-to-one (9:1), more preferably a range of about three-to-two (3:2) to about six-to-one (6:1), and most preferably in a range of about two-to-one (2:1) to about four-to-one (4:1) by weight. This formulation capable of providing therapeutically effective bioavailability of guaifenesin for at least twelve hours after dosing in a human subject. The invention also relates to a modified release product which has two portions: a first portion having an immediate release formulation of guaifenesin and a second portion having a sustained release formulation of guaifenesin, wherein one or both portions further comprises dextromethorphan. The modified release product has a maximum guaifenesin serum concentration equivalent to that of an immediate release guaifenesin tablet, and is capable of providing therapeutically effective bioavailability of guaifenesin for at least twelve hours after dosing in a human subject.

SUSTAINED RELEASE OF GUAIFENESIN COMBINATION DRUGS**Cross-Reference to Related Applications**

[001] This application is a continuation-in-part of United States patent application number U.S. 2004/0018233 which was filed on April 4, 2003 and United States patent application number U.S. 2004/0022851 which was filed on April 4, 2003 both of which are a continuation-in-part of United States patent no. 6,955,821 which is a continuation-in-part of United States patent no. 6,372,252 which was filed on April 28, 2000 and issued on April 16, 2002.

BACKGROUND OF THE INVENTION

[002] The invention is directed to a modified release formulation for oral administration comprising combinations of guaifenesin and optionally at least one additional drug and methods of manufacture thereof. In particular, the invention is directed to a sustained release formulation which maintains a therapeutically effective blood concentration of guaifenesin and optionally the additional drug for a duration of about twelve hours. The invention further relates to combinations which demonstrate a maximum serum concentration equivalent to an immediate release tablet, while maintaining therapeutically effective blood concentration for about twelve hours.

[003] Sustained release pharmaceutical formulations provide a significant advantage over immediate release formulations to both clinicians and their patients. Sustained release dosage forms provide for fewer daily dose administrations than their immediate release counterparts. For example, a standard dosage regimen for a 400 mg immediate release drug with a short half-life, such as guaifenesin, requires administration three times within twelve hours to maintain adequate bioavailability to achieve the desired therapeutic effect. This results in a series of three serum concentration profiles in the patient showing a rapid increase of drug followed by a similar rapid decrease. As a result, patients are provided with only a short window of the appropriate blood

concentration of the medicament for optimum therapy. A 1200 mg sustained release dosage form, on the other hand, may require administration once every twelve hours to achieve therapeutic effect. Sustained release dosage forms generally control the rate of drug absorption, to avoid excessive drug absorption while maintaining effective blood concentration of the drug to provide a patient with a consistent therapeutic effect over an extended duration of time.

[004] Besides reducing the frequency of dosing and providing a more consistent therapeutic effect, sustained release dosage forms generally help reduce side effects caused by a drug. Because sustained release dosage forms deliver the drug in slow, incremental amounts versus the cyclic high and low concentrations of immediate release formulations, it is easier for a patient's body to digest the drug, thereby avoiding undesirable side-effects. For patients who self-administer therapies, sustained release dosage forms generally result in greater compliance due to the lower frequency of dosing, lower quantity of dosage units to be consumed, and reduced undesired side-effects.

[005] Generally, sustained release formulations contain drug particles mixed with or covered by a polymer material, or blend of materials, which is resistant to degradation or disintegration in the stomach and/or in the intestine for a selected period of time. Release of the drug may occur by leeching, erosion, rupture, diffusion or similar actions depending upon the nature of the polymer material or polymer blend used.

[006] Conventionally, pharmaceutical manufacturers have used hydrophilic hydrocolloid gelling polymers such as hydroxypropyl methylcellulose (hydroxypropyl methylcellulose is also known as hypromellose and is used interchangeably throughout the application), hydroxypropyl cellulose, or Pullulan to formulate sustained release tablets or capsules. These polymers first form a gel when exposed to an aqueous environment of low pH thereby slowly diffusing the active medicament that is contained within the polymer matrix. When the gel enters a higher pH environment such as that found in the intestines, however, it dissolves resulting in a less controlled drug release. To provide better sustained release properties in higher pH environments, some

pharmaceutical manufacturers use polymers which dissolve only at higher pHs, such as acrylic resins, acrylic latex dispersions, cellulose acetate phthalate, and hydroxypropyl methylcellulose phthalate, either alone or in combination with hydrophilic polymers.

[007] Generally, these formulations are prepared by combining the medicament with a finely divided powder of the hydrophilic polymer, or the hydrophilic and water-insoluble polymers. These ingredients are mixed and granulated with water or an organic solvent and the granulation is dried. The dry granulation is then usually further blended with various pharmaceutical additives and compressed into tablets.

[008] Although these types of formulations have been successfully used to manufacture dosage forms that demonstrate sustained release properties, these formulations generally do not have the desired release profile or serum concentration of medicament over an extended period of time. These sustained release formulations generally result in a delay in the appearance of drug in the blood stream, thereby delaying therapeutic effect. Additionally, when the drug does appear, its maximum serum concentration ($C_{\max}$) is lower than the maximum concentration required for the most effective therapeutic result. Furthermore, most formulations that claim twelve hour potency release almost all of their drug within six to eight hours, making the formulation less therapeutically effective towards the end of the twelve hour period. To prevent blood serum concentrations of drug from falling below a therapeutically effective level ($C_{\min}$) at extended time periods, many manufacturers increase the drug strength of the dosage form. The increase in drug strength, however, results in a concomitant increase in side-effects.

[009] Other pharmaceutical manufacturers have made tablets and capsules containing a combination of an immediate release formulation and a sustained release formulation to improve the release profile of certain sustained release dosage forms. Although this solution improves the $C_{\max}$ and length of time before the drug appears in the blood stream in some formulations, the extended therapeutic effect is not improved.

[010] Furthermore, medicaments have different solubility properties and pH dependencies, which affect dissolution rate and bioavailability. Bioavailability can also be affected by a number of factors such as the amounts and types of adjuvants used, the granulation process, compression forces (in tablet manufacturing), surface area available for dissolution and environmental factors such as agitation in the stomach and the presence or absence of food. Due to these numerous factors, specific formulations play an important role in the preparation of prolonged action solid dosage forms, particularly in the preparation of solid dosage forms that achieve appropriate bioavailability for optimum therapeutic effect.

[011] Guaifenesin, 3-(2-methoxyphenoxy)-1,2-propanediol, is an expectorant that increases respiratory tract fluid secretions and helps to loosen phlegm. By reducing the viscosity of secretions, guaifenesin increases the efficiency of a cough reflex and of ciliary action in removing accumulated secretions from trachea and bronchi. Guaifenesin is readily absorbed from the intestinal tract and is rapidly metabolized and excreted in urine. Guaifenesin has a typical plasma half-life of approximately one hour. The rapid metabolism and excretion of guaifenesin provides only a short window of therapeutic effectiveness when immediate release dosage is used.

[012] Pseudoephedrine hydrochloride is an orally active sympathomimetic amine and exerts a decongestant action on the nasal mucosa. Pseudoephedrine produces peripheral effects similar to those of ephedrine and central effects similar to, but less intense than, amphetamines. It has the potential for excitatory effects. At the recommended oral dose, it has little or no pressor effect in normotensive adults. Pseudoephedrine has been shown to have a mean elimination half-life of 4-6 hours.

[013] Dextromethorphan acts centrally to elevate the threshold for coughing. It has no analgesic or addictive properties. The major circulating metabolite is dextrorphan.

[014] The need exists for a sustained release dosage form of guaifenesin alone and in combinations, which are capable of sustaining therapeutic effective for

extended periods of time. Further the need exists for sustained release dosage forms of guaifenesin alone and in combination which results in a $C_{\max}$ equivalent to that of an immediate release formulation, appears in the blood stream as quickly as an immediate release formulation, and sustains the therapeutic effect.

[015] SUMMARY OF THE INVENTION

The invention relates to strategies and designs in formulations of modified release guaifenesin and guaifenesin combination dosage forms. This invention provides sustained release pharmaceutical formulation comprising guaifenesin and at least one additional drug. The sustained release formulation (SR) may comprise a combination of at least one hydrophilic polymer and at least one water-insoluble polymer. The total weight ratio of hydrophilic polymer to water-insoluble polymer may be in a range of about one-to-one (1:1) to about nine-to-one (9:1), more preferably in a range of about three-to-two (3:2) to about six-to-one (6:1), and most preferably in a range of about two-to-one (2:1) to about four-to-one (4:1). When a tablet comprising the sustained release formulation is exposed to an aqueous medium of low pH, such as that found in the stomach, the polymer combination gels causing guaifenesin and the drug(s) to diffuse from the gel. When the tablet passes to the intestines where an aqueous medium of higher pH is present, the gel begins to dissolve, thereby releasing guaifenesin and/or the drug(s) in controlled amounts. The tablet is capable of releasing therapeutically effective amounts of guaifenesin over an extended period, *e.g.* twelve or more hours and at least one additional drug immediately, over an extended period, or both.

[016] This invention also encompasses a modified release composition which comprises two portions (*e.g.* a bi-layer tablet, or capsule), an immediate release formulation (IR) and a sustained release formulation (SR). Each formulation comprises a specific quantity of guaifenesin and may optionally contain at least one additional drug. The immediate release formulation is formulated to dissolve in aqueous acidic medium, such as that found in the stomach, to quickly release guaifenesin contained within the portion, and optionally quickly release the at least one additional drug. The sustained release portion may comprise a

combination of hydrophilic polymer and a water-insoluble polymer in a ratio range of about one-to-one (1:1) to about nine-to-one (9:1), more preferably a range of about three-to-two (3:2) to about six-to-one (6:1), and most preferably from about two-to-one (2:1) to about four-to-one (4:1). Likewise, the sustained release portion may also contain the additional drug(s).

[017] The invention also relates to sustained release preparations of the type described above in the form of capsules having beads or granules of both immediate release formulation and beads or granules of sustained release formulation. The beads may comprise a mixture of discrete beads each having only one of the SR or IR formulations or may comprise beads containing both SR and IR formulations associated in a single bead, or combinations of the foregoing. Alternatively, the sustained release formulation may comprise a core that is coated by a layer of the immediate release formulation to form a single tablet. For purpose of illustration only, the invention will be described in detail in the context of the bi-layered tablet embodiment. It should be understood that for either the immediate release and/or the sustained release portion the guaifenesin and optionally the additional drug may be mixed within the same matrix portion or comprise separate release portions which are then either compressed or mixed for capsules (*e.g.* comprise separate beads or granules) etc.

[018] A bi-layer tablet demonstrates a maximum serum concentration ($C_{\max}$) and time of availability in the blood stream that are equivalent to an immediate release tablet. The bi-layer tablet also provides sustained release of guaifenesin over about a twelve hour period from one dose. The bi-layer tablet further maintains serum concentration levels of guaifenesin at a therapeutically effective level for about a twelve hour period without an increase in dosage strength. As the bi-layer tablet may also contain at least one additional drug, the additional drug can be formulated within the sustained release formulation, immediate release formulation, or both. In one embodiment, the bi-layer tablet maintains serum concentration levels of at least one additional drug at a therapeutically effective level for about a twelve hour period without an increase in dosage strength.

[019] In another embodiment, the tablets and capsules of the invention provide a C_{min} which is above the necessary therapeutically effective level for a period of 10 hours, more preferably 12 or more hours. In a more preferred embodiment, a tablet or capsule of the invention provides the above describe C_{min} characteristics and provides the necessary C_{max} to mimic an immediate release product to obtain symptom relief. In a more preferred embodiment, the delivery system provides the above describe C_{min} characteristics and provides the necessary C_{max} to mimic an immediate release product to obtain symptom relief within a substantially similar T_{max} period to an immediate release profile.

[020] In another embodiment of the invention, the delivery system provides a C_{max} which does not result in an equivalent C_{max} of an immediate release product but does provide a C_{max} which is therapeutically effect to relieve systems while reducing the likelihood of side effects due to an increased C_{max} .

[021] The invention also relates to methods of manufacturing sustained release formulations and bi-layer tablets. An example of a manufacturing method for a sustained release formulation comprises mixing a hydrophilic polymer and active ingredients in a mixer, adding water to the mixture and continuing to mix and chop, drying the mixture to obtain hydrophilic polymer encapsulated granules, milling and screening the resulting granulation, and blending it with various pharmaceutical additives, additional hydrophilic polymer, and water insoluble polymer. The formulation may then be tableted and may further be film coated with a protective coating which rapidly dissolves or disperses in gastric juices.

[022] An example of a bi-layer tablet manufacturing method comprises blending a quantity of guaifenesin and optionally, at least one drug with various excipients, colorants, and/or other pharmaceutical additives to form an immediate release formulation, separately blending another quantity of guaifenesin and optionally at least one drug with a hydrophilic polymer, a water-insoluble polymer, and various excipients, colorants, and/or other pharmaceutical additives to form a sustained release formulation, and compressing a quantity of the immediate release formulation with a quantity of the sustained release formulation to form a

bi-layer tablet. The tablet may then optionally be coated with a protective coating which rapidly dissolves or disperses in gastric juices.

[023] Other objects, advantages and embodiments of the invention are described below and will be obvious from this description and practice of the invention.

BRIEF DESCRIPTION OF THE DRAWINGS

[024] Figure 1 is a flow diagram depicting steps in a wet granulation method for manufacturing the sustained release formulation.

[025] Figure 2 is a flow diagram depicting steps in a dry granulation method for manufacturing the sustained release formulation.

[026] Figure 3 is a flow diagram depicting steps in a method for manufacturing the bi-layer tablet.

[027] Figure 4 is a graph demonstrating the dissolution profiles of tablets comprising two different sustained release formulations.

[028] Figure 5 is a graph demonstrating the dissolution profiles of a commercially available immediate release dosage form and two sustained release dosage forms of guaifenesin.

[029] Figure 6 is a graph demonstrating the plasma concentration of guaifenesin over time in healthy human volunteers who were dosed with three different guaifenesin formulations; a commercial immediate release formulation, and two different sustained release formulations (Lot 7B-32 and Lot 7B-31).

[030] Figure 7 is a graph demonstrating the plasma concentration of guaifenesin over time in healthy human volunteers from a commercially available immediate release tablet, a non-layered modified release tablet of the invention, and two bi-layered modified release tablets of the invention (one comprising 600 mg of immediate release formulation and 600 mg of sustained release formulation and the other one comprising 400 mg of immediate release formulation and 800 mg of sustained release formulation).

[031] Figure 8 is a graph demonstrating the dissolution profiles of four sustained release tablets: one tablet is non-layered, comprising 1200 mg of sustained release formulation; another tablet is bi-layered, comprising 600 mg of sustained release formulation and 600 mg of immediate release formulation; another tablet

is bi-layered, comprising 800 mg of sustained release formulation and 400 mg of immediate release formulation; and yet another tablet is bi-layered comprising 1000 mg of sustained release formulation and 200 mg of immediate release formulation.

[032] Figure 9 is a graph demonstrating the plasma concentration of guaifenesin over an averaged 12 hour interval (taken from 11 twelve hour intervals over 5.5 days) in healthy human volunteers from an immediate release tablet and a bi-layered modified release tablet of the invention.

[033] Figure 10 is a graph demonstrating the plasma concentration of guaifenesin over time (the last twelve hour interval of the 11 twelve hour intervals described above) in healthy human volunteers from an immediate release tablet and a bi-layered modified release tablet of the invention.

[034] Figure 11 is a graph demonstrating the averaged plasma concentration of guaifenesin over a 16 hour period in 27 healthy human volunteers from 600 mg bi-layered modified release tablets of the invention administered to fasting volunteers, 1200 mg bi-layered modified release tablets of the invention administered to fasting volunteers, and 1200 mg bi-layered modified release tablets of the invention administered to volunteers who had been fed a high fat meal.

[035] Figure 12 is a graph demonstrating the dissolution profile of dextromethorphan HBr as measured by three different batches of a 1200 mg guaifenesin - 60 mg dextromethorphan tablet over a 12 hour period as measured by the weight percentage of dextromethorphan HBr dissolved over time.

[036] Figure 13 is a graph demonstrating the plasma concentration of guaifenesin following the administration of 1200 mg guaifenesin and 60 mg dextromethorphan HBr to volunteers separately and in formulations of the invention.

[037] Figure 14 is a graph demonstrating the plasma concentrations of dextromethorphan HBr following the administration of 1200 mg guaifenesin and 60 mg dextromethorphan HBr to volunteers in three different formulations.

- [038] Figure 15 is a graph demonstrating the plasma concentrations of the metabolite dextrorphan following the administration of 1200 mg guaifenesin and 60 mg dextromethorphan HBr to volunteers in three different formulations.
- [039] Figure 16 is a graph demonstrating the dissolution profile of pseudoephedrine HCl in three different batches of a 1200 mg guaifenesin - 120 mg pseudoephedrine HCl tablet formulation over a 12 hour period as measured by the percent pseudoephedrine HCl dissolved over time.
- [040] Figure 17 is a graph demonstrating the plasma concentration of guaifenesin following the administration of 1200 mg guaifenesin and 120 mg pseudoephedrine HCl to volunteers separately and in formulations of the invention.
- [041] Figure 18 is a graph demonstrating the plasma concentration of pseudoephedrine HCl following the administration of 1200 mg guaifenesin and 120 mg pseudoephedrine HCl to volunteers in three different formulations.
- [042] Figure 19 is a graph demonstrating the plasma concentration of three different 1200 mg guaifenesin dosages in groups A, B, and C of example 12.
- [043] Figure 20 is a graph demonstrating the plasma concentration of three different 120 mg pseudoephedrine dosages in groups A, B, and C of example 12.
- [044] Figure 21 is a graph demonstrating the plasma concentration of three different 1200 mg guaifenesin dosages for treatments A, B, and C of example 13.
- [045] Figure 20 is a graph demonstrating the plasma concentration of three different 120 mg pseudoephedrine dosages for treatments A, B, and C of example 13.
- [046] Figure 21 depicts guaifenesin concentrations of various formulations and dosage strength.
- [047] Figure 22 depicts pseudoephedrine plasma concentrations following administration of two different dose strengths of pseudoephedrine, as well as, different formulations.

- [048] Figure 23 depicts guaifenesin concentrations following administration of 1200 mg of guaifenesin with 120 mg pseudoephedrine hydrochloride in two different formulations following a high-fat meal.
- [049] Figure 24 depicts pseudoephedrine concentrations following administration of 1200 mg of guaifenesin with 120 mg pseudoephedrine hydrochloride in two different formulations following a high-fat meal.
- [050] Figure 25 depicts steady-state guaifenesin plasma concentrations following administration of 11 doses of 120 mg pseudoephedrine with 1200 mg of guaifenesin in two different formulations.
- [051] Figure 26 depicts steady-state pseudoephedrine plasma concentrations following administration of 11 doses of 120 mg pseudoephedrine with 1200 mg of guaifenesin in two different formulations.
- [052] Figure 27 depicts guaifenesin plasma concentrations following administration of 1200 mg of guaifenesin with and without the co-administration of 120 mg of pseudoephedrine.
- [053] Figure 28 depicts pseudoephedrine plasma concentrations following administration of 120 mg of pseudoephedrine with and without the co-administration of 1200 mg of guaifenesin.
- [054] Figure 29 depicts guaifenesin plasma concentrations following administration of an experimental 1200 mg guaifenesin-120 mg pseudoephedrine formulation to volunteers under fed and fasted conditions.
- [055] Figure 30 depicts pseudoephedrine plasma concentrations following administration of an experimental 1200 mg guaifenesin-120 mg pseudoephedrine formulation to volunteers under fed and fasted conditions.
- [056] Figure 31 depicts guaifenesin dissolution profiles for various batches associated with the studies.
- [057] Figure 32 depicts pseudoephedrine dissolution profiles for various batches associated with the studies.
- [058] Figure 33 depicts guaifenesin plasma concentrations following the administration of 1200 mg guaifenesin with or without the co-administration of 60 mg dextromethorphan hydrobromide.

- [059] Figure 34 depicts mean dextromethorphan plasma concentrations following the administration of dextromethorphan hydrobromide in different formulations, doses and dosing regimens.
- [060] Figure 35 depicts plasma guaifenesin concentrations following the administration of 1200 mg guaifenesin along with 60 dextromethorphan hydrobromide in three different formulations.
- [061] Figure 36 depicts dextromethorphan plasma concentrations following the administration of 60 mg dextromethorphan hydrobromide at three different rates.
- [062] Figure 37 depicts plasma guaifenesin concentrations following the administration of 1200 mg guaifenesin and 60 mg dextromethorphan in an experimental formulation under fed and fasted conditions.
- [063] Figure 38 depicts plasma dextromethorphan concentrations following the administration of 60 mg dextromethorphan hydrobromide and 1200 mg guaifenesin in the fed and fasted conditions.
- [064] Figure 39 depicts steady-state plasma concentrations of guaifenesin following the multiple dose administration of 1200 mg guaifenesin in different formulations.
- [065] Figure 40 depicts mean steady-state guaifenesin plasma concentration-time profiles.
- [066] Figure 41 depicts steady-state plasma concentrations of dextromethorphan following the multiple dose administration of 60 mg dextromethorphan hydrobromide in different formulations and/or different dosage rates.
- [067] Figure 42 depicts dextromethorphan plasma concentrations following the administration of 60 mg dextromethorphan hydrobromide in different formulations and dosage rate.
- [068] Figure 43 depicts a process flow diagram for the manufacture of guaifenesin DC (95%).
- [069] Figure 44 depicts a process flow diagram for a guaifenesin/pseudoephedrine product (1200/120 mg) tablets.
- [070] Figure 45 depicts a process flow diagram for guaifenesin/pseudoephedrine product (600/60 mg) tablets.

DETAILED DESCRIPTION OF THE INVENTION

[071] The invention relates to sustained release formulations of guaifenesin. In a preferred embodiment, the formulations also comprise at least one additional drug in immediate release form, sustained release form, or both. Each formulation comprises a specific quantity of guaifenesin and may optionally contain at least one additional drug. The immediate release formulation is formulated to dissolve in aqueous acidic medium, such as that found in the stomach, to provide rapid release of the guaifenesin and optionally the at least one additional drug. In a preferred embodiment, the sustained release formulation comprises a combination of a hydrophilic polymer and a water-insoluble polymer in a ratio range of about one-to-one (1:1) to about nine-to-one (9:1), more preferably a range of about three-to-two (3:2) to about six-to-one (6:1), and most preferably in a range of about two-to-one (2:1) to about four-to-one (4:1).

[072] In a preferred embodiment the hydrophilic polymers are selected from acacia, gum tragacanth, locust bean gum, guar gum, or karaya gum, methylcellulose, hydroxymethylcellulose, hydroxypropyl methylcellulose, hydroxypropyl cellulose, hydroxyethylcellulose, carboxymethylcellulose, agar, pectin, carrageen, alginates, carboxypolymethylene, gelatin, casein, zein, bentonite, magnesium aluminum silicate, polysaccharides, and modified starch derivatives. In a more preferred embodiment the hydrophilic polymers are selected from cellulose ethers. In a most preferred embodiment the hydrophilic polymers are selected from hydroxypropyl methylcelluloses such as Methocel (E10M). Preferred total amounts of the hydrophilic polymer include more than 0.5% and less than 10% by weight for a 1200 mg tablet. More preferably hydrophilic polymer amounts includes more than 1.0% and less than 7.0%, more than 2% and less than 6.0%. These amounts include the hydrophilic polymer in the Guaifenesin DC described below. The hydrophilic polymer added separately to form the release-delaying matrix is preferably from about 0.5% to 4.0% and more preferably from about 1.0% to 2.0%. It should be recognized that these

amounts may be proportionally present in a 600 mg tablet or any desired formulation strength.

[073] In a preferred embodiment the water-insoluble polymers are selected from polyacrylic acids, acrylic resins, acrylic latex dispersions, cellulose acetate phthalate, polyvinyl acetate phthalate, hydroxypropyl methylcellulose phthalate. In a more preferred embodiment the water-insoluble polymers are selected from acrylic resins. In a most preferred embodiment the water-insoluble polymers are selected from Carbomer™ acrylic resins such as Carbomer™ 934P. Preferred amounts of the water-insoluble polymer include more than about 0.5% and less than about 2.5% by weight for a 1200 mg tablet. More preferably hydrophilic polymer amounts includes more than about .75% and less than about 1.5%, and most preferably more than about .9% and less than 1.25%. It should be recognized that these amounts may be proportionally present in a 600 mg tablet or any desired formulation strength.

[074] The invention also relates to sustained release preparations of the type described above in the form of bi-layered tablets or capsules having a combination of beads or granules of immediate release formulation and beads or granules of sustained release formulation. Alternatively, the sustained release formulation may comprise a core that is coated by a layer of immediate release formulation to form a single tablet. For purpose of illustration only, the invention will be described in detail in the context of the bi-layered tablet embodiment. When the embodiment is a bi-layered tablet, the tablet is made of two portions: one portion comprising a sustained release formulation and a second portion comprising an immediate release formulation. In a preferred embodiment, the at least one additional drug can be present within the sustained release formulation, the immediate release formulation, or both depending upon the desired effect.

[075] For instance, a preferred embodiment of the present invention has the following ingredients and proportions in the sustained release layer (mg/tablet): 1052.6 mg Guaifenesin DC (95%) [1000.0 mg of Guaifenesin, USP and 52.6 mg of hydroxypropyl methylcellulose, USP]; 120.0 mg Pseudoephedrine HCL,

USP; 30.0 mg hydroxypropyl methylcellulose, USP [Methocel™ E10M, USP]; 15.0 mg Carbomer™ 934P, NF [Carbopol™ 974P]; 0.4 mg FD&C Red #40 Aluminum Lake (14-16%); and 10.0 mg magnesium stearate, NF for a total sustained release weight of 1228.0 mg. In a preferred embodiment the immediate release layer has the following proportions: 210.5 mg Guaifenesin DC (95%) [200.0 mg of guaifenesin, USP and 10.5 mg of hydroxypropyl methylcellulose, USP]; 117.5 mg of microcrystalline cellulose, NF [Avicel™ PH102]; 30.0 mg of sodium starch glycolate, NF [EXPLOTAB™]; and 1.0 mg magnesium stearate, NF for a total immediate release weight of 359.0 mg.

[076] In another preferred embodiment a 1200 mg Guaifenesin/120 mg Pseudoephedrine Tablet has the following ingredients and proportions:

Component	Amount (mg/tablet)	Representative Batch (kg) ¹ IR Layer	Representative Batch (kg) ¹ SR Layer
Guaifenesin DC (95%) ²	1263.1	280.00	947.376
Hydroxypropyl methylcellulose (Methocel™)	30.0	N/A	27.000
Pseudoephedrine hydrochloride	120.0	N/A	108.0
Microcrystalline cellulose	117.50	156.28	N/A
Sodium starch glycolate	30.0	39.90	N/A
Carbomer™ 934P	15.0	N/A	13.500
Magnesium stearate	11.0	1.33	9.000
FD&C Red #40 Aluminum Lake (14-16%)	0.4	N/A	0.360
Water, purified	N/A ³	N/A ³	N/A ³
Total Weight	1587.0	477.51	1105.236

¹ Based on batch size of 900,000 tablets

² Guaifenesin direct compression used in the manufacturing process consists of 95% Guaifenesin, USP, 5% hydroxypropyl methylcellulose, USP (Methocel™ E10M) granulated with Purified water, USP (49.21 Kg).

³ Water is removed during processing of Guaifenesin DC 95%.

Agent's File Reference: 62808.000021

[077] In another preferred embodiment a 600 mg Guaifenesin/60 mg Pseudoephedrine Tablet has the following ingredients and proportions:

Component	Amount (mg/tablet)	Representative Batch (kg) ¹ IR Layer	Representative Batch (kg) ¹ SR Layer
Guaifenesin DC (95%) ²	631.55	280.00	947.376
Hydroxypropyl methylcellulose (Methocel TM)	15.0	N/A	27.000
Pseudoephedrine hydrochloride, USP	60.0	N/A	108.0
Microcrystalline cellulose	58.75	156.28	N/A
Sodium starch glycolate	15.0	39.90	N/A
Carbomer 934P	7.5	N/A	13.500
Magnesium stearate	5.50	1.33	9.000
D&C Yellow #6 Aluminum Lake (15-18%)	0.8	N/A	1.440
Water, purified	N/A ³	N/A ³	N/A ³
Total Weight	794.1	477.51	1106.316

¹ Based on batch size of 1,800,000 tablets

² guaifenesin direct compression used in the manufacturing process consists of 95% guaifenesin, USP, 5% hydroxypropyl methylcellulose, USP (MethocelTM E10M) granulated with purified water, USP (49.21 Kg).

³ Water is removed during processing of Guaifenesin DC 95%.

[078] In another example, a 1200 mg Guaifenesin/120 mg Pseudoephedrine Tablet may also have the following properties:

Description	1200 mg bi-layer tablet
Average Tablet Weight	1587.0 mg $\pm$ 3% (1539.4 mg - 1634.6 mg)
Tablet Thickness	0.321" - 0.341"
Tablet Hardness	25-45 SCU
Friability	NMT 0.8%
Loss on Drying (moisture)	NMT 2.0% NMT 31.74 mg/unit dose
Assay-guaifenesin	1140.0 - 1260.0 mg/tablet (95.0 - 105.0%)
Assay-Pseudoephedrine hydrochloride	116.6 to 128.4 mg/tablet (93.0 - 107.0%)
Guaifenesin Identification A	The retention time of the peak obtained from the Assay preparation matches that of the Standard preparation.
Guaifenesin (Identification B)	A deep-cherry red to purple color is produced.
Pseudoephedrine hydrochloride Identification A	The retention time of the peak obtained from the Assay preparation matches that of the Standard preparation.
Pseudoephedrine hydrochloride Identification B	The IR spectrum matches that of the standard in the 2510 cm^{-1} to 2400 range cm^{-1} .
Dose Uniformity	%RSD NMT 6.0% (%RSD NMT 7.8% for Level II) All individual values between 85.0 - 115.0% (For Level II, one value is allowed outside 85.0 - 115.0%, but none outside 75.0 - 125.0%)
Dissolution:	1 Hour: NMT 45%
Guaifenesin	2 Hour: 36 - 56% 6 Hour: 61 - 81% 12 Hour: NLT 85%
Dissolution:	1 Hour: NMT 53%
Pseudoephedrine hydrochloride	2 Hour: 48 - 68% 6 Hour: NLT 75% 12 Hour: NLT 85%

Agent's File Reference: 62808.000021

[079] In another example, a 600 mg Guaifenesin/60 mg Pseudoephedrine Tablet may also have the following properties:

Description	600 mg bi-layer tablet
Average Tablet Weight	794.1 mg $\pm$ 3% (766.4 mg - 821.8 mg)
Tablet Thickness	0.247" - 0.262"
Tablet Hardness	17 - 32 SCU
Friability	NMT 0.8%
Loss on Drying (moisture)	NMT 2.0% NMT 15.88 mg/unit dose
Assay-Guaifenesin	570.0 - 630.0 mg/tablet(95.0 - 105.0%)
Assay-Pseudoephedrine hydrochloride	58.2 to 61.8 mg/tablet (93.0 - 107.0%)
Guaifenesin Identification A	The retention time of the peak obtained from the Assay preparation matches that of the Standard preparation.
Guaifenesin Identification B	A deep-cherry red to purple color is produced.
Pseudoephedrine hydrochloride Identification A	The retention time of the peak obtained from the Assay preparation matches that of the Standard preparation.
Pseudoephedrine hydrochloride Identification B	The IR spectrum matches that of the standard in the 2510 cm ⁻¹ to 2400 range cm ⁻¹ .
Dose Uniformity	%RSD NMT 6.0% (%RSD NMT 7.8% for Level II) All individual values between 85.0 - 115.0% (For Level II, one value is allowed outside 85.0 - 115.0%, but none outside 75.0 - 125.0%)
Dissolution:	1 Hour: NMT 48%
Guaifenesin	2 Hour: 41 - 61% 6 Hour: 73 - 93% 12 Hour: NLT 90%
Dissolution:	1 Hour: NMT 58%
Pseudoephedrine hydrochloride	2 Hour: 56 - 76% 6 Hour: NLT 80% 12 Hour: NLT 85%

[080] In one embodiment, the 1200/60 mg guaifenesin/dextromethorphan weight specification is 1530.4 mg $\pm$ 3.0%, corresponding to a range of 1484.5 - 1576.3

mg. For the 600/30 mg tablet, the weight specification is $765.2 \text{ mg} \pm 3.0\%$, corresponding to a range of 742.2 – 788.2 mg. This specification range of $\pm 3.0\%$ of the theoretical weight is similar to the guaifenesin alone 1200 mg and 600 mg tablets, respectively.

[081] The proposed hardness and thickness specifications for the 1200/60 mg guaifenesin/dextromethorphan tablet are 15-65 SCU and 0.310" - 0.340", respectively. Tablets pressed at 527 tpm at the minimum hardness parameter (12LB86A) ranged from 0.329" - 0.334" and 17-23 SCU. The friability ranged from 0.20-0.33%. Tablets pressed at 737 tpm at the minimum hardness parameter (12LB86B) ranged from 0.331" - 0.335" and 15-24 SCU. The friability ranged from 0.20-0.39%. Dissolution testing was performed for each test condition (527 tpm and 737 tpm) within one hour of compression. No significant difference was seen in the release profile between the test samples and the pilot batches.

[082] Further tablets pressed as thin and as hard as the press would allow at speeds of 527 tpm (12LB86C) and 737 tpm (12LB86D) provided a thickness range of 0.303" - 0.312" with a corresponding initial hardness range of 39-47 SCU at 527 tpm. The friability ranged from 0.07-0.13%. A thickness range of 0.304" - 0.313" was obtained with a corresponding initial hardness range of 38-47 SCU at 737 tpm. The friability ranged from 0.06-0.13%. Historically, it has been noted that these tablets harden during the first few days after compression. Therefore, these 'hard' tablets were tested for dissolution at least 5 days after compression. The hardness range on the fifth day after compression was 52-60 SCU for the tablets pressed at 527 tpm. The hardness range on the fifth day after compression was 48-56 SCU for the tablets pressed at 737 tpm. Again, the dissolution profile for the test samples corresponded closely with that seen in the pilot batches. Additionally, a tablet hardness range of 60-79 SCU was reported for PB01-H30 at the 3-month real-time stability time point. No significant difference in the dissolution profile from "T₀" was noted.

[083] The proposed hardness and thickness specifications for the 600/30 mg guaifenesin/dextromethorphan tablet were 15-65 SCU and 0.220" - 0.260"

Agent's File Reference: 62808.000021

respectively. Tablets pressed at the minimum hardness parameter at 527 tpm (12LB85A) ranged from 0.257" - 0.260" and 8-13 SCU. The friability ranged from 0.13-0.26%. Tablets pressed at the minimum hardness parameter at 840 tpm (12LB85B) ranged from 0.258" - 0.261" and 8-13 SCU. The friability ranged from 0.13-0.26%. Dissolution testing was performed for each test condition (527 tpm and 840 tpm) within one hour of compression. No significant difference was seen in the release profile between the test samples and the pilot batches.

[084] Tablets were then pressed as thin and as hard as the press would allow. A range of 0.232" - 0.241" was obtained at compression with a corresponding hardness ranging from 25-30 SCU at 527 tpm (12LB85C). The friability ranged from 0.13-0.78%. The hardness on the seventh day after compression ranged from 28-34 SCU. A range of 0.230" - 0.241" was obtained at compression with a corresponding hardness ranging from 23-30 SCU at 840 tpm (12LB85D). The friability ranged from 0.00-0.13%. The hardness on the seventh day after compression ranged from 28-33 SCU. Again, the dissolution profile for the test samples (seven days after compression) corresponded closely with that seen in the pilot batches. Additionally, a tablet hardness range of 37-51 SCU was reported for lot PB01-H54 at the 3-month real-time stability time point. No significant difference in the dissolution profile from "T₀" was noted.

[085] The preferred 1200 mg guaifenesin/60 mg dextromethorphan tablets have an average tablet thickness of 0.305" - 0.335", an average tablet hardness of 25 - 35 SCU (in process), and average tablet hardness 20 - 79 SCU (at time of release).

[086] The preferred 600 mg guaifenesin/30 mg dextromethorphan tablets have an average tablet thickness of 0.230" - 0.260", an average tablet hardness of 20 - 30 SCU (in process), and an average tablet hardness of 10 - 51 SCU (at time of release through expiration date).

[087] The specification of NMT 0.8% set for the friability of both guaifenesin/dextromethorphan tablet strengths is based on the limit established with the guaifenesin alone tablets. The specification for Loss on Drying is

comparable to guaifenesin alone, i.e. NMT 2.0%. The moisture limit is 2.0% of the total theoretical tablet weight, recorded in mg/unit dose.

[088] The range for the specification for guaifenesin is based on the labeled amount, 1200 mg or 600 mg $\pm$ 4.0%. For the 1200/60 mg guaifenesin/dextromethorphan tablet, the range is 1152.0 - 1248.0 mg per tablet. For the 600/30 mg guaifenesin/dextromethorphan tablet, the range is 576.0 - 624.0 mg per tablet. The range for the specification for dextromethorphan HBr is based on the labeled amount, 60 mg or 30 mg $\pm$ 4.0%. For the 1200/60 mg tablet, the range is 57.6 - 62.4 mg per tablet. For the 600/30 mg tablet, the range is 28.8 - 31.2 mg per tablet.

[089] Other embodiments of the invention, include a SCU that is preferably less than 43, more preferably less than 41, more preferably less than 38, , more preferably less than 37, and more preferably between 32 and 35. SCU is also preferably greater than 21, more preferably greater than 24, more preferably greater than 28, and more preferably greater than 31.

[090] The weight of 10 bi-layer guaifenesin/pseudoephedrine tablets (1200 mg/120 mg) is preferably less than 16.4g, more preferably less than 16.35g, more preferably less than 16.29g, more preferably less than 16.22g, more preferably less than 16.16g, more preferably less than 16.10g, more preferably less than 16.04g, and more preferably between 15.71g and 16.03g. The weight of 10 bi-layer tablets is also preferably greater than 15.35g, more preferably greater than 15.40g, more preferably greater than 15.46g, more preferably greater than 15.53g, more preferably greater than 15.59g, more preferably greater than 15.65g.

[091] Other embodiments and characteristics of the invention are described in further detail below.

Sustained Release Formulation

[092] In one embodiment of the invention, a sustained release formulation comprises guaifenesin and optionally at least one drug both mixed with a polymer blend which comprises at least one hydrophilic polymer and at least one water-insoluble polymer. In a further embodiment, the sustained release

formulation may comprise a combination of guaifenesin and at least one additional drug, wherein the additional drug may be selected from, but is not limited to, an antitussive such as dextromethorphan hydrobromide, codeine, hydrocodone, a decongestant such as phenylephrine hydrochloride, phenylpropanolamine hydrochloride, pseudoephedrine hydrochloride or ephedrine, an antihistamine such as chlorpheniramine maleate, brompheniramine maleate, phenindamine tartrate, pyrilamine maleate, doxylamine succinate, phenyltoloxamine citrate, diphenhydramine hydrochloride, promethazine, and clemastine fumarate, an analgesic such as AspirinTM, ibuprofen, naprosin, and acetaminophen, or combinations thereof. Preferably, the drug is dextromethorphan hydrobromide, pseudoephedrine hydrochloride, or a combination thereof.

[093] The sustained release matrix utilizes polymers as described below to achieve the required delay release profile *in vivo*. To obtain the release profile proper mixing and formulation is required. For instance, too much hydrophilic polymer will result in too quick of a release and not allow for 12 hour relief while too much hydrophobic polymer will result in inadequate C_{max} for relief of symptoms. Therefore, the selection of polymers, the amounts utilized in total and the amount utilized in comparison to each other provide a matrix which is then formulated according to the below methods to provide the appropriate release profile.

[094] Hydrophilic polymers suitable for use in the sustained release formulation include: one or more natural or partially or totally synthetic hydrophilic gums such as acacia, gum tragacanth, locust bean gum, guar gum, or karaya gum, modified cellulosic substances such as methylcellulose, hydroxymethylcellulose, hydroxypropyl methylcellulose, hydroxypropyl cellulose, hydroxyethylcellulose, carboxymethylcellulose; proteinaceous substances such as agar, pectin, carrageen, and alginates; and other hydrophilic polymers such as carboxypolymethylene, gelatin, casein, zein, bentonite, magnesium aluminum silicate, polysaccharides, modified starch derivatives, and other hydrophilic polymers known to those of skill in the art or a combination of such polymers.

[095] These hydrophilic polymers gel and dissolve slowly in aqueous acidic media thereby allowing the guaifenesin and at least one drug to diffuse from the gel in the stomach. When the gel reaches the intestines, where the guaifenesin and the drug are fairly absorbable, it dissolves in controlled quantities in the higher pH medium to allow sustained release of guaifenesin and at least one drug throughout the digestive tract. Preferred hydrophilic polymers are the hydroxypropyl methylcelluloses such as those manufactured by The Dow Chemical Company and known as Methocel™ ethers. In one preferred embodiment of a sustained release formulation the hydrophilic polymer is a Methocel™ ether known as Methocel™ E10M.

[096] Water-insoluble polymers, which are suitable for use in the sustained release formulation, are polymers which generally do not dissolve in solutions of a pH below 5, and dissolve more slowly in basic solutions than the hydrophilic polymer. Because the polymer is insoluble in low pH environments such as those found in gastric fluid, it aids in retarding drug release in those regions. Likewise, because the polymer dissolves more slowly in solutions of higher pH than hydrophilic polymers, it aids in retarding drug release throughout the intestines. This overall delayed release results in a more uniform serum concentration of guaifenesin.

[097] The water-insoluble polymers suitable for use in this invention include for example: polyacrylic acids, acrylic resins, acrylic latex dispersions, cellulose acetate phthalate, polyvinyl acetate phthalate, hydroxypropyl methylcellulose phthalate, and other polymers common to those of skill in the art. In a preferred embodiment, a sustained release formulation comprises the acrylic resin Carbopol™ 974P supplied by BF Goodrich.

[098] A sustained release formulation of the invention may further comprise pharmaceutical additives including, but not limited to: lubricants such as magnesium stearate, calcium stearate, zinc stearate, powdered stearic acid, hydrogenated vegetable oils, talc, polyethylene glycol, and mineral oil; colorants; binders such as sucrose, lactose, gelatin, starch paste, acacia, tragacanth, povidone polyethylene glycol, Pullulan and corn syrup; glidants such

as colloidal silicon dioxide and talc; surface active agents such as sodium lauryl sulfate, dioctyl sodium sulfosuccinate, triethanolamine, polyoxyethylene sorbitan, poloxalkol, and quarternary ammonium salts; preservatives and stabilizers; excipients such as lactose, mannitol, glucose, fructose, xylose, galactose, sucrose, maltose, xylitol, sorbitol, chloride, sulfate and phosphate salts of potassium, sodium, and magnesium; and/or any other pharmaceutical additives known to those of skill in the art. Colorants include, but are not limited to, Emerald Green Lake, FD&C Red No. 40, FD&C Yellow No. 6, D&C Yellow No. 10, or FD&C Blue No. 1 and other various certified color additives (See 21 CFR, Part 74). In one preferred embodiment, a sustained release formulation further comprises magnesium stearate and Emerald Green Lake. In another preferred embodiment, a sustained release formulation further comprises magnesium stearate and FD&C Blue No. 1 Aluminum Lake Dye.

[099] In another embodiment the modified release formulation comprises at least two drugs, one of which is guaifenesin, at least one hydrophilic polymer, at least one water-insoluble polymer, and at least one pharmaceutical additive which permits dissolution of drugs in a therapeutically effective profile for an extended period of time. It is preferred that the drug profile provides a therapeutically effective profile for greater than 10 hours, more preferably greater than 12 hours, and most preferably greater than 14 hours. In a preferred embodiment, a modified release formulation comprises from about 75% to about 95% guaifenesin by weight, from about 1% to about 15% by weight of an additional drug, from about 0.5% to about 10% hydroxypropyl methylcellulose, from about 0.5% to about 2.5% acrylic resin, from about 0.4% to about 1.5% magnesium stearate, and from about 0.01% to about 1% colorant by weight. In a more preferred embodiment, a modified release formulation comprises from about 75% to about 80% guaifenesin by weight, from about 3% to about 10% by weight of an additional drug, from about 3% to about 6% hydroxypropyl methylcellulose, from about 1% to about 1.5% acrylic resin, from about 0.7% to about 1% magnesium stearate, and from about 0.03% to about 0.13% colorant by weight.

[0100] The sustained release formulation controls the release of guaifenesin and optionally at least one additional drug into the digestive tract over an extended period of time resulting in an improved profile when compared to immediate release combinations. guaifenesin solubility is effected by the pH of the environment in which it is present (*i.e.* stomach versus intestinal tract). In a more acidic environment, such as the stomach, guaifenesin is less soluble while in a higher pH environment, such as the intestines, guaifenesin is readily soluble. The pH changes throughout the digestive tract effect the dissolution rate of guaifenesin and are partially determinate of the concentrations of guaifenesin attained in the blood and tissues.

[0101] To maintain a blood concentration of guaifenesin which provides good therapeutic effect, the release, or dissolution, of guaifenesin from a formulation matrix is preferably retarded and/or controlled through the intestines. The hydrophilic and water-insoluble polymers of the sustained release formulation gel when exposed to media of low pH. This gel matrix allows the sustained release drugs, e.g. guaifenesin alone or in combination with a second drug to diffuse at a controlled rate when exposed to a higher pH environment.

[0102] When using drugs approved by the Food and Drug Administration (FDA), the sustained release formulation may be formulated to mimic the blood serum profile of guaifenesin and optionally the additional drug(s) as described in the clinical documents filed with the FDA or as required by the FDA. In other words, the sustained release formulation releases at least one additional drug at a similar rate to the commercially available formulation, thereby providing a therapeutically effective amount of the additional drug.

[0103] In a preferred embodiment, a sustained release formulation comprises a hydrophilic polymer and a water-insoluble polymer in a ratio of about one-to-one (1:1) to about nine-to-one (9:1), more preferably the range is about three-to-two (3:2) to about six-to-one (6:1), and most preferably the range of hydrophilic polymer to water-insoluble polymer is about two-to-one (2:1) to about four-to-one (4:1). In another embodiment, the sustained release formulation comprises not more than about 10% hydrophilic polymer, preferably, not more than 6%,

Agent's File Reference: 62808.000021

and in a more preferred embodiment, the sustained release formulation also comprises not more than 2.5% of the water-insoluble polymer by weight. In another preferred embodiment, the water- hydrophilic polymer is hydroxypropyl methylcellulose and the water-insoluble polymer is acrylic resin. The ratios result in a serum concentration profile of guaifenesin that provides an optimal therapeutic concentration for about twelve hours.

[0104] A sustained release formulation may be manufactured according to any appropriate method known to those of skill in the art of pharmaceutical manufacture. In one embodiment, guaifenesin and a hydrophilic polymer may be mixed in a mixer with an aliquot of water to form a wet granulation. The granulation may be dried to obtain hydrophilic polymer encapsulated granules of guaifenesin. The resulting granulation may be milled, screened, and then blended with various pharmaceutical additives, water insoluble polymer, and additional hydrophilic polymer. The formulation may then tableted and may further be film coated with a protective coating which rapidly dissolves or disperses in gastric juices.

[0105] In a preferred embodiment the method of preparing a sustained release formulation comprises loading approximately 126 kg of guaifenesin and about 2 kg of Methocel E10M into a high shear mixer. The Methocel E10M and guaifenesin may be mixed for about seven minutes at a mixing speed of about 150 RPM and a chopper speed of about 2000 RPM. The mixing and chopping speeds may then be increased to about 200 RPM and 3000 RPM respectively for about five minutes while about 49 kg of water are added to the mixer contents. The mixer may be run for two additional minutes to complete granulation. In a further preferred embodiment, the shut off for the mixer load is set to 21 kilowatts.

[0106] The wet granulation may be emptied into a fluid bed bowl and placed into a fluid bed dryer set to a dryer air flow of 900 CFM and an inlet temperature of about 50°C to about 55°C until the outlet temperature increases at a rate of 1°C per minute. The air flow may then be decreased to 600 CFM, and the inlet temperature may be decreased to 43°C until the granulation is dried to a moisture

content of no more than 0.5%. In another preferred embodiment, the outlet temperature is set to a cut-off of 48°C. In yet another preferred embodiment, an agitator in the fluid bed bowl may be run intermittently during drying. The dried granulation may be passed through a mill fitted with a suitable screen size so that not more than about 30% of the resulting granulation comes through a 100 mesh screen and not more than about 10% of the resulting granulation is retained on a 10 mesh screen. In one preferred embodiment, the dried granulation may be passed through a mill fitted with a 0.109" size screen at a mill speed of about 500 to about 1500 RPM and a screw feed rate of about 35 to about 45 RPM. The resulting screened granulation is about 95% guaifenesin and is called G Guaifenesin DC (Direct Compressed) herein after. Screened granulation may be transferred to a 10 cubic foot V blender, combined with about another 0.6 kg of Methocel E10M, about 0.3 kg of a colorant such as Emerald Green Lake or FD&C BLUE No. 1, about 0.7 kg of magnesium stearate, and about 1.3 kg of Carbopol 974P. The combination may be blended for about three minutes.

[0107] In another preferred embodiment the method of preparing a sustained release formulation comprises loading about 101 kg to about 150 kg of guaifenesin, about 4.5 kg to about 18 kg of the additional drug, about 4.5 kg to about 5 kg of Methocel E10M, about 1.5 kg to about 2.25 kg of Carbopol® 974P, and about 40 g to about 240 g of colorant into a high shear mixer. If at this time water is to be added, then about 1 kg to about 1.5 kg of magnesium stearate is added as well. The ingredients may be mixed for about ten to about 12 minutes at a mixing speed of about 150 RPM and a chopper speed of about 2000 RPM. The mixing and chopping speeds may then be increased to about 200 RPM and 3000 RPM, respectively, for about five minutes while optionally about 29 kg of water are added to the mixer contents. If no water is added, then from about 1 kg to about 1.5 kg of magnesium stearate can be added at this time. The mixer may be run for ten additional minutes to complete granulation. In a further preferred embodiment, the shut off for the mixer load is set to 21 kilowatts.

[0108] The wet granulation may be emptied into a fluid bed bowl and placed into a fluid bed dryer set to a dryer air flow of 900 CFM and an inlet temperature of

about 38°C to about 48°C until the outlet temperature increases at a rate of 1°C per minute. The air flow may then be decreased to 600 CFM, and the inlet temperature may be decreased to 43°C until the granulation is dried to a moisture content of no more than 0.5%. In another preferred embodiment, the outlet temperature is set to a cut-off of 48°C. In yet another preferred embodiment, an agitator in the fluid bed bowl may be run intermittently during drying. The dried granulation may be passed through a mill fitted with a suitable screen size so that not more than about 30% of the resulting granulation comes through a 100 mesh screen and not more than about 10% of the resulting granulation is retained on a 10 mesh screen. In one preferred embodiment, the dried granulation may be passed through a mill fitted with a size screen of about 0.109" to about 0.125" at a mill speed of about 500 to about 1500 RPM and a screw feed rate of about 35 to about 45 RPM.

[0109] The resulting formulations may further be compressed on a tablet compressor machine using tooling to form tablets. The tablets may be any appropriate weight, size, and shape depending on the desired dosage strength of tablet. In one embodiment, these tablets may further be loaded into a coating pan and film coated with Opadry™ Y-S-3-714 (supplied by Colorcon, Inc.) and air dried in the pan.

[0110] In another embodiment, the method of preparing a sustained release formulation comprises blending the drugs, hydrophilic polymer, water insoluble polymer, and any pharmaceutical additives. The resulting blend may then be compressed into tablets and, if desired, film coated with a protective coating which rapidly dissolves or disperses in gastric juices. In a preferred embodiment of such a method, about 126 kg of Guaifenesin DC (about 95% purity), about 2.6 kg of Methocel™ E10M, about 1.3 kg of Carbopol™ 974P and about 0.333 kg of a colorant such as Emerald Green Lake or FD&C BLUE No. 1 may be loaded into a 10 cubic foot V Blender. The ingredients may be blended for about 20 minutes at which time about 0.6 kg of magnesium stearate may be added to the blended ingredients. This mixture may be blended for about another 10 minutes. The resulting formulation may further be compressed on a tablet compressor machine

Agent's File Reference: 62808.000021

using tooling to form tablets. The tablets may be any appropriate weight, size, and shape depending on the desired dosage strength of the tablet. These tablets may further be loaded into a coating pan and film coated with Opadry Y-S-3-714 (supplied by Colorcon, Inc.) and air dried in the pan.

[0111] One embodiment of the invention uses the following general methods of manufacturing. To make the Guaifenesin DC (95%) intermediate granulation is conducted. The granulator is charged with purified water USP. The guaifenesin USP is added into the granulator. Next the hydroxypropyl methylcellulose USP (Methocel El OM) is added. The guaifenesin intermediate is dried with the air inlet temperature set about 5°C, until the air outlet temperature reached approximately 48°C. A sample may then be taken for in-process control testing (moisture analysis). After the material reaches the target moisture level, discharge the blend and proceed to milling. The dried granulation is then added to the milling machine and the milling process initiated. Again a sample may be taken for in-process control testing (moisture and sieve analysis). The milled material is collected into tared fiber drums, double-lined with plastic bags and containing a desiccant pouch between the inner and outer plastic bags, then transferred to blending. The batches are blended in a 60-cu. foot blender for at least 10 minutes. Again, a sample may be taken for in-process control testing (description, moisture, blend assay and sieve analysis). The final sieve analysis for milled Guaifenesin DC preferably will be as follows: not more than about 2 to 10% retained on a 10-mesh screen (2.00 mm), not less than about 50 to 60% retained on the 20-mesh through 100-mesh screens (150 µm), not less than about 4 to 6% will pass through a 100-mesh screen, and not more than about 15-20% will pass through a 140-mesh screen (106µm). When at least 50%, and preferably at least 60% of the Guaifenesin DC has a particle size in the range of from about 2 mm to about 150 µm, this facilitates both processability and achievement of the desired in vivo release profiles for the single entity and combination drugs described herein. The final Guaifenesin DC (95%) granulation is collected into tared fiber drums, double-lined with double-lined

with plastic bags and containing a desiccant pouch between the inner and outer plastic bags.

[0112] In one embodiment the immediate release layer is produced according to the following general procedures. The released components, Guaifenesin DC (95%) and microcrystalline cellulose, NF (Avicel® PH102), are weighed and blended in a PK V-blender for about 20 minutes. Then sodium starch glycolate, NF (Explotab®), is added to the blender and blend for about 10 minutes. Next magnesium stearate, NF, is added to the blender and blended for approximately an additional 10 minutes. Sample may then be taken for in-process control testing (description, blend assay and sieve analysis).

[0113] In one embodiment the sustained release layer is produced according to the following general procedures. The released components, Guaifenesin DC (95%) and pseudoephedrine HCl, USP, previously screened through a No. 20 screen, are weighed and blended for ten minutes with hydroxypropyl methylcellulose, USP (Methocel E10M), Carbomer 934P and the appropriate colorant (FD & C Red No. 40 aluminum lake dye for 1200 mg guaifenesin/120 mg pseudoephedrine HCl tablets or FD & C Yellow No. 6 aluminum lake dye for 600 mg guaifenesin/60 mg pseudoephedrine HCl tablets). Next, an additional amount of Guaifenesin DC (95%), previously screened through a No. 10 screen, is added and blended for about ten minutes. Then magnesium stearate, NF, previously screened through a No. 20 screen, is added and blended for about ten minutes. Again, samples may be taken for in-process control testing (description, sieve analysis, and blend assay for both guaifenesin and pseudoephedrine HCl). Tablet Compression involved loading each blend (IR and SR) into its respective hopper on the bi-layer tablet compressor and then compressed according to the described parameters.

[0114] In another embodiment 1200 mg guaifenesin and 60 mg dextromethorphan HBr tablets are manufactured using the following protocol. The manufacturing process yields 600,000 tablets per batch for the 1200 mg guaifenesin and 60 mg dextromethorphan HBr or 1,200,000 tablets for 600 mg guaifenesin and 30 mg dextromethorphan HBr tablets. The components for the immediate release layer

(IR layer) for both strength tablets are identical. The components for the sustained release layer (SR layer) for both strength tablets are also identical.

[0115] For the SR layer (for 1200 mg guaifenesin and 60 mg dextromethorphan HBr tablets), the guaifenesin and dextromethorphan HBr (previously screened through a 20-mesh screen), are granulated together with Carbomer™ 934P, hydroxypropyl methylcellulose (Methocel™ E10M), and FD&C blue #1, aluminum lake (11 - 13%) using purified water as the granulating fluid in a Day mixer. The wet mass is evenly spread onto paper-lined trays and dried in a drying oven set at $109 \pm 10^\circ$ F for approximately 25 hours until the average moisture is not more than 1.5%. The process for the SR layer for 600 mg guaifenesin and 30 mg dextromethorphan HBr tablets is identical to the process for the 1200 mg guaifenesin and 60 mg dextromethorphan HBr extended release tablets with the exception of the dye used. The dye used in the half strength tablet is D&C yellow #10, aluminum lake (14 - 18%) while the dye in the full strength tablet is FD&C Blue #1, aluminum lake (11-13%). The dried granulation is milled using a Fitzpatrick Mill fitted with a 0.125" round-hole screen, knives forward at a "fast" speed. The granulation is fed into the mill using an automatic feeder. The six sublots (112.04 kg per subplot, granulated, dried, and milled as described above) are then blended together in a 60-cu. foot blender with magnesium stearate for ten minutes.

[0116] For the IR layer, the guaifenesin and dextromethorphan HBr (previously screened through a 20-mesh screen), are granulated together with sodium starch glycolate (Explotab™), microcrystalline cellulose (Avicel™ PH102), and hydroxypropyl methylcellulose (Methocel™ E10M) using purified water as the granulating fluid in a Day mixer. The wet mass is evenly spread onto paper-lined trays and dried in a drying oven set at $109 \pm 10^\circ$ F for approximately 26 hours until the average moisture is not more than 2.0%. The IR layer process is the same for both tablet strengths. The dried granulation is passed through a Sweco equipped with 10-mesh screen. The granulation retained on the 10-mesh screen is milled using a Fitzpatrick Mill fitted with a 0.125" round-hole screen, knives forward at a "medium" speed. The granulation is fed into the mill using

an automatic feeder. The milled material is later blended with the material that passed through the 10-mesh screen. The three sublots (95.52 kg per subplot, granulated, dried, and milled as described above) are then blended together in a 60 cu.-foot blender with magnesium stearate for ten minutes. Each blend is then loaded into their respective hoppers and compressed into bi-layer tablets.

[0117] Tablets comprising a sustained release formulation were prepared and tested for both *in vitro* and *in vivo* release characteristics as described in Examples 1, 2, and 3 below. In the *in vitro* testing, the dissolution rates of these tablets were compared against modified release tablets formulated without acrylic resin (Example 1), and three commercially available tablets, one being an immediate release formulation and the other two being modified release formulations. Tablets comprising the sustained release formulation demonstrated a slower, more controlled release of guaifenesin over a twelve hour period than any of the other tablets (see e.g., Example 1 and 2, and Figures 4 and 5).

[0118] In the *in vivo* testing, serum concentrations of subjects taking tablets comprising the sustained release formulation were compared with serum concentrations of subjects taking immediate release guaifenesin tablets and modified release guaifenesin tablets formulated without acrylic resin (see Example 3 and Figure 6). Tablets comprising the sustained release formulation demonstrated improved sustained release and therapeutic concentration over an extended time period compared to the other two formulations. Additionally, in the subjects taking tablets comprising the sustained release formulation, it took longer for guaifenesin to appear in the blood stream and the maximum guaifenesin serum concentration ($C_{\max}$) was less than half that of the subjects who took the immediate release tablets.

Modified Release Formulation

[0119] To improve the $C_{\max}$ and guaifenesin appearance speed in patients while maintaining therapeutic effect for about twelve hours, a portion of a sustained release formulation as described above may be combined with a portion of an immediate release formulation in a modified release product. In a preferred embodiment, at least one additional drug can be present within the sustained

release formulation, the immediate release formulation, or both depending upon the desired effect. When using drugs approved by the Food and Drug Administration (FDA), the sustained release formulation, immediate release formulation, or both may be formulated to mimic the blood serum profile of the additional drug as described in the clinical documents filed with the FDA or as required by the FDA. In other words, the sustained and/or immediate release formulations of the modified release formulation may release the at least one additional drug at a similar rate to the commercially available formulation, thereby providing a therapeutically effective amount of the additional drug.

[0120] The modified release formulation can be in the form of bi-layered tablets, capsules having a combination of beads or granules of immediate release formulation and sustained release formulation, or a tablet wherein the sustained release formulation comprises a core that is coated by a layer of the immediate release formulation. For purpose of illustration only, the invention will be described in detail in the context of the bi-layered tablet embodiment.

[0121] The immediate release formulation may comprise guaifenesin and various pharmaceutical additives such as lubricants, colorants, binders, glidants, surface active agents, preservatives, stabilizers, as described above and/or any other pharmaceutical additives known to those of skill in the art. In one embodiment, the immediate release layer comprises at least one drug. In another embodiment, the immediate release layer comprises at least two drugs. In a more preferred embodiment, an immediate release formulation comprises guaifenesin, microcrystalline cellulose, sodium starch glycolate, and magnesium stearate. In another more preferred embodiment, an immediate release formulation comprises guaifenesin, at least one additional drug, microcrystalline cellulose, hydroxypropyl methylcellulose, sodium starch glycolate, and magnesium stearate. In yet another preferred embodiment, an immediate release formulation may comprise about 47% to about 58% guaifenesin, about 32% to about 42% microcrystalline cellulose, about 3% to about 8% sodium starch glycolate, and about 0.3% to about 0.5% magnesium stearate by weight. In yet another preferred embodiment, an immediate release formulation comprises about 47%

to about 58% guaifenesin, about 3% to about 5% of at least one additional drug, about 32% to about 42% microcrystalline cellulose, about 2% to about 5% hydroxypropyl methylcellulose, about 3% to about 8% sodium starch glycolate, and about 0.3% to about 0.5% magnesium stearate by weight.

[0122] The bi-layer tablet may be manufactured according to any method known to those of skill in the art. The resulting tablet comprises the two portions compressed against one another so that the face of each portion is exposed as either the top or bottom of the tablet, or the resulting tablet may comprise the sustained release portion in the center coated by the immediate release portion so that only the immediate release portion is exposed. In a preferred embodiment, a bi-layer tablet comprises the two portions compressed against one another so that the face of each portion is exposed.

[0123] In a preferred method of manufacturing the bi-layer tablets, a sustained release formulation is prepared according to either a wet granulation or dry granulation method as described above. The immediate release formulation may be prepared by simply blending the guaifenesin with any pharmaceutical additives. If at least one additional drug is present, then water may be added to the formulation, as described above. In a further preferred embodiment, appropriate quantities of Guaifenesin DC, microcrystalline cellulose, and sodium starch glycolate are blended in a 10 cubic foot blender for about twenty minutes. An appropriate quantity of magnesium stearate is then added to the ingredients and blended for about ten more minutes to make an immediate release formulation. Portions of the sustained release formulation and immediate release formulation are then compressed by a tablet compressor machine capable of forming bi-layer tablets. In one embodiment, these tablets may further be coated with a protective film which rapidly disintegrated or dissolves in gastric juices.

[0124] The tablets may be made with any ratio of guaifenesin to at least one additional drug which results in a blood profile demonstrating appropriate therapeutic effect over extended time periods. As discussed above, the additional drug may be present in an amount sufficient to mimic the blood serum profile of the commercially available formulation of the drug and not to exceed

Agent's File Reference: 62808.000021

the maximum dose approved by the FDA for the treatment, prevention, or amelioration of a particular illness or disease. In one embodiment, the ratio of total guaifenesin to at least one additional drug is about 1:1 to about 30:1, more preferably about 1:1 to 25:1, and more preferably about 20:1 by weight. Alternatively, the ratio is about 2:1 to about 15:1 by weight, and more preferably, the ratio of guaifenesin to at least one additional drug is about 8:1 to about 12:1 by weight. When present in the immediate release layer, the amount of the at least one additional drug should be sufficient to match the drug release profile of the additional drug within the sustained release profile.

[0125] In a preferred embodiment, the tablets are made with any ratio of guaifenesin to pseudoephedrine which results in a blood profile demonstrating appropriate therapeutic effect over extended time periods. As discussed above, the pseudoephedrine is present in an amount sufficient to mimic the blood serum profile of the commercially available formulation of the drug and not to exceed the maximum dose approved by the FDA for the treatment, prevention, or amelioration of a particular illness or disease. In one embodiment, the ratio of total guaifenesin to pseudoephedrine is about 1:1 to about 30:1, more preferably about 1:1 to 25:1, and more preferably about 20:1 by weight. Alternatively, the ratio of guaifenesin to pseudoephedrine is about 8:1 to about 12:1 by weight. In another embodiment the pseudoephedrine is only present in the immediate release layer.

[0126] In a preferred embodiment, the tablets are made with any ratio of guaifenesin to dextromethorphan which results in a blood profile demonstrating appropriate therapeutic effect over extended time periods. As discussed above, the dextromethorphan is present in an amount sufficient to mimic the blood serum profile of the commercially available formulation of the drug and not to exceed the maximum dose approved by the FDA for the treatment, prevention, or amelioration of a particular illness or disease. In one embodiment, the ratio of total guaifenesin to dextromethorphan is about 1:1 to about 30:1, more preferably about 1:1 to 25:1, and more preferably about 20:1 by weight.

Alternatively, the ratio of guaifenesin to dextromethorphan is about 8:1 to about 12:1 by weight.

[0127] The tablets may be made with any ratio of sustained release to immediate release formulation which results in a blood profile demonstrating appropriate therapeutic effect over extended time periods. In one embodiment, the bi-layer tablets comprise guaifenesin distributed within the sustained release formulation and the immediate release formulation wherein the ratio of guaifenesin in the SR to guaifenesin in the IR is about 1:1 to about 20:1, more preferably about 1:1 to about 1:15 by weight, preferably the ratio is about 3:2 to about 11:1, and more preferably, the ratio of guaifenesin distributed within the sustained release formulation and the immediate release formulation is about 5:1 to about 9:1 by weight, respectively. For example, in a 1200 mg bi-layer modified release guaifenesin tablet, there may be about 200 mg of guaifenesin in the immediate release layer and about 1000 mg of guaifenesin in the sustained release layer.

[0128] The tablets may be made with at least one additional drug only within the sustained release formulation or with the additional drug only in the immediate release formulation. Optionally, the tablets may be made with at least one additional drug distributed within the sustained release formulation and the immediate release formulation. In one embodiment, the bi-layer tablets comprise an additional drug distributed within the sustained release formulation and immediate release formulation wherein the ratio of additional drug in the SR to additional drug in the IR is about 1:1 to about 20:1, more preferably about 1:1 to about 1:15 by weight, preferably the ratio is about 3:2 to about 9:1, and more preferably the ratio is about 3:1 to about 4:1 by weight, respectively. Alternatively the weight ratio for the additional drug is sustained release portion to immediate release portion is about 4:1 to about 1:1, more preferably about 1:1 to about 2:1.

[0129] In one preferred embodiment of manufacturing a 1200 mg bi-layer sustained release guaifenesin tablet, about 105 kg of Guaifenesin DC, about 2.5 kg of Methocel E10M, about 1.25 kg of Carbopol 974P, and about 0.333 kg of Emerald Green Lake or FD&C Blue No. 1 in a 10 cubic foot P.K. blender for

about twenty minutes. About 0.6 kg of magnesium stearate may then be added and blending continued for about another ten minutes to prepare the sustained release formulation. Approximately 21 kg of Guaifenesin DC, approximately 11.75 kg of microcrystalline cellulose, and approximately 3 kg of sodium starch glycolate may be blended in a 3 cubic foot P.K. blender for about twenty minutes. Approximately 0.1 kg of magnesium stearate may then be added and blending continued for about another ten minutes to prepare the immediate release formulation. The two formulations may then be compressed to make bi-layer tablets wherein about 75% of each tablet may be sustained release formulation and about 25% of each tablet may be immediate release formulation. The tablets may be any dosage strength, size, or shape. In a preferred embodiment, 1200 mg tablets are round and about 5/8 inch in diameter, about 0.28 inch - 0.31 inch in thickness, weigh about 1.46 grams and have a hardness range of about 15-40 SCU. In another preferred embodiment, 600 mg tablets are round and about 1/2 inch in diameter, about 0.218 inch – 0.230 inch in thickness, weigh about 0.729 grams and have a hardness range of about 12-30 SCU.

[0130] In another preferred embodiment of manufacturing a 1200 mg bi-layer sustained release guaifenesin tablet, about 101 kg of Guaifenesin DC, about 4.5 kg of at least one additional drug such as dextromethorphan, about 5 kg of Methocel E10M, about 1.5 kg of Carbopol 974P, and about 0.04 kg of FD&C Blue No. 1 are blended in a 10 cubic foot Day mixer for about twelve minutes. Thereafter, about 29 kg of water is added and the mixture is blended for an additional 10 minutes, followed by drying. About 1 kg of magnesium stearate may then be added and blending continued for about another ten minutes to prepare the sustained release formulation. About 45.6 kg of GUAIFENESIN, about 3.6 kg of at least one additional drug such as dextromethorphan, about 40.32 kg of microcrystalline cellulose, and approximately 3 kg of sodium starch glycolate are blended in a 3 cubic foot Day mixer for about 12 minutes. Thereafter, about 36 kg of water is added and the mixture is blended for an additional 10 minutes, followed by drying. About 0.48 kg of magnesium stearate may then be added and blending continued for about another ten minutes

to prepare the immediate release formulation. The two formulations may then be compressed to make bi-layer tablets wherein about 75% of each tablet may be sustained release formulation and about 25% of each tablet may be immediate release formulation. The tablets may be any dosage strength, size, or shape. In a preferred embodiment, 1200 mg tablets are round and about 5/8 inch in diameter, about 0.31 inch - 0.34 inch in thickness, weigh about 15.3 grams and have a hardness range of about 15-35 SCU. In another preferred embodiment, 600 mg tablets are round and about 1/2 inch in diameter, about 0.22 inch – 0.26 inch in thickness, weigh about 7.65 grams and have a hardness range of about 15-65 SCU.

[0131] The immediate release portion of the bi-layer tablet is formulated to dissolve in aqueous media of low pH, such as that found in the stomach, to quickly release the guaifenesin contained within the portion. This results in rapid bioavailability of a high concentration of guaifenesin. As demonstrated in Example 6 and Figures 9 and 10 below, the immediate release portion of the bi-layer tablet results in a maximum serum concentration ($C_{\max}$) and time of maximum serum concentration ($T_{\max}$) equivalent to the $C_{\max}$ obtained when the first of three doses of a standard immediate release formulation having one third the amount of guaifenesin is dosed every four hours over a 12 hour period.

[0132] The sustained release portion gels when exposed to media of low pH allowing the sustained release portion of the tablet to be passed into the intestinal tract. In the intestines, the gelled sustained release portion is exposed to a higher pH environment, causing the gel to slowly dissolve, thereby allowing guaifenesin to diffuse and dissolve out of the gelled matrix. This results in controlled bioavailability over an extended time period (*i.e.* eight to twelve or more hours) causing the tablet to provide extended therapeutic effect. As shown in Example 6 and Figures 9 and 10, the half-life of the modified release bi-layer tablet is increased to more than 3 hours and the tablet has an AUC_{inf} (the area under a plasma concentration versus time curve from time 0 to infinity) of greater than 8000 hr-ng/mL.

[0133] As demonstrated in Example 7 and Figure 11, the bi-layer tablets of the invention had a further surprising result in that a 600 mg tablet had a $T_{\max}$ equivalent to that of a 1200 mg and a $C_{\max}$ and AUC_{inf} approximately half of a 1200 mg tablet. Thus, without adjusting or changing the composition of the sustained release formulation or bi-layer tablet, a lower dosage strength guaifenesin tablet of the invention exhibits a plasma concentration profile that is approximately directly proportional to that of a higher dosage strength guaifenesin tablet. As further demonstrated in Example 7 and Figure 11, the bi-layer tablets resulted in that the $C_{\max}$ and AUC_{inf} of a 1200 mg tablet administered to volunteers who had been fasting and the $C_{\max}$ and AUC_{inf} of a 1200 mg tablet administered to volunteers who had consumed a high fat meal were approximately equivalent. Thus, a bi-layer tablet of the invention demonstrates a reduced food effect, being approximately equally effective when administered to a patient on an empty or full stomach. Similar results were obtained for combination formulations for instance as described in Examples 8-21.

[0134] Several combination formulations were also compared to commercial drugs for bioavailability. For instance, Example 8 shows three batches of the 1200 mg guaifenesin/ 60 mg dextromethorphan HBr which were dissolved to determine the amount of dextromethorphan HBr released over time. Generally, the formulations had 1200 mg of guaifenesin and 60 mg dextromethorphan HBr and were studied over a 12 hour period. The released amount of dextromethorphan HBr was determined as a weight percent of dissolved dextromethorphan in contrast to the total weight of dextromethorphan prior to dissolution. After 1 hour about 46% to 47% of the dextromethorphan had dissolved. After 2 hours the about 59% to 60% had dissolved, after 6 hours 73% to 76% had dissolved, and after 12 hours about 86% to 89% by weight of the dextromethorphan had dissolved. Thus, the formulations of the invention reproducibly release dextromethorphan over time. (see, Figure 12). While, example 9, for instance demonstrates the *in vivo* bioavailability of a sustained release guaifenesin with dextromethorphan.

[0135] Various combination guaifenesin/pseudoephedrine compositions were also examined to determine their dissolution rates and bioavailability. Examples 10 and 11, provide a formulations of guaifenesin and pseudoephedrine in the sustained release portion of a bi-layered tablet. Results demonstrated that combining the drugs into a single tablet according to methods of the invention did not effect their dissolution profile or their *in vivo* release profile.

[0136] The two prototype lots of example 12 showed similar *in vitro* release to market Mucinex™ and Sudafed®. In particular, Formulation B (lot PB01-K61) produced optimal bioavailability for both guaifenesin and pseudoephedrine and was therefore used in subsequent bioavailability studies.

[0137] Example 13 compared combination products for guaifenesin/pseudoephedrine HCL) of 1200/120 mg strength, Formulation B (lot PB01-M65A2) and of 600/60 mg strength, Formulation C (lot PB01-A12A) to commercial Mucinex™ and Sudafed® 12 Hour. The 1200/120 mg strength showed bioequivalence for ratios of both C_{max} and AUC_{inf} with a 90% confidence interval, which is contained in the 80-125% range. Further, the 600/60 mg strength demonstrated proportional dosage pharmacokinetics.

[0138] Example 14 compared reference Mucinex™ and Sudafed® 12 Hour to a 1200/120 mg strength test formulation (lot PB01-M65A3) for steady-state bioavailability in an 11 day twice-daily dose regime. The test formulation was bioequivalent (within the 80-125% range with a 90% confidence interval) when compared to the reference formulation. Therefore, for both guaifenesin and pseudoephedrine, the steady state for C_{max} and AUC_{ss} were bioequivalent.

[0139] Examples 15 and 17 compared the effect of a high fat meal for both reference formulations and combination formulations of the invention. The test formulation (lot PB01-M65) was not bioequivalent with regard to C_{max} for guaifenesin but was for the pseudoephedrine portion when compared to the reference. However, the AUC_{inf} was bioequivalent for both guaifenesin and pseudoephedrine within the 80-125% range.

[0140] Example 16 compared single-dose relative bioavailability and interaction potential of guaifenesin and pseudoephedrine administered as Mucinex™ and

Sudafed® 12 Hour alone or in combination. The results demonstrate that the pharmacokinetics of guaifenesin and pseudoephedrine are unaffected with regard to both AUC_{inf} and C_{max} in the presence or absence of one another (ratios within 80-125%). This further confirms the results of the other examples which demonstrate bioequivalence for the combination formulations of the invention.

[0141] Example 18 compared the bioavailability of guaifenesin and dextromethorphan from an experimental formulation containing both guaifenesin and dextromethorphan as compared to reference guaifenesin and dextromethorphan. The pharmacokinetics of guaifenesin and dextromethorphan were not affected by the presence of the other component and the pharmacokinetics of dextromethorphan were linear over the range studied.

[0142] Example 19 compared the relative bioavailability of guaifenesin and dextromethorphan from an experimental formulation, containing both guaifenesin and dextromethorphan, as compared to reference guaifenesin and dextromethorphan. The guaifenesin in the experimental tablet was clearly bioequivalent to that of the Reference, Mucinex, in terms of C_{max} , AUC_{0-t} or AUC_{inf} . Dextromethorphan hydrobromide in the experimental tablet was also found to be bioequivalent to both 30 mg dextromethorphan hydrobromide every 6 hours, and 20 mg every 4 hours, in terms of C_{max} , AUC_{0-t} or AUC_{inf} .

[0143] Example 20 compared the relative bioavailability of guaifenesin and dextromethorphan from an experimental formulation containing both guaifenesin and dextromethorphan following the consumption of a high fat meal as compared to following an overnight fast. There was no food effect on the absorption of guaifenesin from the experimental tablet. There was an effect of food on the rate of absorption of dextromethorphan from the experimental tablet formulation (a small increase in the rate of absorption) but not on the extent of absorption.

[0144] Example 21 compared the relative bioavailability of guaifenesin and dextromethorphan from an experimental formulation containing both guaifenesin and dextromethorphan, as compared to reference guaifenesin and dextromethorphan products. The guaifenesin in the experimental tablet was

bioequivalent to that of the Reference, Mucinex, in terms of C_{max} and AUC_{ss} within 80% to 125%. Dextromethorphan hydrobromide in the experimental tablet was bioequivalent to both 30 mg dextromethorphan hydrobromide every 6 hours, and 20 mg every 4 hours, in terms of C_{max} and AUC_{ss} within 80% to 125%.

[0145] These studies demonstrate the compositions of the invention provide systemic levels of drug over a 12-hour period. Additionally, the studies demonstrate the bioequivalence of the combination formulations.

Comparison to FDA Approved Drugs

[0146] When using drugs approved by the Food and Drug Administration (FDA), the sustained release formulation alone or in combination with an immediate release component may be formulated to mimic the blood serum profile of guaifenesin and optionally the additional drug(s) as described in the clinical documents filed with the FDA or as required by the FDA. For instance, a single dose 400 mg immediate release tablet has a C_{max} of $2,463 \pm 1033$, a T_{max} of .5, an AUC_{0-12} , $8,382 \pm 3,282$, an AUC_{inf} $8,529 \pm 3,362$, and a $T_{1/2}$ of 0.78 ± 0.09 . Alternatively, multiple doses of a 400 mg immediate release tablet has a C_{max} of $2,278 \pm 791$, a T_{max} of .5, an AUC_{0-12} $7,751 \pm 2,697$, C_{min0} 112 ± 52 , and a C_{min12} 137 ± 98 . Preferably, the formulations result in a maximum serum concentration (C_{max}) and/or time of maximum serum concentration (T_{max}) equivalent to the C_{max} obtained when the first of three doses of a standard immediate release formulation having one third the amount of guaifenesin is dosed every four hours over a 12 hour period. In other words, the sustained release formulation releases both the guaifenesin and at least one additional drug at a similar rate to the commercially available formulation, thereby providing a therapeutically effective amount of both drugs. Alternatively, the parameters may be calculated through any of the following or combinations thereof: C_{max} , C_{min} , T_{max} , AUC_{inf} , AUC_{0-t} , AUC_{ss} and $T_{1/2}$. Unless otherwise specified, all reference to AUC_{04} in the specification and claims shall refer to data which corresponds to a time (t) of

24 hours. The parameters may also be calculated from *in vivo* studies such as those presented herein where equivalence is determined from the mean and an 80-125% range with a 90% confidence level and/or one standard deviation from the mean. Alternatively, the parameters may also be calculated from *in vivo* studies such as those presented herein where equivalence is determined from the median and an 80-125% range with a 90% confidence level and/or one standard deviation from the median. Due to the extreme variability for dextromethorphan, as recognized by the FDA and the inherent variability of measuring plasma serum levels at the picogram level the equivalence is determined from the mean and a 50-150% range, more preferably the equivalence is determined from the mean and a 60-140% range, and most preferably the equivalence is determined from the mean and a 80-125% range with a 90% confidence level. Figures 31 and 32 demonstrate specification ranges for various batch compositions of the invention.

[0147] Additionally the $C_{\max}$ for either guaifenesin, the additional drug(s) or both is preferably between 80% and 125% of the FDA approved mean, more preferably between 90% and 115%, and most preferably between 95% and 115%. These ranges do not have to adjust commensurately, that is to say the mean may for instance preferably be between 90% and 125% of the FDA mean depending on the formulation. Alternatively, the low end of the $C_{\max}$ for guaifenesin is preferably greater than 640 ng/mL, more preferably 700 ng/mL, more preferably 800 ng/mL, more preferably 900 ng/mL, more preferably 1000 ng/mL, more preferably 1100 ng/mL, and most preferably 1250 ng/mL depending on the formulation. The high end of the $C_{\max}$ for guaifenesin is preferably less than 3750 ng/mL, more preferably 3500 ng/mL, more preferably 3250 ng/mL, more preferably 3000 ng/mL, more preferably 2750 ng/mL, and most preferably 2500 ng/mL depending on the formulation. For a 1200 mg tablet the range is preferably between 1000 ng/mL and 3750 ng/mL, 1200 ng/mL and 3500 ng/mL, 1350 ng/mL and 3000 ng/mL, and 1450 ng/mL and 2750 ng/mL. For a 600 mg tablet the range is preferably between 320 ng/mL and 1875 ng/mL, 400 ng/mL and 1500 ng/mL, 500 ng/mL and 1375 ng/mL, and 625 ng/mL and 1250 ng/mL.

[0148] Alternatively, the low end of the $C_{\max}$ for pseudoephedrine is preferably greater than 150 ng/mL, more preferably 175 ng/mL, more preferably 200 ng/mL, and most preferably 250 ng/mL depending on the formulation. The high end of the $C_{\max}$ for pseudoephedrine is preferably less than 500 ng/mL, more preferably 450 ng/mL, more preferably 400 ng/mL, and most preferably 375 ng/mL depending on the formulation. For a 120 mg tablet the range is preferably between 150 ng/mL and 500 ng/mL, 175 ng/mL and 500 ng/mL, 200 ng/mL and 450 ng/mL, 250 ng/mL and 400 ng/mL, and 300 ng/mL and 375 ng/mL. For a 60 mg tablet the range is preferably between 75 ng/mL and 250 ng/mL, 88 ng/mL and 250 ng/mL, 100 ng/mL and 225 ng/mL, 125 ng/mL and 200 ng/mL, and 150 ng/mL and 188 ng/mL.

[0149] Alternatively, the low end of the $C_{\max}$ for dextromethorphan is preferably greater than 3840 pg/mL, more preferably 5,500 pg/mL, more preferably 6,600 pg/mL, more preferably 7,000 pg/mL, more preferably 7,700 pg/mL, more preferably 8,000 pg/mL, more preferably 8,800 pg/mL, more preferably 9,900 pg/mL, and most preferably 10,000 pg/mL depending on the formulation. The high end of the $C_{\max}$ for dextromethorphan is preferably less than 22,500 pg/mL, more preferably 16,500 pg/mL, more preferably 15,400 pg/mL, more preferably 14,300 pg/mL, more preferably 13,200 pg/mL, and most preferably 12,100 pg/mL depending on the formulation. For a 60 mg tablet the range is preferably between 9,600 pg/mL and 15,000 pg/mL, 10,800 pg/mL and 13,500 pg/mL, 10,800 pg/mL and 12,000 pg/mL, and 12,000 pg/mL and 13,500 pg/mL. For a 30 mg tablet the range is preferably between 7,200 pg/mL and 11,250 pg/mL, 8,100 pg/mL and 10,125 pg/mL, 8,100 pg/mL and 9,000 pg/mL, and 9,000 pg/mL and 10,125 pg/mL. In an alternative embodiment the low end of the $C_{\max}$ for dextromethorphan is preferably greater than 1300 pg/mL, more preferably 1,550 pg/mL, more preferably 1,860 pg/mL, more preferably 2,170 pg/mL, more preferably 2,480 pg/mL, and most preferably 2,790 pg/mL depending on the formulation. The high end of the $C_{\max}$ for dextromethorphan is preferably less than 5,400 pg/mL, more preferably 4,650 pg/mL, more preferably 4,350 pg/mL,

more preferably 4,000 pg/mL, more preferably 3,750 pg/mL, and most preferably 3,400 pg/mL depending on the formulation.

[0150] The $C_{\min}$ is another aspect which is often not met by various extended release drugs found on the market. Formulations of the invention provide a $C_{\min}$ which maintains its therapeutic effectiveness for a period of at least 10 hours, more preferably 12 hours and most preferably 14 or more hours. Additionally the $C_{\min}$ for either guaifenesin, the additional drug(s) or both is preferably between 80% and 125% of the FDA approved mean, more preferably between 90% and 115%, and most preferably between 95% and 115%. These ranges do not have to adjust commensurately, that is to say the mean may for instance preferably be between 90% and 125% of the FDA mean depending on the formulation. Alternatively, the low end of the $C_{\min}$ for guaifenesin is preferably greater than 40 ng/mL, more preferably 50 ng/mL, more preferably 60 ng/mL, and most preferably 70 ng/mL depending on the formulation. The high end of the $C_{\min}$ for guaifenesin is preferably less than 200 ng/mL, more preferably 175 ng/mL, more preferably 150 ng/mL, and most preferably 125 ng/mL depending on the formulation. The $C_{\min}$ range for either a 1200 or a 600 mg tablet may be selected from 50 ng/mL and 150 ng/mL, 50 ng/mL and 125 ng/mL, 60 ng/mL, 125 ng/mL, 70 ng/mL and 125 ng/mL, 80 ng/mL and 125 ng/mL, between 35 ng/mL and 75 ng/mL, 40 ng/mL and 70 ng/mL, 45 ng/mL and 65 ng/mL, and 50 ng/mL and 60 ng/mL.

[0151] Alternatively, the low end of the $C_{\min}$ for pseudoephedrine is preferably greater than 75 ng/mL, more preferably 100 ng/mL, more preferably 125 ng/mL, and most preferably 150 ng/mL depending on the formulation. The high end of the $C_{\min}$ for pseudoephedrine is preferably less than 300 ng/mL, more preferably 250 ng/mL, more preferably 225 ng/mL, and most preferably 200 ng/mL depending on the formulation. The $C_{\min}$ range for either a 120 mg or 60 mg tablet may be selected from 75 ng/mL and 300 ng/mL, 100 ng/mL and 250 ng/mL, 125 ng/mL and 225 ng/mL, 150 ng/mL and 200 ng/mL.

[0152] Alternatively, the low end of the $C_{\min}$ for dextromethorphan is preferably greater than 1,250 pg/mL, more preferably 1,500 pg/mL, more preferably 1,700

pg/mL, more preferably 2,000 pg/mL, and most preferably 2,250 pg/mL. Alternatively, the high end of the $C_{\min}$ for dextromethorphan is preferably less than 3,750 pg/mL, more preferably 3,500 pg/mL, more preferably 3,250 pg/mL, more preferably 3,000 pg/mL, and most preferably 2,750 pg/mL depending on the formulation. Alternatively, the $C_{\min}$ range for a 60 mg tablet may be selected from 7,200 pg/mL and 11,250 pg/mL, 8,100 pg/mL and 10,125 pg/mL, 8,100 pg/mL and 9,000 pg/mL, and 9,000 pg/mL and 10,125 pg/mL. The $C_{\min}$ range for a 30 mg tablet may be selected from 5,400 pg/mL and 8,400 pg/mL, 6,075 pg/mL and 7,600 pg/mL, 6,075 pg/mL and 6,750 pg/mL, and 6,750 pg/mL and 7,600 pg/mL. In another embodiment the low end of the $C_{\min}$ for dextromethorphan is preferably greater than 1,050 pg/mL, more preferably 1,250 pg/mL, more preferably 1,450 pg/mL, more preferably 1,650 pg/mL, and most preferably 1,850 pg/mL. The high end of the $C_{\min}$ for dextromethorphan is preferably less than 3,150 pg/mL, more preferably 2,950 pg/mL, more preferably 2,700 pg/mL, more preferably 2,500 pg/mL, and most preferably 2,300 pg/mL depending on the formulation.

[0153] Formulations of the invention provide a $T_{\max}$ for either guaifenesin, the additional drug(s) or both which is preferably between 80% and 125% of the FDA approved mean, more preferably between 90% and 115%, and most preferably between 95% and 115%. These ranges do not have to adjust commensurately, that is to say the mean may for instance preferably be between 90% and 125% of the FDA mean depending on the formulation. Alternatively, the low end of the $T_{\max}$ for guaifenesin is preferably greater than 0.6 hours, more preferably 0.8 hours, more preferably 0.9 hours, more preferably 1.0 hours, and most preferably 1.1 hours depending on the formulation. The high end of the $T_{\max}$ for guaifenesin is preferably less than 3.0 hours, more preferably 2.5 hours, more preferably 2.25 hours, and most preferably 2 hours depending on the formulation. The $T_{\max}$ range may also be selected from between 0.6 hours and 3.0 hours, 0.8 hours and 2.5 hours, 0.9 hours and 2.25 hours, 1.0 hours and 2 hours, and 1.1 hours and 2 hours.

[0154] Alternatively, the low end of the $T_{\max}$ for pseudoephedrine is preferably greater than 3.75 hours, more preferably 4.0 hours, more preferably 4.25 hours, more preferably 4.5 hours, and most preferably 4.75 hours depending on the formulation. The high end of the $T_{\max}$ for pseudoephedrine is preferably less than 9.0 hours, more preferably 8.5 hours, more preferably 8.0 hours, and most preferably 7.5 hours depending on the formulation. The $T_{\max}$ range may also be selected from between 3.75 hours and 9.0 hours, 4.0 hours and 8.5 hours, 4.25 hours and 8.0 hours, 4.5 hours and 7.5 hours, and 4.75 hours and 7.5 hours.

[0155] Alternatively, the low end of the $T_{\max}$ for dextromethorphan is preferably greater than 3.3 hours, more preferably 3.9 hours, more preferably 4.6 hours, more preferably 5.2 hours, and most preferably 5.85 hours depending on the formulation. The high end of the $T_{\max}$ for dextromethorphan is preferably less than 10.6 hours, more preferably 9.8 hours, more preferably 9.1 hours, more preferably 8.8 hours, more preferably 8.5 hours, more preferably 7.8 hours and most preferably 7.2 hours depending on the formulation. The $T_{\max}$ range may also be selected from between 6.2 hours and 9.7 hours, 6.7 hours and 8.8 hours, 6.7 hours and 7.75 hours, and 7.75 hours and 8.8 hours for a 60 mg tablet. The $T_{\max}$ range may also be selected from between 4.6 hours and 7.25 hours, 5.2 hours and 6.5 hours, 5.2 hours and 5.8 hours, and 5.8 hours and 6.5 hours for a 30 mg tablet.

[0156] Formulations of the invention provide a AUC_{inf} for either guaifenesin, the additional drug(s) or both which is preferably between 80% and 125% of the FDA approved mean, more preferably between 90% and 115%, and most preferably between 95% and 115%. These ranges do not have to adjust commensurately, that is to say the mean may for instance preferably be between 90% and 125% of the FDA mean depending on the formulation. Alternatively, the low end of the AUC_{inf} for guaifenesin is preferably greater than 4,000 hr-ng/mL, more preferably 5,000 hr-ng/mL, more preferably 5,500 hr-ng/mL, and most preferably 6,000 hr-ng/mL depending on the formulation. The high end of the AUC_{inf} for guaifenesin is preferably less than 12,500 hr-ng/mL, more preferably 10,000 hr-ng/mL, more preferably 9,500 hr-ng/mL, and most

preferably 9,000 hr-ng/mL depending on the formulation. For a 1200 mg tablet the AUC_{inf} range may be selected from between 4,000 hr-ng/mL and 12,500 hr-ng/mL, 5,000 hr-ng/mL and 10,000 hr-ng/mL, 5,500 hr-ng/mL and 9,500 hr-ng/mL, and 6,000 hr-ng/mL and 9,000 hr-ng/mL. For a 600 mg tablet the AUC_{inf} range may be selected from between 2,000 hr-ng/mL and 6,250 hr-ng/mL, 2,500 hr-ng/mL and 5,000 hr-ng/mL, 2,250 hr-ng/mL and 4,750 hr-ng/mL, and 3,000 hr-ng/mL and 4,500 hr-ng/mL.

[0157] Alternatively, the low end of the AUC_{inf} for pseudoephedrine is preferably greater than 2,500 hr-ng/mL, more preferably 2,800 hr-ng/mL, more preferably 3,500 hr-ng/mL, and most preferably 3,750 hr-ng/mL depending on the formulation. The high end of the AUC_{inf} for pseudoephedrine is preferably less than 6,000 hr-ng/mL, more preferably 5,800 hr-ng/mL, more preferably 5,500 hr-ng/mL, and most preferably 5,000 hr-ng/mL depending on the formulation. For a 120 mg tablet the AUC_{inf} may be selected from between 2,500 hr-ng/mL and 6,000 hr-ng/mL, 2,800 hr-ng/mL and 5,800 hr-ng/mL, 3,500 hr-ng/mL and 5,500 hr-ng/mL, and 3,750 hr-ng/mL and 5,000 hr-ng/mL. For a 60 mg tablet the AUC_{inf} may be selected from between 1,250 hr-ng/mL and 3,000 hr-ng/mL, 1,400 hr-ng/mL and 2,900 hr-ng/mL, 1,750 hr-ng/mL and 2,750 hr-ng/mL, and 1,875 hr-ng/mL and 2,500 hr-ng/mL.

[0158] Alternatively, the low end of the AUC_{inf} for dextromethorphan is preferably greater than 55,200 hr-ng/mL, more preferably 145,000 hr-ng/mL, more preferably 174,000 hr-ng/mL, more preferably 192,000 hr-ng/mL, more preferably 203,000 hr-ng/mL, more preferably 216,000 hr-ng/mL, more preferably 232,000 hr-ng/mL, more preferably 240,000 hr-ng/mL, and most preferably 261,000 hr-ng/mL depending on the formulation. The high end of the AUC_{inf} for dextromethorphan is preferably less than 587,500 hr-ng/mL, more preferably 435,000 hr-ng/mL, more preferably 405,000 hr-ng/mL, more preferably 400,000 hr-ng/mL, more preferably 377,000 hr-ng/mL, more preferably 360,000 hr-ng/mL, more preferably 348,000 hr-ng/mL, and most preferably 320,000 hr-ng/mL depending on the formulation. For a 60 mg tablet the AUC_{inf} may be selected from between 256,000 hr-ng/mL and 400,000 hr-

ng/mL, 288,000 hr-ng/mL and 360,000 hr-ng/mL, 288,000 pg/mL and 320,000 hr-ng/mL, and 320,000 hr-ng/mL and 360,000 hr-ng/mL. For a 30 mg tablet the AUC_{inf} may be selected from between 192,000 hr-ng/mL and 300,000 hr-ng/mL, 216,000 hr-ng/mL and 270,000 hr-ng/mL, 216,000 hr-ng/mL and 240,000 hr-ng/mL, and 240,000 hr-ng/mL and 270,000 hr-ng/mL. In another embodiment the low end of the AUC_{inf} for dextromethorphan is preferably greater than 15,000 hr-ng/mL, more preferably 18,000 hr-ng/mL, more preferably 21,000 hr-ng/mL, more preferably 24,000 hr-ng/mL, and most preferably 27,000 hr-ng/mL depending on the formulation. The high end of the AUC_{inf} for dextromethorphan is preferably less than 46,900 hr-ng/mL, more preferably 45,000 hr-ng/mL, more preferably 42,000 hr-ng/mL, more preferably 39,000 hr-ng/mL, more preferably 36,000 hr-ng/mL, and most preferably 33,000 hr-ng/mL depending on the formulation.

[0159] Formulations of the invention provide a AUC_{0-t} for either guaifenesin, the additional drug(s) or both which is preferably between 80% and 125% of the FDA approved mean, more preferably between 90% and 115%, and most preferably between 95% and 115%. These ranges do not have to adjust commensurately, that is to say the mean may for instance preferably be between 90% and 125% of the FDA mean depending on the formulation. Alternatively, the low end of the AUC_{0-t} for guaifenesin is preferably greater than 3,200 hr-ng/mL, more preferably 3,700 hr-ng/mL, more preferably 4,000 hr-ng/mL, and most preferably 4,500 hr-ng/mL depending on the formulation. The high end of the AUC_{0-t} for guaifenesin is preferably less than 11,250 hr-ng/mL, more preferably 10,500 hr-ng/mL, more preferably 9,500 hr-ng/mL, more preferably 9,000 hr-ng/mL, and most preferably 8,500 hr-ng/mL depending on the formulation. For a 1200 mg tablet the AUC_{0-t} may be selected from between 3,200 hr-ng/mL and 11,250 hr-ng/mL, 3,700 hr-ng/mL and 10,500 hr-ng/mL, 4,000 hr-ng/mL and 9,500 hr-ng/mL, 4,250 hr-ng/mL and 9,000 hr-ng/mL, and 4,500 hr-ng/mL and 8,500 hr-ng/mL. For a 600 mg tablet the AUC_{0-t} may be selected from between 1,600 hr-ng/mL and 5,625 hr-ng/mL, 1,850 hr-ng/mL and

5,250 hr-ng/mL, 2,000 hr-ng/mL and 4,750 hr-ng/mL, 2,125 hr-ng/mL and 4,500 hr-ng/mL, and 2,250 hr-ng/mL and 4,250 hr-ng/mL.

[0160] Alternatively, the low end of the AUC_{0-t} for pseudoephedrine is preferably greater than 2,000 hr-ng/mL, more preferably 2,200 hr-ng/mL, more preferably 2,500 hr-ng/mL, and most preferably 2,800 hr-ng/mL depending on the formulation. The high end of the AUC_{0-t} for pseudoephedrine is preferably less than 6,000 hr-ng/mL, more preferably 5,750 hr-ng/mL, more preferably 5,500 hr-ng/mL, more preferably 5,250 hr-ng/mL, and most preferably 5,000 hr-ng/mL depending on the formulation. For a 120 mg tablet the AUC_{0-t} may be selected from between 2,000 hr-ng/mL and 6,000 hr-ng/mL, 2,200 hr-ng/mL and 5,750 hr-ng/mL, 2,500 hr-ng/mL and 5,500 hr-ng/mL, 2,700 hr-ng/mL and 5,250 hr-ng/mL, and 2,800 hr-ng/mL and 5,000 hr-ng/mL. For a 60 mg tablet the AUC_{0-t} may be selected from between 1,000 hr-ng/mL and 3,000 hr-ng/mL, 1,100 hr-ng/mL and 2,875 hr-ng/mL, 1,250 hr-ng/mL and 2,750 hr-ng/mL, 1,350 hr-ng/mL and 2,625 hr-ng/mL, and 1,400 hr-ng/mL and 2,500 hr-ng/mL.

[0161] Alternatively, the low end of the AUC_{0-t} for dextromethorphan is preferably greater than 59,000 hr-ng/mL, more preferably 119,000 hr-ng/mL, more preferably 143,000 hr-ng/mL, more preferably 162,000 hr-ng/mL, more preferably 166,000 hr-ng/mL, more preferably 182,000 hr-ng/mL, more preferably 190,000 hr-ng/mL, more preferably 202,000 hr-ng/mL, and most preferably 214,000 hr-ng/mL depending on the formulation. The high end of the AUC_{0-t} for dextromethorphan is preferably less than 475,000 hr-ng/mL, more preferably 360,000 hr-ng/mL, more preferably 337,500 hr-ng/mL, more preferably 333,000 hr-ng/mL, more preferably 309,000 hr-ng/mL, more preferably 300,000 hr-ng/mL, more preferably 286,000 hr-ng/mL, more preferably 270,000 hr-ng/mL, and most preferably 262,000 hr-ng/mL depending on the formulation. For a 60 mg tablet the AUC_{0-t} may be selected from between 216,000 hr-ng/mL and 337,500 hr-ng/mL, 243,000 hr-ng/mL and 300,000 hr-ng/mL, 243,000 hr-ng/mL and 270,000 hr-ng/mL, and 270,000 hr-ng/mL and 300,000 hr-ng/mL. For a 30 mg tablet the AUC_{0-t} may be selected from between 162,000 hr-ng/mL and 250,000 hr-ng/mL, 182,000 hr-ng/mL and 230,000 hr-

ng/mL, 182,000 hr-ng/mL and 202,000 hr-ng/mL, and 202,000 hr-ng/mL and 230,000 hr-ng/mL. In another embodiment the low end of the AUC_{0-t} for dextromethorphan is preferably greater than 15,000 hr-ng/mL, more preferably 18,000 hr-ng/mL, more preferably 21,000 hr-ng/mL, more preferably 24,000 hr-ng/mL, and most preferably 27,000 hr-ng/mL depending on the formulation. The high end of the AUC_{0-t} for dextromethorphan is preferably less than 47,300 hr-ng/mL, more preferably 45,000 hr-ng/mL, more preferably 42,000 hr-ng/mL, more preferably 39,000 hr-ng/mL, more preferably 36,000 hr-ng/mL, and most preferably 33,000 hr-ng/mL depending on the formulation.

[0162] Formulations of the invention provide a AUC_{ss} for either guaifenesin, the additional drug(s) or both which is preferably between 80% and 125% of the FDA approved mean, more preferably between 90% and 115%, and most preferably between 95% and 115%. These ranges do not have to adjust commensurately, that is to say the mean may for instance preferably be between 90% and 125% of the FDA mean depending on the formulation. Alternatively, the low end of the AUC_{ss} for guaifenesin is preferably greater than 5000 hr-ng/mL, more preferably 5600 hr-ng/mL, more preferably 6000 hr-ng/mL, and most preferably 6500 hr-ng/mL depending on the formulation. The high end of the AUC_{ss} for guaifenesin is preferably less than 9000 hr-ng/mL, more preferably 8750 hr-ng/mL, more preferably 8250 hr-ng/mL, and most preferably 8000 hr-ng/mL depending on the formulation. The AUC_{ss} for a 1200 mg tablet may be selected from between 5000 hr-ng/mL and 9000 hr-ng/mL, 5600 hr-ng/mL and 8750 hr-ng/mL, 6000 hr-ng/mL and 8000 hr-ng/mL, and 6500 hr-ng/mL and 8250 hr-ng/mL. The AUC_{ss} for a 600 mg tablet may be selected from between 2,500 hr-ng/mL and 4,500 hr-ng/mL, 2,800 hr-ng/mL and 4,375 hr-ng/mL, 3,000 hr-ng/mL and 4,000 hr-ng/mL, and 3,250 hr-ng/mL and 4,125 hr-ng/mL.

[0163] Alternatively, the low end of the AUC_{ss} for pseudoephedrine is preferably greater than 2,100 hr-ng/mL, more preferably 2,400 hr-ng/mL, more preferably 2,650 hr-ng/mL, and most preferably 2,800 hr-ng/mL depending on the formulation. The high end of the AUC_{ss} for pseudoephedrine is preferably less

than 5,500 hr-ng/mL, more preferably 5,000 hr-ng/mL, more preferably 4,500 hr-ng/mL, and most preferably 4,000 hr-ng/mL depending on the formulation. The AUC_{ss} for a 120 mg tablet may be selected from between 2,100 hr-ng/mL and 5,500 hr-ng/mL, 2,400 hr-ng/mL and 5,000 hr-ng/mL, 2,650 hr-ng/mL and 4,500 hr-ng/mL, and 2,800 hr-ng/mL 4,000 hr-ng/mL. The AUC_{ss} for a 60 mg tablet may be selected from between 1,050 hr-ng/mL and 2,250 hr-ng/mL, 1,200 hr-ng/mL and 2,500 hr-ng/mL, 1,325 hr-ng/mL and 2,250 hr-ng/mL, and 1,400 hr-ng/mL 2,000 hr-ng/mL.

[0164] Alternatively, the low end of the AUC_{ss} for dextromethorphan is preferably greater than 87,750 hr-ng/mL, more preferably 105,000 hr-ng/mL, more preferably 120,000 hr-ng/mL, more preferably 132,000 hr-ng/mL, more preferably 140,000 hr-ng/mL, and most preferably 158,000 hr-ng/mL depending on the formulation. The high end of the AUC_{ss} for dextromethorphan is preferably less than 263,000 hr-ng/mL, more preferably 245,000 hr-ng/mL, more preferably 228,000 hr-ng/mL, more preferably 220,000 hr-ng/mL, more preferably 210,000 hr-ng/mL, more preferably 197,000 hr-ng/mL, and most preferably 193,000 hr-ng/mL depending on the formulation. The AUC_{ss} for a 60 mg tablet may be selected from between 140,000 hr-ng/mL and 220,000 hr-ng/mL, 157,500 hr-ng/mL and 197,000 hr-ng/mL, 157,500 hr-ng/mL and 175,000 hr-ng/mL, and 175,000 hr-ng/mL and 197,000 hr-ng/mL. The AUC_{ss} for a 30 mg tablet may be selected from between 105,000 hr-ng/mL and 165,000 hr-ng/mL, 120,000 hr-ng/mL and 149,000 hr-ng/mL, 120,000 hr-ng/mL and 132,000 hr-ng/mL, and 132,000 hr-ng/mL and 149,000 hr-ng/mL. In another embodiment the low end of the AUC_{ss} for dextromethorphan is preferably greater than 19,000 hr-ng/mL, more preferably 22,800 hr-ng/mL, more preferably 26,600 hr-ng/mL, more preferably 30,500 hr-ng/mL, and most preferably 34,000 hr-ng/mL depending on the formulation. The high end of the AUC_{ss} for dextromethorphan is preferably less than 57,000 hr-ng/mL, more preferably 53,000 hr-ng/mL, more preferably 49,500 hr-ng/mL, more preferably 45,600 hr-ng/mL, and most preferably 41,800 hr-ng/mL depending on the formulation.

[0165] Formulations of the invention provide a $T_{1/2}$ for either guaifenesin, the additional drug(s) or both which is preferably between 80% and 125% of the FDA approved mean, more preferably between 90% and 115%, and most preferably between 95% and 115%. These ranges do not have to adjust commensurately, that is to say the mean may for instance preferably be between 90% and 125% of the FDA mean depending on the formulation. Alternatively, the low end of the $T_{1/2}$ for guaifenesin is preferably greater than 0.7 hours, more preferably 0.9 hours, more preferably 1.1 hours, more preferably 1.3 hours, and most preferably 1.4 hours depending on the formulation. The high end of the $T_{1/2}$ for guaifenesin is preferably less than 7.25 hours, more preferably 6.0 hours, more preferably 5.0 hours, and most preferably 3.5 hours depending on the formulation. The $T_{1/2}$ for a 1200 mg tablet may be selected from between 0.7 hours and 7.25 hours, 0.9 hours and 6.0 hours, 1.1 hours and 5.0 hours, 1.3 hours and 3.5 hours, and 1.4 hours and 3.5 hours. The $T_{1/2}$ for a 600 mg tablet may be selected from between 0.35 hours and 3.63 hours, 0.45 hours and 3.0 hours, .55 hours and 2.5 hours, .65 hours and 1.75 hours, and .70 hours and 1.75 hours.

[0166] Alternatively, the low end of the $T_{1/2}$ for pseudoephedrine is preferably greater than 3.2 hours, more preferably 3.6 hours, more preferably 4.0 hours, more preferably 4.2 hours, and most preferably 4.5 hours depending on the formulation. The high end of the $T_{1/2}$ for pseudoephedrine is preferably less than 8.0 hours, more preferably 7.5 hours, more preferably 7.0 hours, and most preferably 6.25 hours depending on the formulation. The $T_{1/2}$ for a 120 mg tablet may be selected from between 3.2 hours and 8.0 hours, 3.6 hours and 7.5 hours, 4.0 hours and 7.0 hours, 4.2 hours and 6.25 hours, and 4.5 hours and 6.25 hours. The $T_{1/2}$ for a 60 mg tablet may be selected from between 1.60 hours and 4.0 hours, 1.80 hours and 3.75 hours, 2.0 hours and 3.5 hours, 2.1 hours and 3.13 hours, and 2.25 hours and 3.13 hours.

[0167] Alternatively, the low end of the $T_{1/2}$ for dextromethorphan is preferably greater than 4.6 hours, more preferably 5.6 hours, more preferably 6.5 hours, more preferably 7.0 hours, more preferably 7.4 hours, more preferably 7.9 hours, more preferably 8.4 hours, and most preferably 8.8 hours depending on the

formulation. The high end of the $T_{1/2}$ for dextromethorphan is preferably less than 15.75 hours, 14.7 hours, more preferably 13.0 hours, more preferably 13.0 hours, more preferably 12.1 hours, more preferably 11.75 hours, more preferably 11.2 hours, and most preferably 10.2 hours depending on the formulation. The $T_{1/2}$ for a 60 mg tablet may be selected from between 9.4 hours and 14.7 hours, 10.6 hours and 13.2 hours, 10.6 hours and 11.75 hours, and 11.75 hours and 13.2 hours. The $T_{1/2}$ for a 60 mg tablet may be selected from between 7.0 hours and 11.0 hours, 7.9 hours and 9.9 hours, 7.9 hours and 8.8 hours, and 8.8 hours and 9.9 hours.

[0168] Examples of other sustained release/immediate release formulations with and without additional drugs are discussed further in the examples which follow.

EXAMPLES

[0169] The invention is further defined by reference to the following examples describing in detail the compositions and methods of the invention. It will be apparent to those skilled in the art that many modifications, both to materials and methods, may be practiced without departing from the purpose and interest of this invention.

[0170] For the *in vivo* study portions, the following general procedures were used for sample analysis unless otherwise indicated. Blood samples (5-10 mLs with sodium heparin as anticoagulant) were taken prior to dosing and at specific intervals after dosing. All blood samples were chilled and centrifuged within 30 minutes of being drawn. The plasma was separated, transferred to a polypropylene tube, frozen at -20°C or below and stored frozen until being shipped for drug analysis. The plasma samples were then analyzed by a fully validated HPLC method. This resulting plasma concentration v. time data was subjected to pharmacokinetic analysis using non-compartmental analysis with Winnonlin 1.5.

[0171] When necessary, volunteers were then given at least a seven day washout period (where no guaifenesin was administered to them under the study) prior to being crossed-over to the next treatment group. Generally, the subjects weighed

within 15% of their Ideal Body Weight as defined by the 1983 Metropolitan Life chart.

Example 1

[0172] A batch of sustained release guaifenesin tablets, LotNo. 7LB-31FC, with the following composition was prepared:

Components	Weight per Tablet
Guaifenesin DC	1260 mg
Methocel E10M	30 mg
Emerald Green Lake	4 mg
Magnesium Stearate	6.8 mg
Opadry Y-S-3-7413	13.01 mg

[0173] Another batch of sustained release guaifenesin tablets, Lot No. 7LB-32FC, with the following composition was prepared:

Components	Weight per Tablet
Guaifenesin DC	1260 mg
Methocel E10M	30 mg
Carbopol 974P	15 mg
Emerald Green Lake	4 mg
Magnesium Stearate	6.8 mg
Opadry Y-S-3-7413	13.16 mg

[0174] Six tablets from Lot 7LB-31FC and six tablets from Lot 7LB-32FC were tested for *in vitro* guaifenesin release using an Acid/Base dissolution (slightly modified USP 23/NF 18 <711> Drug Release using Apparatus 2). Six dissolution vessels of a USP calibrated Hanson dissolution bath, equipped with shafts and paddles, and were filled with 675 mL of 0.1N hydrochloric acid at 37.0°C. The bath and vessels were maintained at a temperature of 37.0 ± 0.5°C throughout the 12 hour dissolution test. The paddles were set to rotate at 50 RPM and slowly lowered into the vessels. One tablet of lot 7LB-31 was then dropped into each vessel.

[0175] At the one hour and two hour intervals of testing, 5 mL samples of dissolution solution were withdrawn from each vessel and filtered through a 10 micron polyethylene filter into glass HPLC vials. Immediately after the two hour samples were withdrawn, 225 mL of 0.2M sodium phosphate tribasic was

added to each vessel to increase the solution pH to about 6.8. The dissolution was run for ten additional hours, 2.0 mL samples being withdrawn from each vessel at the four, eight, 10, and 12 hour intervals. The filtered samples were then run on an HPLC to determine percent guaifenesin released.

[0176] The same dissolution testing procedure was performed for lot 7LB-32 FC.

The lots gave dissolution profiles shown below and depicted in Figure 4.

Lot 7LB-31

Vessel No.	1 hr.	2 hr.	4 hr.	8 hr.	10 hr.	12 hr.
1	26	38	55	77	84	88
2	27	39	54	75	81	86
3	22	37	50	73	78	85
4	23	33	47	64	73	79
5	25	36	52	75	81	86
6	24	35	49	74	81	87
Average	24.5	36.3	51.2	73.0	79.7	85.2

Lot 7LB-32FC

Vessel No.	1 hr.	2 hr.	4 hr.	8 hr.	10 hr.	12 hr.
1	25	36	42	54	59	64.0
2	24	35	42	55	61	66
3	26	38	45	59	65	69
4	24	35	42	54	60	65
5	24	36	43	54	59	64
6	23	34	38	50	55	59
Average	24.3	35.7	42.0	54.3	59.8	64.5

[0177] Both formulations demonstrated sustained release of guaifenesin over a 12 hour period. Lot 7LB-32FC demonstrated identical release properties to Lot 7LB-31FC in 0.1N HCl. In buffered solution, however, Lot 7LB-32FC, the lot comprising a 2:1 ratio of Methocel E10M to Carbopol 974P, demonstrated a statistically slower release than Lot 7LB-31FC, comprising Methocel E10M and no Carbopol 974P. A slower release rate *in vitro* translates to a slower, more controlled release with longer drug action *in vivo* – a favorable characteristic for pharmaceutical products containing a high concentration of an active ingredient with a short half-life (e.g. guaifenesin).

Example 2

[0178] A dissolution study was run to compare dissolution profiles of lots 7LB-32FC and 7LB-31FC with currently available guaifenesin dosage forms. One immediate release tablet, ORGANIDIN NR, and two sustained release tablets, HUMIBID L.A. and DURATUSS, were subjected to the same dissolution study as described for lots 7LB-31FC and 7LB-32FC in Example 1 above. The following is a summary of the results which are also depicted in Figure 5.

	Organidin NR % guaifenesin released	Humibid LA % guaifenesin released	Duratuss % guaifenesin released
1 hr.	100	36	24
2 hr.	103	51	35
4 hr.	104	72	47
8 hr.	103	91	75
10 hr.	103	96	86
12 hr.	105	100	92

[0179] The immediate release Organidin released 100% of guaifenesin content within the first hour of dissolution. The two commercial sustained release dosage forms demonstrated a slower release of guaifenesin. However, both the Humibid LA and Duratuss released guaifenesin more rapidly than either Lot 7LB-31FC or 7LB-32FC, particularly after the eight hour interval. Both Humibid LA and Duratuss would, therefore, exhibit a faster rate of release and thus a shorter lived therapeutic effect *in vivo*.

Example 3

[0180] The *in vivo* behavior of sustained release tablets of Lot 7LB-31FC and Lot 7LB-32FC from Example 1 were compared to the *in vivo* behavior of an immediate release formulation (Organidin NR). The open-label study involved 9 healthy volunteers averaging 38 ± 11.01 years of age with a range of 23 years to 55 years of age. The subjects weighed 175.56 ± 24.22 lbs. with a range of 143 to 210 lbs. One subject was female and the remainder was male. Each subject received either one 1200 mg dose of 7LB-31FC, 7LB-32FC or a commercial 400 mg immediate release tablet (every four hours for 3 doses).

[0181] The results of the pharmacokinetic parameters analysis are described below and depicted in Figure 6.

Subject	Formulation	T _{max} (hr.)	C _{max} (ng/mL)	AUC ₀₋₁₂ (hr-ng/mL)	T _{1/2} (hrs.)	AUC _{inf} (hr-ng/mL)
1	7LB-31FC	2.00	827.02	4817.20	4.64	6339.25
2	7LB-31FC	1.50	834.65	4695.89	2.71	5291.71
3	7LB-31FC	1.50	802.44	4142.14	3.44	4728.33
4	7LB-32FC	0.75	625.48	3034.31	5.78	5134.35
5	7LB-32FC	1.00	1052.00	5872.46	5.99	8298.33
6	7LB-32FC	2.00	1372.00	7924.35	5.53	9557.78
7	Organidin NR	0.50	2140.00	6921.94	0.86	7009.68
8	Organidin NR	4.25	18.17.00	6598.26	0.73	6674.65
9	Organidin NR	0.50	2831.00	9389.76	0.81	9570.91
Mean	7LB-31FC	1.67	821.37	4551.74	3.59	5453.10
Mean	7LB-32FC	1.25	1016.49	5610.37	5.77	7663.49
Mean	Organidin NR	1.75	2262.67	7636.65	0.80	7751.74
Ratio (%)	7LB-31FC/IR	95.43	36.30	59.60	448.27	70.35
Ratio (%)	7LB-32FC/IR	71.43	44.92	73.47	718.92	98.86

[0182] Subjects given the 1200 mg formulation 7LB-32FC reached maximum plasma guaifenesin concentrations of 1016 ng/mL in 1.25 hours and had an AUC_{inf} of 7663 hr-ng/mL. The subjects given formulation 7LB-31FC reached maximum plasma guaifenesin concentrations of 821 ng/mL in 1.67 hours and had an AUC_{inf} of 5453 hr-ng/mL. The subjects given the immediate release formulation, Organidin NR, reached maximum plasma guaifenesin concentrations of 2263 ng/mL in 1.75 hours (2 subjects peaked at 0.5 hours after the first dose and the third peaked at 0.25 hours after the second dose at 4 hours) and had an AUC_{inf} of 7752 hr-ng/mL. The two controlled release formulations demonstrated sustained release in that their half-lives were longer, 5.77 hours for the 7LB-32FC and 3.59 hours for the 7LB-31 FC compared to 0.8 hours for the immediate release formulation, Organidin NR.

[0183] Both formulations 7LB-32FC (with both Methocel E10M and Carbopol 974P) and 7LB-31FC (with Methocel E10M only) control the release of guaifenesin from the tablet compared to the immediate release Organidin NR. Formulation 7LB-32FC, the formulation containing a 6:1 ratio of Methocel

Agent's File Reference: 62808.000021

E10M to Carbopol 974P, had the longest half life at 5.77 hours with the largest AUC_{inf} between the two sustained release formulation. However, both sustained release formulations have a C_{max} less than half of the C_{max} of the immediate release Organidin NR.

Example 4

[0184] Three different sustained release tablet lots of guaifenesin alone were prepared: i) Formulation I - 1200 mg SR; ii) Formulation II - 400 mg IR and 800 mg SR; and iii) Formulation III - 600 mg IR and 600 mg SR.

Non-layered tablet (sustained release)

Formulation I

Components	Weight per Tablet
Guaifenesin DC	1260 mg
Methocel E10M	40 mg
Carbopol 974P	20 mg
Emerald Green Lake	4 mg
Magnesium Stearate	6.8 mg

Bi-layered tablets (sustained release and immediate release)

Immediate release layer

Formulation II

Formulation III

Components	Weight per Tablet	Weight per Tablet
Guaifenesin DC	421 mg	630.8 mg
Microcrystalline Cellulose (Avicel)	40 mg	353 mg
Sodium Starch Glycolate (Explotab)	60 mg	90.1 mg
Magnesium Stearate	2 mg	3 mg

Sustained release layer

Formulation II

Formulation III

Components	Weight per Tablet	Weight per Tablet
Guaifenesin DC	842 mg	630.8 mg
Methocel E10M	27 mg	40 mg
Carbopol 974P	13.5 mg	20 mg
Emerald Green Lake	3 mg	4 mg
Magnesium Stearate	4.5 mg	6.8 mg

[0185] The *in vivo* behavior of each of the three sustained release tablets and a commercial immediate release formulation (Organidin NR) were compared. The open-label study involved 15 healthy volunteers averaging 31.67 ± 11.89 years of age with a range of 20 years to 51 years of age. The subjects weighed 162.00 ± 25.05 lbs. with a range of 123 to 212 lbs. All 15 subjects were administered 400 mg of the immediate release formulation every 4 hours for a total of 12 hours in on one day. On another day, 5 subjects were administered Sustained Formulation I, another 5 subjects were administered Sustained Formulation II, and yet another 5 subjects were administered Sustained Formulation III.

[0186] The results of the pharmacokinetic parameters analysis are described below and depicted in Figure 7.

	Formulation	T _{max} (hr.)	C _{max} (ng/mL)	AUC ₀₋₁₂ (hr-ng/mL)	T _{1/2} (hrs.)	AUC _{inf} (hr-ng/mL)
Mean	Organidin NR	0.90	2609.40	8768.40	1.28	9082.78
Mean	Formulation I	2.30	1631.40	5549.30	2.88	6044.93
Mean	Formulation II	2.30	2415.40	7304.38	1.48	7509.78
Mean	Formulation III	1.95	2938.00	8904.62	2.05	9161.03

[0187] Sustained Formulations II and III exhibited a C_{max} more comparable to the immediate release formulation and an increased AUC_{inf} from that of the non-layered Sustained Formulation I. The half-lives of both Sustained Formulation II and III were reduced from the half-life of Sustained Formulation I. These bi-layer tablets, however, showed an improved serum concentration of guaifenesin and an increased overall concentration with time.

Example 5

[0188] A dissolution study was run to compare dissolution profiles of Formulation I, Formulation II and Formulation III prepared as defined in Example 4 above, and Formulation IV, a bi-layer tablet lot with 200 mg IR and 1000 mg SR prepared with the following composition:

Agent's File Reference: 62808.000021

Immediate release layerFormulation IV

Components	Weight per Tablet
Guaifenesin DC	211 mg
Microcrystalline Cellulose (Avicel)	118 mg
Sodium Starch Glycolate (Explotab)	30 mg
Magnesium Stearate	1 mg

Sustained release layerFormulation IV

Components	Weight per Tablet
Guaifenesin DC	1053 mg
Methocel E10M	25 mg
Carbopol 974P	12.5 mg
Emerald Green Lake	3.3 mg
Magnesium Stearate	5.7 mg

The following is a summary of the results which are also depicted in Figure 8.

	Formulation I % released	Formulation II % released	Formulation III % released	Formulation IV % released
1 hr.	22	45	38	29
2 hr.	34	54	46	38
4 hr.	43	65	56	48
6 hr.	50	70	61	53
8 hr.	58	73	66	60
10 hr.	62	78	70	66
12 hr.	66	81	75	71

[0189] Formulation I, the non bi-layered tablet, demonstrated the slowest release of guaifenesin. Formulation II and Formulation III had the fastest rates of release and would, therefore, exhibit a faster rate of release and thus a shorter lived therapeutic effect *in vivo*. Formulation IV has a rate of release which was faster than Formulation I, comprising no immediate release blend, but slower than Formulation II and Formulation III, both comprising more immediate release blend than Formulation IV.

Example 6

[0190] The *in vivo* behavior of Formulation IV bi-layered tablets, prepared as described above in Example 5, was compared to an immediate release formulation (Organidin NR). The open-label, multiple dose, randomized, 2-way crossover study involved 26 healthy volunteers averaging 31.31 ± 9.81 years of age with a range of 19 years to 50 years of age. The subjects weighed 166.77 ± 29.83 lbs. The subjects were placed into one of two treatment groups. Group 1 received Formulation IV tablet with 240 mL of water after an overnight fast every 12 hours for 5 days and a single dose on day 6. Group 2 received 400 mg of Organidin NR (2 x 200 mg tablets) with 240 mL of water every 4 hours for 5 days and one 400 mg dose every four hours for a total of 3 doses on day 6.

[0191] Blood samples (5 mL with sodium heparin as anticoagulant) were taken prior to dosing on days 1, 4, 5, and 6. On Day 1, additional blood samples (5 mL with sodium heparin as anticoagulant) were also obtained at 0.5, 0.75, 1, 1.5, 2, 3, 4, 4.5, 4.75, 5, 5.5, 6, 7, 8, 8.5, 8.75, 9, 9.5, 10, 11, and 12 hours after the initial dose. On Day 6, additional blood samples (5 mL with sodium heparin as anticoagulant) were also obtained at 0.5, 0.75, 1, 1.5, 2, 3, 4, 4.5, 4.75, 5, 5.5, 6, 7, 8, 8.5, 8.75, 9, 9.5, 10, 11, 12, 14, 16, and 24 hours after the initial dose.

[0192] The results of the pharmacokinetic parameters analysis are below.

Averaged Testing – 11 Twelve-Hour Intervals

	Formulation	T _{max} (hr.)	C _{max} (ng/mL)	AUC ₀₋₁₂ (hr-ng/mL)	T _{1/2} (hrs.)	AUC _{inf} (hr-ng/mL)
Mean	Organidin NR	1.69	2463.20	8381.93	0.78	8528.51
Mean	Formulation IV	1.05	2111.38	7875.68	3.31	8686.08

The results of the testing are depicted in Figure 9.

Steady State Testing

	Formulation	T _{max} (hr.)	C _{max} (ng/mL)	AUC ₀₋₁₂ (hr-ng/mL)	T _{1/2} (hrs.)	AUC _{inf} (hr-ng/mL)
Mean	Organidin NR	2.03	2278.20	7751.23	0.88	7962.14
Mean	Formulation IV	0.86	2349.6	8202.47	3.61	9259.24

[0193] The results of the testing are depicted in Figure 10.

[0194] The 200/1000 mg bi-layered tablet exhibited a $C_{\max}$ and a $AUC_{\inf}$ equivalent to that of the immediate release blend, a short $T_{\max}$ and an extended half-life. Thus, a bi-layered tablet with 200 mg guaifenesin in the immediate release formulation and 1000 mg of guaifenesin in the sustained release formulation results in a tablet which delivers a high serum concentration in a short period of time, yet maintains an effective concentration of guaifenesin in the blood stream for a full twelve hours.

Example 7

[0195] A study was performed to examine the relative bioavailability of two different dosage strengths of modified release guaifenesin formulations of the invention as well as the effect of food on the relative bioavailability of a guaifenesin formulation of the invention in normal, healthy male and/or female volunteers. Two batches of guaifenesin bi-layer tablets, one 600 mg and one 1200 mg, were prepared.

Immediate release layer

	<u>600 mg Tablet</u>	<u>1200 mg Tablet</u>
Components	Weight per 200,000 Tablets	Weight per 100,000 Tablets
Guaifenesin DC	21.05 kg	21.05 kg
Microcrystalline Cellulose (Avicel PH102)	11.75 kg	11.75 kg
Sodium Starch Glycolate (Explotab)	3.00 kg	3.00 kg
Magnesium Stearate	0.10 kg	0.10 kg

Sustained release layer

	<u>600 mg Tablet</u>	<u>1200 mg Tablet</u>
Components	Weight per 200,000 Tablets	Weight per 100,000 Tablets
Guaifenesin DC	105.27 kg	105.27 kg
Hydroxypropyl Methyl Cellulose (Methocel E10M)	2.50 kg	2.50 kg
Carbomer (Carbopol 974P)	1.25 kg	1.25 kg
FD&C Blue No. 1 Aluminum Lake Dye	0.33 kg	0.33 kg
Magnesium Stearate	0.57 kg	0.57 kg

[0196] The 600 mg and 1200 mg tablets were similarly prepared, the with the exception of the number of tablets produced from the amount of materials used.

[0197] The *in vivo* behaviors of a 600 mg tablet administered to volunteers in the fasting state (about 10 hours pre-dose until about 4 hours after dosing), the 1200 mg tablet administered to volunteers in the fasting state (about 10 hours pre-dose until about 4 hours after dosing), and the 1200 mg tablet administered to volunteers after a high fat meal (consumed within 30 minutes of dosing) were compared. The open-label study involved 27 healthy volunteers between the ages of 18 and 55. The 27 volunteers were divided into 3 treatment groups, 9 receiving the 600 mg tablet, 9 receiving the 1200 mg tablet while fasting, and 9 receiving a 1200 mg tablet after consuming a high fat meal for Period 1 of the trial. After completion of Period 1, the volunteers were crossed-over for Period 2 (*e.g.* so that the 9 volunteers who had been receiving the 600 mg tablet in Period 1 received the 1200 mg tablet while fasting in Period 2). After completion of Period 2, the volunteers were crossed-over again into their 3rd and final treatment group (*i.e.* the 9 volunteers who received the 1200 mg tablet while fasting in Period 2 and the 600 mg tablet while fasting in Period 1 received the 1200 mg tablet after consumption of a high fat meal in Period 3). Each volunteer was administered one dose of the appropriate tablet and then monitored over a 16 hour period.

[0198] Blood samples were taken about one hour prior to dosing and at specific intervals up to 16 hours after dosing (at 0.25, 0.5, 0.75, 1, 1.5, 2, 3, 4, 6, 8, 10, 12, 14, and 16 hours). The results of the pharmacokinetic parameters analysis are described below and in Figure 11.

	Formulation	T _{max} (hr.)	C _{max} (ng/mL)	AUC ₀₋₁₂ (hr-ng/mL)	T _{1/2} (hrs.)	AUC _{inf} (hr-ng/mL)
Mean	600 mg Fasted	0.81	1074.26	3623.03	2.33	3676.23
Mean	1200 mg Fasted	0.94	1948.62	7483.20	3.33	7912.61
Mean	1200 mg Fed	2.18	1988.08	7424.20	0.91	7425.29

[0199] The 600 mg tablet demonstrated a serum profile approximately directly proportional to the serum profile of the 1200 mg tablet. The C_{max} of the 600 mg tablet was about 55% that of the 1200 mg tablet. The AUC₀₋₁₂ of the 600 mg

tablet was about 48% that of the 1200 mg tablet and the AUC_{inf} of the 600 mg tablet was about 46% that of the 1200 mg. improved serum concentration of guaifenesin and an increased overall concentration with time, their half-life was compromised.

[0200] The 1200 mg tablet demonstrated that the bi-layer tablets of the invention greatly reduce the food effect in bioavailability and serum concentration of guaifenesin. The C_{max} of the 1200 mg tablet administered after a high fat meal (fed tablet) was about 102% of the C_{max} of the 1200 mg tablet administered after fasting (fasted tablet). The AUC_{0-12} of the 1200 mg fed tablet was about 99% that of the fasted tablet and the AUC_{inf} of the 1200 mg fed tablet was about 94% that of the fasted tablet.

Example 8

[0201] In an example of a combination drug formulation, two batches of guaifenesin/dextromethorphan HBr bi-layer tablets were prepared: i) 600 mg/ 30 mg dextromethorphan and ii) 1200 mg/ 60 mg. In the 30 mg dextromethorphan tablet 7.5 mg was within the immediate release layer and 22.5 mg within the sustained release layer. The 60 mg dextromethorphan tablet comprised double the dextromethorphan respectively.

[0202] Sustained release layer

	<u>600 mg/ 30 mg</u>	<u>1200 mg/ 60 mg</u>
Components	Weight per 200,000 tablets (kg)	Weight per 100,000 tablets (kg)
Guaifenesin, USP	101.00	101.00
Dextromethorphan HBr	4.50	4.50
Carbopol 974P, NF	1.50	5.00
Microcrystalline Cellulose (Methocel E10M)	5.00	1.50
D&C Yellow No. 10 Aluminum Lake (14-18%)	0.04	0.04
Magnesium Stearate	1.00	1.0

Immediate release layer600 mg/ 30 mg1200 mg/ 60 mg

Components	Weight per 480,000 tablets (kg)	Weight per 240,000 tablets (kg)
Guaifenesin, USP	45.60	45.60
Dextromethorphan HBr	3.60	3.60
Sodium Starch Glycolate, NF (Explotab)	3.60	3.60
Microcrystalline Cellulose (Avicel PH102)	40.32	40.32
Methocel E10M, USP	2.40	2.40
Magnesium Stearate, NF	0.48	0.48

[0203] The following is a summary of 1200 mg guaifenesin/ 60 mg dextromethorphan HBr Dissolution Rate for three different batches also depicted in Figure 12.

	PB01-H30 (clinical batch) % released	PB01-H43 % released	PB01-H44 % released
1 hr	46	47	47
2 hr	59	60	61
6 hr	73	74	76
12 hr	86	87	89

[0204] The *in vivo* behavior of the 1200 mg guaifenesin and 60 mg tablet was studied by measuring the plasma concentration of guaifenesin, dextromethorphan HBr, and the metabolite dextrophan. Figures 13-15 illustrate the plasma concentration for each drug or metabolite in two formulations, Formulation B and Formulation C, during a 24 hour period. Immediately after administration the plasma concentration of guaifenesin peaks in about an hour, followed by a gradual plasma concentration decrease over 24 hours. Immediately after administration, guaifenesin plasma concentration never decreased to less than 200 ng/mL over 12 hours. Thereafter, guaifenesin plasma concentration gradually decreased over the next 12 hours. Plasma concentration of dextromethorphan HBr peaks at about 6 hours at about 12 ng/mL and the concentration is maintained for the following 19 hours.

[0205] Formulations B and C of Figure 13, exhibited guaifenesin release profiles similar to the reference formulation. The reference formulation for Figure 13 was Formulation IV of Example 5. Formulation B comprised 77% guaifenesin by weight, 3.8% by weight dextromethorphan, 9.1% by weight microcrystalline cellulose, 1.9% by weight Methocel E10M, and 0.9% Carbopol® 974P. Formulation C comprised 76.5% by weight guaifenesin, 3.8% by weight dextromethorphan, 9.7% by weight microcrystalline cellulose, 1.9% by weight Methocel E10M, and 0.9% by weight Carbopol® 974P. Formulations B and C exhibited similar behavior and had a guaifenesin release profile similar to the reference formulation. Accordingly, the combination formulations of the invention did not interfere with the release of guaifenesin. In particular, after 12 hours Formulation C released a greater dose of guaifenesin than the reference formulation.

[0206] Formulations B and C of Figure 13 were compared against a reference consisting of an extended release formulation of dextromethorphan commercially available under the name Delsym sold by Celltech. The comparison was carried out to determine the behavior of guaifenesin-dextromethorphan formulations of the invention as compared to separately administered combination formulations of dextromethorphan. Formulations B and C had longer dextromethorphan release profiles than the reference, as shown in Figure 14. Additionally, the combined formulations of the inventions had no detrimental effect upon the release profile of dextromethorphan.

[0207] Another method to monitor dextromethorphan plasma concentrations is to measure the plasma concentration of the metabolite dextrophan. The plasma concentration of dextrophan metabolite of the reference formulation and Formulations B and C of Figure 14 were plotted in Figure 15. Generally, the formulations exhibited similar dextrophan concentrations, with Formula C exhibiting the highest dextrophan concentration after 12 hours. Figure 15 demonstrates that the formulations of the invention containing guaifenesin do not inhibit the release of dextromethorphan, as determined by measuring the presence of the metabolite dextrophan.

Example 9

[0208] A study was performed to examine the relative bioavailability of a sustained release guaifenesin with dextromethorphan formulation of the invention with normal, healthy male and/or female volunteers. A batch of guaifenesin and dextromethorphan bi-layer tablet, 1200 mg, was prepared according to the composition described above for Example 8.

[0209] The *in vivo* behaviors of the 1200 mg tablet administered to volunteers in the fasting state (about 10 hours pre-dose until about 4 hours after dosing) was determined. The open-label study involved 29 healthy volunteers between the ages of 18 and 55. The 29 volunteers were divided into two treatment groups half receiving the 1200 mg tablet while fasting for Period 1 of the trial. Each volunteer was administered one dose of the appropriate tablet and then monitored over a 16 hour period.

[0210] Blood samples (7 mL with sodium heparin as anticoagulant) were taken about one hour prior to dosing and at specific intervals up to 16 hours after dosing (at 0.25, 0.5, 0.75, 1, 1.5, 2, 3, 4, 6, 8, 10, 12, 14, and 16 hours). The results of the pharmacokinetic parameters analysis for guaifenesin include a T_{max} of 1.48 hr, C_{max} (ng/mL) of 2196, AUC_{0-12} (hr-ng/mL) of 8702, $T_{1/2}$ of 1.32 hrs., and an AUC_{inf} (hr-ng/mL) of 8732.5. The results of the pharmacokinetic parameters analysis for dextromethorphan include a T_{max} of 5.0 hrs, C_{max} (pg/mL) of 5157, AUC_{0-12} (hr-pg/mL) of 74209, $T_{1/2}$ of 7.93 hrs., and an AUC_{inf} (hr-pg/mL) of 75016.

Example 10

[0211] In another example of a combination formulation, two batches of guaifenesin-pseudoephedrine HCl bi-layer tablets, one 600 mg and one 1200 mg, were prepared in the following amounts.

Sustained release layer600 mg/ 60 mg1200 mg/ 120mg

Components	Weight per 300,000 tablets (kg)	Weight per 150,000 tablets (kg)
Guaifenesin DC (95%)	157.90	157.89
Pseudoephedrine HCl	18.0	18.00
Hydroxypropyl Methylcellulose (Methocel E10M)	4.50	4.50
Carbopol 974P, NF	2.25	2.25
FD&C Yellow No. 6 Aluminum Lake (15-18%)	0.24	0.06
Magnesium Stearate	1.50	1.50

Immediate release layer600 mg/ 60 mg1200 mg/ 120mg

Components	Weight per 300,000 tablets (kg)	Weight per 150,000 tablets (kg)
Guaifenesin DC (95%)	39.476	39.476
Microcrystalline Cellulose (Avicel PH102)	22.028	22.028
Sodium Starch Glycolate	5.626	5.626
Magnesium Stearate, NF	0.188	0.188

[0212] The following is a summary of 1200 mg guaifenesin/ 120 mg pseudoephedrine dissolution rates also depicted in Figure 16.

	PB01-M65 (clinical batch) % released	PB01-M68 % released	PB01-M71 % released
1 hr	45	44	43
2 hr	60	59	58
6 hr	89	87	82
12 hr	97	98	96

[0213] The *in vivo* behavior of the 1200 mg guaifenesin and 120 mg pseudoephedrine tablet was studied by measuring the plasma concentration of guaifenesin, and pseudoephedrine HCl. The three batches of the 1200 mg

guaifenesin/ 120 mg pseudoephedrine HCl formulation were dissolved to determine the amount of pseudoephedrine HCl released over time. Generally, the formulations had 1200 mg of guaifenesin and 120 mg pseudoephedrine HCl and were studied over a 12 hour period. The released amount of pseudoephedrine HCl was determined as a weight percent of dissolved pseudoephedrine HCl in contrast to the total weight of pseudoephedrine HCl prior to dissolution. After 1 hour about 43% to 45% of the pseudoephedrine HCl had dissolved. After 2 hours the about 58% to 60% dissolved, after 6 hours 82% to 89% had dissolved, and after 12 hours about 96% to 97% by weight of the pseudoephedrine HCl had dissolved. (See Figure 16).

[0214] Three formulations of guaifenesin, two containing an additional drug, pseudoephedrine, were compared to determine whether an additional drug affects the release profile of guaifenesin. Figures 17-18 illustrate the plasma concentration for each drug (Formulation B and Formulation C) during a 24 hour period. Immediately after administration the plasma concentration of guaifenesin peaks in about an hour, followed by a gradual plasma concentration decrease over 24 hours. Immediately after administration, guaifenesin plasma concentration never decreased below 200 ng/mL over 12 hours. Thereafter, guaifenesin plasma concentration gradually decreased over the next 12 hours. Plasma concentration of pseudoephedrine HCl peaked at about 6 hours and gradually decreased over the next 18 hours. The plasma concentration of pseudoephedrine HCl never decreased to less than 50 ng/mL after 30 minutes of administration.

[0215] In Figure 17, the reference formulation included formulation IV of Example 5 and a separate Sudafed® 12 hour formulation available from Pfizer Inc. 201 Tabor Road, Morris Plains, New Jersey, 07950. The reference formulation was compared to Formulation B and Formulation C of the invention. Formulation B comprised a sustained release formulation having 86% by weight Guaifenesin DC, 9.8% by weight pseudoephedrine HCl, 2.4% by weight hydroxypropyl methylcellulose, and 1.2% by weight Carbopol® 974P, and an immediate release formulation having 52% by weight Guaifenesin DC and 39% by weight

microcrystalline cellulose by weight. Formulation C comprised 77% by weight Guaifenesin DC, 7.7% by weight pseudoephedrine, 9% by weight microcrystalline cellulose, 1.8% by weight Methocel E10M, and 0.9% by weight Carbopol® 974P. Formulations B and C exhibited similar behavior to separately administered formulations, thus demonstrating that formulations of the invention did not interfere with the profile release of pseudoephedrine.

[0216] The plasma concentration for pseudoephedrine HCl was studied to determine whether the formulations of the invention interfered with the release profile of pseudoephedrine. The pseudoephedrine plasma concentrations for the formulations of Figure 17 were plotted over a 24 hour period. As illustrated in Figure 18, Formulations B and C of Figure 17 exhibited higher pseudoephedrine concentrations than the reference formulation. Thus, the combined formulations of the invention release pseudoephedrine in comparable or better release profiles than formulations containing pseudoephedrine alone.

Example 11

[0217] A study was performed to examine the relative bioavailability of sustained release guaifenesin with pseudoephedrine formulations of the invention in normal, volunteers. A batch of guaifenesin and pseudoephedrine bi-layer tablets, 1200 mg, was prepared according to the composition described above for Example 10.

[0218] The *in vivo* behaviors of a 1200 mg tablet administered to volunteers in the fasting state (about 10 hours pre-dose until about 4 hours after dosing) were compared. The open-label study involved 29 healthy volunteers between the ages of 18 and 55. The 29 volunteers were divided into two treatment groups, half receiving the 1200 mg tablet while fasting for Period 1 of the trial. Each volunteer was administered one dose of the appropriate tablet and then monitored over a 16 hour period.

[0219] Blood samples (7 mL with sodium heparin as anticoagulant) were taken about one hour prior to dosing and at specific intervals up to 16 hours after dosing (at 0.25, 0.5, 0.75, 1, 1.5, 2, 3, 4, 6, 8, 10, 12, 14, and 16 hours). The results of the pharmacokinetic parameters analysis for guaifenesin include a $T_{\max}$

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of 1.48 hr, $C_{\max}$ (ng/mL) of 2196, AUC_{0-12} (hr-ng/mL) of 8702, $T_{1/2}$ of 1.32 hrs., and an $AUC_{\inf}$ (hr-ng/mL) of 8732.5. The results of the pharmacokinetic parameters analysis for pseudoephedrine include a $T_{\max}$ of 6 hrs, $C_{\max}$ (ng/mL) of 300, AUC_{0-12} (hr-ng/mL) of 4201, $T_{1/2}$ of 5.98 hrs., and an $AUC_{\inf}$ (hr-ng/mL) of 4709.

Example 12

[0220] Guaifenesin and pseudoephedrine sustained release formulations were compared to commercial controlled release guaifenesin and pseudoephedrine products in healthy volunteers in an open label, single dose, randomized, 3-way crossover study in 15 subjects.

[0221] The subjects were randomized and placed into one of three treatment groups. Group A was given Formulation A, one 1200 mg controlled release guaifenesin product (Mucinex) plus a 120 mg controlled release pseudoephedrine hydrochloride product (Sudafed- 12 Hour) with 240 mL of water after an overnight fast. Group B received Formulation B (lot PB01-K61), an experimental controlled release tablet containing 1200 mg guaifenesin and 120 mg of pseudoephedrine hydrochloride with 240 mL of water after an overnight fast. Group C received Formulation C (lotCB00-01A), another experimental controlled release tablet containing 1200 mg guaifenesin and 120 mg pseudoephedrine hydrochloride with 240 mL of water after an overnight fast. There was at least a 7-day washout between doses.

[0222] The volunteers averaged 26.4 ± 10.57 years of age (Mean $\pm$ Standard Deviation) with a range of 18 years to 50 years of age. They were 66.93 ± 4.37 inches tall with a range of 60 to 74 inches. They weighed 160.87 ± 26.22 pounds with a range of 118 to 222 pounds. Seven were male (47%) and eight female (53%). Ten (67%) of the subjects had a large frame size, three (20%) had a medium frame and two (13%) had a small frame. Thirteen volunteers (87%) were Caucasian and two (13%) were Multiracial. Blood (10 mL, sodium heparin anticoagulant) was obtained at the following times: Pre dose, 0.5, 0.75, 1, 1.5, 2, 3, 4, 6, 8, 10, 12, 14, 16 and 24 hours post dose.

[0223] Subjects given 1200 mg of guaifenesin as guaifenesin ER (reference) reached a $C_{\max}$ of 1847 ng/mL in 0.78 hours and had an AUC_{inf} of 7302 hr-ng/mL. Subjects given 1200 mg guaifenesin as Formulation B reached a $C_{\max}$ of 1784 ng/mL (103% of that of the reference) in 0.82 hour (113% of that of the reference) and had an AUC_{inf} of 7602 hr-ng/mL (109% of that of the reference). Subjects given 1200 mg guaifenesin as Formulation C reached a $C_{\max}$ of 1154 ng/mL (65% of that of the reference) in 1.22 hours (179% of that of the reference) and had an AUC_{inf} of 7128 hr-ng/mL (100% of that of the reference).

[0224] Subjects given 120 mg pseudoephedrine hydrochloride as Sudafed-12 Hour (reference) reached a $C_{\max}$ of 300 ng/mL (mean $\pm$ standard deviation) in 6 hours and had an AUC_{inf} of 4710 hr-ng/mL. Subjects given 120 mg pseudoephedrine hydrochloride as Formulation B reached a $C_{\max}$ of 285 ng/mL (99% of that of the reference) in 6 hours (101% of that of the reference) and had an AUC_{inf} of 4449 hr-ng/mL (100% of that of the reference). Subjects given 120 mg pseudoephedrine hydrochloride as Formulation C reached a $C_{\max}$ of 256 ng/mL (86% of that of the reference) in 8 hours (151% of that of the reference) and had an AUC_{inf} of 4444 hr-ng/mL (97% of that of the reference).

[0225] The plasma concentrations of guaifenesin are depicted in Figure 19. The resulting pharmacokinetic data is shown in Tables 1 through 4. The maximum plasma concentrations of guaifenesin following a 1200 mg oral dose as Mucinex were 1847 ± 686.6 ng/mL and occurred in 0.78 ± 0.28 hours. The resulting area under the plasma concentration vs. time curve (AUC_{inf} was 7302 ± 2866.4 hr-ng/mL. The maximum plasma concentrations of guaifenesin following a 1200 mg oral dose as Formulation B were 1784 ± 549.9 ng/mL (102.93% $\pm$ 36.57% of that of the reference formulation) and occurred in 0.82 ± 0.27 hours (112.78% $\pm$ 43.29% that of the reference formulation). The resulting AUC_{inf} was 7602 ± 2492.8 hr-ng/mL (108.67% $\pm$ 23.93% of that of the reference formulation). The maximum plasma concentrations of guaifenesin following a 1200 mg oral dose as Formulation C were 1154 ± 523.3 ng/mL (64.56% $\pm$ 28.03% of that of the reference formulation) and occurred in 1.22 ± 0.45 hours (178.9% $\pm$ 100.64%

that of the reference formulation). The resulting AUC_{inf} was 7128 ± 3166.0 hr ng/mL(99.81% ± 34.23% of that of the reference formulation).

Table 1. Guaifenesin Pharmacokinetic Variables Following the Administration of 1200 mg Guaifenesin as Mucinex along with Sudafed 12 Hour to Normal Volunteers						
Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	1847	0.78	7143	7302	3.60	188.98
Median	1530	0.75	5776	5863	3.21	204.68
Standard Deviation	686.63	0.28	2793.41	2866.39	2.05	74.55
Standard Error	183.51	0.08	746.57	766.08	0.55	19.92
% CV	37.18	35.92	39.11	39.26	56.94	39.45
Maximum	1847	0.78	7143	7302	3.60	188.98
Minimum	1530	0.75	5776	5863	3.21	204.68

Table 2. Guaifenesin Pharmacokinetic Variables Following the Administration of 1200 mg Guaifenesin and 120 mg Pseudoephedrine Hydrochloride as Formulation B to Normal Volunteers						
Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	1784	0.82	7557	7602	1.59	172.56
Median	1730	0.75	7297	7349	1.35	163.30
Standard Deviation	549.90	0.27	2487.33	2492.75	0.59	49.49
Standard Error	146.97	0.07	664.77	666.22	0.16	13.23
% CV	30.82	33.67	32.91	32.79	37.09	28.68
Maximum	1800	0.75	5818	5842	1.35	205.42
Minimum	1120	0.5	4952	4979	1.14	241.01

Table 3. Guaifenesin Pharmacokinetic Variables Following the Administration of 1200 mg Guaifenesin and 120 mg Pseudoephedrine Hydrochloride as Formulation C to Normal Volunteers

Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	1154	1.22	6989	7128	2.40	202.57
Median	1050	1.00	6291	6314	2.38	190.05
Standard Deviation	523.29	0.45	3078.23	3165.98	1.06	89.63
Standard Error	139.86	0.12	822.69	846.14	0.28	23.96
% CV	45.35	37.14	44.04	44.41	44.30	44.25
Maximum	612	0.75	3157	3205	1.25	374.38
Minimum	781	0.75	4902	4949	2.49	242.46

Table 4. Ratio of Guaifenesin Pharmacokinetic Variables Following the Administration of 1200 mg Guaifenesin and 120 mg Pseudoephedrine Hydrochloride as Formulation B Compared to that of the Reference Formulation to Normal Volunteers (%)

Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	102.93	112.78	110.31	108.67	66.51	95.42
Median	90.59	100.00	102.28	100.45	50.76	99.55
Standard Deviation	36.57	43.29	23.94	23.93	65.61	16.90
Standard Error	9.77	11.57	6.40	6.40	17.53	4.52
% CV	35.53	38.38	21.70	22.02	98.64	17.72
Maximum	165.14	75	122.87	121.60	83.97	82.24
Minimum	80	50	87.60	84.93	17.70	117.75

[0226] The plasma concentrations of pseudoephedrine are depicted in Figure 20.

The resulting pharmacokinetic data is shown in Tables 5 through 9. The maximum plasma concentrations of pseudoephedrine following a 120 mg oral dose as Sudafed-12 Hour (reference) were 300.3 ± 91.44 ng/mL and occurred in 6 ± 1.69 hours. The resulting AUC_{inf} was 4710 ± 1394.5 hr-ng/mL. The maximum plasma concentrations of pseudoephedrine following a 120 mg oral dose as Formulation B were 285.3 ± 53.28 ng/mL (99.3 1% $\pm$ 20.39% of that of the reference formulation) and occurred in 5.80 ± 2.40 hours (101.11% $\pm$

41.77% of that of the reference formulation). The resulting AUC_{inf} was 4449 ± 1079.6 hr-ng/mL (99.87% $\pm$ 26.40% of that of the reference formulation). The maximum plasma concentrations of pseudoephedrine following a 120 mg oral dose as Formulation C were 256.4 ± 80.7 ng/mL (86.37% $\pm$ 14.38% of that of the reference formulation) and occurred in 8.27 ± 2.71 hours (51.11% $\pm$ 73.25% of that of the reference formulation). The resulting AUC_{inf} was 4444 ± 1212.1 hr-ng/mL (96.78% $\pm$ 17.90% of that of the reference formulation).

Table 5. Pseudoephedrine Pharmacokinetic Variables Following the Administration of 120 mg Pseudoephedrine Hydrochloride as Sudafed-12 Hour along with 1200 mg Guaifenesin as Mucinex to Normal Volunteers

Subject	C_{max} (ng/mL)	T_{max} (hr)	AUC_{0-t} (hr- ng/mL)	AUC_{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	300.27	6.00	4201.62	4709.88	5.98	22.93
Median	287.00	6.00	4042.53	4601.31	5.19	21.37
Standard Deviation	91.44	1.69	1182.92	1394.49	1.68	7.77
Standard Error	24.44	0.45	316.15	372.69	0.45	2.08
% CV	30.45	28.17	28.15	29.61	28.01	33.87
Maximum	523	8	6518.45	7137.33	10.18	38.94
Minimum	183	4	2419.97	2524.37	4.29	13.77

Table 6. Pseudoephedrine Pharmacokinetic Variables Following the Administration of 120 mg Pseudoephedrine Hydrochloride and 1200 mg Guaifenesin as Formulation B to Normal Volunteers

Subject	C_{max} (ng/mL)	T_{max} (hr)	AUC_{0-t} (hr- ng/mL)	AUC_{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	285.33	5.80	4080.27	4448.85	5.40	23.41
Median	269.00	6.00	3985.05	4463.18	5.21	22.03
Standard Deviation	53.28	2.40	946.92	1079.61	1.01	6.06
Standard Error	14.24	0.64	253.07	288.54	0.27	1.62
% CV	18.67	41.32	23.21	24.27	18.64	25.88
Maximum	387	10	6003.14	6799.07	7.44	37.40
Minimum	215	2	2381.18	2628.19	3.85	14.46

Table 7. Pseudoephedrine Pharmacokinetic Variables Following the Administration of 120 mg Pseudoephedrine Hydrochloride and 1200 mg Guaifenesin as Formulation C to Normal Volunteers

Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	256.40	8.27	4008.32	4444.09	5.39	23.85
Median	226.00	10.00	3888.93	4266.92	5.15	23.04
Standard Deviation	80.71	2.71	1084.90	1212.13	1.10	7.16
Standard Error	21.57	0.72	289.95	323.96	0.29	1.91
% CV	31.48	32.80	27.07	27.28	20.41	30.03
Maximum	448	10	6200.18	6756.67	8.66	40.05
Minimum	162	2	2360.01	2454.79	4.09	14.55

Table 8. Ratio of Pseudoephedrine Pharmacokinetic Variables Following the Administration of 120 mg Pseudoephedrine Hydrochloride and 1200 mg Guaifenesin as Formulation B Compared to that of the Reference Formulation to Normal Volunteers (%)

Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	99.31	101.11	101.58	99.87	93.38	109.24
Median	94.74	100.00	104.95	101.63	90.66	98.40
Standard Deviation	20.39	41.77	24.96	26.40	17.54	40.60
Standard Error	5.45	11.16	6.67	7.06	4.69	10.85
% CV	20.53	41.31	24.57	26.44	18.79	37.13
Maximum	140.40	200	139.07	144.72	120.84	234.43
Minimum	65.97	25	50.46	42.66	60.12	69.10

Table 9. Ratio of Pseudoephedrine Pharmacokinetic Variables Following the Administration of 120 mg Pseudoephedrine Hydrochloride and 1200 mg Guaifenesin as Formulation C Compared to that of the Reference Formulation to Normal Volunteers (%)

Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	86.37	151.11	96.79	96.78	93.98	107.04
Median	85.66	133.33	98.75	99.37	96.77	100.63
Standard Deviation	14.38	73.25	14.24	17.90	21.06	22.01
Standard Error	3.84	19.58	3.80	4.78	5.63	5.88
% CV	16.65	48.48	14.71	18.49	22.41	20.56
Maximum	115.30	250	126.82	132.10	129.45	153.94
Minimum	62.60	50	75.98	64.96	51.20	75.70

[0227] The data indicates that both formulations produce optimum guaifenesin bioavailability (although Formulation B appears to more closely match the reference) and Formulation B produces optimal pseudoephedrine bioavailability.

Example 13

[0228] The bioavailability of a sustained release combination formulation of 1200 mg guaifenesin and 120 mg Pseudoephedrine Hydrochloride was used to examine the dose proportionality of Pseudoephedrine normal volunteers compared to reference guaifenesin and Pseudoephedrine Hydrochloride in an open label, single dose, randomized, 3-way crossover study with 36 subjects. The example also demonstrates the dose proportionality of pseudoephedrine.

[0229] The subjects were randomized and placed into one of three treatment groups. Group I received Treatment A, a 1200 controlled release guaifenesin product (Mucinex) plus a 120 mg controlled release pseudoephedrine product (Sudafed® 12 Hour) with 240 mL of water after an overnight fast (Reference). Group 2 received Treatment B(PB01-M65A2), an experimental controlled release formulation containing 1200 mg guaifenesin and 120 mg pseudoephedrine hydrochloride with 240 mL of water after an overnight fast (test). Group 3 received Treatment C(PB01-A12A), an experimental controlled release

formulation containing 600 mg guaifenesin and 60 mg pseudoephedrine with 240 mL of water after an overnight fast.

[0230] The volunteers averaged 23.06 ± 7.05 years of age (Mean $\pm$ Standard Deviation) with a range of 18 years to 48 years of age. They were 70.58 ± 3.08 inches tall with a range of 64 to 75 inches. They weighed 167.42 ± 26.14 pounds with a range of 114 to 229 pounds. Twenty-four were male (67%) and twelve female (33%). Sixteen (44%) of the subjects had a large frame size, thirteen (36%) had a medium frame and seven (19%) had a small frame. Thirty-two volunteers (89%) were Caucasian, three (8%) were Black and one (3%) Multiracial. Blood (10 mL, sodium heparin anticoagulant) was obtained at the following times: Pre-dose, 0.5, 0.75, 1, 1.5, 2, 3, 4, 6, 8, 10, 12, 14, 16 and 24 hours post dose (the total blood loss for guaifenesin and pseudoephedrine analysis will be 450 mL).

[0231] Subjects given 1200 mg of guaifenesin as Mucinex and 120 mg pseudoephedrine hydrochloride as Sudafed® 12 Hour (Treatment A, Reference) reached a $C_{\max}$ of 1940 ng/mL in 0.77 hours and had an AUC_{inf} of 8061 hr-ng/mL. Subjects given 1200 mg guaifenesin and 120 mg pseudoephedrine hydrochloride as Treatment B (Test) reached a $C_{\max}$ of 1813 ng/mL (98% of that of the reference) in 1.04 hour (140% of that of the reference) and had an $AUC_{0-\infty}$ of 8124 hr ng/mL (101% of that of the reference). Subjects given 600 mg guaifenesin and 60 mg pseudoephedrine hydrochloride as Treatment C reached a $C_{\max}$ of 920 ng/mL (54% of that of the reference) in 0.99 hours (116% of that of the reference) and had an AUC_{inf} of 3565 hr-ng/mL (46% of that of the reference).

[0232] Subjects given 120 mg pseudoephedrine hydrochloride as Sudafed® 12 Hour and 1200 mg guaifenesin as Mucinex (Treatment A, Reference) reached a mean $C_{\max}$ of 250 ng/mL in 6 hours and had an AUC_{inf} of 3847 hr-ng/mL. Subjects given 120 mg pseudoephedrine and 1200 mg guaifenesin as an experimental formulation (Treatment B, Test) reached a of 263 ng/mL (107% of that of the reference) in 5 hours (85% of that of the reference) and had an AUC_{inf} of 3884 hr-ng/mL (103% of that of the reference). Subjects given 60 mg

pseudoephedrine hydrochloride and 600 mg guaifenesin in an experimental formulation (Treatment C) reached a $C_{\max}$ of 141 ng/mL (54% of that of Formulation B) in 5 hours (100% of that of Formulation B) and had an $AUC_{\inf}$ of 1968 hr-ng/mL (50% of that of Formulation B).

[0233] Blood (10 mL, sodium heparin anticoagulant) was obtained at the following times: Pre-dose, 0.5, 0.75, 1, 1.5, 2, 3, 4, 6, 8, 10, 12, 14, 16 and 24 hours post dose. Bioequivalence was examined between the test (Treatment B - guaifenesin or pseudoephedrine hydrochloride experimental formulation) and the reference (Treatment A - guaifenesin or pseudoephedrine hydrochloride reference formulations) groups. The dose response relationship was also examined between the test (Treatment B- guaifenesin or pseudoephedrine hydrochloride experimental formulation) and the reference (Treatment C - guaifenesin or pseudoephedrine hydrochloride reference formulations) groups.

[0234] The plasma concentrations of guaifenesin is depicted in Figure 21. The resulting pharmacokinetic data is shown in Tables 10 through 14. The maximum plasma concentrations of guaifenesin following a 1200 mg oral dose as Mucinex and 120 mg pseudoephedrine hydrochloride as Sudafed® 12 Hour were 1940 ± 889 ng/mL and occurred in 0.77 ± 0.22 hours. The resulting area under the plasma concentration vs. time curve ($AUC_{\inf}$ was 8061 ± 3329 hr-ng/mL. The maximum plasma concentrations of guaifenesin following a 1200 mg oral dose as Treatment B were 1813 ± 900 ng/mL ($98.1\% \pm 35.8\%$ of that of the reference formulation) and occurred in 1.04 ± 0.49 hours ($140\% \pm 65.3\%$ that of the reference formulation). The resulting $AUC_{\inf}$ was 8124 ± 3677 hr-ng/mL ($101\% \pm 19.3\%$ of that of the reference formulation). The maximum plasma concentrations of guaifenesin following a 600 mg oral dose as Treatment C were 920 ± 481 ng/mL ($54.3\% \pm 20.2\%$ of that of the reference formulation) and occurred in 0.99 ± 0.46 hours ($116\% \pm 78.7\%$ that of the reference formulation). The resulting $AUC_{\inf}$ was 3565 ± 1442 hr-ng/mL ($45.6\% \pm 10.2\%$ of that of the reference formulation).

Table 10. Guaifenesin Pharmacokinetic Variables Following the Administration of 1200 mg guaifenesin Mucinex along with Sudafed 12 Hour to Normal Volunteers (%)

Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half- life (hr)	Clearance (L/hr)
Mean	1847	0.78	7143	7302	3.60	188.98
Median	1530	0.75	5776	5863	3.21	204.68
Standard Deviation	686.63	0.28	2793.41	2866.39	2.05	74.55
Standard Error	183.51	0.08	746.57	766.08	0.55	19.92
% CV	37.18	35.92	39.11	39.26	56.94	39.45
Maximum	1847	0.78	7143	7302	3.60	188.98
Minimum	1530	0.75	5776	5863	3.21	204.68

Table 11. Guaifenesin Pharmacokinetic Variables Following the Administration of 1200 mg guaifenesin and 120 mg Pseudoephedrine Hydrochloride as an Experimental Formulation to Normal Volunteers (Treatment B, Test)

Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	1813	1.04	8002	8124	2.21	175
Median	1530	0.75	7036	7083	1.99	169
Standard Deviation	900	0.49	3677	3677	1.19	68.2
Standard Error	154	0.08	631	631	0.20	11.7
% CV	49.6	46.9	45.9	45.3	53.9	38.9

Table 12. Guaifenesin Pharmacokinetic Variables Following the Administration of 600 mg Guaifenesin and 60 mg Pseudoephedrine Hydrochloride to Normal Volunteers (Treatment C)

Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	920	0.99	3529	3565	1.76	192
Median	721	0.75	3078	3098	1.47	194
Standard Deviation	481	0.46	1437	1442	0.92	66.5
Standard Error	81.3	0.08	243	244	0.16	11.2
% CV	52.3	46.0	40.7	40.4	52.4	34.5

Table 13. Ratio of Guaifenesin Pharmacokinetic Variables Following the Administration of 1200 mg Guaifenesin and 120 mg Pseudoephedrine Hydrochloride as Formulation B Compared to that of the Reference Formulation (Treatment A) to Normal Volunteers (%)						
Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	98.1	140	104	101	66.2	103
Median	96.8	133	106	100	53.1	99.5
Standard Deviation	35.8	65.3	20.3	19.3	42.0	24.2
Standard Error	6.14	11.2	3.48	3.31	7.20	4.16
% CV	36.5	46.5	19.5	19.1	63.4	23.5

Table 14. Ratio of Guaifenesin Pharmacokinetic Variables Following the Administration of 600 mg Guaifenesin and 60 mg Pseudoephedrine Hydrochloride (Treatment C) Compared to that of (Treatment B) to Normal Volunteers (%)						
Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	54.3	116	45.9	45.6	97.0	114
Median	48.8	100	43.9	44.0	86.1	114
Standard Deviation	20.2	78.7	10.6	10.2	61.6	23.2
Standard Error	3.47	13.50	1.82	1.75	10.57	3.98
% CV	37.3	67.9	23.1	22.4	63.5	20.3

[0235] The plasma concentrations of pseudoephedrine are depicted in Figure 22.

The resulting pharmacokinetic data is shown in Tables 15 through 19. The maximum plasma concentrations of pseudoephedrine following a 120 mg oral dose as Sudafed® 12 Hour and 1200 mg guaifenesin as Mucinex (Treatment A, Reference) were 250 ± 53.4 ng/mL and occurred in 6.29 ± 1.76 hours. The resulting AUC_{inf} was 3847 ± 910 hr-ng/mL. The maximum plasma concentrations of pseudoephedrine following a 120 mg oral dose as an experimental formulation (Treatment B) were 263 ± 58.5 ng/mL ($107\% \pm 18.9\%$

of that of the reference formulation) and occurred in 5.11 ± 1.78 hours ($85.2\% \pm 31.5\%$ of that of the reference formulation). The resulting AUC_{inf} was 3884 ± 911 hr-ng/mL ($103\% \pm 20.2\%$ of that of the reference formulation). The maximum plasma concentrations of pseudoephedrine following a 60 mg oral dose as an experimental formulation (Treatment C) were 141 ± 30.3 ng/mL ($53.5\% \pm 6.52\%$ of that of Formulation B) and occurred in 4.94 ± 1.60 hours ($99.5\% \pm 25.9\%$ of that of Formulation B). The resulting AUC_{inf} was 1968 ± 477 hr-ng/mL ($50.5\% \pm 8.77\%$ of that of Formulation B).

Table 15. Pseudoephedrine Pharmacokinetic Parameters Following the Administration of 120 mg Pseudoephedrine Hydrochloride as Sudafed® 12 Hour and 1200 mg Guaifenesin as Mucinex to Normal Volunteers (Treatment A)

Subject	C_{max} (ng/mL)	T_{max} (hr)	AUC_{0-t} (hr- ng/mL)	AUC_{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	250	6.29	3479	3847	5.75	27.1
Median	252	6	3381	3652	5.42	26.9
Standard Deviation	53.4	1.76	805	910	1.02	7.11
Standard Error	9.16	0.30	138	156	0.18	1.22
% CV	21.3	28.0	23.2	23.7	17.8	26.2

Table 16. Pseudoephedrine Pharmacokinetic Following the Administration 120 mg Pseudoephedrine Hydrochloride and 1200 mg Guaifenesin in an Experimental Formulation to Normal Volunteers (Treatment B)

Subject	C_{max} (ng/mL)	T_{max} (hr)	AUC_{0-t} (hr- ng/mL)	AUC_{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	263	5.11	3591	3884	5.22	26.7
Median	257	4.00	3507	3824	5.19	25.7
Standard Deviation	58.5	1.78	824	911	0.89	6.23
Standard Error	10.0	0.31	141	156	0.15	1.07
% CV	22.3	34.8	23.0	23.5	16.9	23.3

Agent's File Reference: 62808.000021

Table 17. Pseudoephedrine Pharmacokinetic Parameters Following the Administration of 60 mg Pseudoephedrine Hydrochloride and 600 mg Guaifenesin in an Experimental Formulation to Normal Volunteers (Treatment C)						
Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	141	4.94	1781	1968	5.57	26.5
Median	134	4.00	1696	1855	5.38	26.5
Standard Deviation	30.3	1.60	445	477	1.02	6.58
Standard Error	5.12	0.27	75.1	80.6	0.17	1.11
% CV	21.5	32.4	25.0	24.2	18.4	24.9

Table 18. Ratio of the Pseudoephedrine Pharmacokinetic Parameters Following the Administration of 120 mg Pseudoephedrine Hydrochloride and 1200 mg Guaifenesin as an Experimental Formulation (Treatment B) Compared to that Following the Administration of 120 mg Pseudoephedrine Hydrochloride as Sudafed® 12 Hour and 120 mg Guaifenesin as Mucinex (Treatment A) (%)						
Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	107	85.2	105	103	92.1	101
Median	106	75.0	102	101	93.7	98.7
Standard Deviation	18.9	31.5	19.39	20.16	15.19	22.03
Standard Error	3.24	5.41	3.33	3.46	2.61	3.78
% CV	17.7	37.0	18.4	19.5	16.5	21.8

Table 19. Ratio of Pseudoephedrine Pharmacokinetic Parameters Following the Administration of 60 mg Pseudoephedrine Hydrochloride and 600 mg Guaifenesin as an Experimental Formulation (Treatment C) Relative to that Following the Administration of 120 mg Pseudoephedrine Hydrochloride and 1200 mg Guaifenesin in an Experimental Formulation (Treatment B) (%)						
Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	53.5	99.5	49.1	50.5	108	102
Median	52.6	100	46.7	48.0	105	104
Standard Deviation	6.52	25.9	7.80	8.77	17.4	16.2
Standard Error	1.12	4.44	1.34	1.50	2.98	2.78
% CV	12.2	26.0	15.9	17.4	16.2	15.9

[0236] In conclusion, the experimental formulation containing 1200 mg guaifenesin and 120 mg pseudoephedrine hydrochloride is bioequivalent to the reference formulations given in separate doses. In addition the pharmacokinetics of guaifenesin and pseudoephedrine are linear over the range studied.

Example 14

[0237] The effects of a high fat meal on the bioavailability of a combination formulation were tested. The bioavailability of a 1200 mg guaifenesin and 120 mg Pseudoephedrine Hydrochloride formulation in volunteers was compared to reference drug bioavailability in an open-label, single-dose, randomized, 2-way-crossover study using 36 subjects.

[0238] The subjects were randomized and placed into one of two treatment groups. Group 1 received a 1200-mg controlled-release guaifenesin product (Mucinex) and 120 mg pseudoephedrine hydrochloride (Sudafed® 12 Hour) with 240 mL of water, 30 minutes after the beginning of the consumption of a high-fat breakfast (Reference). Group 2 received an experimental formulation containing 1200 mg guaifenesin and 120 mg pseudoephedrine hydrochloride with 240 mL of water, 30 minutes after the beginning of the consumption of a high-fat breakfast (Test)(PB01-M65A3).

[0239] Blood (10 mL, sodium heparin anticoagulant) was obtained at the following times: Pre dose, 0.5, 0.75, 1, 1.5, 2, 3, 4, 6, 8, 10, 12, 14, 16 and 24 hours post

dose (the total blood loss for guaifenesin and pseudoephedrine analysis was 300 mL).

[0240] Subjects given 1200 mg of guaifenesin as Mucinex (Reference) reached a $C_{\max}$ of 2207 ng/mL in 1.85 hours and had an $AUC_{\inf}$ of 8067 hr-ng/mL. Subjects given 1200 mg guaifenesin as an experimental formulation (Treatment B) reached a $C_{\max}$ of 1649 ng/mL (79% of that of the Reference) in 1.84 hour (118% of that of the Reference) and had an $AUC_{\inf}$ of 7663 hr-ng/mL (93% of that of the Reference).

[0241] Subjects given 120 mg pseudoephedrine hydrochloride as Sudafed® 12 Hour (Reference) reached a $C_{\max}$ of 268 ng/mL in 6.38 hours and had an $AUC_{\inf}$ of 3636 hr-ng/mL. Subjects given 120 mg pseudoephedrine hydrochloride as an experimental formulation (Treatment B) reached a $C_{\max}$ of 274 ng/mL (103% of that of the Reference) in 4.80 hours (76.5% of that of the Reference) and had an $AUC_{\inf}$ of 3528 hr-ng/mL (96.5% of that of the Reference).

[0242] Additionally, bioequivalence data was examined between the Test group (Treatment B - 1200 mg guaifenesin and 120 mg pseudoephedrine hydrochloride as an experimental formulation) and the Reference group (Treatment A - the reference 1200 mg guaifenesin and 120 mg pseudoephedrine hydrochloride formulations).

[0243] The plasma concentrations of guaifenesin are depicted in Figure 23. The resulting pharmacokinetic data are shown in Tables 20 through 22. The maximum plasma concentrations of guaifenesin following a 1200 mg oral dose as Mucinex were 2207 ± 952 ng/mL and occurred in 1.85 ± 1.06 hours. The resulting area under the plasma concentration vs. time curve ($AUC_{\inf}$ was 8067 ± 2663 hr-ng/mL. The maximum plasma concentrations of guaifenesin following a 1200-mg oral dose as an experimental formulation (Treatment B) was 1649 ± 690 ng/mL (79% $\pm$ 31.5% of the Reference formulation) and occurred in 1.84 ± 0.818 hours (118% $\pm$ 68.8% of the Reference formulation). The resulting $AUC_{\inf}$ was 7663 ± 2864 hr-ng/mL (93% $\pm$ 17.6% of that of the Reference formulation).

Table 20. guaifenesin Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin as Mucinex Along with 120 mg Pseudoephedrine Hydrochloride as Sudafed® 12 Hour to Normal Volunteers Following the Consumption of a High-Fat Meal (Treatment A, Reference)

Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	2207	1.85	8049	8067	1.22	168
Median	2140	1.50	8160	8196	0.983	146
Standard Deviation	952	1.06	2666	2663	0.621	64.4
Standard Error	166	0.184	464	464	0.108	11.2
% CV	43.2	57.2	33.1	33.0	51.1	38.3

Table 21. Guaifenesin Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin and 120 mg Pseudoephedrine Hydrochloride in an Experimental Formulation to Normal Volunteers Following the Consumption of a High-Fat Meal (Treatment B, Test)

Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	1649	1.84	7611	7663	1.40	181
Median	1580	2.00	7474	7485	1.07	160
Standard Deviation	690	0.818	2816	2864	0.793	77.6
Standard Error	118	0.140	483	491	0.136	13.3
% CV	41.9	44.4	37.0	37.4	56.6	42.9

Table 22. Ratio of Guaifenesin Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin and 120 mg Pseudoephedrine Hydrochloride in an Experimental Formulation Compared to those of Treatment A (Reference) to Normal Volunteers Following the Consumption of a High-Fat Meal (%)						
Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	79	118	93	93	135	109.9
Median	73	100	91	91	99	109.8
Standard Deviation	31.5	68.8	17.5	17.6	97.1	16.8
Standard Error	5.57	12.2	3.09	3.12	17.2	2.96
% CV	39.8	58.3	18.8	18.9	72.0	15.3

[0244] The plasma concentrations of pseudoephedrine are depicted in Figure 24.

The resulting pharmacokinetic data are shown in Tables 23 through 25. The maximum plasma concentrations of pseudoephedrine following a 120 mg oral dose as Sudafed® 12 Hour (Reference) was 268 ± 69.7 ng/mL and occurred in 6.38 ± 1.26 hours. The resulting AUC_{inf} was 3636 ± 940 hr-ng/mL. The maximum plasma concentrations of pseudoephedrine following a 120 mg oral dose as an experimental formulation (Treatment B) was 274 ± 72.3 ng/mL ($103\% \pm 10.3\%$ of that of the Reference formulation) and occurred in 4.80 ± 1.28 hours ($76.5\% \pm 23.1\%$ of that of the Reference formulation). The resulting AUC_{inf} was 3528 ± 962 hr-ng/mL ($96.5\% \pm 11.7\%$ of that of the Reference formulation).

Table 23. Pseudoephedrine Pharmacokinetic Parameters Following the Administration of 120 mg Pseudoephedrine Hydrochloride as Sudafed® 12 Hour Along with 1200 mg Guaifenesin as Mucinex to Normal Volunteers Following the Consumption of a High-Fat Meal (Treatment A, Reference)						
Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	268	6.38	3362	3636	5.28	28.8
Median	249	6.00	3238	3545	4.97	27.7
Standard Deviation	69.7	1.26	847	940	1.08	7.55
Standard Error	12.1	0.219	147	164	0.188	1.31
% CV	26.03	19.67	25.18	25.86	20.42	26.19

Table 24. Pseudoephedrine Pharmacokinetic Parameters Following the Administration of 120 mg of Pseudoephedrine Hydrochloride and 1200 mg Guaifenesin in an Experimental Formulation to Normal Volunteers Following the Consumption of a High-Fat Meal (Treatment B, Test)						
Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	274	4.80	3273	3528	5.26	30.0
Median	268	4.00	3198	3448	5.31	28.5
Standard Deviation	72.3	1.28	876	962	1.02	8.48
Standard Error	12.2	0.216	148	163	0.172	1.43
% CV	26.4	26.6	26.8	27.3	19.4	28.3

Table 25. Ratio of Pseudoephedrine Pharmacokinetic Parameters Following the Administration of 120 mg Pseudoephedrine Hydrochloride and 1200 mg Guaifenesin in an Experimental Formulation Compared to those of Treatment A (Reference) to Normal Volunteers Following the Consumption of a High-Fat Meal (%)						
Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	103	76.5	96.5	96.5	101	105
Median	103	66.7	95.7	94.2	99.5	106
Standard Deviation	10.3	23.1	10.6	11.7	17.9	12.6
Standard Error	1.82	4.09	1.88	2.06	3.17	2.23
% CV	10.0	30.3	11.0	12.1	17.7	12.0

[0245] The rate of absorption of guaifenesin from the experimental formulation, as assessed by C_{max} is not bioequivalent to the test formulation in the presence of a high fat meal with a 95% confidence interval between 67.9% and 81.8%. The extent of absorption of guaifenesin from the experimental tablet, as assessed by AUC_{inf} is equivalent to the test formulation in the presence of a high fat meal.

[0246] In conclusion, the rate of guaifenesin absorption from the experimental formulation is not bioequivalent to the Reference formulations; whereas the extent of guaifenesin absorption is bioequivalent to the Reference formulation in the presence of a high-fat meal. The rate and extent of pseudoephedrine absorption from the experimental formulation are bioequivalent to the Reference formulation in the presence of a high-fat meal.

Example 15

[0247] A combination guaifenesin and Pseudoephedrine formulation was tested for steady state pharmacokinetics as compared to references in an open-label, multiple-dose, randomized, 2-way-crossover study using 36 subjects. The subjects were randomly placed into one of two treatment groups. Group 1 received a 1200 mg controlled-release guaifenesin product (Mucinex) plus a 120 mg controlled-release pseudoephedrine product (Sudafed® 12 Hour) with 240 mL of water after an overnight fast and again 12 hours later for 11 doses (Reference). Group 2 received an experimental controlled-release formulation

comprising 1200 mg guaifenesin and 120 mg pseudoephedrine hydrochloride with 240 mL of water after an overnight fast and again 12 hours later for 11 doses (Test)(PB01-M65).

[0248] Blood (10 mL, sodium heparin anticoagulant) was obtained at the following times: Pre dose blood sample before the AM dose on Days 1, 4, 5 and 6. On Day 6 additional blood samples (5 mL, sodium heparin anticoagulant) were also obtained at 0.5, 0.75, 1, 1.5, 2, 3, 4, 6, 8, 10, 12, 14, 16 and 24 hours after the last dose (total blood loss for guaifenesin determination was 380 mL).

[0249] The subjects given 1200 mg guaifenesin, as Mucinex every 12 hours for 11 doses, reached a maximum steady-state plasma guaifenesin concentration of 1960 ng/mL at 0.81 hours after the last dose (120.81 hours after the first dose). The mean AUC_{ss} was 7209 hr-ng/mL and the mean C_{min} was 52 ng/mL. Those subjects given 1200 mg guaifenesin, as an experimental formulation every 12 hours for 11 doses, reached a maximum steady-state plasma guaifenesin concentration of 1983 ng/mL (103% of the Reference formulation) at 0.96 hours after the last dose (120.96 hours after the first dose, 100% of that of the Reference formulation). The mean AUC_{ss} was 8183 hr-ng/mL (114% of that of the Reference formulation) and the mean C_{min} was 117 ng/mL.

[0250] At steady state, the subjects given 120 mg pseudoephedrine hydrochloride, as Sudafed® 12 Hour, every 12 hours for 11 doses, reached a steady-state maximum plasma pseudoephedrine concentration of 361 ng/mL at 4.89 hours after the last dose (124.89 hours after the first dose). The mean AUC_{ss} was 3528 hr-ng/mL and the mean C_{min} was 182 ng/mL. Those subjects, when given the 120 mg pseudoephedrine hydrochloride as an experimental formulation, reached a steady-state maximum plasma pseudoephedrine concentration of 365 ng/mL (103% of that of the Reference) 4.10 hours after the last dose (124.10 hours after the first dose, 99.4% of that of the Reference). The mean AUC_{ss} was 3550 hr-ng/mL (102% of that of the Reference) and the mean C_{min} was 173 ng/mL.

[0251] The mean plasma concentrations of guaifenesin are depicted in Figure 25. The resulting pharmacokinetic data are shown in Tables 26 through 28. At steady state, the subjects given 1200 mg guaifenesin every 12 hours, as

Reference Mucinex for 11 doses, reached a steady-state maximum plasma guaifenesin concentration of 1960 ± 859 ng/mL (Mean $\pm$ Standard Deviation) in $0.81 \text{ hours} \pm 0.305$ hour after the last dose (120.81 hours after the first dose) and the steady-state AUC (AUC_{ss}) was 7209 ± 3746 hr-ng/mL. At steady state, the subjects given 1200 mg guaifenesin every 12 hours, as an experimental tablet formulation for 11 doses, reached a steady-state maximum plasma guaifenesin concentration of 1983 ± 1019 ng/mL ($103\% \pm 29.6\%$ of the Reference Mucinex) in $0.96 \text{ hours} \pm 0.645$ hour after the last dose (120.96 hours after the first dose, $100\% \pm 0.494\%$). The AUC_{ss} was 8183 ± 5141 hr-ng/mL ($114\% \pm 27.0\%$).

Table 26. Guaifenesin Steady-State Pharmacokinetic Parameters Following the Administration of 11 Doses of 1200 mg guaifenesin as Mucinex and 120 mg Pseudoephedrine Hydrochloride as Sudafed® 12 Hour to Normal Volunteers - Treatment A (Reference)

Subject	AUC_{ss} (hr-ng/mL)	C_{min} (ng/mL)	C_{max} (ng/mL)	T_{max} (hr)	$C_{AVERAGE}$ (ng/mL)
Mean	7209	52.0	1960	120.81	604
Median	6554	28.3	1850	120.75	547
Standard Deviation	3746	48.1	859	0.305	311
Standard Error	633	8.13	145	0.052	52.6
% CV	52.0	92.5	43.8	0.253	51.5

Table 27. guaifenesin Steady-State Pharmacokinetic Parameters Following the Administration of 11 Doses of 1200 mg guaifenesin and 120 mg Pseudoephedrine Hydrochloride in an Experimental Formulation to Normal Volunteers - Treatment B (Test)

Subject	AUC_{ss} (hr-ng/mL)	C_{min} (ng/mL)	C_{max} (ng/mL)	T_{max} (hr)	$C_{AVERAGE}$ (ng/mL)
Mean	8183	117	1983	120.96	686
Median	6769	100	1750	120.75	564
Standard Deviation	5141	87.2	1019	0.645	431
Standard Error	869	14.7	172	0.109	72.8
% CV	62.8	74.5	51.4	0.533	62.7

Table 28. Ratio of Guaifenesin Steady-State Pharmacokinetic Parameters Following the Administration of 11 Doses of 1200 mg Guaifenesin and 120 mg Pseudoephedrine Hydrochloride in an Experimental Formulation Compared to Reference Formulations to Normal Volunteers (%)					
Subject	AUC _{ss}	C _{min}	C _{max}	T _{max}	C _{AVERAGE}
Mean	114	550	103	100	114
Median	116	261	104	100	113
Standard Deviation	27.0	712	29.6	0.494	26.4
Standard Error	4.57	120	5.01	0.084	4.46
% CV	23.7	129	28.6	0.494	23.2

[0252] The mean plasma concentration of Pseudoephedrine are shown in Figure 26.

The resulting pharmacokinetic data are shown in Tables 29 through 31. At steady state, the subjects given 120 mg pseudoephedrine hydrochloride, as Sudafed® 12 Hour, every 12 hours for 11 doses, reached a steady-state maximum plasma pseudoephedrine concentration of 361 ± 77.7 ng/mL in 4.89 hours ± 2.14 hour after the last dose (124.89 hours after the first dose). The AUC_{ss} was 3528 ± 862 hr-ng/mL. At steady state, the subjects given 120 mg pseudoephedrine hydrochloride every 12 hours, as an experimental tablet formulation for 11 doses, reached a steady-state maximum plasma pseudoephedrine concentration of 365 ± 83.3 ng/mL ($103\% \pm 2.14\%$ of the Reference Sudafed 12-Hour) in 4.10 hours ± 1.85 hours after the last dose (124.10 hours after the first dose, $99.4\% \pm 2.09\%$). The AUC_{ss} was 3550 ± 898 hr-ng/mL ($102\% \pm 19.6\%$).

Table 29. Pseudoephedrine Steady-State Pharmacokinetic Parameters Following the Administration of 11 Doses of 120 mg Pseudoephedrine Hydrochloride as Sudafed® 12 Hour and 1200 mg Guaifenesin as Mucinex to Normal Volunteers - Treatment A (Reference)

Subject	AUC _{ss} (hr-ng/mL)	C _{min} (ng/mL)	C _{max} (ng/mL)	T _{max} (hr)	C _{AVERAGE} (ng/mL)
Mean	3528	182	361	124.89	294
Median	3462	164	362	124.00	288
Standard Deviation	862	66.4	77.7	2.14	71.9
Standard Error	146	11.2	13.1	0.361	12.1
% CV	24.4	36.5	21.5	1.71	24.4

Table 30. Pseudoephedrine Steady-State Pharmacokinetic Parameters Following the Administration of 11 Doses of 120 mg Pseudoephedrine Hydrochloride and 1200 mg Guaifenesin in an Experimental Formulation to Normal Volunteers - Treatment B (Test)

Subject	AUC _{ss} (hr-ng/mL)	C _{min} (ng/mL)	C _{max} (ng/mL)	T _{max} (hr)	C _{AVERAGE} (ng/mL)
Mean	3550	173	365	124.10	296
Median	3399	170	350	124.00	283
Standard Deviation	898	55.2	83.3	1.85	74.8
Standard Error	152	9.34	14.1	0.313	12.7
% CV	25.3	32.0	22.8	1.49	25.3

Table 31. Ratio of Pseudoephedrine Steady-State Pharmacokinetic Parameters Following the Administration of 11 Doses of 120 mg Pseudoephedrine Hydrochloride and 1200 mg Guaifenesin in an Experimental Formulation Compared to Reference Formulations to Normal Volunteers (%)

Subject	AUC _{ss}	C _{min}	C _{max}	T _{max}	C _{AVERAGE}
Mean	102	100	103	99.4	102
Median	99.6	102	100	99.2	100
Standard Deviation	19.6	28.0	21.4	2.09	19.6
Standard Error	3.31	4.73	3.62	0.354	3.31
% CV	19.1	27.9	20.8	2.11	19.1

[0253] In conclusion, the experimental tablet formulation was bioequivalent to the Reference formulations at steady state. The experimental formulation is bioequivalent to the Reference formulations in terms of both C_{max} and AUC_{ss} for guaifenesin and pseudoephedrine hydrochloride.

Example 16

[0254] In another study drug interaction potential for combination drugs was examined. The interaction potential for 1200 mg guaifenesin and 120 mg Pseudoephedrine Hydrochloride was compared to reference in an open label, single dose, randomized, 3-way crossover study using 36 subjects.

[0255] The subjects were randomized and placed into one of three treatment groups. group A received a 1200 mg controlled release guaifenesin product (Mucinex) with 240 mL of room-temperature water after an overnight fast. Group B received a 120 mg controlled release pseudoephedrine product (Sudafed® 12 Hour) with 240 mL of room-temperature water after an overnight fast. Group C received a 1200 mg guaifenesin product (Mucinex) and 120 mg pseudoephedrine hydrochloride (Sudafed® 12 Hour) with 240 mL of room-temperature water after an overnight fast.

[0256] Blood (10 mL, sodium heparin anticoagulant) was obtained at the following times: Pre dose, 0.5, 0.75, 1, 1.5, 2, 3, 4, 6, 8, 10, 12, 14, 16 and 24 hours post dose (the total blood loss for guaifenesin and pseudoephedrine analysis was 450 mL).

[0257] Subjects given 1200 mg of guaifenesin as Mucinex (Treatment A, Reference) reached a C_{max} of 2009 ng/mL in 0.89 hours and had an AUC_{inf} of 8138 hr-ng/mL. Subjects given 1200 mg guaifenesin as Mucinex along with 120 mg Pseudoephedrine hydrochloride as Sudafed® 12 Hour (Treatment C, Test) reached a C_{max} of 1989 ng/mL (102% of that of the reference) in 0.84 hour (104% of that of the reference) and had an AUC_{inf} of 8052 hr-ng/mL (100% of that of the reference).

[0258] Subjects given 120 mg pseudoephedrine hydrochloride as Sudafed® 12 Hour (Treatment B, Reference) reached a C_{max} of 296 ng/mL in 6 hours and had an AUC_{inf} of 4505 hr ng/mL. Subjects given 120 mg pseudoephedrine

hydrochloride as Sudafed® 12 Hour, along with 1200 mg guaifenesin as Mucinex (Treatment C, Test) reached a C of 289 ng/mL (98% of that of the reference) in 6 hours (101% of that of the reference) and had an AUC_{inf} of 4396 hr-ng/mL (98% of that of the reference).

[0259] The plasma concentrations of guaifenesin are depicted in Figure 27. The resulting pharmacokinetic data is shown in Tables 38 through 41. The maximum plasma concentrations of guaifenesin following a 1200 mg oral dose as Mucinex (Treatment A, Reference) were 2009 ± 819.2 ng/mL and occurred in 0.89 ± 0.42 hours. The resulting area under the plasma concentration vs. time curve (AUC_{inf}) was 8138 ± 3253 hr-ng/mL. The maximum plasma concentrations of guaifenesin following a 1200 mg oral dose as Mucinex along with 120 mg pseudoephedrine hydrochloride (Treatment C, Test) were 1989 ± 863 ng/mL ($102.33\% \pm 31.40\%$ of that of the reference formulation) and occurred in 0.84 ± 0.31 hours ($103.94\% \pm 35.38\%$ that of the reference formulation). The resulting AUC_{inf} was 8052 ± 3344 hr-ng/mL ($100.06\% \pm 18.09\%$ of that of the reference formulation).

Table 38. Guaifenesin Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin to Normal Volunteers (Treatment A)						
Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr-ng/mL)	AUC _{inf} (hr-ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	2009	0.89	7921	8138	4.00	172.13
Median	1695	0.75	7063.8	7284.17	2.82	164.87
Standard Deviation	819.22	0.42	3196.53	3253.39	5.58	70.19
Standard Error	138.47	0.07	540.31	549.92	0.94	11.87
% CV	40.77	46.79	40.35	39.98	139.48	40.78

Table 39. Guaifenesin Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin Along with 120 mg Pseudoephedrine Hydrochloride to Normal Volunteers (Treatment C)

Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	1989	0.84	7923	8052	3.41	175.45
Median	1770	0.75	6689	6745	3.33	177.93
Standard Deviation	863.36	0.31	3337	3344	1.72	71.07
Standard Error	145.93	0.05	564.04	565.25	0.29	12.01
% CV	43.41	36.37	42.12	41.53	50.56	40.51

Table 40. Ratio of Guaifenesin Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin Along with 120 mg Pseudoephedrine Hydrochloride Compared to 1200 mg Guaifenesin Alone to Normal Volunteers (%)

Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	102.33	103.94	100.87	100.06	128.38	103.47
Median	95.79	100	103.14	101.71	107.41	98.32
Standard Deviation	31.40	35.38	18.01	18.09	79.38	20.60
Standard Error	5.31	5.98	3.05	3.06	13.42	3.48
% CV	30.69	34.04	17.86	18.08	61.83	19.91

Table 41. Pseudoephedrine Pharmacokinetic Parameters Following the Administration of 120 mg Pseudoephedrine Hydrochloride to Normal Volunteers (Treatment B)

Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	295.8	6.17	4024	4505	6.05	23.66
Median	297.5	6	3823	4430	5.81	22.20
Standard Deviation	73.25	1.92	1047	1250	1.44	7.24
Standard Error	12.38	0.32	177	211	0.24	1.22
% CV	24.76	31.13	26.02	27.75	23.83	30.60

[0260] The plasma concentrations of pseudoephedrine are depicted in Figure 28.

The resulting pharmacokinetic data is shown in Tables 42 through 43. The maximum plasma concentrations of pseudoephedrine following a 120 mg oral dose as Sudafed® 12 Hour (Treatment B, Reference) were 295.8 ± 73.25 ng/mL and occurred in 6.17 ± 1.92 hours. The resulting AUC_{inf} was 4505 ± 1250 hr-ng/mL. The maximum plasma concentrations of pseudoephedrine following a 120 mg oral dose as Sudafed® 12 Hour along with 1200 mg guaifenesin as Mucinex (Treatment C, Test) were 289.3 ± 77.61 ng/mL ($98.41\% \pm 12.77\%$ of that of the reference formulation) and occurred in 5.75 ± 1.54 hours ($100.74\% \pm 38.65\%$ of that of the reference formulation). The resulting AUC_{inf} was 4396 ± 1347 hr-ng/mL ($98.40\% \pm 15.24\%$ of that of the reference formulation).

Table 42. Pseudoephedrine Pharmacokinetic Following the Administration of 120 mg Pseudoephedrine Hydrochloride Along with 1200 mg guaifenesin to Normal Volunteers (Treatment C)

Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	289.33	5.75	3925	4396	6.04	24.30
Median	286	6	3932	4247	5.63	23.16
Standard Deviation	77.61	1.54	1089	1347	1.38	6.95
Standard Error	13.12	0.26	184	228	0.23	1.17
% CV	26.82	26.74	27.75	30.65	22.79	28.60

Table 43. Ratio of Pseudoephedrine Pharmacokinetic Parameters Following the Administration of 120 mg Along with 1200 mg Guaifenesin Hydrochloride Compared to 120 mg Pseudoephedrine Alone to Normal Volunteers (%)

Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	98.41	100.74	98.22	98.40	103.30	103.99
Median	98.40	100	96.90	97.91	97.46	102.14
Standard Deviation	12.77	38.65	13.15	15.24	30.44	15.96
Standard Error	2.16	6.53	2.22	2.58	5.14	2.70
% CV	12.97	38.36	13.39	15.49	29.47	15.35

[0261] In conclusion, the pharmacokinetics of guaifenesin and pseudoephedrine hydrochloride are unaffected by the presence or absence of one another.

Example 17

[0262] In another experiment the effect of a high-fat on the bioavailability of an of the combination of 1200 mg guaifenesin and 120 mg Pseudoephedrine Hydrochloride in normal healthy volunteers was again compared to reference drug in an open-label, single-dose, randomized, 2-way- crossover study using 36 subjects.

[0263] The subjects were randomized and placed into one of two treatment groups. Each treatment group was fasted overnight. Treatment A received an experimental formulation containing 1200 mg guaifenesin and 120 mg pseudoephedrine hydrochloride with 240 mL of water (Reference). Treatment B received an experimental controlled-release formulation containing 1200 mg guaifenesin and 120 mg pseudoephedrine hydrochloride with 240 mL of water, 30 minutes after the beginning of the consumption of a high-fat breakfast (Test).

[0264] Blood (10 mL, sodium heparin anticoagulant) was obtained at the following times: Pre dose, 0.5, 0.75, 1, 1.5, 2, 3, 4, 6, 8, 10, 12, 14, 16 and 24 hours post dose (the total blood loss for guaifenesin and pseudoephedrine analysis was 300 mL). Subjects given 1200 mg of guaifenesin and 120 mg pseudoephedrine hydrochloride as an experimental formulation following an overnight fast (Treatment A, Reference) reached a plasma guaifenesin C_{max} of 1857 ng/mL in 1.06 hours and had an AUC_{inf} of 8142 hr-ng/mL. Subjects given 1200 mg guaifenesin and 120 mg pseudoephedrine hydrochloride as an experimental formulation after the consumption of a high-fat meal (Treatment B, Test) reached a plasma guaifenesin C_{max} of 1364 ng/mL (79.3% of that of the Reference) in 2.06 hour (238% of that of the Reference) and had an AUC_{inf} of 7469 hr-ng/mL (94.1% of that of the Reference).

[0265] Subjects given 120 mg pseudoephedrine hydrochloride as an experimental formulation after an overnight fast (Treatment A, Reference) reached a plasma pseudoephedrine C_{max} of 283 ng/mL in 4.6 hours and had an AUC_{inf} of 3746 hr-

ng/mL. Subjects given 120 mg pseudoephedrine hydrochloride as an experimental formulation following the consumption of a high-fat meal (Treatment B, Test) reached a plasma pseudoephedrine $C_{\max}$ of 301 ng/mL (108% of that of the Reference) in 5.77 hours (137% of that of the Reference) and had an AUC_{inf} of 3660 hr-ng/mL (99% of that of the Reference).

[0266] The plasma concentrations of guaifenesin are depicted in Figure 29. The resulting pharmacokinetic data are shown in Tables 44 through 46. The maximum plasma concentrations of guaifenesin following 1200 mg guaifenesin and 120 mg pseudoephedrine hydrochloride after an overnight fast were 1857 ± 838 ng/mL (Mean $\pm$ Standard Deviation) and occurred in 1.06 ± 0.582 hours. The resulting area under the plasma concentration vs. time curve (AUC_{inf} was 8142 ± 3500 hr-ng/mL. The maximum plasma concentrations of guaifenesin, following 1200 mg oral guaifenesin and 120 mg pseudoephedrine hydrochloride as an experimental formulation following the consumption of a high-fat meal (Treatment B, Test), were 1364 ± 691 ng/mL ($79.3\% \pm 34.7\%$ of that of the Reference formulation) and occurred in 2.06 ± 1.16 hours ($238\% \pm 157\%$ that of the Reference formulation). The resulting AUC_{inf} was 7469 ± 3217 hr-ng/mL ($94.1\% \pm 23.1\%$ of that of the Reference formulation).

Table 44. Guaifenesin Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin and 120 mg Pseudoephedrine Hydrochloride in an Experimental Formulation to Normal Volunteers After an Overnight Fast (Treatment A, Reference)						
Subject	$C_{\max}$ (ng/mL)	$T_{\max}$ (hr)	AUC_{0-t} (hr-ng/mL)	AUC_{inf} (hr-ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	1857	1.06	8091	8142	1.82	18.0
Median	1830	0.750	8228	8244	1.68	14.6
Standard Deviation	838	0.582	3501	3500	0.702	8.46
Standard Error	144	0.100	600	600	0.120	1.45
% CV	45	55.0	43.3	43.0	38.6	47.0

Table 45. Guaifenesin Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin and 120 mg Pseudoephedrine Hydrochloride in an Experimental Formulation to Normal Volunteers After the Consumption of a High-Fat Meal (Treatment B, Test)						
Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	1364	2.06	7403	7469	1.39	18.9
Median	1190	2.00	6842	6857	1.12	17.5
Standard Deviation	691	1.16	3185	3217	0.833	7.80
Standard Error	119	0.200	546	552	0.143	1.34
% CV	50.7	56.6	43.0	43.1	60.0	41.2

Table 46. Ratio of Guaifenesin Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin and 120 mg Pseudoephedrine Hydrochloride in an Experimental Formulation Following the Consumption of a High-Fat Meal (Treatment B, Test) Compared to that After an Overnight Fast (Treatment A, Reference) to Normal Volunteers (%)						
Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	79.3	238	94.0	94.1	87.2	112
Median	71.4	200	89.7	89.6	68.1	112
Standard Deviation	34.7	157	23.4	23.1	53.2	24.5
Standard Error	6.04	27.4	4.07	4.02	9.27	4.26
% CV	43.8	66.1	24.8	24.6	61.1	21.9

[0267] The plasma concentrations of pseudoephedrine are depicted in Figure 45.

The resulting pharmacokinetic data are shown in Tables 47 through 49. The maximum plasma concentrations of pseudoephedrine following a 120 mg pseudoephedrine hydrochloride and 1200 mg guaifenesin, in an experimental formulation after an overnight fast (Treatment A, Reference), were 283 ± 79.6 ng/mL and occurred in 4.60 ± 1.56 hours. The resulting AUC_{inf} was 3746 ± 997 hr-ng/mL. The maximum plasma concentrations of pseudoephedrine following 120 mg pseudoephedrine hydrochloride and 1200 mg guaifenesin, in an experimental formulation following the consumption of a high-fat meal

(Treatment B, Test), were 301 ± 80.4 ng/mL ($108\% \pm 18.5\%$ of that of the Reference formulation) and occurred in 5.77 ± 1.78 hours ($137\% \pm 61.9\%$ of that of the Reference formulation). The resulting AUC_{inf} was 3660 ± 963 hr-ng/mL ($99.0\% \pm 20.1\%$ of that of the Reference formulation).

Table 47. Pseudoephedrine Pharmacokinetic Parameters Following the Administration of 120 mg of Pseudoephedrine Hydrochloride and 1200 Guaifenesin in an Experimental Formulation to Normal Volunteers After an Overnight Fast (Treatment A, Reference)						
Subject	C_{max} (ng/mL)	T_{max} (hr)	AUC_{0-t} (hr-ng/mL)	AUC_{inf} (hr-ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	283	4.60	3477	3746	5.01	28.2
Median	266	4.00	3374	3552	4.94	27.7
Standard Deviation	79.6	1.56	884	997	1.06	8.03
Standard Error	13.7	0.267	152	171	0.182	1.38
% CV	28.2	33.8	25.4	26.6	21.2	28.5

Table 48. Pseudoephedrine Pharmacokinetic Parameters Following the Administration of 120 mg of Pseudoephedrine Hydrochloride and 1200 mg guaifenesin in an Experimental Formulation to Normal Volunteers After Consumption of a High-Fat Meal (Treatment B, Test)						
Subject	C_{max} (ng/mL)	T_{max} (hr)	AUC_{0-t} (hr-ng/mL)	AUC_{inf} (hr-ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	301	5.77	3403	3660	4.64	28.8
Median	292	6.00	3152	3455	4.45	28.5
Standard Deviation	80.4	1.78	915	963	1.05	7.91
Standard Error	13.8	0.306	157	165	0.180	1.36
% CV	26.7	30.9	26.9	26.3	22.6	27.5

Table 49. Ratio of Pseudoephedrine Pharmacokinetic Parameters Following the Administration of 120 mg Pseudoephedrine Hydrochloride and 1200 mg guaifenesin in an Experimental Formulation After the Consumption of a High-Fat Meal (Treatment B, Test) Compared to that After an Overnight Fast (Treatment A, Reference) to Normal Volunteers (%)						
Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr- ng/mL)	AUC _{inf} (hr- ng/mL)	Half-life (hr)	Clearance (L/hr)
Mean	108	137	98.9	99.0	93.7	105
Median	109	133	96.9	95.9	88.4	104
Standard Deviation	18.5	61.9	20.8	20.1	17.1	20.2
Standard Error	3.22	10.8	3.62	3.50	2.97	3.52
% CV	17.1	45.2	21.0	20.3	18.2	19.3

[0268] The rate of absorption of guaifenesin from the experimental formulation, as assessed by C_{max} is not bioequivalent to the Test formulation in the presence of a high-fat meal. The extent of absorption of guaifenesin from the experimental tablet, as assessed by AUC_{inf}, is equivalent to the Test formulation in the presence of a high-fat meal.

[0269] The rate and extent of pseudoephedrine absorption from the experimental formulation was bioequivalent to the Reference formulation in the presence of a high-fat meal.

[0270] In conclusion, the rate of guaifenesin absorption from the experimental formulation is not bioequivalent to the Reference formulation; whereas the extent of guaifenesin absorption is bioequivalent to the Reference formulation in the presence of a high-fat meal. The rate and extent of pseudoephedrine absorption from the experimental formulation are bioequivalent to the Reference formulation in the presence of a high-fat meal.

Example 18

[0271] In another experiment the relative bioavailability of guaifenesin and dextromethorphan from an experimental modified release formulation containing both guaifenesin and dextromethorphan was compared to reference guaifenesin and dextromethorphan products in normal volunteers was determined in a 36 subject open-label, randomized, 4-way crossover study.

Agent's File Reference: 62808.000021

[0272] The subjects were randomized and placed into one of four treatment groups.

Group 1 received an experimental combination tablet containing 1200 mg of controlled-release guaifenesin and 60 mg of controlled-release dextromethorphan hydrobromide (Treatment A) with 240 mL of water, after an overnight fast. Group 2 received a reference controlled-release tablet containing 1200 mg guaifenesin (Mucinex, Treatment B) with 240 mL of water, after an overnight fast. Group 3 received 60 mg of dextromethorphan hydrobromide in a reference immediate-release liquid formulation according to 2 different dosing regimes (one half of the volunteers received 30 mg of dextromethorphan and a second 30 mg dose 6 hours later [Treatment C], while the other half received 20 mg dextromethorphan every 4 hours for three doses [Treatment D]) with 240 mL of water, after an overnight fast. Group 4 received 30 mg of dextromethorphan hydrobromide in a reference immediate-release liquid formulation according to 2 different dosing regimes (one half of the volunteers received 15 mg of dextromethorphan and a second 15 mg dose 6 hours later [Treatment E], while the other half received 10 mg dextromethorphan every 4 hours for three doses [Treatment F]) with 240 mL of water, after an overnight fast. Those subjects that received 30 mg dextromethorphan hydrobromide in one treatment period received 15 mg dextromethorphan in another treatment period; similarly, those that received 20 mg dextromethorphan in one treatment period received 10 mg dextromethorphan in a subsequent treatment period. In this experiment there was a 14-day washout between doses.

[0273] Blood (7 mL, sodium heparin anticoagulant) was obtained at the following times: Pre-dose, 0.5, 0.75, 1, 1.5, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 14, 16, 24, 36, 48, 72 and 96 hours post dose (the total blood loss for guaifenesin and dextromethorphan analysis was to be 644 mL).

[0274] Subjects given 1200 mg of guaifenesin as Mucinex (reference, Treatment B) reached a mean $C_{\max}$ of 2145 ng/mL in 0.9 hours and had a mean AUC_{inf} of 8953 hr-ng/mL. Subjects given 1200 mg guaifenesin as an experimental formulation, also containing 60 mg dextromethorphan hydrobromide (Treatment A), reached

Agent's File Reference: 62808.000021

a mean guaifenesin $C_{\max}$ of 2176 ng/mL in 1.4 hours and had a mean $AUC_{\inf}$ of 8766 hr-ng/mL.

[0275] Subjects given 60 mg dextromethorphan hydrobromide along with 1200 mg guaifenesin in an experimental formulation (Treatment A) reached a mean dextromethorphan $C_{\max}$ of 4834 pg/mL in 5 hours and had a mean $AUC_{\inf}$ of 68851 hr-pg/mL. Subjects given 60 mg dextromethorphan hydrobromide as 30 mg every 6 hours (Treatment C) reached a mean dextromethorphan $C_{\max}$ of 4711 pg/mL in 8.3 hours and had a mean $AUC_{\inf}$ of 82655 hr-pg/mL. Subjects given 60 mg dextromethorphan hydrobromide as 20 mg every 4 hours (Treatment D) reached a mean dextromethorphan $C_{\max}$ of 3344 pg/mL in 7 hours and had a mean $AUC_{\inf}$ of 44683 hr-pg/mL. Subjects given 30 mg dextromethorphan hydrobromide as 15 mg every 6 hours (Treatment E) reached a mean dextromethorphan $C_{\max}$ of 2180 pg/mL in 8 hours and had a mean $AUC_{\inf}$ of 40324 hr-pg/mL. Subjects given 30 mg dextromethorphan hydrobromide as 10 mg every 4 hours (Treatment F) reached a mean dextromethorphan $C_{\max}$ of 1286 pg/mL in 7.7 hours and had a mean $AUC_{\inf}$ of 20114 hr-pg/mL.

[0276] The plasma concentrations of guaifenesin is shown in Figure 33. The resulting pharmacokinetic data is shown in Tables 50 through 52. Subjects given 1200 mg of guaifenesin as Mucinex (Treatment B) reached a mean $C_{\max}$ of 2145 ± 997 ng/mL (Mean $\pm$ Standard Deviation) in 0.91 ± 0.5 hours and had an $AUC_{\inf}$ of 8953 ± 4272 hr-ng/mL. Subjects given 1200 mg guaifenesin as an experimental formulation also containing 60 mg dextromethorphan (Treatment A) reached a mean guaifenesin $C_{\max}$ of 2176 ± 1320 ng/mL ($101.36\% \pm 29.88\%$ of that of Mucinex) in 1.44 ± 0.67 hour ($178.57\% \pm 82.70\%$ of that of Mucinex) and had an $AUC_{\inf}$ of 8761 ± 4755 hr-ng/mL ($99.57\% \pm 24.27\%$ of that of Mucinex). These data indicate that the pharmacokinetics of guaifenesin are not affected by the presence of dextromethorphan.

Agent's File Reference: 62808.000021

Table 50 Guaifenesin Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin along with 60 mg Dextromethorphan Hydrobromide to Normal Volunteers - Treatment A						
Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr*ng/mL)	AUC _{inf} (hr*ng/mL)	Half Life (hr)	Clearance (L/hr)
Mean	2176	1.44	8732	8761	1.31	179
Median	1830	1.50	7579	7734	1.08	155
Standard Deviation	1320	0.67	4761	4755	1.12	93.93
Standard Error	237.15	0.12	855	854	0.20	16.87
%CV	60.67	46.88	54.52	54.27	85.67	52.59

Table 51 Guaifenesin Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin alone to Normal Volunteers - Treatment B						
Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr*ng/mL)	AUC _{inf} (hr*ng/mL)	Half Life (hr)	Clearance (L/hr)
Mean	2145	0.91	8657	8953	4.79	171
Median	1915	0.75	8346	8826	3.03	136
Standard Deviation	997	0.50	4268	4272	4.85	94.28
Standard Error	179	0.09	766	767	0.87	16.93
%CV	46.49	54.97	49.29	47.71	101.41	55.17

Table 52 Ratio of the Guaifenesin Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin in an Experimental Tablet along with 60 mg Dextromethorphan Hydrobromide Compared to Guaifenesin Alone (%)						
Subject	C _{max}	T _{max}	AUC _{0-t}	AUC _{inf}	Half Life	Clearance
Mean	101.36	178.57	102.78	99.57	47.71	106.07
Median	100.00	200.00	98.64	95.57	34.50	104.64
Standard Deviation	29.88	82.70	23.27	24.27	39.04	25.35
Standard Error	5.46	15.10	4.25	4.43	7.13	4.63
%CV	29.48	46.31	22.64	24.37	81.83	23.90

[0277] The plasma concentrations of dextromethorphan is shown in Figure 34. The resulting pharmacokinetic data is shown in Tables 53 through 61. Subjects given 60 mg dextromethorphan hydrobromide as an experimental formulation also containing 1200 mg guaifenesin (Treatment A) reached a mean dextromethorphan C_{max} of 4834 ± 6182 pg/mL in 5.06 ± 0.93 hours and had an AUC_{inf} of 68851 ± 112906 hr-pg/mL. Subjects given 60 mg dextromethorphan hydrobromide as 30 mg every 6 hours (Treatment C) reached a mean dextromethorphan C_{max} of 4711 ± 6124 pg/mL (141.85% ± 82.73% of that of the

Agent's File Reference: 62808.000021

experimental tablet, Treatment A) in 8.31 ± 1.58 hours ($62.07\% \pm 23.12\%$ of that of Treatment A) and had an AUC_{inf} of 82655 ± 123509 hr-pg/mL ($108\% \pm 44.44\%$ of that of Treatment A). Subjects given 60 mg dextromethorphan hydrobromide as 20 mg every 4 hours (Treatment D) reached a mean dextromethorphan C_{max} of 3130 ± 2355 pg/mL ($100.31\% \pm 37.06\%$ of that of the reference) in 7.01 ± 1.93 hours ($80.02\% \pm 22.83\%$ of that of Treatment A) and had an AUC_{inf} of 44683 ± 37119 hr-pg/mL ($82.77\% \pm 22.93\%$ of that of Treatment A). These results indicate that the tablet is not bioequivalent to either dextromethorphan dosing regimen, but is equivalent to the range generated by these two dosing regimens. These data also indicate that the pharmacokinetics of dextromethorphan are not affected by the presence of guaifenesin.

[0278] Subjects given 30 mg dextromethorphan hydrobromide as 15 mg every 6 hours (Treatment E) reached a mean dextromethorphan C_{max} of 2180 ± 2650 pg/mL ($53.89\% \pm 17.62\%$ of that of Treatment C) in 8.03 ± 2.52 hours ($96.08\% \pm 24.88\%$ of that of Treatment C) and had an AUC_{inf} of 40324 ± 62644 hr-pg/mL ($51.73\% \pm 16.77\%$ of that of Treatment C). Subjects given 30 mg dextromethorphan hydrobromide as 10 mg every 4 hours (Treatment F) reached a mean dextromethorphan C_{max} of 1286 ± 903 pg/mL ($53.41\% \pm 12.82\%$ of that of Treatment D) in 7.73 ± 2.43 hours ($142.42\% \pm 67.86\%$ of that of Treatment D) and had an AUC_{inf} of 6945 ± 16158 hr-pg/mL ($54.32\% \pm 16.37\%$ of that of Treatment D). These data suggest that the pharmacokinetics of dextromethorphan are linear over the range studied.

Table 53 Dextromethorphan Pharmacokinetic Parameters Following the Administration of an Experimental Tablet Formulation Containing 60 mg Dextromethorphan Hydrobromide and 1200 mg Guaifenesin to Normal Volunteers - Treatment A						
Subject	C_{max} (pg/mL)	T_{max} (hr)	AUC_{0-t} (hr*pg/mL)	AUC_{inf} (hr*pg/mL)	Half Life (hr)	Clearance (L/hr)
Mean	4834	5.06	68189	68851	7.73	1697
Median	2550	5.00	27821	28088	6.94	1088
Standard Deviation	6182	0.929	112242	112906	1.78	1585
Standard Error	1129	0.170	20493	20614	0.33	289
%CV	127.88	18.34	164.61	163.99	23.04	93.39

Agent's File Reference: 62808.000021

Table 54 Dextromethorphan Pharmacokinetic Parameters Following the Administration of 60 mg Dextromethorphan Hydrobromide as Two Doses of 30 mg Six Hours Apart to Normal Volunteers - Treatment C

Subject	C _{max} (pg/mL)	T _{max} (hr)	AUC _{0-t} (hr*pg/mL)	AUC _{inf} (hr*pg/mL)	Half Life (hr)	Clearance (L/hr)
Mean	4711	8.31	82279	82655	7.46	1291
Median	1665	8.50	23483	23860	6.76	999
Standard Deviation	6124	1.58	123157	123509	1.94	1078
Standard Error	1581	0.41	31799	31890	0.50	278
%CV	129.99	19.01	149.68	149.43	25.97	83.45

Table 55 Dextromethorphan Pharmacokinetic Parameters Following the Administration of 60 mg Dextromethorphan Hydrobromide as Three Doses of 20 mg Four Hours Apart to Normal Volunteers - Treatment D

Subject	C _{max} (pg/mL)	T _{max} (hr)	AUC _{0-t} (hr*pg/mL)	AUC _{inf} (hr*pg/mL)	Half Life (hr)	Clearance (L/hr)
Mean	3130	7.01	44287	44683	7.04	1335
Median	2720	6.00	26142	26321	6.60	1124
Standard Deviation	2355	1.93	36759	37119	1.57	1098
Standard Error	630	0.515	9824	9920	0.44	293
%CV	75.26	27.50	83.00	83.07	22.32	82.26

Table 56 Dextromethorphan Pharmacokinetic Parameters Following the Administration of 30 mg Dextromethorphan Hydrobromide as Two Doses of 15 mg Six Hours Apart to Normal Volunteers - Treatment E

Subject	C _{max} (pg/mL)	T _{max} (hr)	AUC _{0-t} (hr*pg/mL)	AUC _{inf} (hr*pg/mL)	Half Life (hr)	Clearance (L/hr)
Mean	2180	8.03	39746	40324	7.32	2940
Median	1180	9.00	16061	16226	6.48	2735
Standard Deviation	2650	2.52	61502	62644	2.28	2234
Standard Error	684	0.65	15880	16175	0.59	577
%CV	121.59	31.37	154.74	155.35	31.13	75.98

Agent's File Reference: 62808.000021

Table 57 Dextromethorphan Pharmacokinetic Parameters Following the Administration of 30 mg Dextromethorphan Hydrobromide as Three Doses of 10 mg Four Hours Apart to Normal Volunteers - Treatment F

Subject	C _{max} (pg/mL)	T _{max} (hr)	AUC _{0-t} (hr*pg/mL)	AUC _{inf} (hr*pg/mL)	Half Life (hr)	Clearance (L/hr)
Mean	1286	7.73	19833	20114	7.44	3894
Median	795	6.00	12940	13170	6.95	2860
Standard Deviation	903	2.43	16162	16158	2.02	3274
Standard Error	241	0.650	4319	4318	0.54	875
%CV	70.19	31.47	81.49	80.33	27.18	84.09

Table 58 Ratio of Dextromethorphan Pharmacokinetic Parameters Following the Administration of 60 mg Dextromethorphan Hydrobromide as Treatment A Compared to Two Doses of 30 mg Six Hours Apart (Treatment C) in Normal Volunteers %

Subject	C _{max}	T _{max}	AUC _{0-t}	AUC _{inf}	Half Life	Clearance
Mean	141.85	62.07	106.81	108.00	107.71	122.40
Median	121.79	59.03	95.92	96.02	108.89	107.97
Standard Deviation	82.73	23.12	43.92	44.44	9.65	60.31
Standard Error	21.36	5.97	11.34	11.47	2.49	15.57
%CV	58.32	37.25	41.12	41.15	8.96	49.28

Table 59 Ratio of Dextromethorphan Pharmacokinetic Parameters Following the Administration of 60 mg Dextromethorphan Hydrobromide as Treatment A Compared to Three Doses of 20 mg Four Hours Apart (Treatment D) in Normal Volunteers %

Subject	C _{max}	T _{max}	AUC _{0-t}	AUC _{inf}	Half Life	Clearance
Mean	100.31	80.02	83.01	82.77	107.26	164.60
Median	94.35	83.33	77.49	77.84	101.62	158.65
Standard Deviation	37.06	22.83	23.39	22.93	16.71	88.09
Standard Error	10.70	6.59	6.75	6.62	4.82	25.43
%CV	36.94	28.53	28.18	27.71	15.57	53.52

Table 60 Ratio of Dextromethorphan Pharmacokinetic Parameters Following the Administration of 30 mg Dextromethorphan Hydrobromide as Two Doses of 15 mg Six Hours Apart (Treatment E) Compared to 60 mg Dextromethorphan Hydrobromide as Two Doses of 30 mg Six Hours Apart (Treatment C) (%)

Subject	C _{max}	T _{max}	AUC _{0-t}	AUC _{inf}	Half Life	Clearance
Mean	53.89	96.08	51.35	51.73	98.33	278.94
Median	57.20	100.00	50.70	50.64	103.29	214.90
Standard Deviation	17.62	24.88	16.64	16.77	14.88	172.08
Standard Error	4.55	6.42	4.30	4.33	3.84	44.43
%CV	32.70	25.89	32.40	32.42	15.14	61.69

Agent's File Reference: 62808.000021

Table 61 Ratio of Dextromethorphan Pharmacokinetic Parameters Following the Administration of 30 mg Dextromethorphan Hydrobromide as Three Doses of 10 mg Four Hours Apart (Treatment F) Compared to 60 mg Dextromethorphan Hydrobromide as Three Doses of 20 mg Four Hours Apart (Treatment D) (%)						
Subject	C _{max}	T _{max}	AUC _{0-t}	AUC _{inf}	Half Life	Clearance
Mean	53.41	142.42	54.28	54.32	103.46	313.85
Median	56.73	166.67	52.75	52.23	89.13	255.28
Standard Deviation	12.82	67.86	16.26	16.37	35.81	143.22
Standard Error	6.41	33.93	8.13	8.19	17.91	71.61
%CV	24.00	47.65	29.95	30.14	34.62	45.63

[0279] In conclusion, the pharmacokinetics of guaifenesin and dextromethorphan are not affected by the presence of the other component and the pharmacokinetics of dextromethorphan are linear over the range studied.

Example 19

[0280] In another experiment the relative bioavailability of guaifenesin and dextromethorphan from an experimental modified release formulation, containing both guaifenesin and dextromethorphan was compared to reference guaifenesin and dextromethorphan was determined in normal volunteers in a 36 subject open-label, single-dose, randomized, 3-way-crossover study.

[0281] The subjects were randomized and placed into one of three treatment groups. Group 1 received a 1200-mg controlled-release guaifenesin product (Mucinex) plus 60 mg of dextromethorphan hydrobromide (administered as 30 mg every 6 hours), with 240 mL of water after an overnight fast (Reference). Group 2 received a 1200-mg controlled-release guaifenesin product (Mucinex) plus 60 mg of dextromethorphan hydrobromide (administered as 20 mg every 4 hours), with 240 mL of water after an overnight fast (Reference). Group 3 received an experimental controlled-release tablet containing 1200 mg guaifenesin and 60 mg of dextromethorphan hydrobromide, with 240 mL of water after an overnight fast (Test). In this experiment there was a 14-day washout between doses.

[0282] Blood (7 mL sodium heparin anticoagulant) was obtained at the following times: Pre-dose, 0.5, 0.75, 1, 1.5, 2, 3, 4, 4.5, 4.75, 5, 5.5, 6, 6.5, 6.75, 7, 7.5, 8, 9, 10, 11, 12, 14, 16, 24, 36, 48, 72 and 96 hours post dose (the total blood loss for guaifenesin and dextromethorphan analysis was 609 mL). Subjects given 1200 mg of guaifenesin as Mucinex, along with 60 mg dextromethorphan

Agent's File Reference: 62808.000021

hydrobromide as two 30-mg doses 6 hours apart (Treatment A, Reference), reached a mean plasma guaifenesin $C_{\max}$ of 1743 ng/mL in 1.25 hours and had an $AUC_{\inf}$ of 7836 hr-ng/mL. Subjects given 1200 mg of guaifenesin as Mucinex, along with 60 mg dextromethorphan hydrobromide as three 20-mg doses 4 hours apart (Treatment B, Reference), reached a mean plasma guaifenesin $C_{\max}$ of 1783 ng/mL in 1.27 hours and had an $AUC_{\inf}$ of 7616 hr-ng/mL. Subjects given 1200 mg guaifenesin as an experimental formulation, also containing 60 mg dextromethorphan hydrobromide (Treatment C, Test), reached a mean plasma guaifenesin $C_{\max}$ of 1710 ng/mL in 1.55 hour and had an $AUC_{\inf}$ of 7102 hr-ng/mL.

[0283] Subjects given 1200 mg guaifenesin as Mucinex, along with 60 mg dextromethorphan hydrobromide as 30 mg Vick's Formula 44 Cough Medicine and a second 30-mg dextromethorphan hydrobromide dose 6 hours later (Treatment A, Reference), reached a mean plasma dextromethorphan $C_{\max}$ of 7946 pg/mL in 8.32 hours and had an $AUC_{\inf}$ of 294267 hr-pg/mL. Subjects given 1200 mg guaifenesin as Mucinex, along with 60 mg dextromethorphan hydrobromide as 20 mg Vick's Formula 44 Cough Medicine, a second 20-mg dextromethorphan hydrobromide dose 4 hours later and a third 20-mg dextromethorphan hydrobromide dose 4 hours after that (Treatment B, Reference), reached a mean plasma dextromethorphan $C_{\max}$ of 8598 pg/mL in 8.90 hours and had an $AUC_{\inf}$ of 339447 hr-pg/mL. Subjects given 1200 mg guaifenesin along with 60 mg dextromethorphan hydrobromide in an experimental formulation (Treatment C, Test), reached a mean plasma dextromethorphan $C_{\max}$ of 7483 pg/mL in 6.30 hours and had an $AUC_{\inf}$ of 316592 hr-pg/mL.

[0284] The plasma concentrations of guaifenesin are shown in Figure 35. The resulting pharmacokinetic data are shown in Tables 62 through 64. Subjects given 1200 mg of guaifenesin as Mucinex, along with 60 mg dextromethorphan hydrobromide as two 30-mg doses 6 hours apart (Treatment A, Reference), reached a mean plasma guaifenesin $C_{\max}$ of 1743 ± 903 ng/mL (Mean $\pm$ Standard Deviation) in 1.25 ± 0.660 hours and had an $AUC_{\inf}$ of 7836 ± 3616 hr-ng/mL.

Agent's File Reference: 62808.000021

Subjects given 1200 mg of guaifenesin as Mucinex, along with 60 mg dextromethorphan hydrobromide as three 20-mg doses 4 hours apart (Treatment B, Reference), reached a mean plasma guaifenesin C_{max} of 1783 ± 808 ng/mL in 1.27 ± 0.833 hours and had an AUC_{inf} of 7616 ± 3398 hr-ng/mL. Subjects given 1200 mg guaifenesin as an experimental formulation, also containing 60 mg dextromethorphan hydrobromide (Treatment C, Test), reached a mean plasma guaifenesin C_{max} of 1710 ± 807 ng/mL in 1.55 ± 0.789 hour and had an AUC_{inf} of 7102 ± 2807 hr-ng/mL.

Table 62 Guaifenesin Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin as Mucinex along with 60 mg Dextromethorphan Hydrobromide as 30 mg Vick's Formula 44 Cough Medicine and a Second 30-mg Dextromethorphan Hydrobromide Dose 6 Hours Later to Normal Volunteers — Treatment A (Reference)						
Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr*ng/mL)	AUC _{inf} (hr*ng/mL)	Half Life (hr)	Clearance (L/hr)
Mean	1743	1.25	7730	7836	2.60	192
Median	1545	1.00	6854	6956	2.27	173
Standard Deviation	903	0.660	3578	3616	1.37	109
Standard Error	147	0.107	580	587	0.221	17.7
% CV	51.8	52.7	46.3	46.1	52.4	57.0

Table 63 Guaifenesin Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin as Mucinex along with 60 mg Dextromethorphan Hydrobromide as 20 mg Vick's Formula 44 Cough Medicine, a Second 20-mg Dextromethorphan Hydrobromide Dose 4 Hours Later and a Third 20-mg Dextromethorphan Hydrobromide Dose 4 hours After That to Normal Volunteers — Treatment B (Reference)						
Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr*ng/mL)	AUC _{inf} (hr*ng/mL)	Half Life (hr)	Clearance (L/hr)
Mean	1783	1.27	7477	7616	3.19	191
Median	1615	1.00	6948	7268	2.77	165
Standard Deviation	808	0.833	3369	3398	1.81	90.1
Standard Error	137	0.141	570	574	0.307	15.2
% CV	45.3	65.5	45.1	44.6	56.9	47.2

Table 64 Guaifenesin Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin along with 60 mg Dextromethorphan Hydrobromide in an Experimental Formulation to Normal Volunteers — Treatment C (Test)						
Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr*ng/mL)	AUC _{inf} (hr*ng/mL)	Half Life (hr)	Clearance (L/hr)
Mean	1710	1.55	7082	7102	1.24	201
Median	1525	1.50	6847	6899	1.05	174
Standard Deviation	807	0.789	2805	2807	0.501	100
Standard Error	141	0.137	488	489	0.087	17.4
% CV	47.2	51.0	39.6	39.5	40.5	49.8

[0285] The plasma concentrations of dextromethorphan are shown in Figure 36.

The resulting pharmacokinetic data are shown in Tables 65 through 67. Subjects given 1200 mg guaifenesin as Mucinex, along with 60 mg dextromethorphan hydrobromide as 30 mg Vick's Formula 44 Cough Medicine and a second 30-mg dextromethorphan hydrobromide dose 6 hours later (Treatment A, Reference), reached a mean plasma dextromethorphan C_{max} of 7946 ± 12386 pg/mL in 8.32 ± 2.88 hours and had an AUC_{inf} of 294267 ± 724235 hr-pg/mL. Subjects given 1200 mg guaifenesin as Mucinex, along with 60 mg dextromethorphan hydrobromide as 20 mg Vick's Formula 44 Cough Medicine, a second 20-mg dextromethorphan hydrobromide dose 4 hours later and a third 20-mg dextromethorphan hydrobromide dose 4 hours after that (Treatment B, Reference), reached a mean plasma dextromethorphan C_{max} of 8598 ± 13559 pg/mL in 8.90 ± 3.62 hours and had an AUC_{inf} of 339447 ± 850232 hr-pg/mL. Subjects given 60 mg dextromethorphan hydrobromide, along with 1200 mg guaifenesin in an experimental formulation (Treatment C, Test), reached a mean plasma dextromethorphan C_{max} of 7483 ± 12332 pg/mL in 6.30 ± 2.64 hours and had an AUC_{inf} of 316592 ± 796975 hr-pg/mL.

Agent's File Reference: 62808.000021

Table 65 Dextromethorphan Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin as Mucinex Along with 60 mg Dextromethorphan Hydrobromide as 30 mg Vick's Formula 44 Cough Medicine and a Second 30-mg Dextromethorphan Hydrobromide Dose 6 Hours Later to Normal Volunteers — Treatment A (Reference)						
Subject	C _{max} (pg/mL)	T _{max} (hr)	AUC _{0-t} (hr*pg/mL)	AUC _{inf} (hr*pg/mL)	Half Life (hr)	Clearance (L/hr)
Mean	7946	8.32	248123	294267	10.9	2044
Median	2375	8.00	31290	31544	7.57	1394
Standard Deviation	12386	2.88	575122	724235	9.42	2153
Standard Error	2009	0.468	93297	117486	1.53	349
% CV	156	34.7	232	246	86.2	105

Table 66 Dextromethorphan Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin as Mucinex along with 60 mg Dextromethorphan Hydrobromide as 20 mg Vick's Formula 44 Cough Medicine and a Second 20-mg Dextromethorphan Hydrobromide Dose 4 Hours Later and a Third 20-mg Dextromethorphan Hydrobromide Dose 4 Hours After That to Normal Volunteers — Treatment B (Reference)						
Subject	C _{max} (pg/mL)	T _{max} (hr)	AUC _{0-t} (hr*pg/mL)	AUC _{inf} (hr*pg/mL)	Half Life (hr)	Clearance (L/hr)
Mean	8598	8.90	271074	339447	11.3	1920
Median	2470	7.75	31698	31978	7.11	1374
Standard Deviation	13559	3.62	641451	850232	11.4	1655
Standard Error	2292	0.612	108425	143715	1.93	280
% CV	158	40.7	237	250	101	86.2

Table 67 Dextromethorphan Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin and 60 mg Dextromethorphan Hydrobromide in an Experimental Formulation to Normal Volunteers — Treatment C (Test)						
Subject	C _{max} (pg/mL)	T _{max} (hr)	AUC _{0-t} (hr*pg/mL)	AUC _{inf} (hr*pg/mL)	Half Life (hr)	Clearance (L/hr)
Mean	7483	6.30	253196	316592	12.6	2756
Median	2550	5.50	24730	24981	8.64	1760
Standard Deviation	12332	2.64	604557	796975	11.5	3530
Standard Error	2115	0.453	105240	138735	2.00	614
% CV	165	42.00	239	252	91.7	128

[0286] Dextromethorphan hydrobromide is widely recognized as a highly variable drug and therefore one can consider confidence interval width of 70% to 143% as bioequivalent rather than the classical 80% to 125%. In conclusion,

Agent's File Reference: 62808.000021

guaifenesin in the experimental tablet is clearly bioequivalent to that of the Reference, Mucinex, in terms of $C_{\max}$, AUC_{0-t} or $AUC_{\inf}$ as the 90% confidence intervals are all contained within 80% to 125%. Dextromethorphan hydrobromide in the experimental tablet can be considered bioequivalent to both 30 mg dextromethorphan hydrobromide every 6 hours, and 20 mg every 4 hours, in terms of $C_{\max}$, AUC_{0-t} or $AUC_{\inf}$ as the 90% confidence intervals are contained within 70% to 143%.

Example 20

[0287] To determine the relative bioavailability of guaifenesin and dextromethorphan from an experimental modified release formulation containing both guaifenesin and dextromethorphan following the consumption of a high fat meal was compared to following an overnight fast in normal volunteers an open label, single dose, randomized, 2-way crossover study was conducted in 36 subjects.

[0288] The subjects were randomized and placed into one of two treatment groups. Treatment A received a 1200 mg guaifenesin and 60 mg dextromethorphan hydrobromide with 240 mL of water after an overnight fast (Reference). Treatment B received a 1200 mg guaifenesin and dextromethorphan hydrobromide experimental tablet with 240 mL of water within 30 minutes after the beginning of the consumption of a high fat meal (Test). There was a 14 day washout between doses.

[0289] Blood (7 mL, sodium heparin anticoagulant) was obtained at the following times: Pre-dose, 0.5, 0.75, 1, 1.5, 2, 3, 4, 5, 6, 8, 10, 12, 14, 16, 24, 36, 48, 72 and 96 hours post dose (the total blood loss for guaifenesin and dextromethorphan analysis will be 280 mL). Subjects given 1200 mg of guaifenesin and 60 mg dextromethorphan hydrobromide in an experimental formulation following an overnight fast (Treatment A, Reference) reached a mean $C_{\max}$ of 2030 ng/mL in 1.61 hours and had an $AUC_{\inf}$ of 8128 hr-ng/mL. Subjects given 1200 mg of guaifenesin and 60 mg dextromethorphan hydrobromide following the consumption of a high fat meal (Treatment B, Test) reached a mean $C_{\max}$ of 1825 ng/mL (98.0% of that of Treatment A) in 2.93

hours (248% of that of Treatment A) and had an AUC_{inf} of 7093 hr-ng/mL (92.9% of that of Treatment A).

[0290] Subjects given 60 mg dextromethorphan hydrobromide and 1200 mg guaifenesin in an experimental formulation following an overnight fast (Treatment A, Reference) reached a mean dextromethorphan C_{max} of 10722 pg/mL in 6.23 hours and had an AUC_{inf} of 466518 hr-pg/mL. Subjects given 60 mg dextromethorphan hydrobromide and 1200 mg guaifenesin in an experimental formulation after the consumption of a high fat meal (Treatment B, Test) reached a mean dextromethorphan C_{max} of 12757 pg/mL (132% of that of Treatment A) in 5.74 hours (104% of that of Treatment A) and had an AUC_{inf} of 472064 hr-pg/mL (117% of that of Treatment A).

[0291] The plasma concentrations of guaifenesin is shown in Figure 37. The resulting pharmacokinetic data is shown in Tables 68 through 70. Subjects given 1200 mg of guaifenesin and 60 mg dextromethorphan hydrobromide in an experimental formulation following an overnight fast (Treatment A, Reference) reached a mean C_{max} of 2030 ± 882 ng/mL (Mean $\pm$ Standard Deviation) in 1.61 ± 1.15 hours and had an AUC_{inf} of 8128 ± 3497 hr-ng/mL. Subjects given 1200 mg of guaifenesin and 60 mg dextromethorphan hydrobromide in an experimental formulation after the consumption of a high fat meal (Treatment B, Test) reached a mean C_{max} of 1825 ± 789 ng/mL ($98.0\% \pm 40.3\%$ of that of Treatment A) in 2.93 ± 1.44 hours ($248\% \pm 164\%$ of that of Treatment A) and had an AUC_{inf} of 7093 ± 2787 hr-ng/mL ($92.9\% \pm 23.6\%$ of that of Treatment A).

Table 68 Guaifenesin Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin and 60 mg Dextromethorphan Hydrobromide in an Experimental Formulation to Normal Volunteers Following an Overnight Fast — Treatment A (Reference)						
Subject	C_{max} (ng/mL)	T_{max} (hr)	AUC_{0-t} (hr*ng/mL)	AUC_{inf} (hr*ng/mL)	Half Life (hr)	Clearance (L/hr)
Mean	2030	1.61	8107	8128	1.15	172
Median	1760	1.5	777	7789	1.04	154
Std. Dev.	882	1.15	3485	3497	0.356	65.7
Std. Err.	151	0.198	598	600	0.0611	11.3
% CV	43.4	71.4	43.0	43.0	30.97	38.1

Table 69 Guaifenesin Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin and 60 mg Dextromethorphan Hydrobromide in an Experimental Formulation to Normal Volunteers After the Consumption of a High Fat Meal — Treatment B (Test)						
Subject	C _{max} (ng/mL)	T _{max} (hr)	AUC _{0-t} (hr*ng/mL)	AUC _{inf} (hr*ng/mL)	Half Life (hr)	Clearance (L/hr)
Mean	1825	2.93	7077	7093	0.849	190
Median	1520	3	6201	6228	0.854	193
Std. Dev.	789	1.44	2788	2787	0.115	60.6
Std. Err.	133	0.243	471	471	0.0194	10.2
% CV	43.2	49.1	39.4	39.3	13.5	31.9

Table 70 Ratio of Guaifenesin Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin and 60 mg Dextromethorphan Hydrobromide After the Consumption of a High Fat Meal Compared to that Following an Overnight Fast (%)						
Subject	C _{max}	T _{max}	AUC _{last}	AUC _{tot}	t _{half}	Clearance
Mean	98.0	248	92.9	92.9	79.5	114
Median	89.8	250	88.9	88.3	79.5	113
Std. Dev.	40.3	163.7	23.7	23.6	19.4	26.8
Std. Err.	6.92	28.1	4.07	4.05	3.33	4.60
% CV	41.1	66.0	25.6	25.4	24.4	23.5

[0292] The plasma concentrations of dextromethorphan is shown in Figure 38. The resulting pharmacokinetic data is shown in Tables 71 to 73. Subjects given 60 mg dextromethorphan hydrobromide and 1200 mg guaifenesin in an experimental formulation following an overnight fast (Treatment A, Reference) reached a mean dextromethorphan C_{max} of 10722 ± 15966 pg/mL in 6.23 ± 3.55 hours and had an AUC_{inf} of 466518 ± 987204 hr-pg/mL. Subjects given 60 mg dextromethorphan hydrobromide and 1200 mg guaifenesin in an experimental formulation after the consumption of a high fat meal (Treatment B, Test) reached a mean dextromethorphan C_{max} of 12757 ± 17914 pg/mL (132% ± 69.8% of that of Treatment A) in 5.74 ± 2.27 hours (104% ± 43.4% of that of Treatment A) and had an AUC_{inf} of 472064 ± 977485 hr-pg/mL (117% ± 61.5% of that of Treatment A).

Agent's File Reference: 62808.000021

Table 71 Dextromethorphan Pharmacokinetic Parameters Following the Administration of 60 mg Dextromethorphan Hydrobromide and 1200 mg Guaifenesin in an Experimental Formulation to Normal Volunteers Following an Overnight Fast — Treatment A (Reference)						
Subject	C _{max} (pg/mL)	T _{max} (hr)	AUC _{0-t} (hr*pg/mL)	AUC _{inf} (hr*pg/mL)	Half Life (hr)	Clearance (L/hr)
Mean	10722	6.23	372897	466518	13.8	2343
Median	3020	6.0	33799	34134	8.52	1287
Std. Dev.	15966	3.55	753127	987204	12.8	3352
Std. Err.	2738	0.609	129160	169304	2.19	575
% CV	149	57.0	202	212	92.7	143

Table 72 Dextromethorphan Pharmacokinetic Parameters Following the Administration of 60 mg Dextromethorphan Hydrobromide and 1200 mg Guaifenesin to Normal Volunteers After the Consumption of a High Fat Meal — Treatment B (Test)						
Subject	C _{max} (pg/mL)	T _{max} (hr)	AUC _{0-t} (hr*pg/mL)	AUC _{inf} (hr*pg/mL)	Half Life (hr)	Clearance (L/hr)
Mean	12757	5.74	381391	472064	13.5	2246
Median	3470	5	37515	37808	7.98	1174
Std. Dev.	17914	2.27	753249	977485	13.3	2905
Std. Err.	3028	0.384	127322	165225	2.3	491
% CV	140	39.6	198	207	98.5	129

Table 73 Ratio of Dextromethorphan Pharmacokinetic Parameters Following the Administration of 60 mg Dextromethorphan Hydrobromide and 1200 mg Guaifenesin After the Consumption of a High Fat Meal Compared to that Following an Overnight Fast (%)						
Subject	C _{max}	T _{max}	AUC _{0-t}	AUC _{inf}	Half Life	Clearance
Mean	132	104	118	117	98.6	100
Median	124	100	106	106	100	94.4
Std. Dev.	69.8	43.4	62.2	61.5	18.8	35.6
Std. Err.	12.0	7.5	10.7	10.5	3.22	6.10
% CV	52.8	41.9	52.8	52.6	19.0	35.7

[0293] In conclusion, there is no food effect on the absorption of guaifenesin from the experimental tablet. There is an effect of food on the rate of absorption of dextromethorphan from the experimental tablet formulation (a small increase in the rate of absorption) but not on the extent of absorption.

Example 21

[0294] To determine the relative bioavailability of guaifenesin and dextromethorphan from an experimental modified release formulation containing both guaifenesin and dextromethorphan was compared to reference guaifenesin and dextromethorphan products in normal volunteers an open-label, multiple-dose, randomized, 3-way-crossover study was conducted in 36 subjects.

[0295] The subjects were randomized and placed into one of three treatment groups.

Group 1 received a 1200-mg controlled-release guaifenesin product (Mucinex) plus 60 mg of dextromethorphan hydrobromide (administered as 30 mg every 6 hours) with 240 mL of water after an overnight fast, and again 12 hours later for 11 twelve-hour dosing periods (Treatment A, Reference). Group 2 received a 1200-mg controlled-release guaifenesin product (Mucinex) plus 60 mg of dextromethorphan hydrobromide (administered as 20 mg every 4 hours) with 240 mL of water after an overnight fast, and again 12 hours later for 11 twelve-hour dosing periods (Treatment B, Reference). Group 3 received an experimental controlled-release tablet containing 1200 mg guaifenesin and 60 mg of dextromethorphan hydrobromide with 240 mL of water after an overnight fast, and again 12 hours later for 11 twelve-hour dosing periods (Treatment C, Test). There was a 14-day washout between doses.

[0296] Blood (7 mL, sodium heparin anticoagulant) was obtained at the following times: Day 1 Pre-AM dose, Day 4 Pre-AM dose and Day 5 Pre-AM dose for all three treatment groups. On Day 6 Treatment A subjects were bled at: Pre-Dose, 0.5, 0.75, 1, 1.5, 2, 3, 4, 5, 6, 6.5, 6.75, 7, 7.5, 8, 9, 10, 11, 12, 14, 16, 24, 36, 48, 72, and 96 hours post dose. Treatment B subjects were bled at: Pre-dose, 0.5, 0.75, 1, 1.5, 2, 3, 4, 4.5, 4.75, 5, 5.5, 6, 7, 8, 8.5, 8.75, 9, 9.5, 10, 11, 12, 14, 16, 24, 36, 48, 72 and 96 hours post dose. On Day 6, Treatment C subjects were bled at: Pre-dose, 0.5, 0.75, 1, 1.5, 2, 3, 4, 5, 6, 8, 10, 12, 14, 16, 24, 36, 48, 72 and 96 hours post dose (the total blood loss for guaifenesin and dextromethorphan analysis was 588 mL).

[0297] Subjects given 1200 mg of guaifenesin as Mucinex, along with 60 mg dextromethorphan hydrobromide as two 30-mg doses 6 hours apart (Treatment A, Reference), reached a mean steady-state plasma guaifenesin $C_{\max}$ of 1935 ng/mL in 1.27 hours after the last dose (121 hours after the first dose); had a $C_{\min}$ of 75.5 ng/mL, a C_{AVE} of 631 ng/mL and an $\text{AUC}_{\text{Steady State}}$ of 7540 hr-ng/mL. Subjects given 1200 mg of guaifenesin as Mucinex, along with 60 mg dextromethorphan hydrobromide as three 20-mg doses 4 hours apart (Treatment B, Reference), reached a mean steady-state plasma guaifenesin $C_{\max}$ of 1938

ng/mL in 0.850 hours after the last dose (121 hours after the first dose), had a $C_{\min}$ of 59.6 ng/mL, a C_{AVE} of 618 ng/mL and an $\text{AUC}_{\text{Steady State}}$ of 7403 hr-ng/mL. Subjects given 1200 mg guaifenesin as an experimental formulation, also containing 60 mg dextromethorphan hydrobromide (Treatment C, Test), reached a mean steady-state plasma guaifenesin $C_{\max}$ of 1780 ng/mL in 1.35 hours after the last dose (121 hours after the first dose), had a $C_{\min}$ of 18.2 ng/mL, a C_{AVE} of 601 ng/mL and an $\text{AUC}_{\text{Steady State}}$ of 7138 hr-ng/mL.

[0298] Subjects given 60 mg dextromethorphan hydrobromide as 30 mg Vick's Formula 44 Cough Medicine along with 1200 mg guaifenesin as Mucinex and a second 30-mg dextromethorphan hydrobromide dose 6 hours later (Treatment A, Reference), reached a mean steady-state plasma dextromethorphan $C_{\max}$ of 17960 pg/mL in 5.03 hours after the last dose (125 hours after the first dose), had a $C_{\min}$ of 11949 pg/mL, a C_{AVE} of 15167 pg/mL and an $\text{AUC}_{\text{Steady State}}$ of 181904 hr-pg/mL. Subjects given 60 mg dextromethorphan hydrobromide as three 20-mg doses of Vick's Formula 44 Cough Medicine four hours apart, along with 1200 mg of guaifenesin as Mucinex (Treatment B, Reference), reached a mean steady-state plasma dextromethorphan $C_{\max}$ of 17251 pg/mL in 5.91 hours after the last dose (126 hours after the first dose), had a $C_{\min}$ of 11018 pg/mL, a C_{AVE} of 14097 pg/mL and an $\text{AUC}_{\text{Steady State}}$ of 169160 hr-pg/mL. Subjects given 60 mg dextromethorphan hydrobromide and 1200 mg guaifenesin as an experimental formulation (Treatment C, Test), reached a mean steady-state plasma dextromethorphan $C_{\max}$ of 17213 pg/mL in 5.10 hours after the last dose (125 hours after the first dose), had a $C_{\min}$ of 10978 pg/mL, a C_{AVE} of 14609 pg/mL and an $\text{AUC}_{\text{Steady State}}$ of 175309 hr-pg/mL.

[0299] The plasma concentrations of guaifenesin are shown in figures 39 and 40. The resulting pharmacokinetic data are shown in Tables 74 through 76. Subjects given 1200 mg of guaifenesin as Mucinex, along with 60 mg dextromethorphan hydrobromide as two 30-mg doses 6 hours apart (Treatment A, Reference), reached a mean steady-state plasma guaifenesin $C_{\max}$ of 1935 ± 746 ng/mL at 121 ± 0.854 hours after the first dose (1.27 hours after the last dose), had a $C_{\min}$ of 75.5 ± 73.9 ng/mL, a C_{AVE} of 631 ± 212 ng/mL and an $\text{AUC}_{\text{Steady State}}$ of $7540 \pm$

2570 hr-ng/mL. Subjects given 1200 mg of guaifenesin as Mucinex, along with 60 mg dextromethorphan hydrobromide as three 20-mg doses 4 hours apart (Treatment B, Reference), reached a mean steady-state plasma guaifenesin $C_{\max}$ of 1938 ± 637 ng/mL at 121 ± 0.463 hours after the first dose (0.850 hours after the last dose), had a $C_{\min}$ of 59.6 ± 51.9 ng/mL, a C_{AVE} of 618 ± 205 ng/mL and an $\text{AUC}_{\text{Steady State}}$ of 7403 ± 2474 hr-ng/mL. Subjects given 1200 mg guaifenesin as an experimental formulation, also containing 60 mg dextromethorphan hydrobromide (Treatment C, Test), reached a mean steady-state plasma guaifenesin $C_{\max}$ of 1780 ± 633 ng/mL at 121 ± 0.864 hours after the first dose (1.35 hours after the last dose), had a $C_{\min}$ of 18.2 ± 18.3 ng/mL, a C_{AVE} of 601 ± 189 ng/mL and an $\text{AUC}_{\text{Steady State}}$ of 7138 ± 2268 hr-ng/mL.

Table 74 Steady-State Guaifenesin Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin as Mucinex Every 12 Hours for 11 Doses and 60 mg Dextromethorphan Hydrobromide as 30 mg Vick's Formula 44 Every 6 Hours for 22 Doses to Normal Volunteers (Treatment A, Reference)									
Subject	AUC_{ss} (hr-ng/mL)	$C_{\min}$ (ng/mL)	$C_{\max}$ (ng/mL)	$T_{\max}$ (hr)	C_{average} (ng/mL)	%Ptf (%)	%Swing (%)	L_z (hr ⁻¹)	$T_{1/2}$ (hr)
Mean	7540	75.5	1935	122	631	296	5828	0.270	3.11
Median	7366	59.0	1910	121	614	297	2962	0.226	3.07
Std. Dev.	2570	73.9	746	0.854	212	56.2	6702	0.151	1.26
Std. Error	441	12.7	128	0.146	36.4	9.64	1149	0.026	0.217
% CV	34.1	97.9	38.6	0.704	33.7	19.0	115	55.8	40.6

Table 75 Steady-State Guaifenesin Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin as Mucinex Every 12 Hours for 11 Doses and 60 mg Dextromethorphan Hydrobromide as 20 mg Vick's Formula 44 Every 4 Hours for 22 Doses to Normal Volunteers (Treatment B, Reference)									
Subject	AUC_{ss} (hr-ng/mL)	$C_{\min}$ (ng/mL)	$C_{\max}$ (ng/mL)	$T_{\max}$ (hr)	C_{average} (ng/mL)	%Ptf (%)	%Swing (%)	L_z (hr ⁻¹)	$T_{1/2}$ (hr)
Mean	7403	59.6	1938	121	618	313	7215	0.269	3.22
Median	7230	36.1	1910	121	603	294	3173	0.227	3.05
Std. Dev.	2474	51.9	637	0.463	205	72	8948	0.164	1.36
Std. Error	424	8.90	109	0.079	35.2	12.4	1535	0.028	0.232
% CV	33.4	87.1	32.9	0.383	33.2	23.2	124	61.0	42.1

Agent's File Reference: 62808.000021

Table 76 Steady-State Guaifenesin Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin and 60 mg Dextromethorphan Hydrobromide in an Experimental Formulation Every 12 Hours for 11 Doses to Normal Volunteers (Treatment C, Reference)									
Subject	AUC _{ss} (hr-ng/mL)	C _{min} (ng/mL)	C _{max} (ng/mL)	T _{max} (hr)	C _{average} (ng/mL)	%Ptf (%)	%Swing (%)	L _z (hr ⁻¹)	T _{1/2} (hr)
Mean	7138	18.2	1780	121	601	292	14215	0.431	1.91
Median	6992	13.7	1770	121	583	291	10240	0.414	1.67
Std. Dev.	2268	18.3	633	0.864	189	45.2	11362	0.177	0.832
Std. Error	395	3.18	110	0.150	32.8	7.88	1978	0.031	0.145
% CV	31.8	101	35.6	0.712	31.4	15.5	79.9	41.1	43.6

[0300] The plasma concentrations of dextromethorphan are shown in figures 41 and 42. The resulting pharmacokinetic data are shown in Tables 77 through 79. Subjects given 60 mg dextromethorphan hydrobromide as 30 mg Vick's Formula 44 Cough Medicine, along with 1200 mg guaifenesin as Mucinex and a second 30-mg dextromethorphan hydrobromide dose 6 hours later (Treatment A, Reference), reached a mean steady-state plasma dextromethorphan C_{max} of 17960 ± 37537 pg/mL at 125 ± 2.94 hours after the first dose (5.03 hours after the last dose), had a C_{min} of 11949 ± 28101 pg/mL, a C_{AVE} of 15167 ± 33349 pg/mL and an AUC_{Steady State} of 181904 ± 400226 hr-pg/mL. Subjects given 60 mg dextromethorphan hydrobromide as three 20-mg doses of Vick's Formula 44 Cough Medicine 4 hours apart, along with 1200 mg of guaifenesin as Mucinex (Treatment B, Reference), reached a mean steady-state plasma dextromethorphan C_{max} of 17251 ± 39562 pg/mL, at 126 ± 1.73 hours after the first dose (5.91 hours after the last dose), had a C_{min} of 11018 ± 26007 pg/mL, a C_{AVE} of 14097 ± 33537 pg/mL and an AUC_{Steady State} of 169160 ± 402449 hr-pg/mL. Subjects given 60 mg dextromethorphan hydrobromide and 1200 mg guaifenesin as an experimental formulation (Treatment C, Test), reached a mean steady-state plasma dextromethorphan C_{max} of 17213 ± 33703 pg/mL at 125 ± 1.62 hours (5.10 hours after the last dose), had a C_{min} of 10978 ± 24713 pg/mL, a C_{AVE} of 14609 ± 30804 pg/mL and an AUC_{Steady State} of 175309 ± 369653 hr-pg/mL.

Agent's File Reference: 62808.000021

Table 77 Steady-State Dextromethorphan Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin as Mucinex Every 12 Hours for 11 Doses and 60 mg Dextromethorphan Hydrobromide as 30 mg Vick's Formula 44 Every 6 Hours for 22 Doses to Normal Volunteers (Treatment A, Reference)

Subject	AUC _{ss} (hr-pg/mL)	C _{min} (pg/mL)	C _{max} (pg/mL)	T _{max} (hr)	C _{average} (pg/mL)	%Ptf (%)	%Swing (%)	L _z (hr ⁻¹)	T _{1/2} (hr)
Mean	181904	11949	17960	125	15167	56.4	80.0	0.108	8.67
Median	39400	2270	4100	124	3312	53.1	73.1	0.113	6.13
Std. Dev.	400226	28101	37537	2.94	33349	19.7	37.7	0.045	8.50
Std. Error	68638	4819	6438	0.503	5719	3.38	6.47	0.008	1.46
% CV	220	235	209	2.35	220	35.0	47.2	41.4	98.1

Table 78 Steady-State Dextromethorphan Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin as Mucinex Every 12 Hours for 11 Doses and 60 mg Dextromethorphan Hydrobromide as 20 mg Vick's Formula 44 Every 4 Hours for 22 Doses to Normal Volunteers (Treatment B, Reference)

Subject	AUC _{ss} (hr-pg/mL)	C _{min} (pg/mL)	C _{max} (pg/mL)	T _{max} (hr)	C _{average} (pg/mL)	%Ptf (%)	%Swing (%)	L _z (hr ⁻¹)	T _{1/2} (hr)
Mean	169160	11018	17251	126	14097	57.2	78.4	0.090	11.8
Median	36778	2280	4250	126	3065	58.7	75.6	0.075	9.27
Std. Dev.	402449	26007	39562	1.73	33537	19.0	32.1	0.054	9.54
Std. Error	69019	4460	6785	0.297	5752	3.26	5.51	0.009	1.64
% CV	238	236	229	1.38	238	33.2	41.0	59.7	80.9

Table 79 Steady-State Dextromethorphan Pharmacokinetic Parameters Following the Administration of 1200 mg Guaifenesin and 60 mg Dextromethorphan Hydrobromide in an Experimental Formulation Every 12 Hours for 11 Doses to Normal Volunteers (Treatment C, Reference)

Subject	AUC _{ss} (hr-pg/mL)	C _{min} (pg/mL)	C _{max} (pg/mL)	T _{max} (hr)	C _{average} (pg/mL)	%Ptf (%)	%Swing (%)	L _z (hr ⁻¹)	T _{1/2} (hr)
Mean	175309	10978	17213	125	14609	74.0	129	0.112	7.84
Median	37663	1855	4355	125	3139	73.4	126	0.113	6.12
Std. Dev.	369653	24713	33703	1.62	30804	23.2	56.3	0.042	5.71
Std. Error	64348	4302	5867	0.282	5362	4.04	9.80	0.007	0.994
% CV	211	225	196	1.30	211	31.4	43.6	37.6	72.8

[0301] In conclusion, guaifenesin in the experimental tablet is bioequivalent to that of the Reference, Mucinex, in terms of C_{max} and AUC_{ss}, as the 90% confidence

Agent's File Reference: 62808.000021

intervals are all contained within 80% to 125%. Dextromethorphan hydrobromide in the experimental tablet is bioequivalent to both 30 mg dextromethorphan hydrobromide every 6 hours, and 20 mg every 4 hours, in terms of $C_{\max}$ and AUC_{ss} , as the 90% confidence intervals are contained within 80% to 125%.

[0302] Other embodiments and uses of the invention will be apparent to those of skill in the art from consideration of the specification and practice of the invention disclosed herein. The specification and examples should be considered exemplary only with the true scope and spirit of the invention indicated by the following claims. As will be easily understood by those of skill in the art, variations and modifications of each of the disclosed embodiments can be easily made within the scope of this invention as defined by the following claims.

The embodiments of the present invention for which an exclusive property or privilege is claimed are defined as follows:

1. A modified release drug product comprising a first quantity of guaifenesin and an additional active ingredient in an immediate release formulation wherein the guaifenesin becomes bioavailable in a subject's stomach; a second quantity of guaifenesin in a release-delaying matrix; and at least one additional drug,

wherein the release-delaying matrix comprises a hydrophilic polymer and a water-insoluble polymer in a weight ratio of hydrophilic polymer to water-insoluble polymer from about 1:1 to about 9:1,

wherein the immediate release formulation guaifenesin has a C_{max} in a human subject equivalent to the C_{max} obtained when a dose of a standard immediate release formulation having one third the amount of guaifenesin is dosed, and immediately after administration the serum concentration of guaifenesin peaks in about an hour, followed by a gradual serum concentration decrease over twenty-four hours but the serum concentration of guaifenesin never decreases below the minimum concentration of said standard immediate release formulation over twelve hours, and

wherein the drug product releases a therapeutically effective bioavailable guaifenesin dose for at least twelve hours after a single dose in the human subject according to serum analysis.

2. The modified release drug product according to claim 1, wherein the hydrophilic polymer is acacia, gum tragacanth, locust bean gum, guar gum, karaya gum, modified cellulosic, methylcellulose, hydroxymethylcellulose, hydroxypropyl methylcellulose, hydroxypropyl cellulose, hydroxyethylcellulose, carboxymethylcellulose, agar, pectin, carrageen, alginate, carboxypolymethylene, gelatin, casein, zein, bentonite, magnesium aluminum silicate, polysaccharide, modified starch derivatives, or a combination thereof.

3. The modified release drug product according to claim 1, wherein the water-insoluble polymer is polyacrylic acid, acrylic resin, acrylic latex dispersion, cellulose acetate phthalate, polyvinyl acetate phthalate, hydroxypropyl methylcellulose phthalate, or a combination thereof.

4. The modified release drug product according to claim 1, wherein the hydrophilic polymer is hydroxypropyl methylcellulose and the water-insoluble polymer is an acrylic resin.
5. The modified release drug product according to claim 1, wherein the immediate release formulation, release-delaying matrix, or both further comprises the at least one additional drug.
6. The modified release drug product according to claim 1, wherein the additional drug is an antitussive, a decongestant, an antihistamine, an analgesic, or combinations thereof.
7. The modified release drug product according to claim 6, wherein the additional drug is dextromethorphan hydrobromide, codeine, hydrocodone, phenylephrine hydrochloride, phenylpropanolamine hydrochloride, pseudoephedrine hydrochloride, ephedrine, chlorpheniramine maleate, brompheniramine maleate, phenindamine tartrate, pyrilamine maleate, doxylamine succinate, phenyltoloxamine citrate, diphenhydramine hydrochloride, promethazine, clemastine fumarate, AspirinTM, ibuprofen, acetaminophen, naprosin, or combinations thereof.
8. The modified release drug product according to claim 6, wherein the additional drug is dextromethorphan hydrobromide, pseudoephedrine hydrochloride, or a combination thereof.
9. The modified release drug product according to claim 1, further comprising binders, colorants, excipients, glidants, lubricants, preservatives, stabilizers, surface active agents, or combinations thereof.
10. The modified release drug product according to claim 9, wherein the lubricant is magnesium stearate, calcium stearate, zinc stearate, powdered stearic acid, hydrogenated vegetable oil, talc, polyethylene glycol, mineral oil, or a combination thereof.
11. The modified release drug product according to claim 9, wherein the binder is sucrose, lactose, gelatin, starch paste, acacia, tragacanth, povidone, polyethylene glycol, Pullulan, corn syrup, or a combination thereof.
12. The modified release drug product according to claim 9, wherein the glidant is colloidal silicon dioxide, talc, or a combination thereof.

13. The modified release drug product according to claim 9, wherein the surface active agent is sodium lauryl sulfate, dioctyl sodium sulfosuccinate, triethanolamine, polyoxyethylene sorbitan, poloxalkol, quaternary ammonium salts, or a combination thereof.
14. The modified release drug product according to claim 9, wherein the excipient is mannitol, glucose, fructose, xylose, galactose, maltose, xylitol, sorbitol, potassium chloride, potassium sulfate, potassium phosphate, sodium chloride, sodium sulfate, sodium phosphate, magnesium chloride, magnesium sulfate, magnesium phosphate, microcrystalline cellulose, sodium starch glycolate, or a combination thereof.
15. The modified release drug product according to claim 9, wherein the colorant is Emerald Green Lake, FD&C Red #40, FD&C Yellow #6, FD&C Yellow #10, FD&C Blue #1, or a combination thereof.
16. The modified release drug product according to claim 1, wherein the immediate release formulation further comprises microcrystalline cellulose, sodium starch glycolate, and magnesium stearate.
17. The modified release drug product according to claim 1, wherein a total quantity of guaifenesin is from about 600 mg to about 1200 mg.
18. The modified release drug product according to claim 1, wherein a ratio of a total quantity of guaifenesin to the additional drug is from about 1:1 to about 4:1 by weight.
19. The modified release drug product according to claim 1, wherein a ratio of a total quantity of guaifenesin to the additional drug is from about 3:2 to about 9:1 by weight.
20. The modified release drug product according to claim 1 or 17, wherein a ratio of the first quantity of guaifenesin to the second quantity of guaifenesin is about 1:1 to about 1:49 by weight.
21. The modified release drug product according to claim 1 or 17, wherein a ratio of the first quantity of guaifenesin to the second quantity of guaifenesin is from about 2:3 to about 1:19.
22. The modified release drug product according to claim 17, wherein guaifenesin has a C_{max} of at least about 1900 ng/ml and an AUC_{inf} of at least 7000 hr*ng/ml.

23. The modified release drug product according to claim 17, wherein guaifenesin has a C_{max} of at least 1000 ng/ml and an AUC_{inf} of at least 3500 hr*ng/ml.

24. The modified release drug product according to claim 1, wherein the guaifenesin has a half life of at least 3 hours as determined by serum analysis.

25. The modified release drug product according to claim 1, wherein the release-delaying matrix comprises about 75% to about 95% by weight of guaifenesin, from about 1% to about 15% of the additional drug, from about 1% to about 10% of the hydrophilic polymer, and about 0.5% to about 2.5% of the water-insoluble polymer by weight.

26. The modified release drug product according to claim 1, wherein the immediate release formulation and the release-delaying matrix each comprise abutting substantially planar layers which form a bilayer tablet.

27. The modified release drug product according to claim 1, wherein the release-delaying matrix is coated by a layer of the immediate release formulation.

28. The modified release drug product according to claim 17, wherein the release-delaying matrix comprises from about 80% to about 90% by weight of guaifenesin, from about 3% to about 10% by weight of the additional drug, from about 2% to about 5% of the hydrophilic polymer, and from about 1% to about 1.5% by weight of the water-insoluble polymer.

29. A modified release drug product comprising a first quantity of guaifenesin and an additional active ingredient in an immediate release formulation wherein the guaifenesin becomes bioavailable in a subject's stomach; a second quantity of guaifenesin in a sustained release form,

wherein the sustained release form comprises a hydrophilic polymer and a water-insoluble polymer in a weight ratio of hydrophilic polymer to water-insoluble polymer from about 1:1 to about 9:1,

wherein the immediate release formulation guaifenesin has a C_{max} in a human subject equivalent to the C_{max} obtained when a dose of a standard immediate release formulation having one third the amount of guaifenesin is dosed, and immediately after administration the serum concentration of guaifenesin peaks in about an hour, followed by a gradual serum

concentration decrease over twenty-four hours but the serum concentration of guaifenesin never decreases below the minimum concentration of said standard immediate release formulation over twelve hours, and

wherein the drug product releases a therapeutically effective bioavailable guaifenesin dose for at least twelve hours after a single dose in the human subject according to serum analysis.

30. The modified release drug product according to claim 29, wherein a total quantity of guaifenesin is from about 600 mg to about 1200 mg.

31. The modified release drug product of claim 30, wherein a ratio of the first quantity of guaifenesin to the second quantity of guaifenesin is about 1:1 to about 1:49.

32. The modified release drug product of claim 30, wherein a ratio of the first quantity of guaifenesin to the second quantity of guaifenesin is about 2:3 to about 1:19.

33. The modified release drug product according to claim 30, wherein guaifenesin has a C_{max} from about 1600 to 2500 ng/ml and an AUC_{inf} of about 5600 to 8750 hr*ng/ml.

34. The modified release drug product according to claim 30, wherein the guaifenesin has a C_{max} of at least 1900 ng/ml and an AUC_{inf} of at least 7000 hr*ng/ml.

35. The modified release drug product according to claim 30, wherein the guaifenesin has a C_{max} of about 800 to 1250 ng/ml and an AUC_{inf} of about 2800 to 4375 hr*ng/ml.

36. The modified release drug product according to claim 30, wherein the guaifenesin has a C_{max} of at least 1000 ng/ml and an AUC_{inf} of at least 3500 hr*ng/ml.

37. The modified release drug product according to claim 29, wherein the guaifenesin has a half life of at least three hours as determined by serum analysis.

38. The modified release drug product according to claim 29, wherein the immediate release formulation and the sustained release form each comprise abutting substantially planar layers which form a bilayer tablet.

39. The modified release drug product according to claim 29, wherein the sustained release form is coated by a layer of the immediate release formulation.

40. The modified release drug product according to claim 29, wherein the drug product is shaped as a capsule and contains the immediate release formulation and the sustained release form.

41. The modified release drug product according to claim 29, wherein the drug product is approximately equally effective when administered to the human subject with an empty or full stomach.

42. The modified release drug product according to claim 30, wherein the drug product has a guaifenesin serum concentration profile of FIG. 10.

43. A modified release drug product comprising a first quantity of guaifenesin and an additional active ingredient in an immediate release formulation wherein the guaifenesin becomes bioavailable in a subject's stomach; a second quantity of guaifenesin in a sustained release formulation; and at least one additional drug,

wherein the sustained release formulation comprises a hydrophilic polymer and a water-insoluble polymer in a weight ratio of hydrophilic polymer to water-insoluble polymer from about 1:1 to about 9:1,

wherein the ratio of the first quantity to the second quantity of guaifenesin is about 1:1 to about 1:49,

wherein the immediate release formulation guaifenesin has a C_{max} in a human subject equivalent to the C_{max} obtained when a dose of a standard immediate release formulation having one third the amount of guaifenesin is dosed, and immediately after administration the serum concentration of guaifenesin peaks in about an hour, followed by a gradual serum concentration decrease over twenty-four hours but the serum concentration of guaifenesin never decreases below the minimum concentration of said standard immediate release formulation over twelve hours, and

wherein the drug product provides a therapeutically effective bioavailable guaifenesin dose for at least twelve hours after a single dose in the human subject according to serum analysis.

44. The modified release drug product according to claim 43, wherein a total quantity of guaifenesin is from about 600 mg to about 1200 mg.

45. The modified release drug product according to claim 43, wherein the additional drug is an antitussive, decongestant, antihistamine, analgesic, or combinations thereof.
46. The modified release drug product according to claim 45, wherein the additional drug is dextromethorphan hydrobromide, codeine, hydrocodone, phenylephrine hydrochloride, phenylpropanolamine hydrochloride, pseudoephedrine hydrochloride, ephedrine, chlorpheniramine maleate, brompheniramine maleate, phenindamine tartrate, pyrilamine maleate, doxylamine succinate, phenyltoloxamine citrate, diphenhydramine hydrochloride, promethazine, clemastine fumarate, acetaminophen, AspirinTM, ibuprofen, naprosin, or combinations thereof.
47. The modified release drug product according to claim 45, wherein the additional drug is dextromethorphan hydrobromide, pseudoephedrine hydrochloride, or a combination thereof.
48. The modified release drug product according to claim 43, wherein a ratio of a total quantity of guaifenesin to the additional drug is from about 1:1 to about 4:1 by weight.
49. The modified release drug product according to claim 43, wherein a ratio of a total quantity of guaifenesin to the additional drug is from about 3:2 to about 9:1 by weight.
50. The modified release drug product according to claim 43 or 49, wherein a ratio of the first quantity of guaifenesin to the second quantity of guaifenesin is from about 2:3 to about 1:19.
51. The modified release drug product according to claim 44, wherein a guaifenesin C_{max} of the drug product is from about 1600 to 2500 ng/ml and an AUC_{inf} is from about 5600 to 8750 hr*ng/ml.
52. The modified release drug product according to claim 44, wherein a guaifenesin C_{max} is at least 1900 ng/ml and an AUC_{inf} is at least 7000 hr*ng/ml.
53. The modified release drug product according to claim 44, wherein a guaifenesin C_{max} is about 800 to 1250 ng/ml and an AUC_{inf} is from about 2800 to 4375 hr*ng/ml.
54. The modified release drug product according to claim 44, wherein a guaifenesin C_{max} is at least 1000 ng/ml and an AUC_{inf} is at least 3500 hr*ng/ml.

55. The modified release drug product according to claim 43, wherein the guaifenesin has a half life of at least three hours as determined by serum analysis.
56. The modified release drug product according to claim 43, wherein the immediate release formulation and the sustained release formulation each comprise abutting substantially planar layers which form a bilayer tablet.
57. The modified release drug product according to claim 43, wherein the sustained release formulation is coated by a layer of the immediate release formulation.
58. The modified release drug product according to claim 43, wherein the drug product is shaped as a capsule containing the immediate release formulation and the sustained release formulation.
59. The modified release drug product according to claim 43, wherein the drug product is approximately equally effective when administered to the human subject with an empty or full stomach.
60. The modified release drug product according to claim 44, wherein the drug product has the serum guaifenesin concentration profile of FIG. 10.
61. A use, for treating coughing and symptoms or diseases associated with coughing in a subject in need of such treatment, of a therapeutically effective amount of a modified release drug product according to claim 1, 29 or 43 effective to treat coughing and symptoms or diseases associated with coughing in the subject.
62. The use according to claim 61, wherein the drug product is in a form for oral administration.
63. The use according to claim 61, wherein the additional drug is an antitussive, a decongestant, an antihistamine, an analgesic, or combinations thereof.
64. The use according to claim 63, wherein the additional drug is dextromethorphan hydrobromide, codeine, hydrocodone, phenylephrine hydrochloride, phenylpropanolamine hydrochloride, pseudoephedrine hydrochloride, ephedrine, chlorpheniramine maleate, brompheniramine maleate, phenindamine tartrate, pyrilamine maleate, doxylamine succinate, phenyltoloxamine citrate, diphenhydramine hydrochloride, promethazine, clemastine fumarate, AspirinTM, ibuprofen, acetaminophen, naprosin, or combinations thereof.

65. The use according to claim 63, wherein the additional drug is dextromethorphan hydrobromide, pseudoephedrine hydrochloride, or a combination thereof.

66. The use according to claim 61, wherein a total quantity of guaifenesin is from about 600 mg to about 1200 mg.

67. The use according to claim 61, wherein a ratio of a total quantity of guaifenesin to the additional drug is from about 1:1 to about 4:1 by weight.

68. The use according to claim 61, wherein a ratio of the first quantity of guaifenesin to the second quantity of guaifenesin is about 1:1 to about 1:49 by weight.

69. The use according to claim 61, wherein guaifenesin has a C_{max} of at least about 1900 ng/ml and an AUC_{inf} of at least 7000 hr*ng/ml.

70. A use, for treating coughing and symptoms or diseases associated with coughing in a subject in need of such treatment, of a therapeutically effective amount of a modified release drug product having a first quantity of guaifenesin in an immediate release formulation which becomes fully bioavailable in a subject's stomach and a second quantity of guaifenesin in a release-delaying matrix comprising a hydrophilic polymer and a water-insoluble polymer wherein a weight ratio of said hydrophilic polymer to said water-insoluble polymer is in a range of from about 1:1 to about 6:1, wherein said immediate release formulation guaifenesin demonstrates a C_{max} in a human subject equivalent to the C_{max} obtained when a dose of a standard immediate release formulation having one third the amount of guaifenesin is dosed, and immediately after administration the serum concentration of guaifenesin peaks in about an hour, followed by a gradual serum concentration decrease over twenty-four hours but the serum concentration of guaifenesin never decreases below the minimum concentration of said standard immediate release formulation over twelve hours, and wherein said drug product provides therapeutically effective bioavailability for at least twelve hours after a single dose in the human subject according to serum analysis.

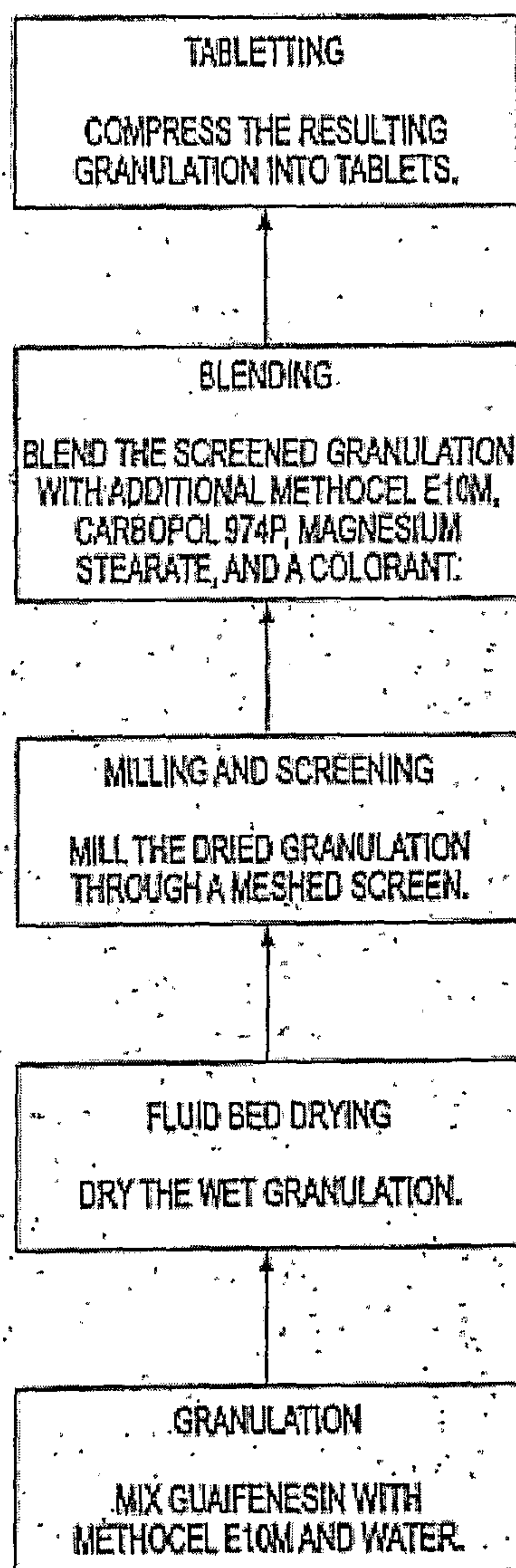
71. The use according to claim 70, wherein the drug product is in a form for oral administration.

72. The use according to claim 70, wherein a ratio of the first quantity of guaifenesin to the second quantity of guaifenesin is about 1:1 to about 1:49 by weight.

73. The use according to claim 70, wherein guaifenesin has a C_{max} of at least about 1900 ng/ml and an AUC_{inf} of at least 7000 hr*ng/ml.
74. The modified release drug product according to claim 1 or 43, wherein a ratio of a total quantity of guaifenesin to the additional drug is from about 3:1 to about 20:1 by weight.
75. The modified release drug product according to claim 1 or 43, wherein the guaifenesin has a half life of at least 1.3 hours as determined by serum analysis.
76. The modified release drug product according to claim 43, wherein the immediate release formulation, sustained release formulation, or both comprises the at least one additional drug.
77. The use according to claim 61, wherein a ratio of a total quantity of guaifenesin to the additional drug is from about 3:1 to about 20:1 by weight.

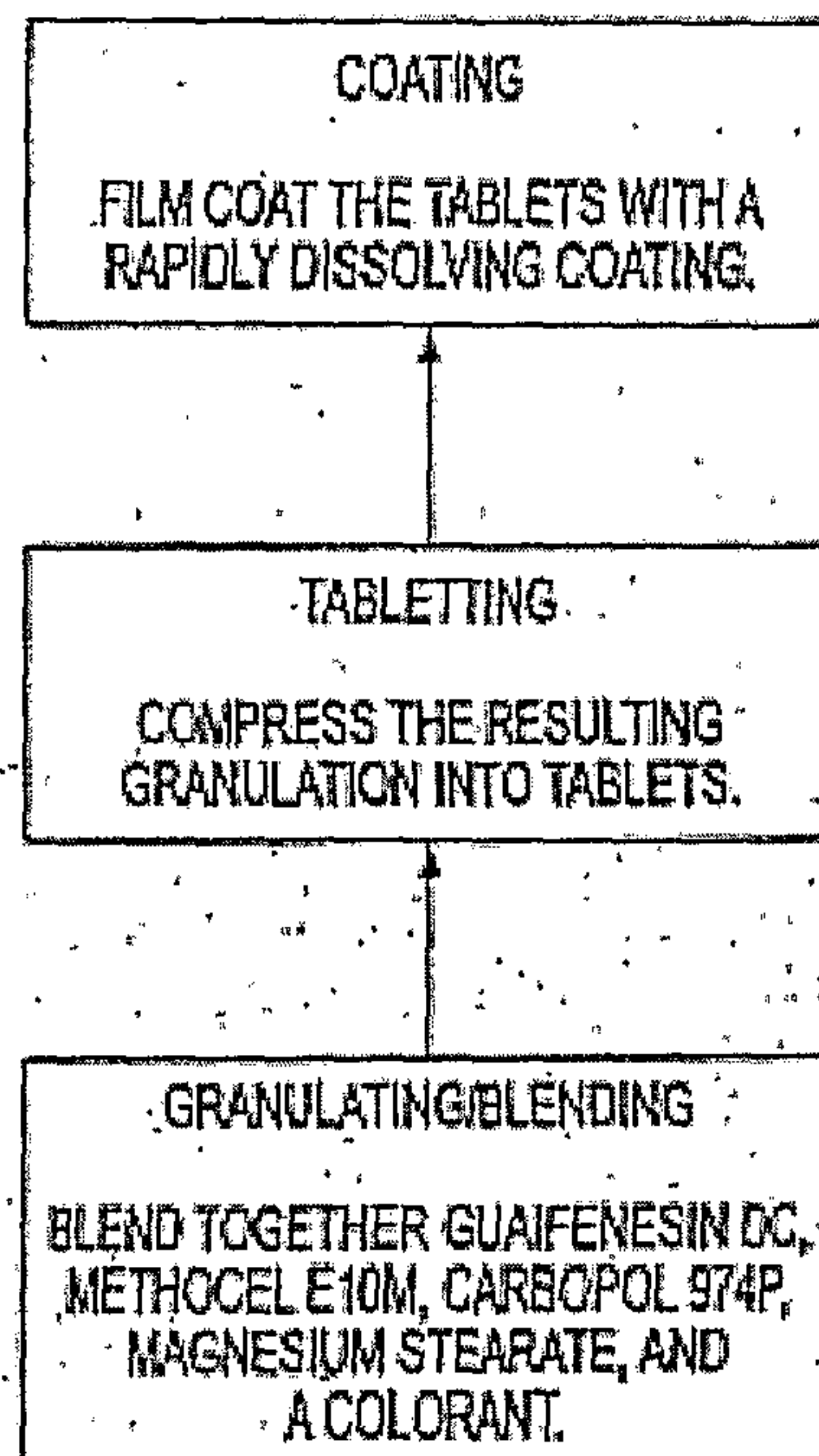
1 / 45

Figure 1



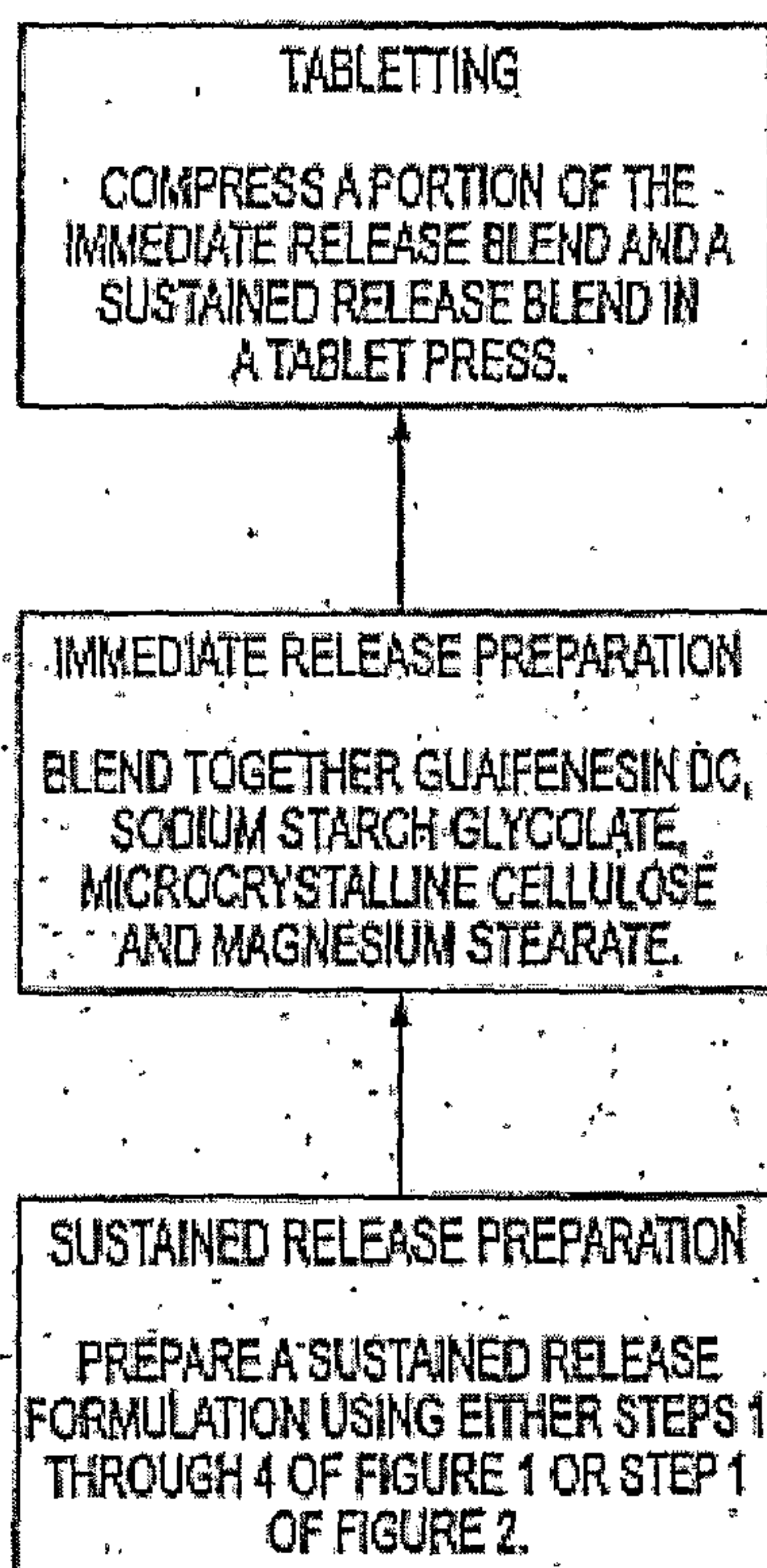
2 / 45

Figure 2



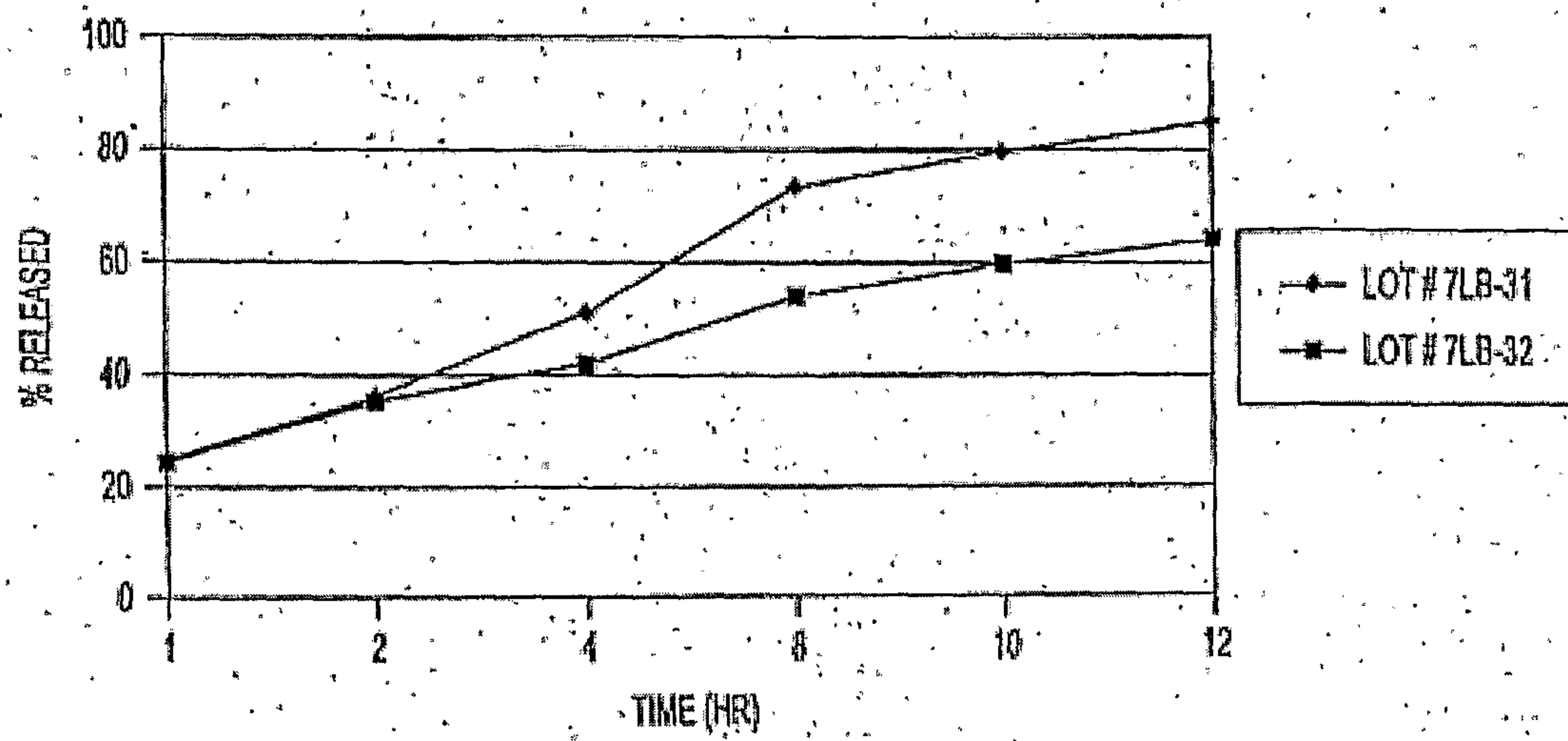
3 / 45

Figure 3



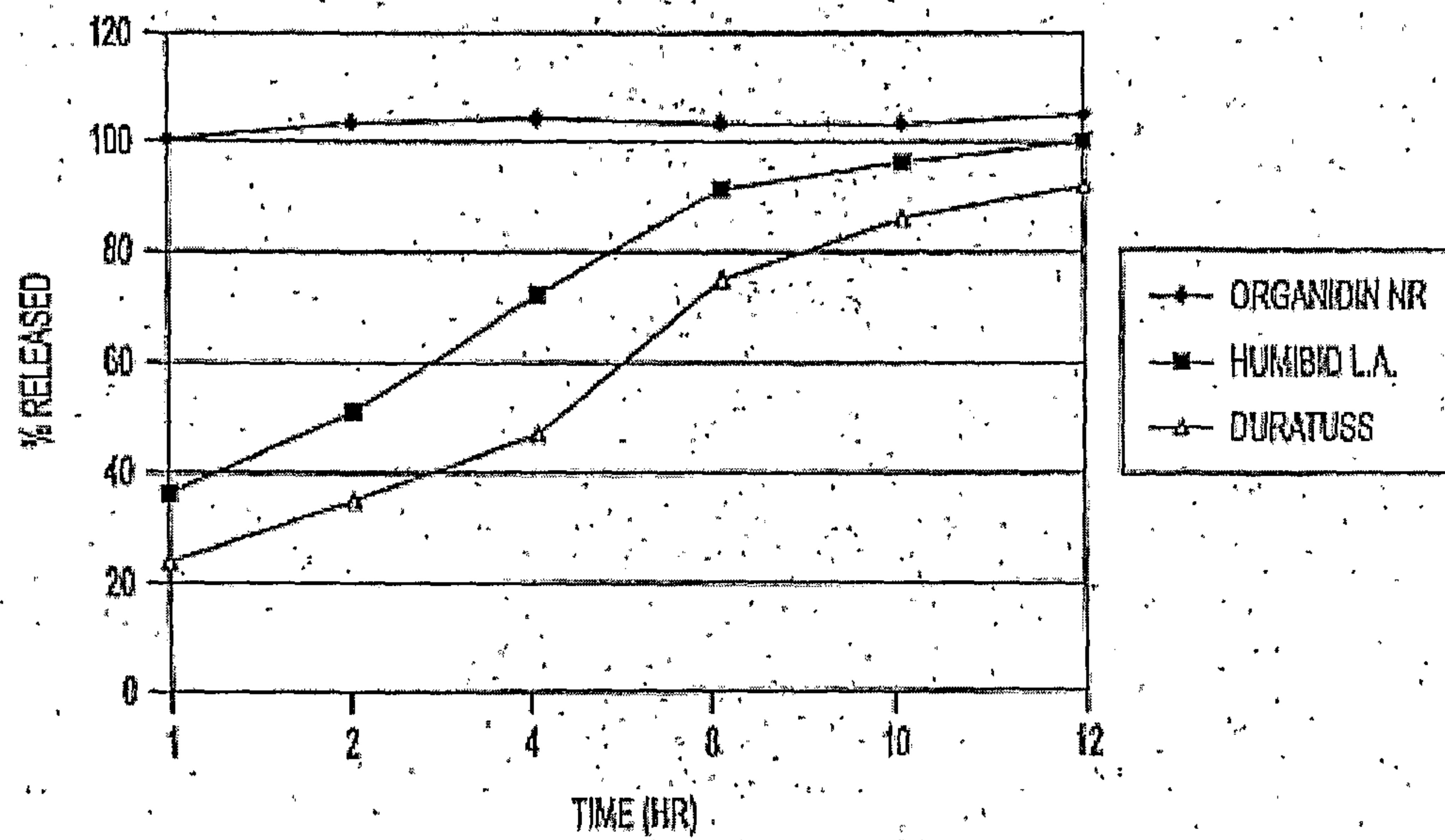
4 / 45

Figure 4



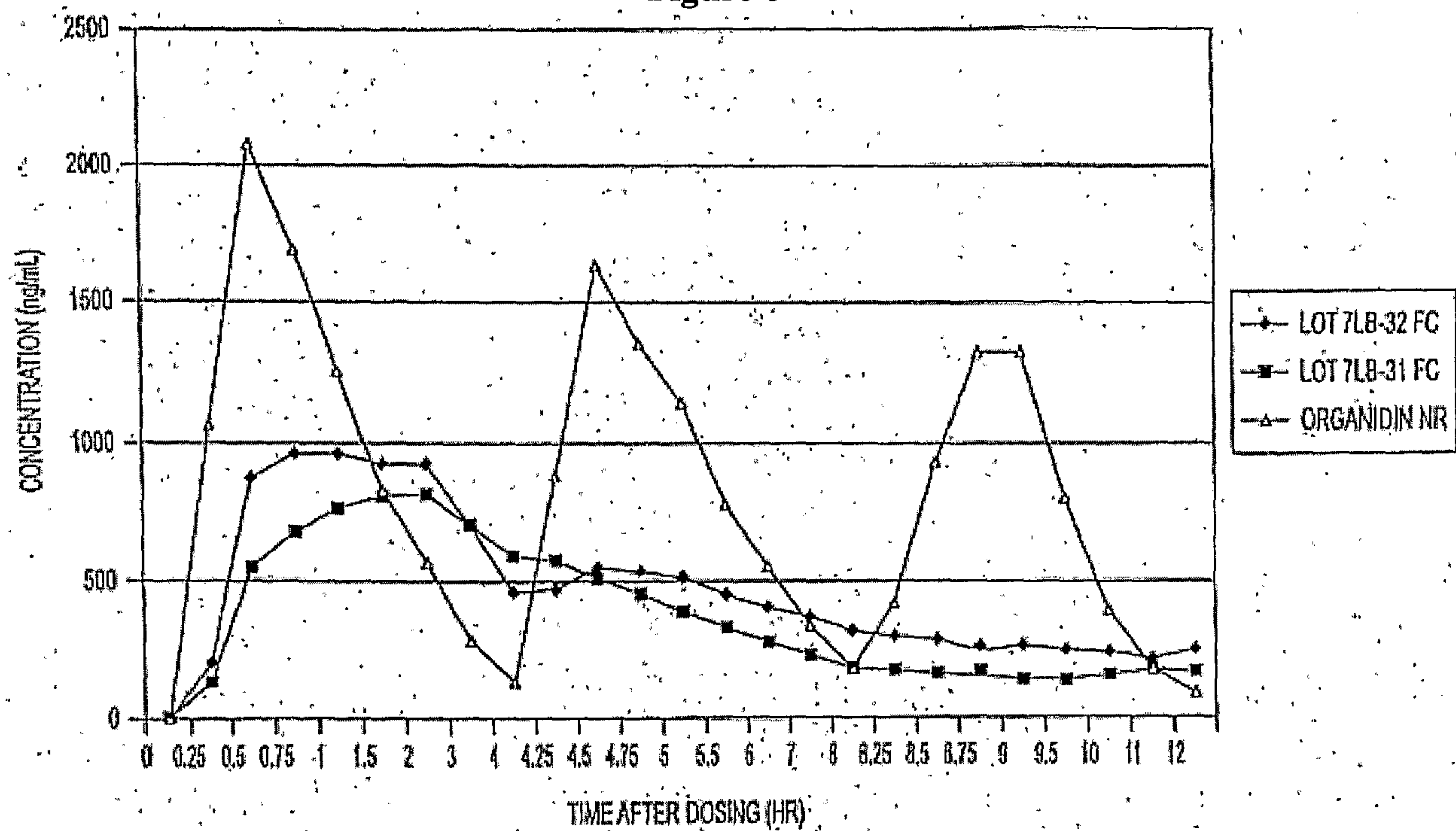
5 / 45

Figure 5



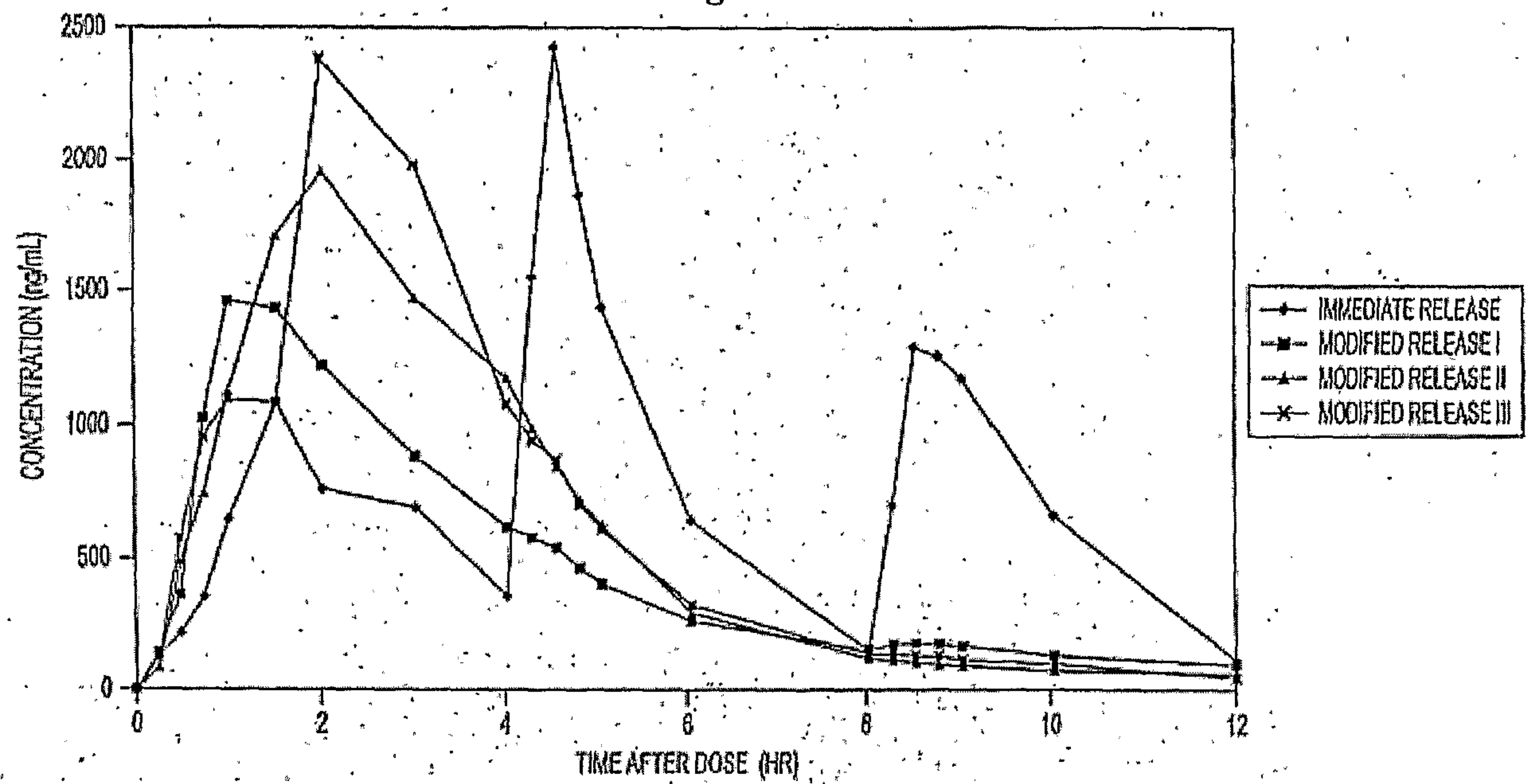
6 / 45

Figure 6



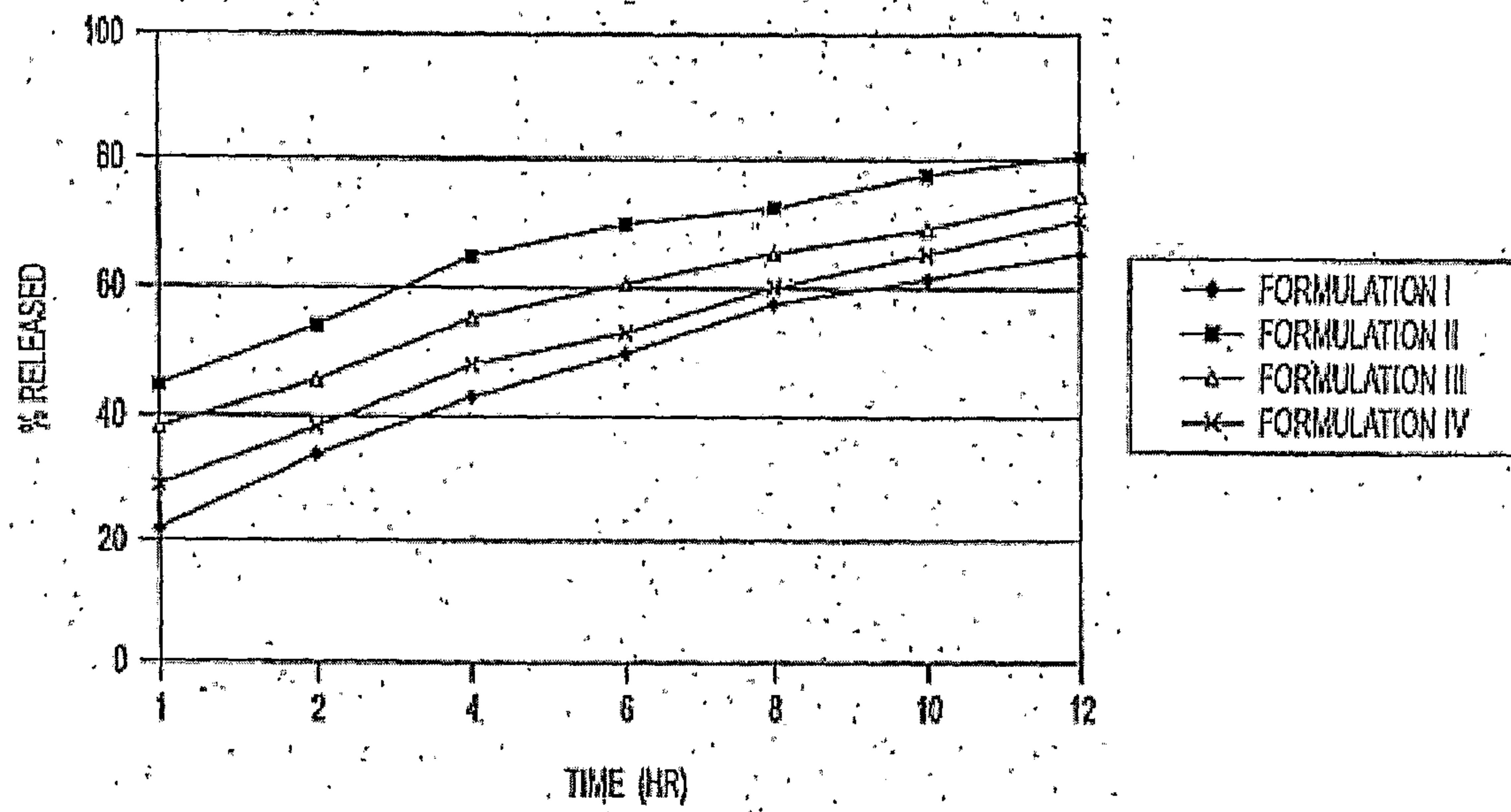
7 / 45

Figure 7



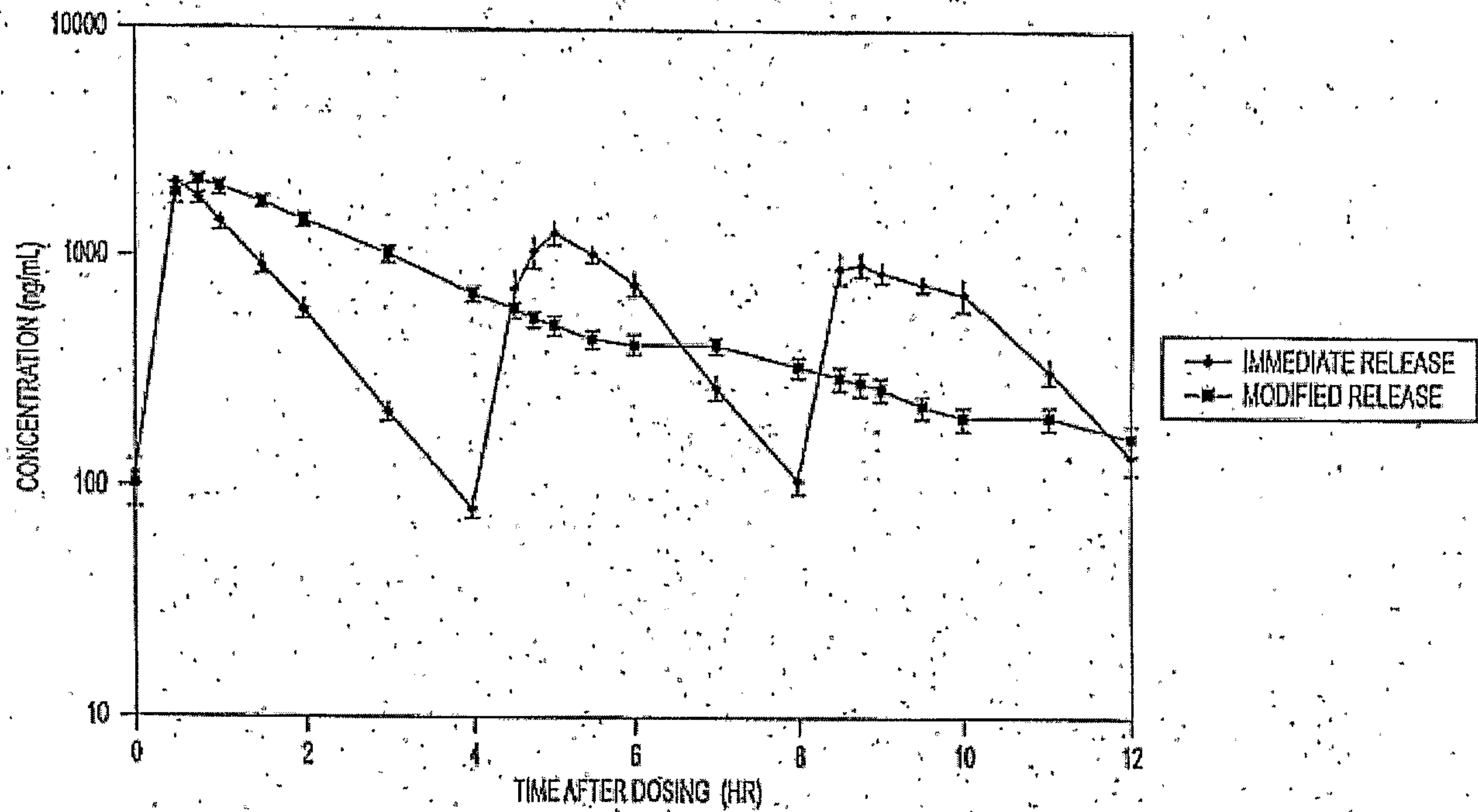
8 / 45

Figure 8



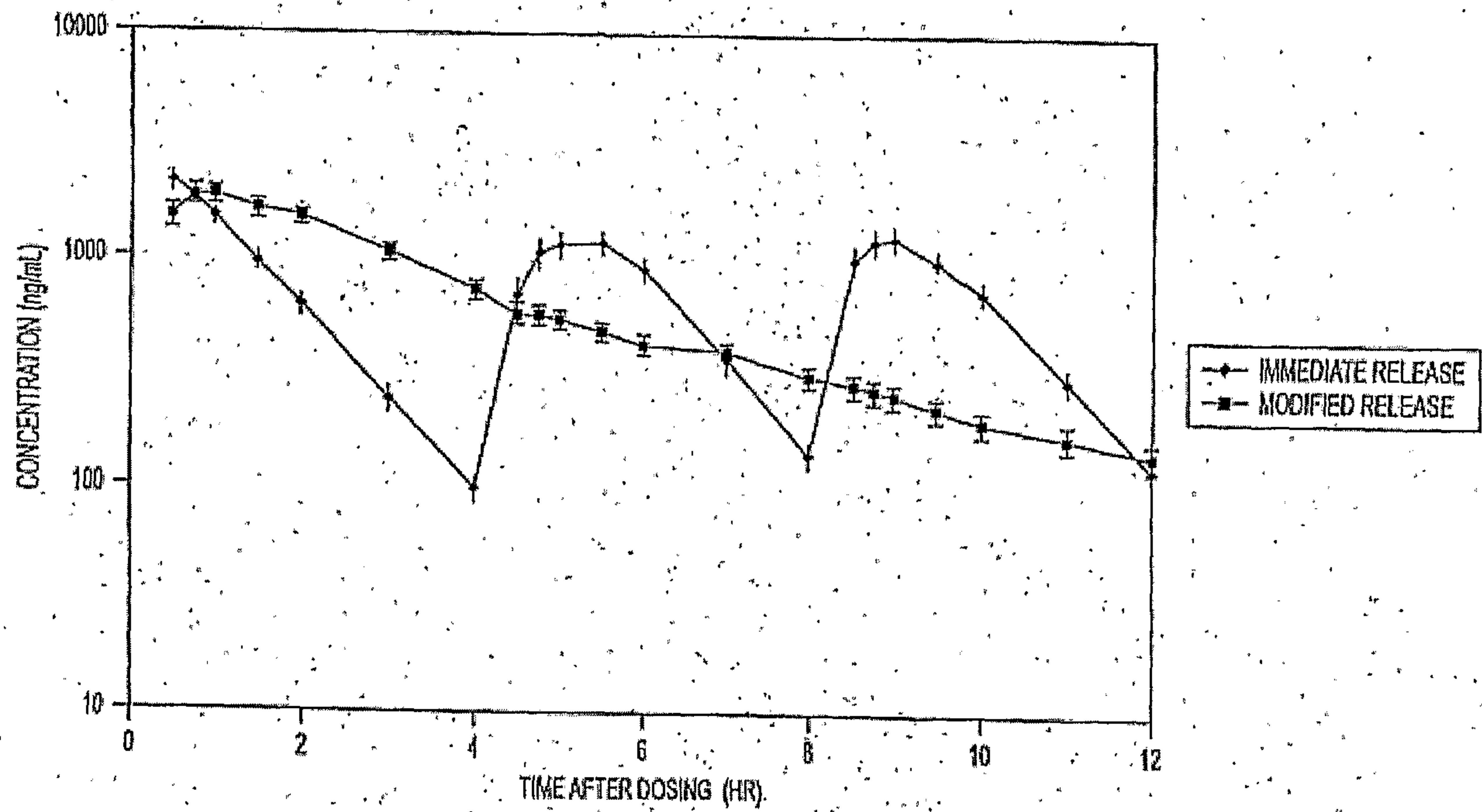
9 / 45

Figure 9



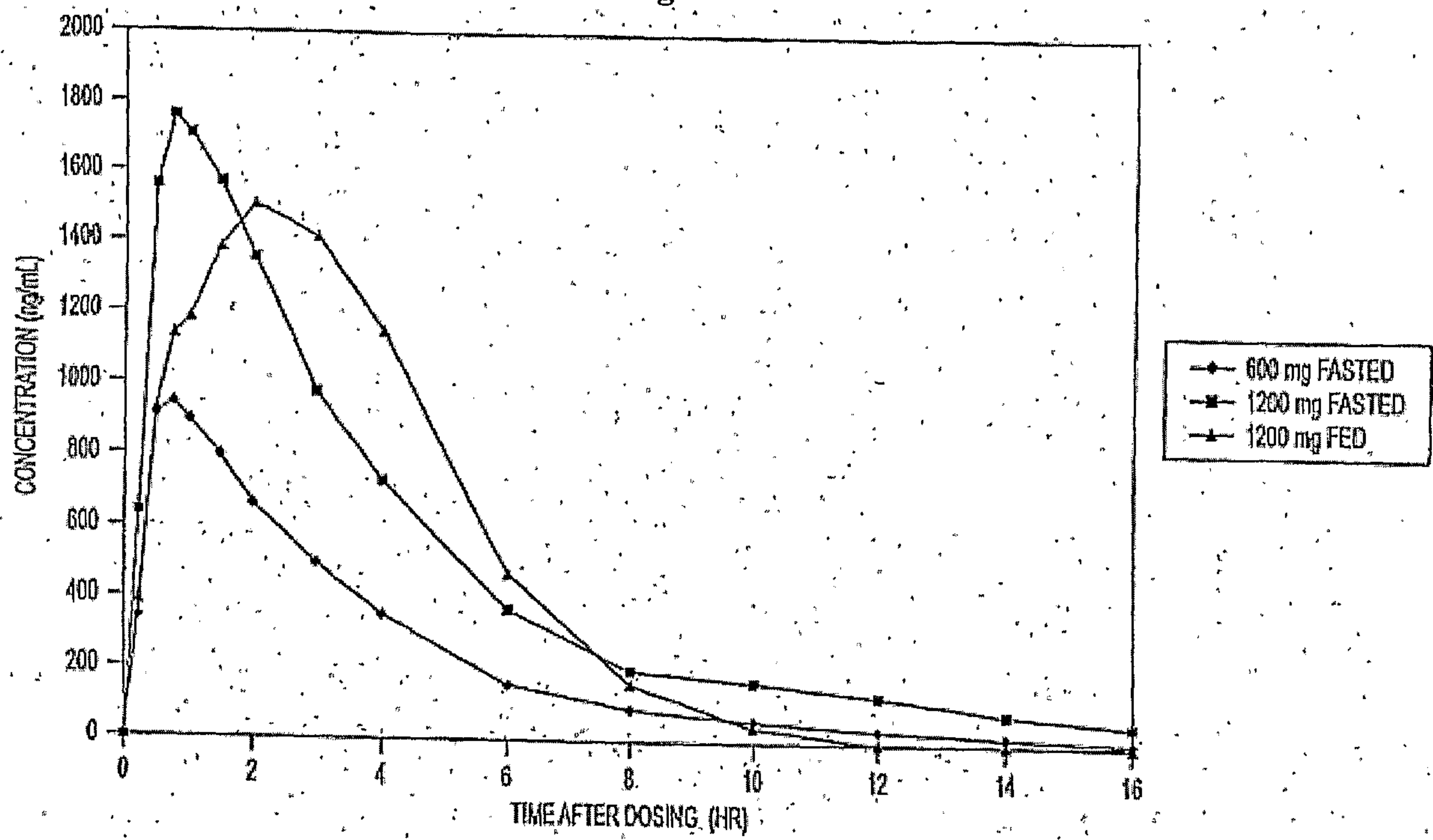
10 / 45

Figure 10



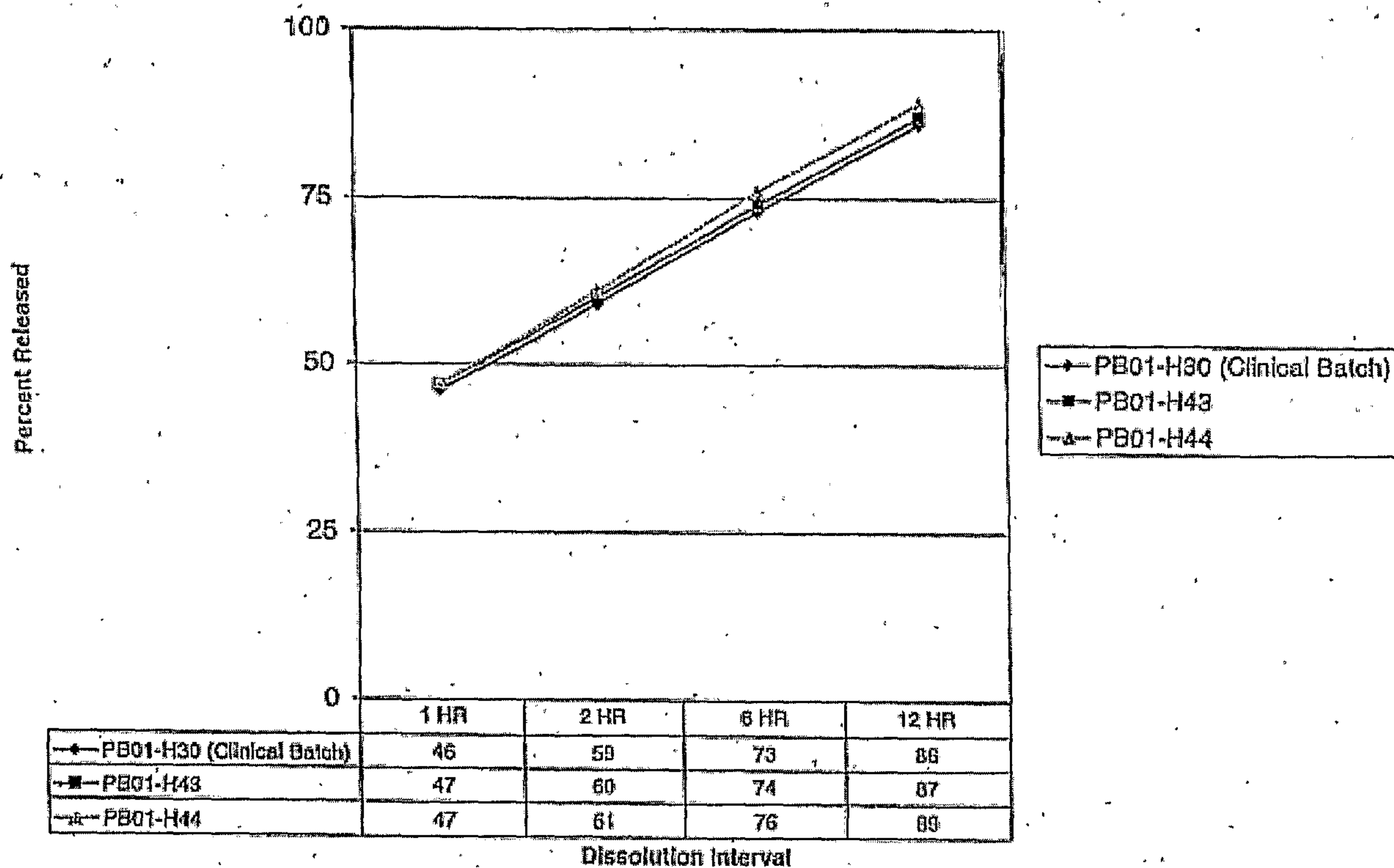
11 / 45

Figure 11



12 / 45

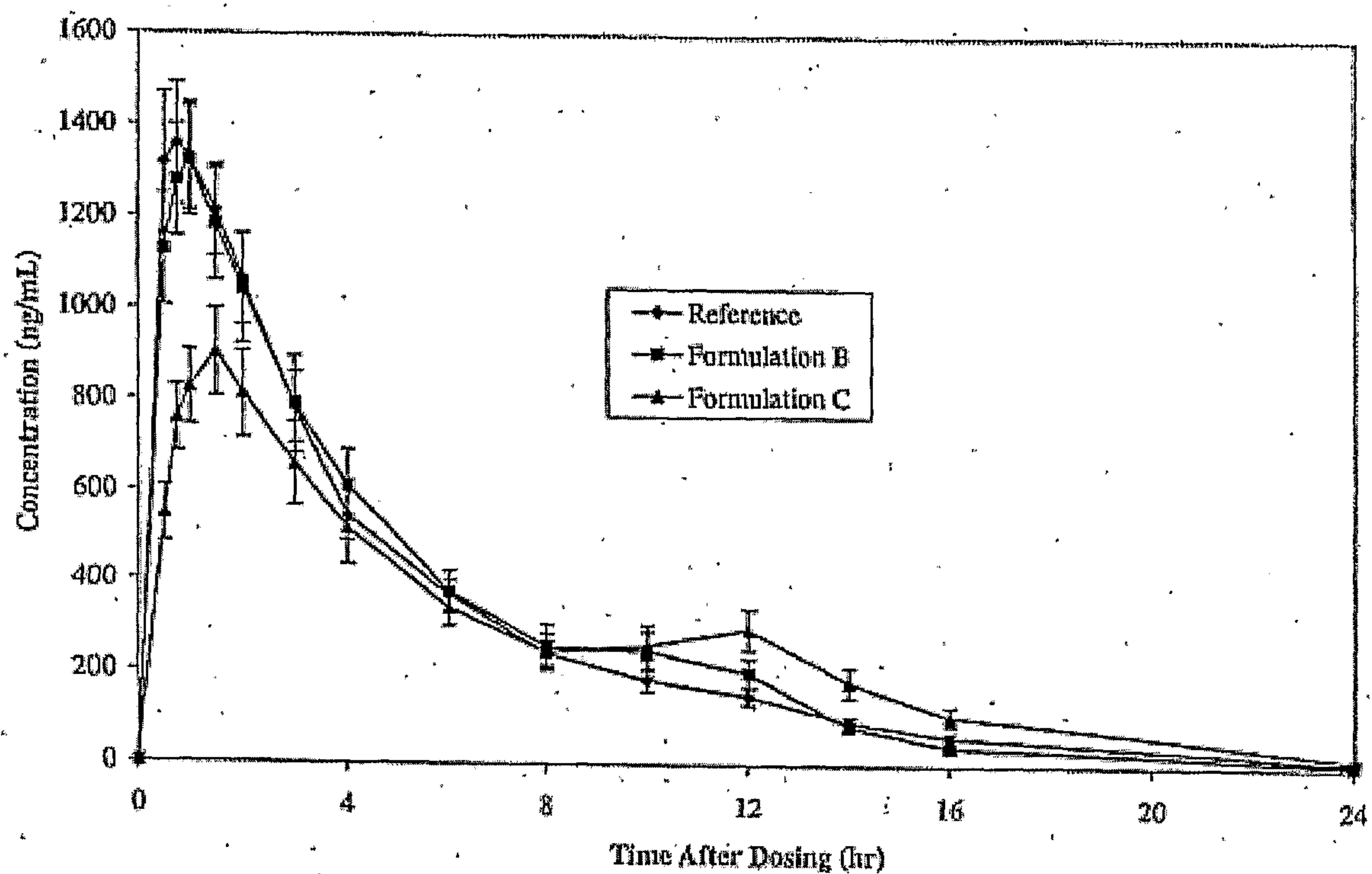
Figure 12
Dextromethorphan HBr Dissolution Release Rates for Mucinex DM
1200 mg Guaifenesin / 60 mg Dextromethorphan HBr (Mean, Standard Error)



13 / 45

Figure 13

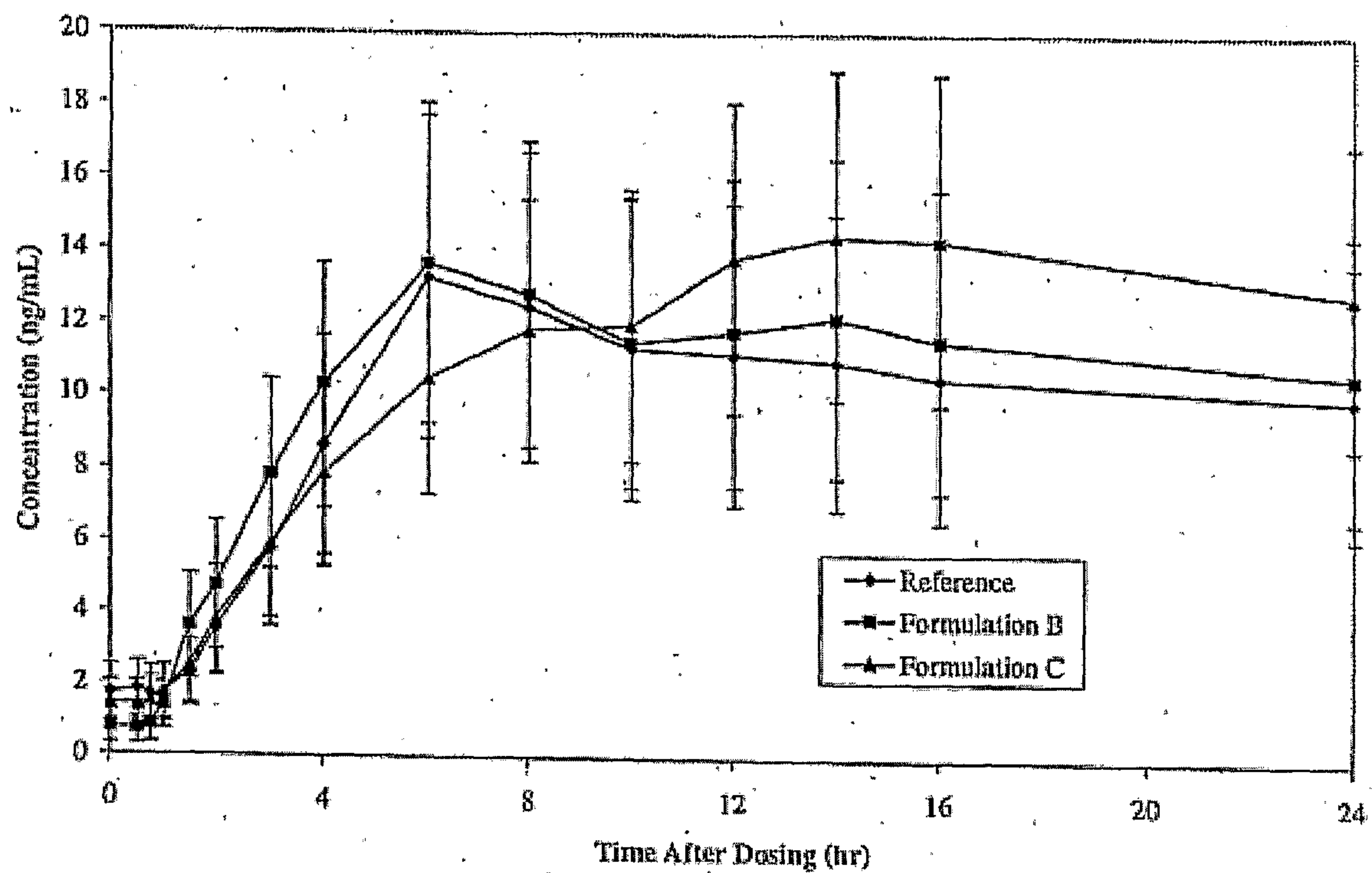
Guaifenesin Plasma Concentrations Following the Administration of 1200 mg Guaifenesin and 60 mg Dextromethorphan Hydrobromide to Normal Volunteers in Three Formulations (Mean, Standard Error)



14/ 45

Figure 14

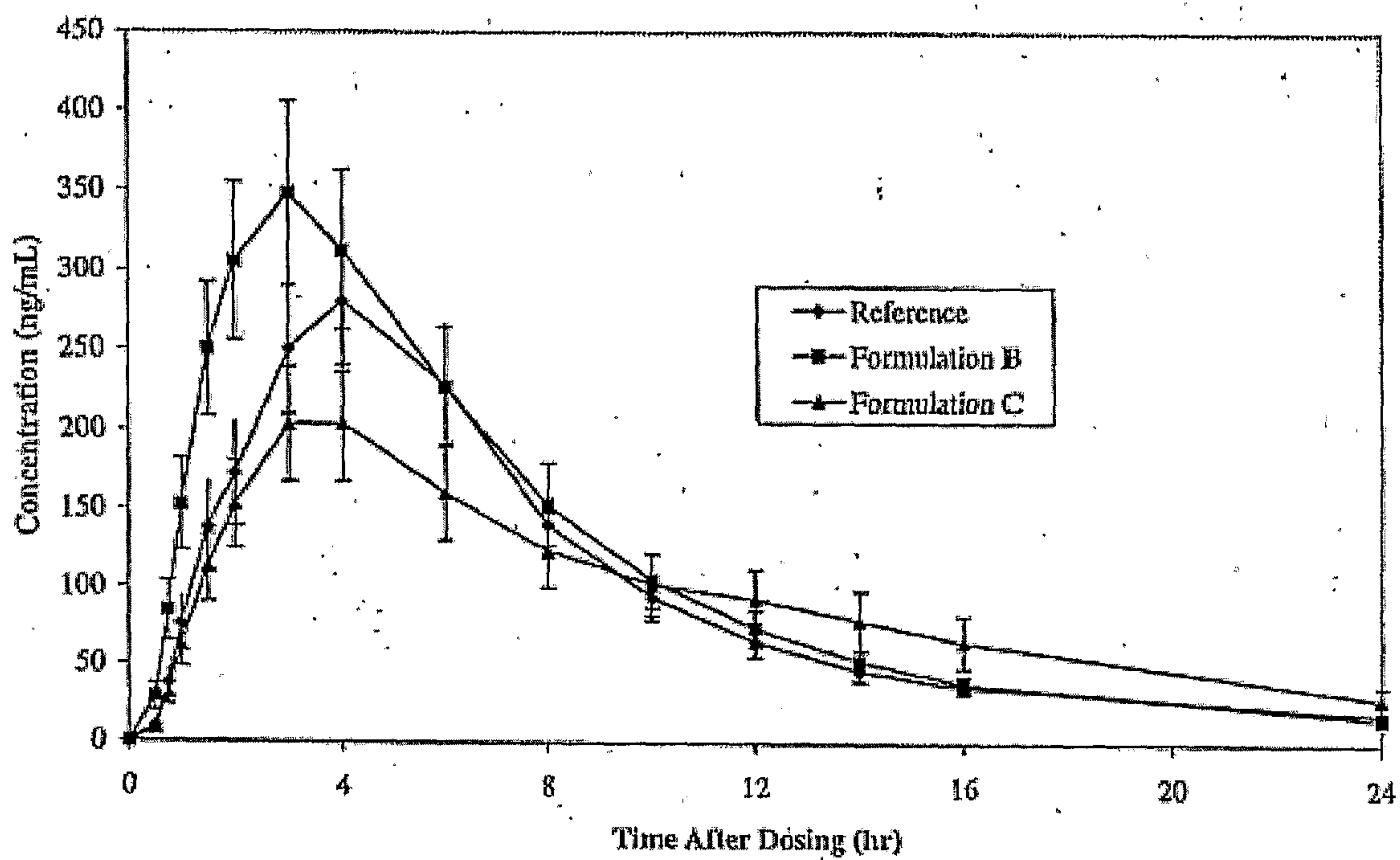
Dextromethorphan Plasma Concentrations Following the Administration of 1200 mg Guafenesin and 60 mg Dextromethorphan Hydrobromide to Normal Volunteers in Three Formulations (Mean, Standard Error)



15 / 45

Figure 15

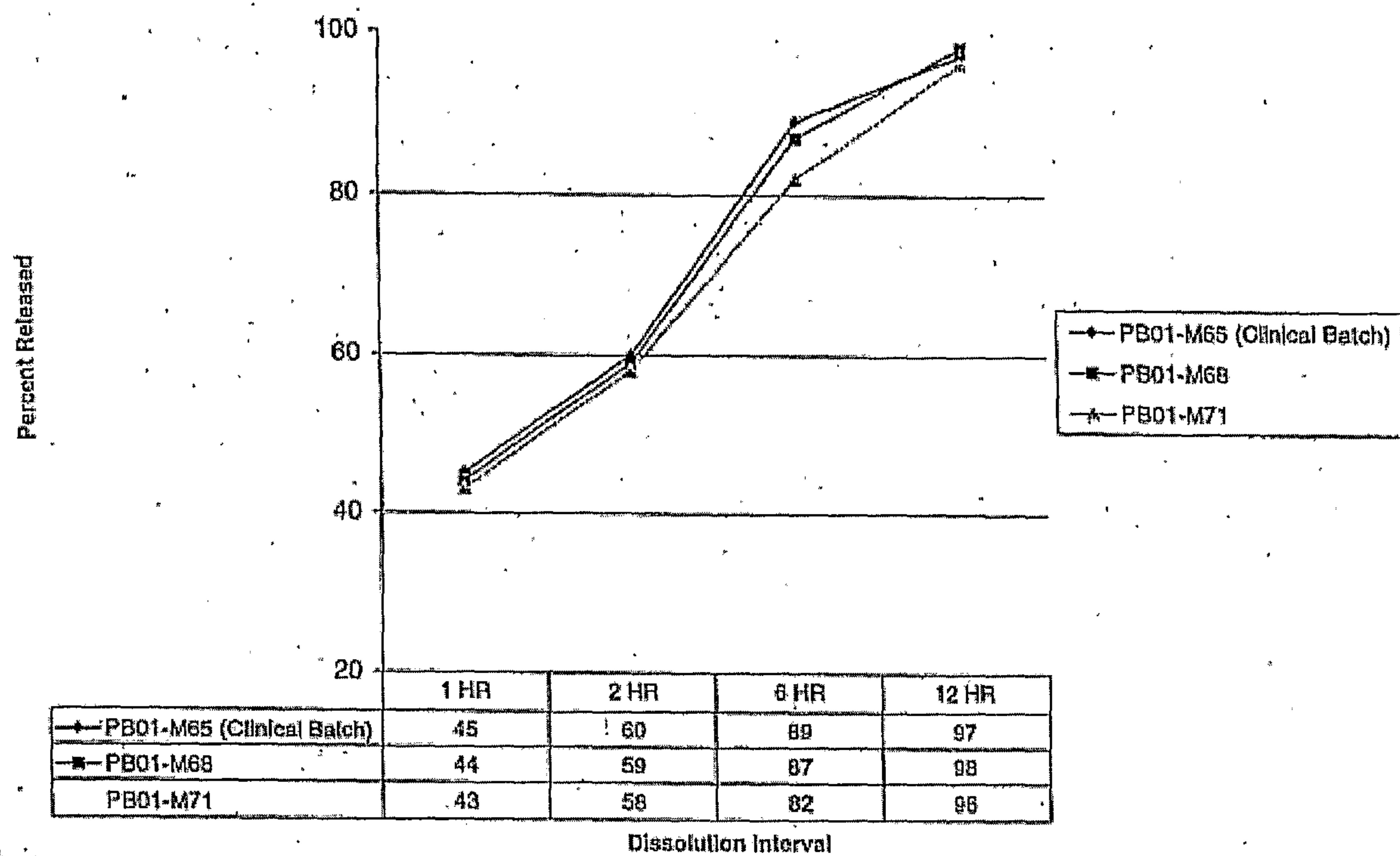
Dextrophan Plasma Concentrations Following the Administration of 1200 mg Guafenesin and 60 mg Dextromethorphan Hydrobromide to Normal Volunteers in Three Formulations (Mean, Standard Error)



16 / 45

Figure 16

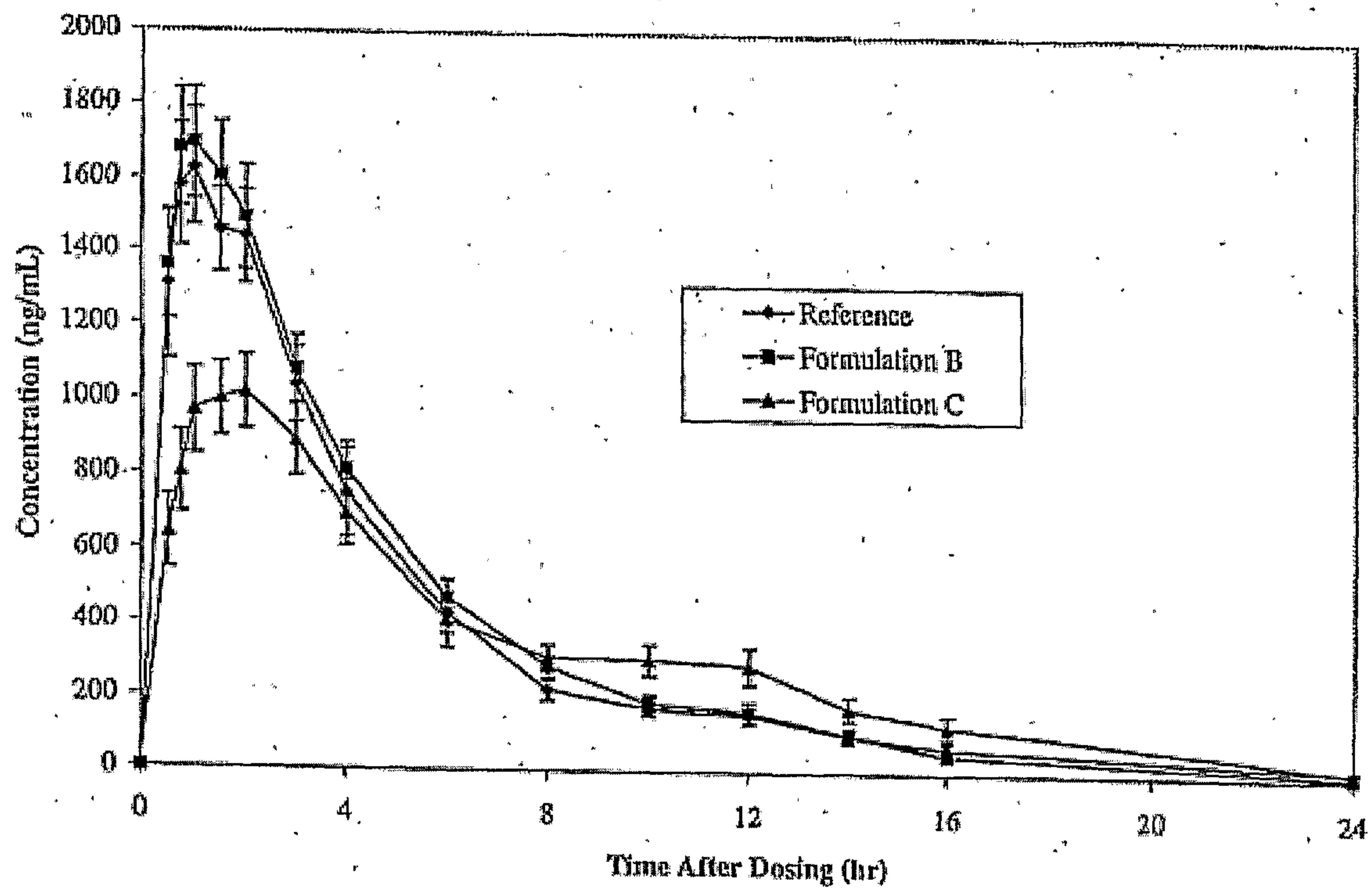
Pseudoephedrine HCl Dissolution Release Rates for Mucinex D
1200 mg Guaifenesin/ 120 mg Pseudoephedrine HCl



17 / 45

Figure 17

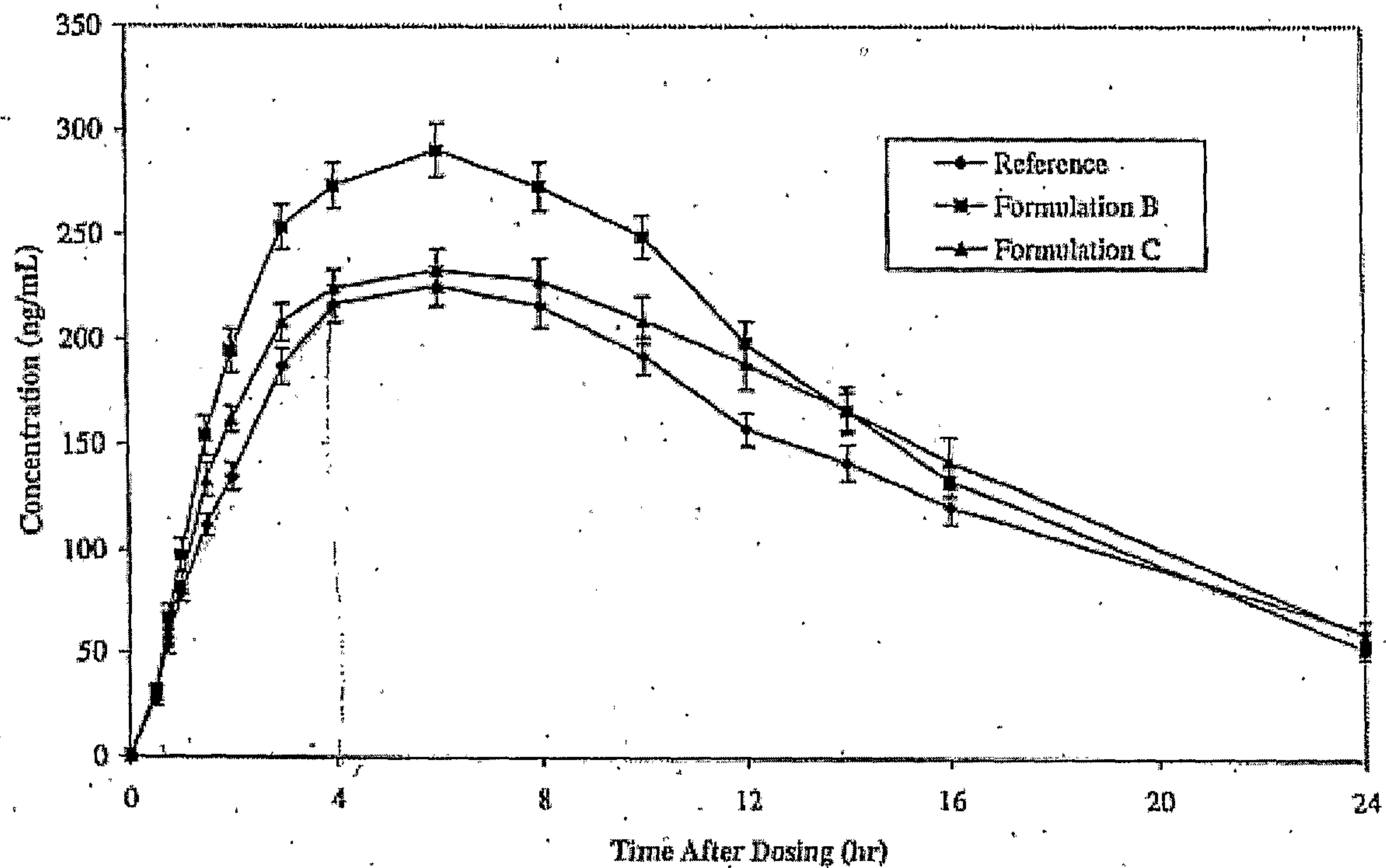
Plasma Guaifenesin Concentration Following Administration of 1200 mg Guaifenesin Along with 120 mg Pseudoephedrine HCl to Normal Volunteers (Mean, Standard Error)



18 / 45

Figure 18

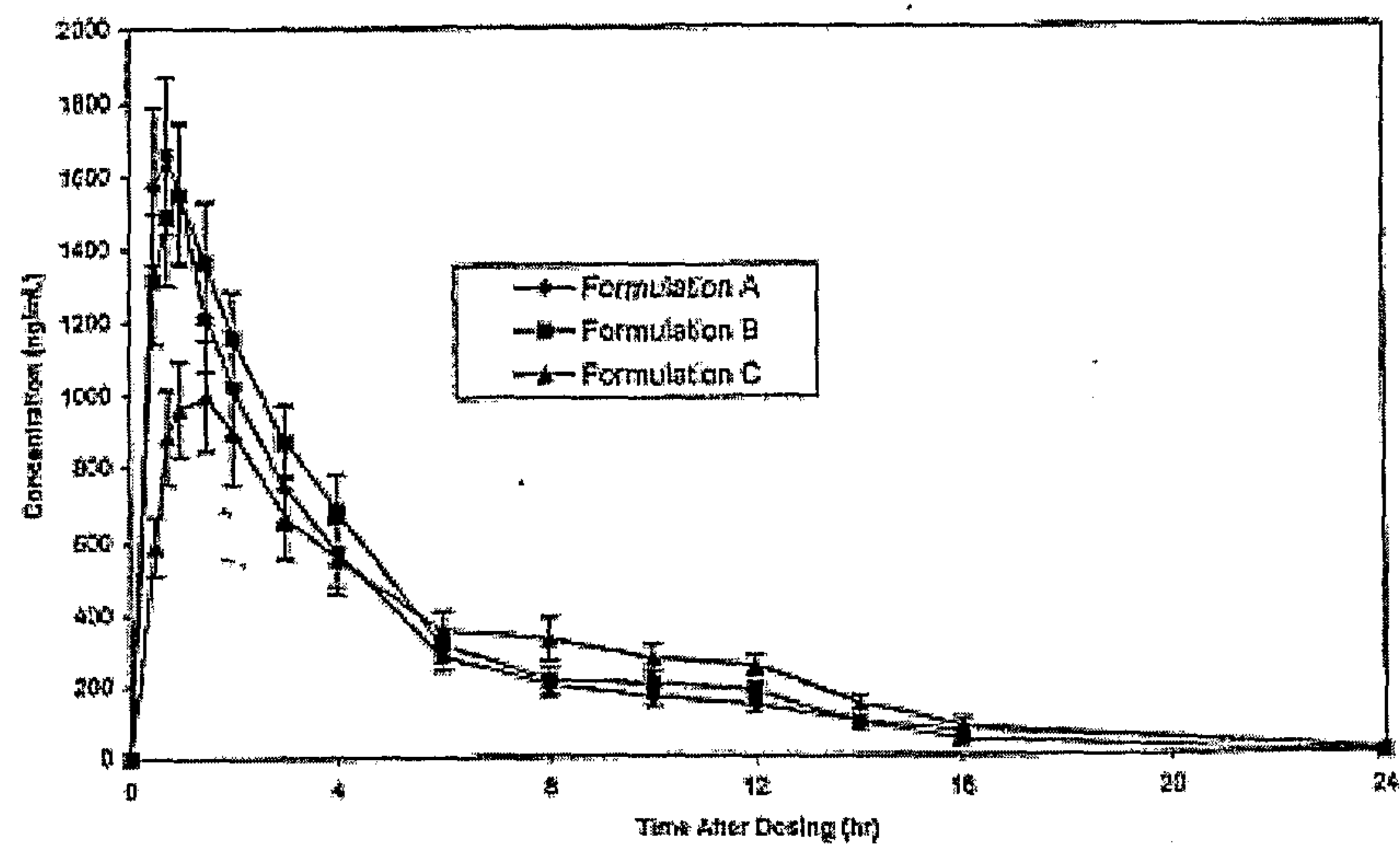
Plasma Pseudoephedrine Concentration Following Administration of 120 mg Pseudoephedrine HCl along with 1200 mg Guaifenesin to Normal Volunteers (Mean, Standard Error)



19 / 45

Figure 19

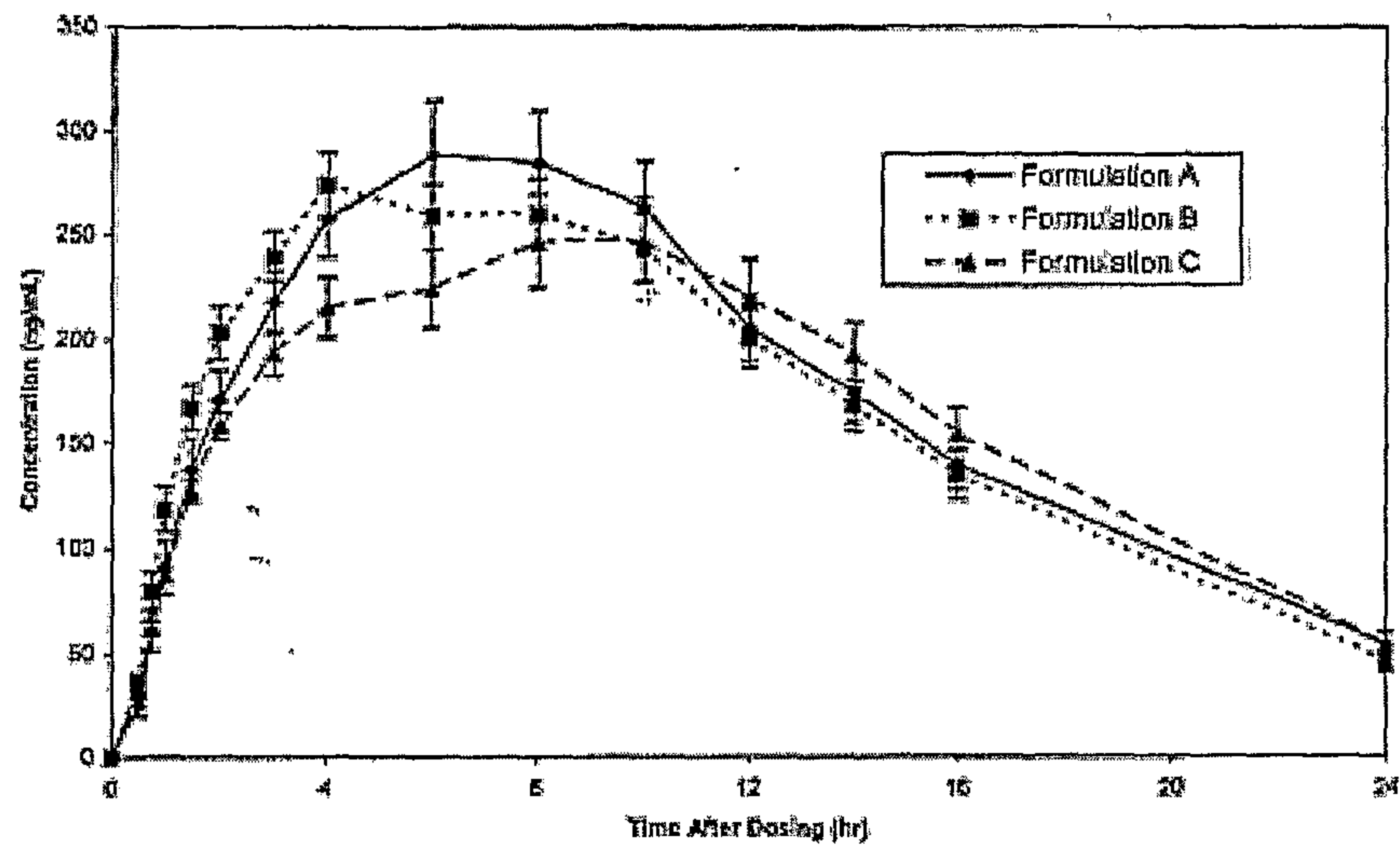
Plasma Guafenesin Concentrations Following the Administration of 1200 mg Guafenesin in
Three Different Formulations to Normal Volunteers
(Mean, Standard Error)



20 / 45

Figure 20

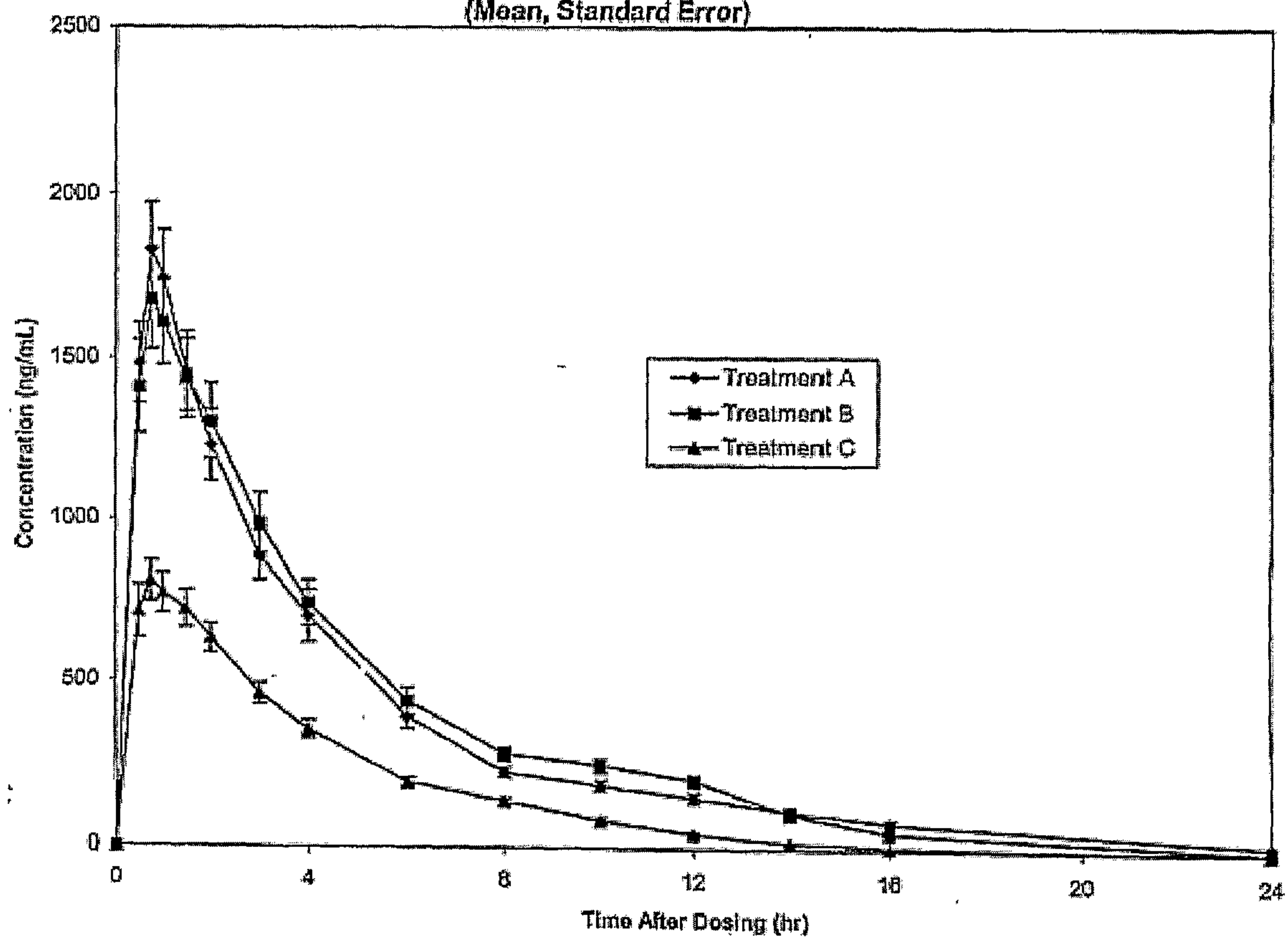
Pseudoephedrine Plasma Concentration Following the Administration of 1200 mg Guaifenesin and 120 mg Pseudoephedrine Hydrochloride to Normal Volunteers in Three Different Formulations (Mean, Standard Error)



21 / 45

Figure 21

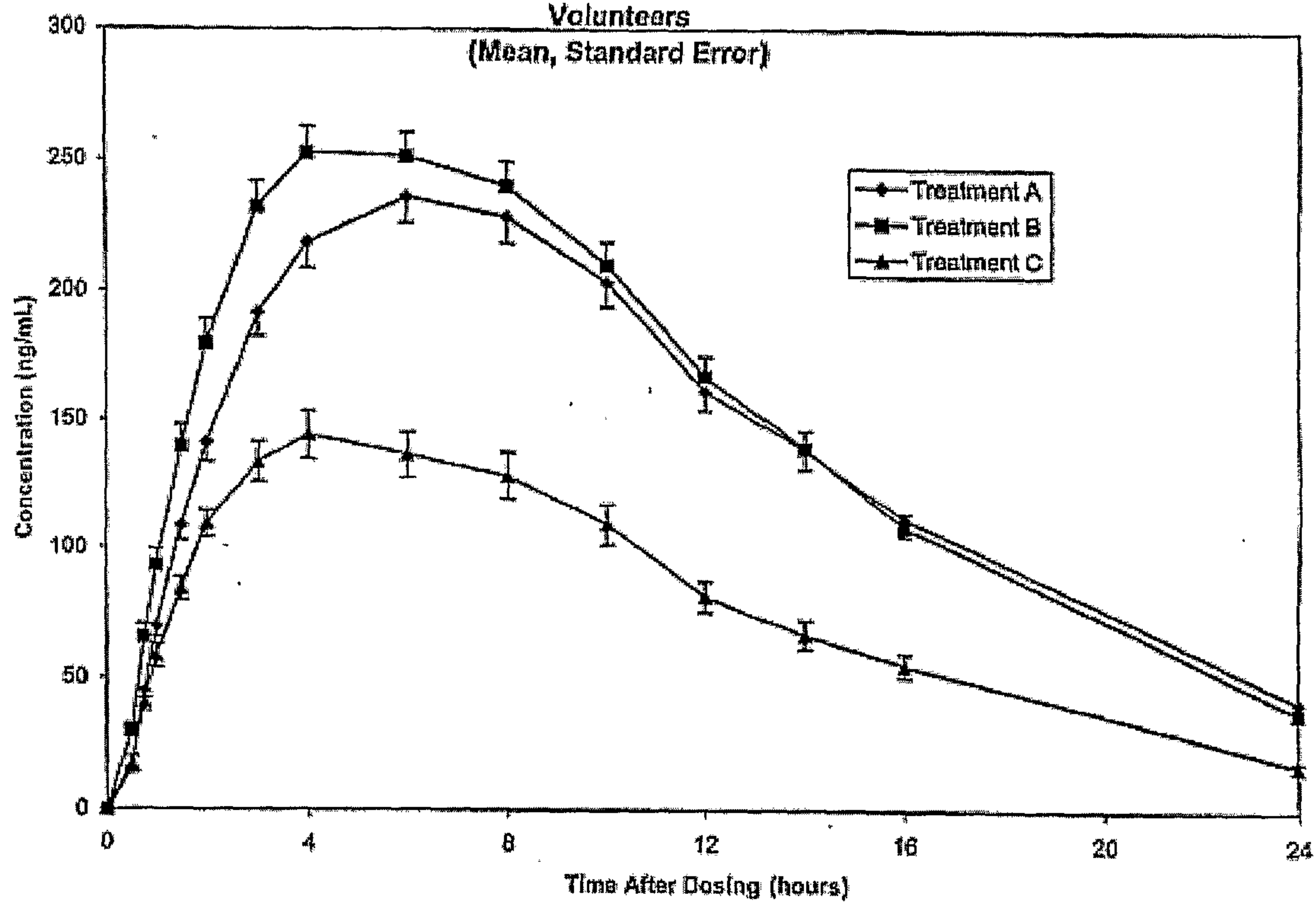
Plasma Guaifenesin Concentrations Following the Administration of Guaifenesin In Different Formulations and Different Doses to Normal Volunteers
(Mean, Standard Error)



22 / 45

Figure 22

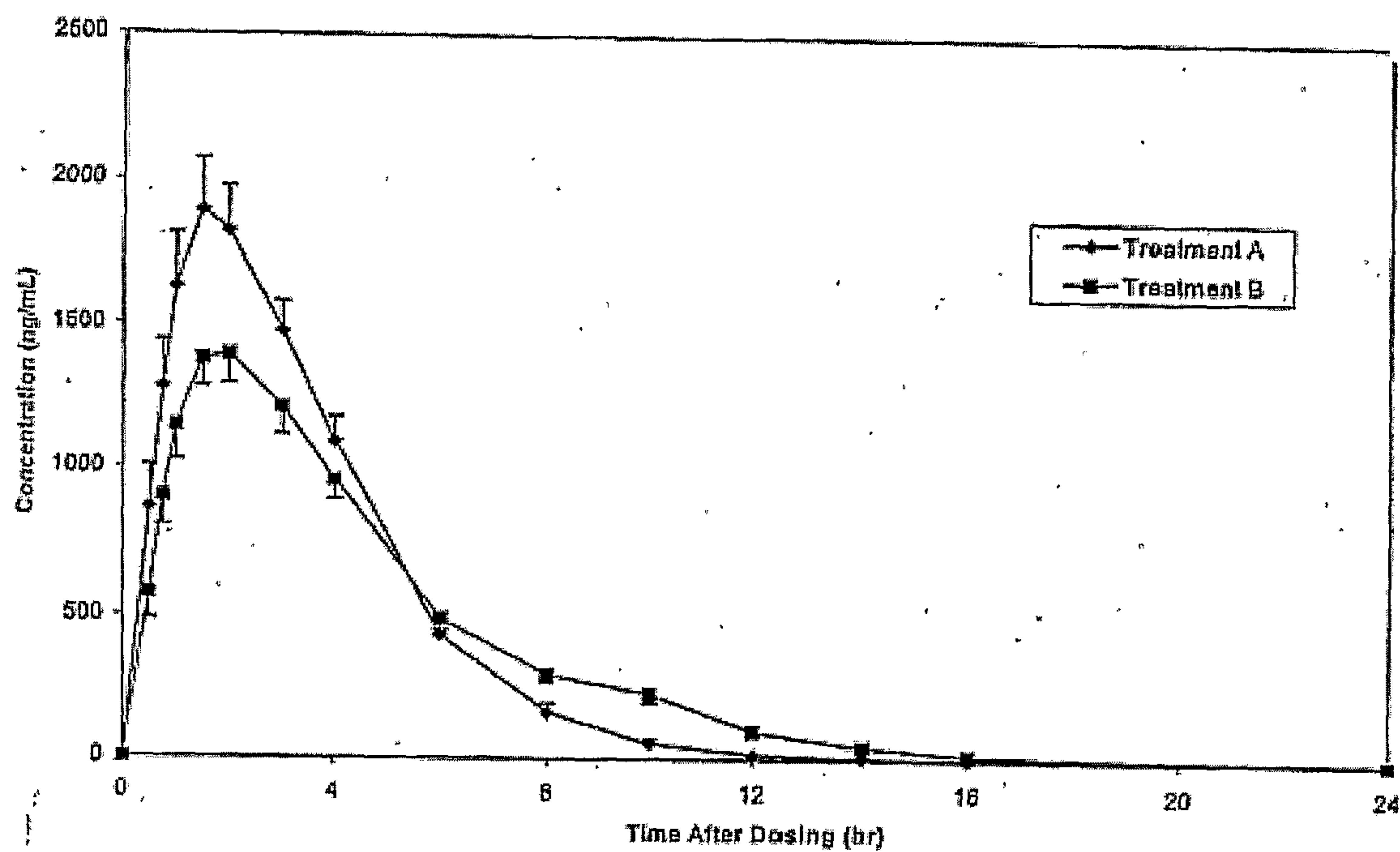
Plasma Pseudoephedrine Concentrations Following the Administration of Two Different Dose Strengths of Pseudoephedrine Hydrochloride as well as Different Formulations to Normal Volunteers
(Mean, Standard Error)



23 / 45

Figure 23

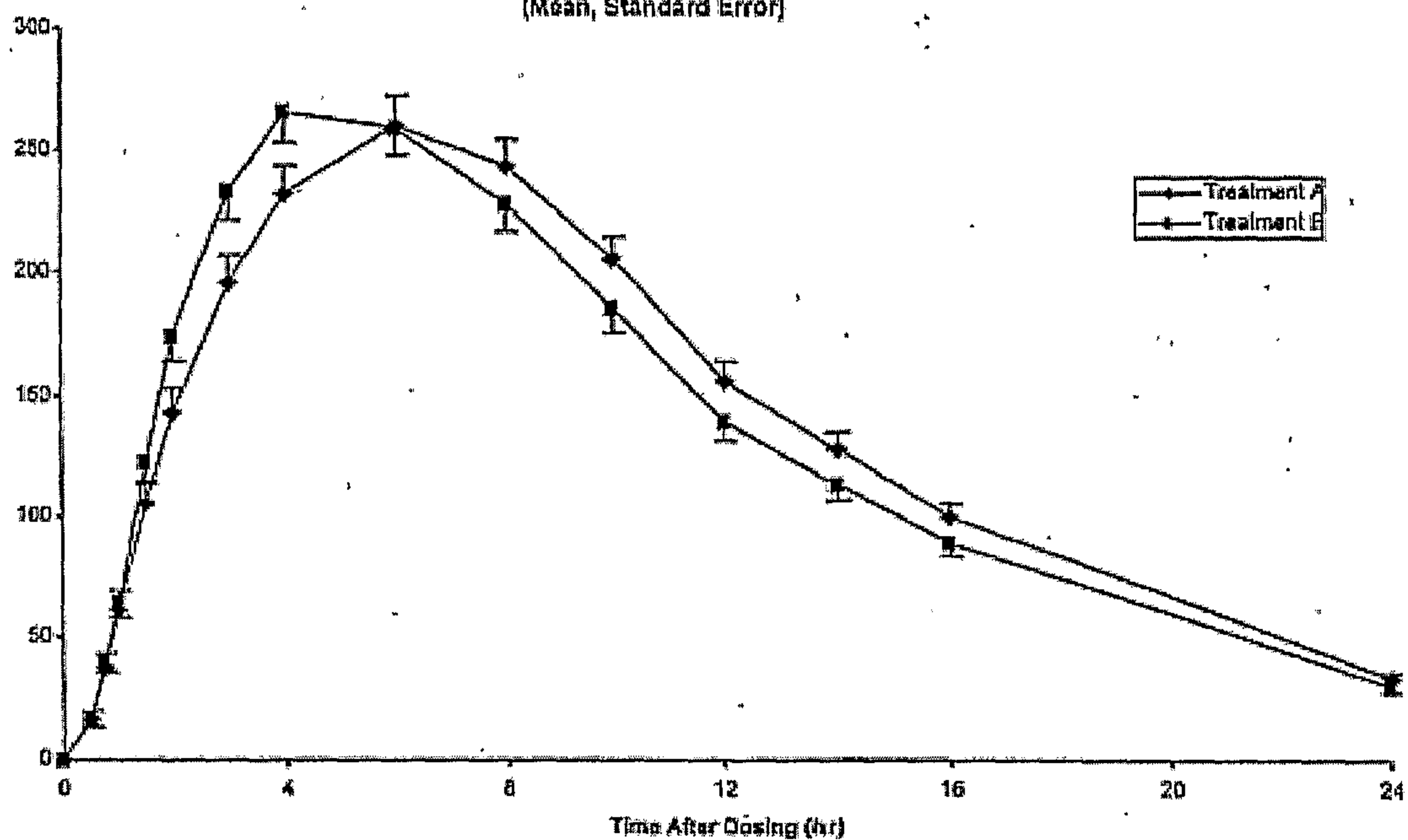
Plasma Guaifenesin Concentrations Following the Administration of 1200 mg Guaifenesin
Along with 120 mg Pseudoephedrine Hydrochloride in Two Different Formulations
Following the Consumption of a High-Fat Meal
(Mean, Standard Error)



24 / 45

Figure 24

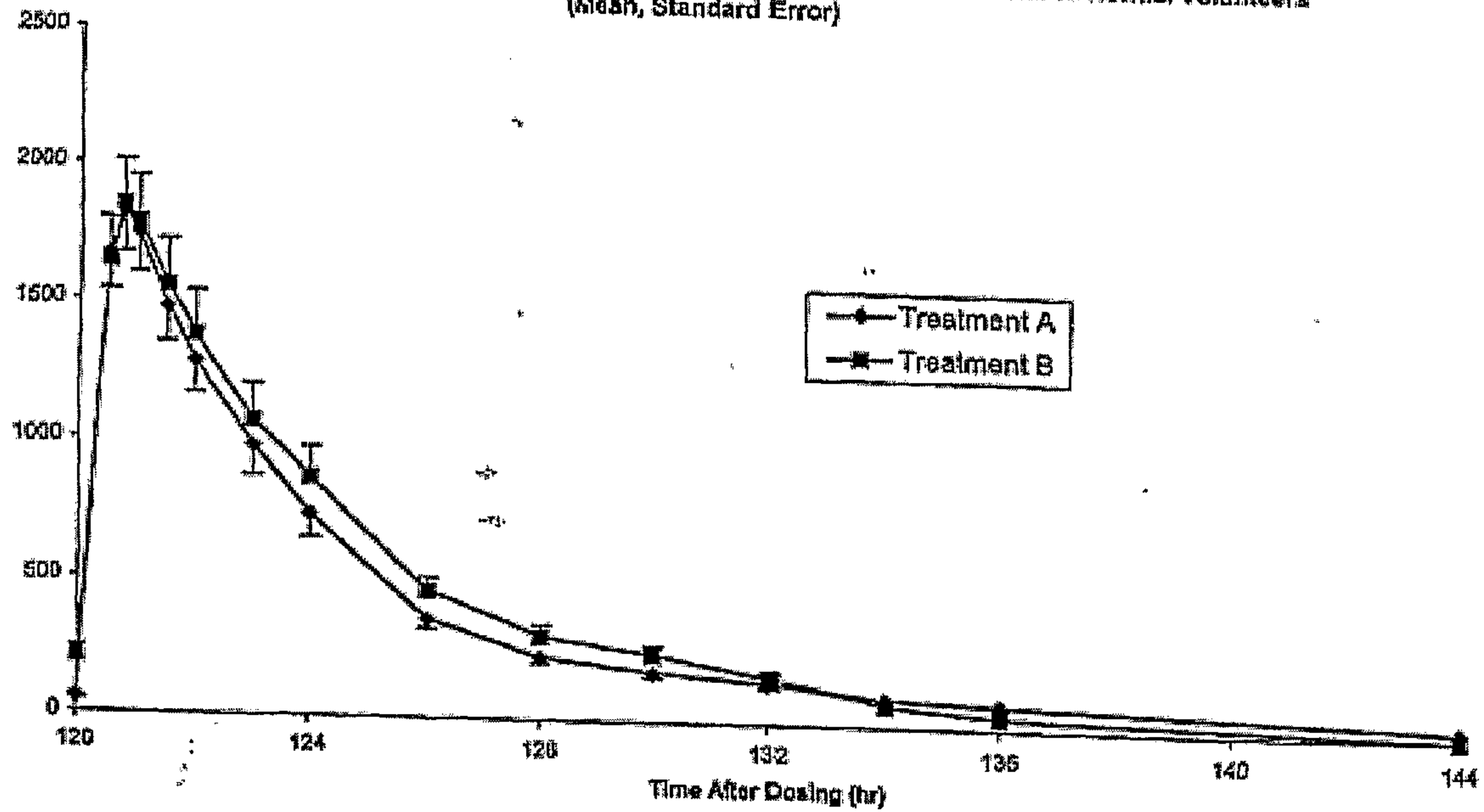
Plasma Pseudoephedrine Concentrations Following a Dose of 120 mg Pseudoephedrine Hydrochloride Administered in Two Different Formulations Following the Consumption of a High-Fat Meal (Mean, Standard Error)



25 / 45

Figure 25

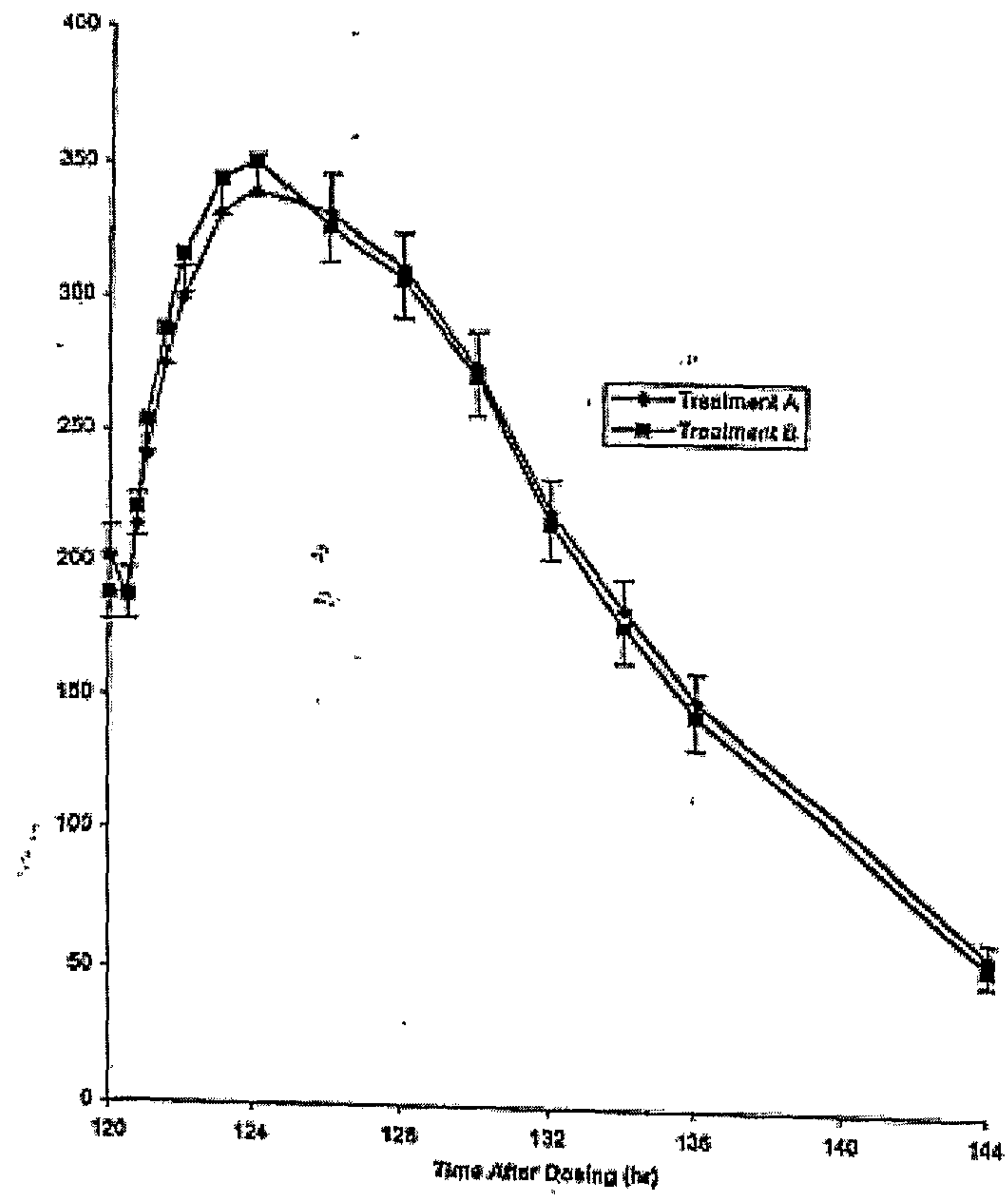
Steady-State Plasma Guafenesin Concentrations Following the Administration of 11 Doses of 1200 mg Guafenesin along with 120 mg Pseudoephedrine Hydrochloride in 2 Different Formulations to Normal Volunteers (Mean, Standard Error)



26 / 45

Figure 26

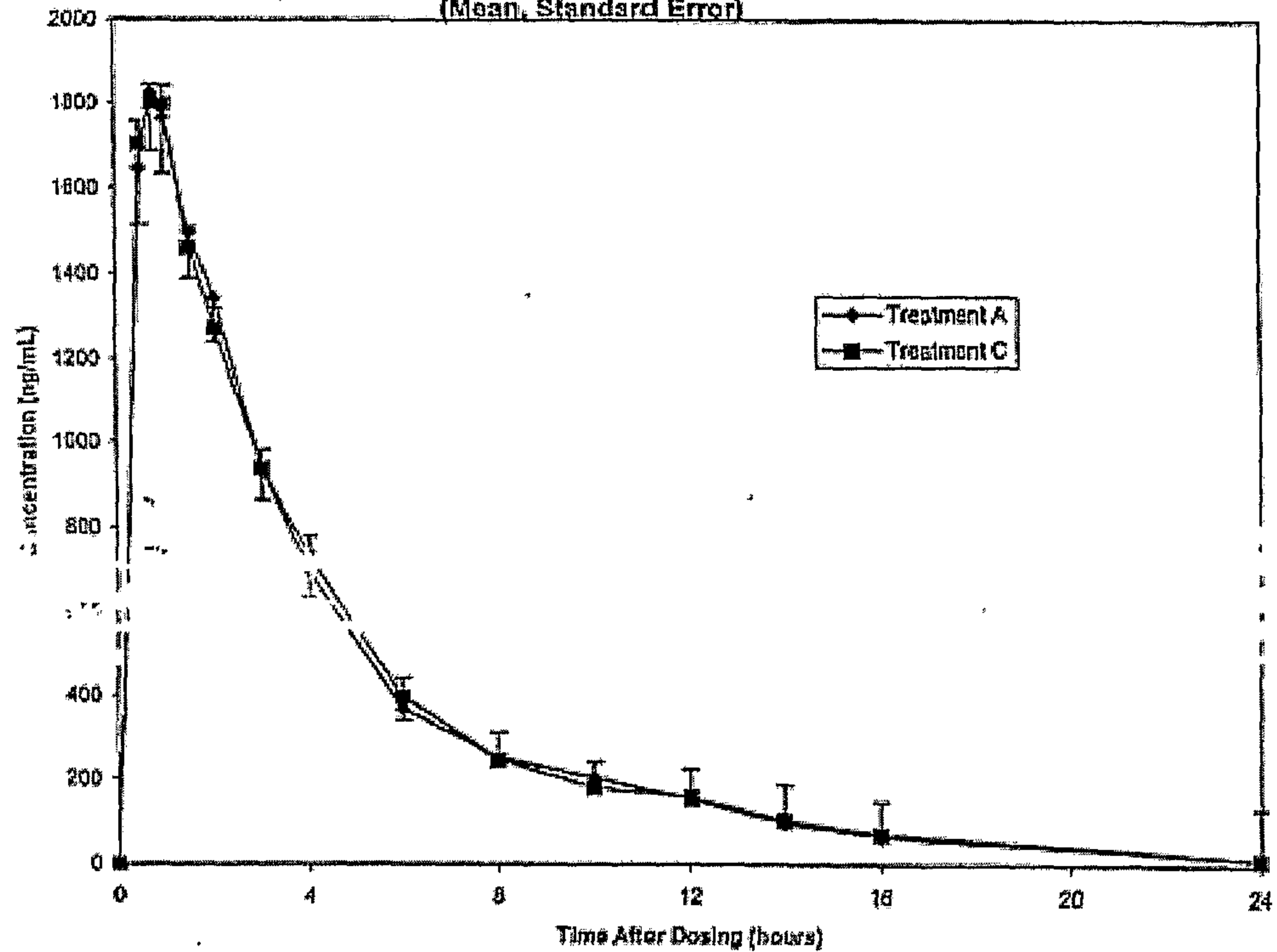
Steady-State Plasma Pseudoephedrine Concentrations Following the Administration of 11 Doses of 120 mg Pseudoephedrine Hydrochloride Along with 1200 mg of Guaifenesin in 2 Different Formulations to Normal Volunteers (Mean, Standard Error)



27 / 45

Figure 27

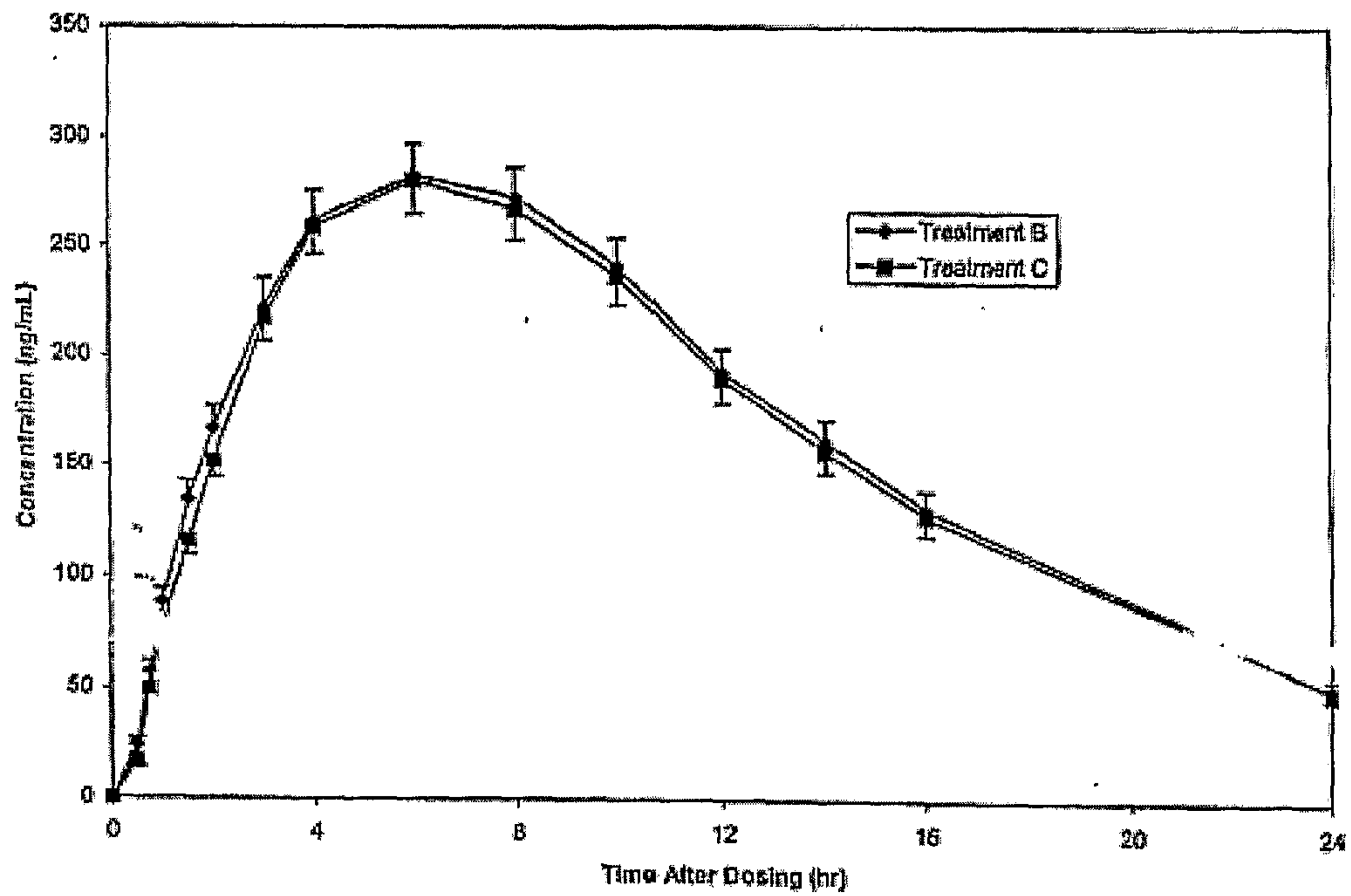
Plasma Guaifenesin Concentrations Following the Administration of 1200 mg Guaifenesin
with or without the Coadministration of 120 mg Pseudoephedrine Hydrochloride in Normal
Volunteers
(Mean, Standard Error)



28 / 45

Figure 28

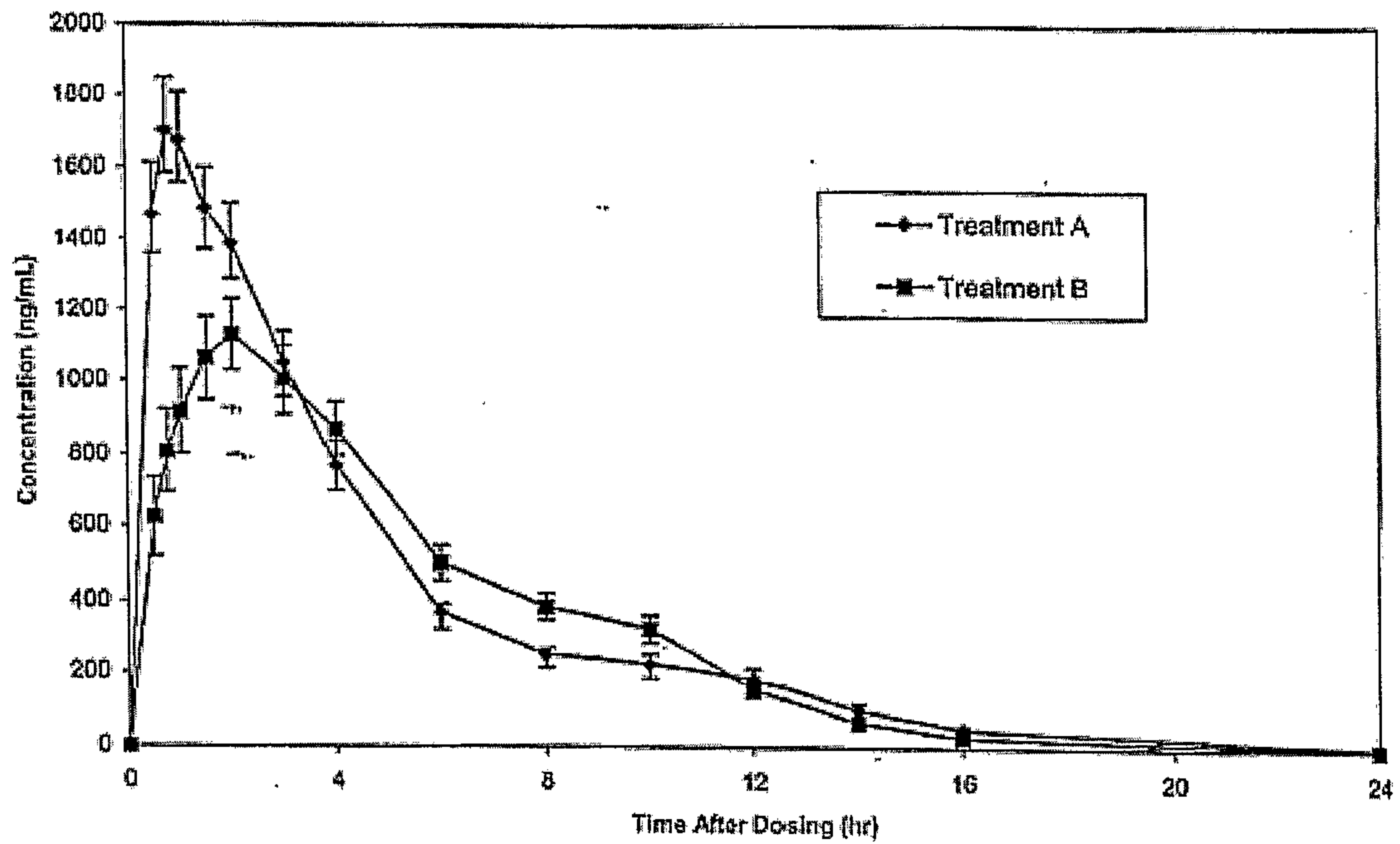
Plasma Pseudoephedrine Concentrations Following the Administration of 120 mg Pseudoephedrine Hydrochloride to Normal Volunteers with or without the Coadministration of 1200 mg Guaifenesin (Mean, Standard Error)



29 / 45

Figure 29

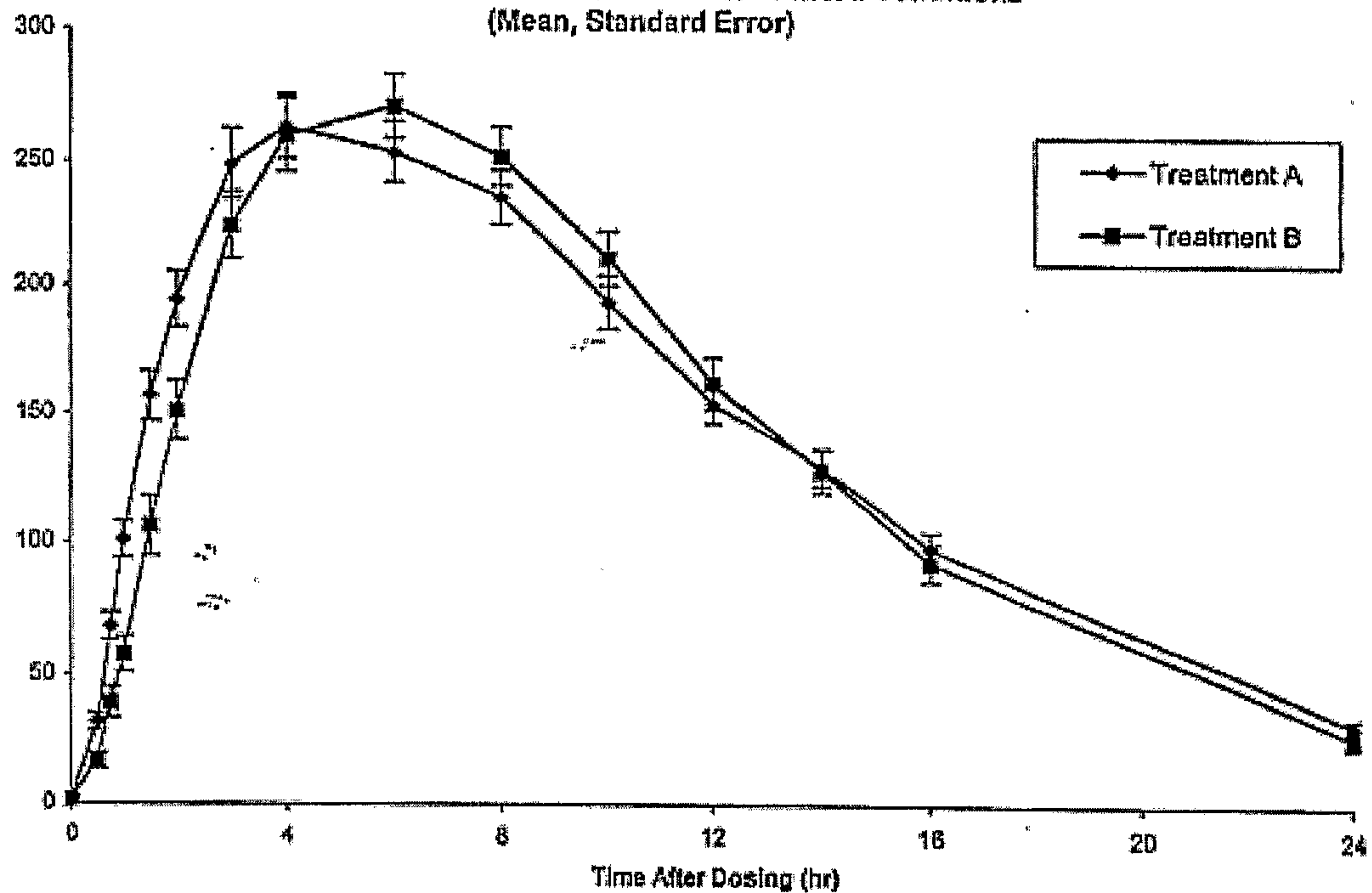
Plasma Guaifenesin Concentrations Following the Administration of 1200 mg Guaifenesin and 120 mg Pseudoephedrine Hydrochloride in an Experimental Formulation to Normal Volunteers Under Fed and Fasted Conditions
(Mean, Standard Error)



30 / 45

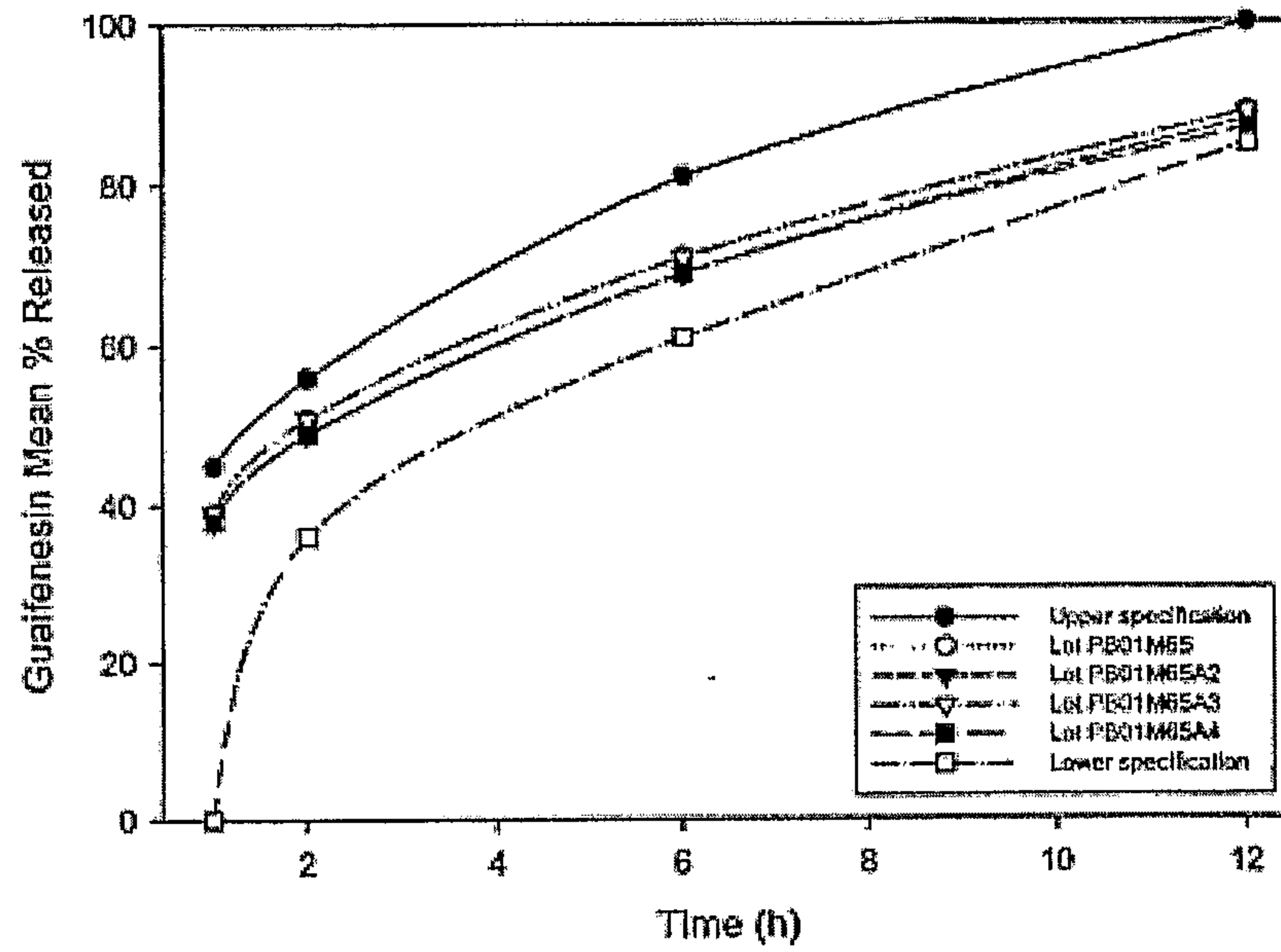
Figure 30

Plasma Pseudoephedrine Concentrations Following the Administration of 120 mg of Pseudoephedrine Hydrochloride and 1200 mg Guaifenesin in an Experimental Formulation to Normal Volunteers Under Fed and Fasted Conditions (Mean, Standard Error)



31 / 45

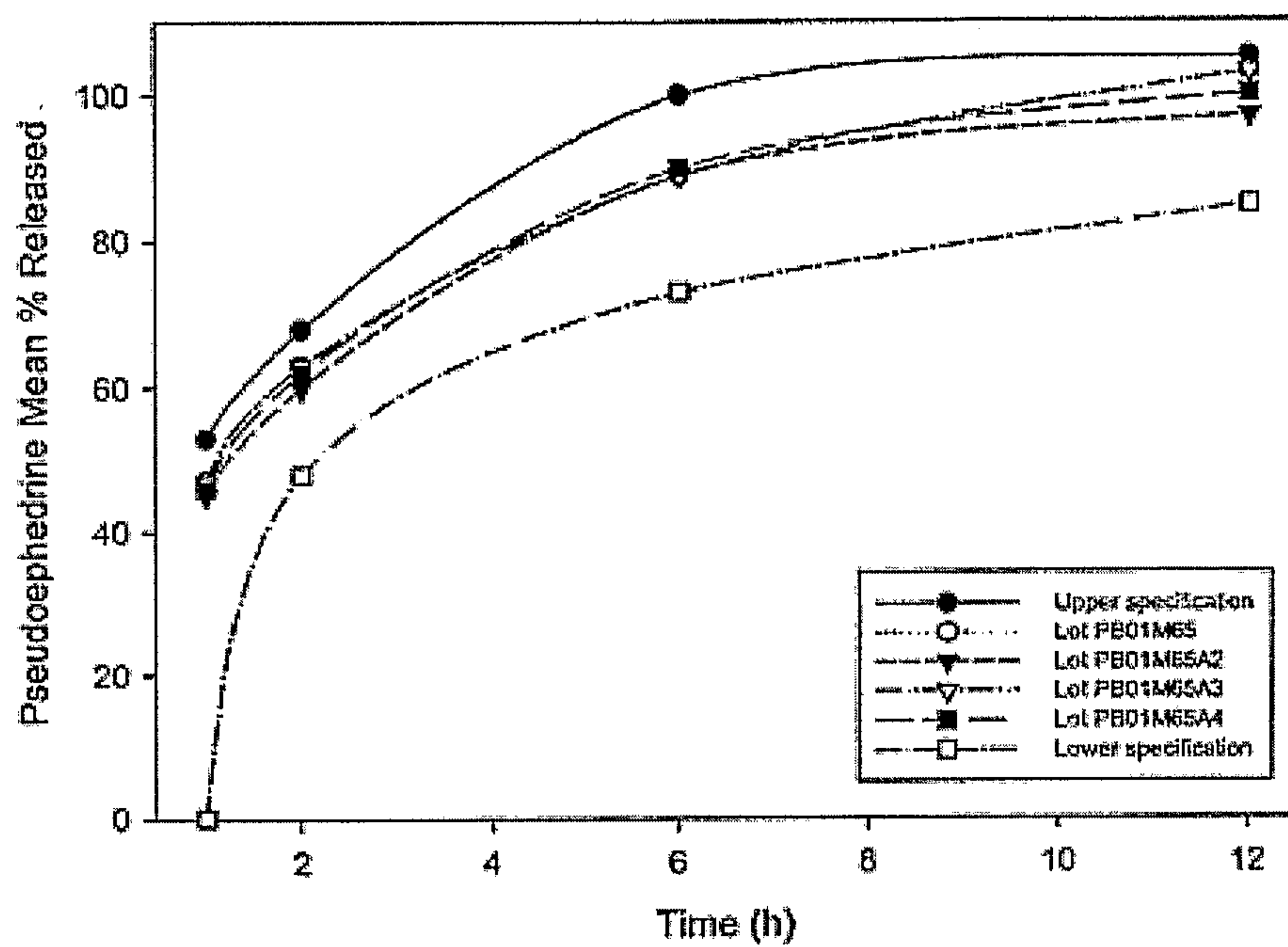
Figure 31



Mucinex™ D mean guaifenesin dissolution profiles for various clinical batches used in the bioavailability studies with associated dissolution specifications.

32 / 45

Figure 32

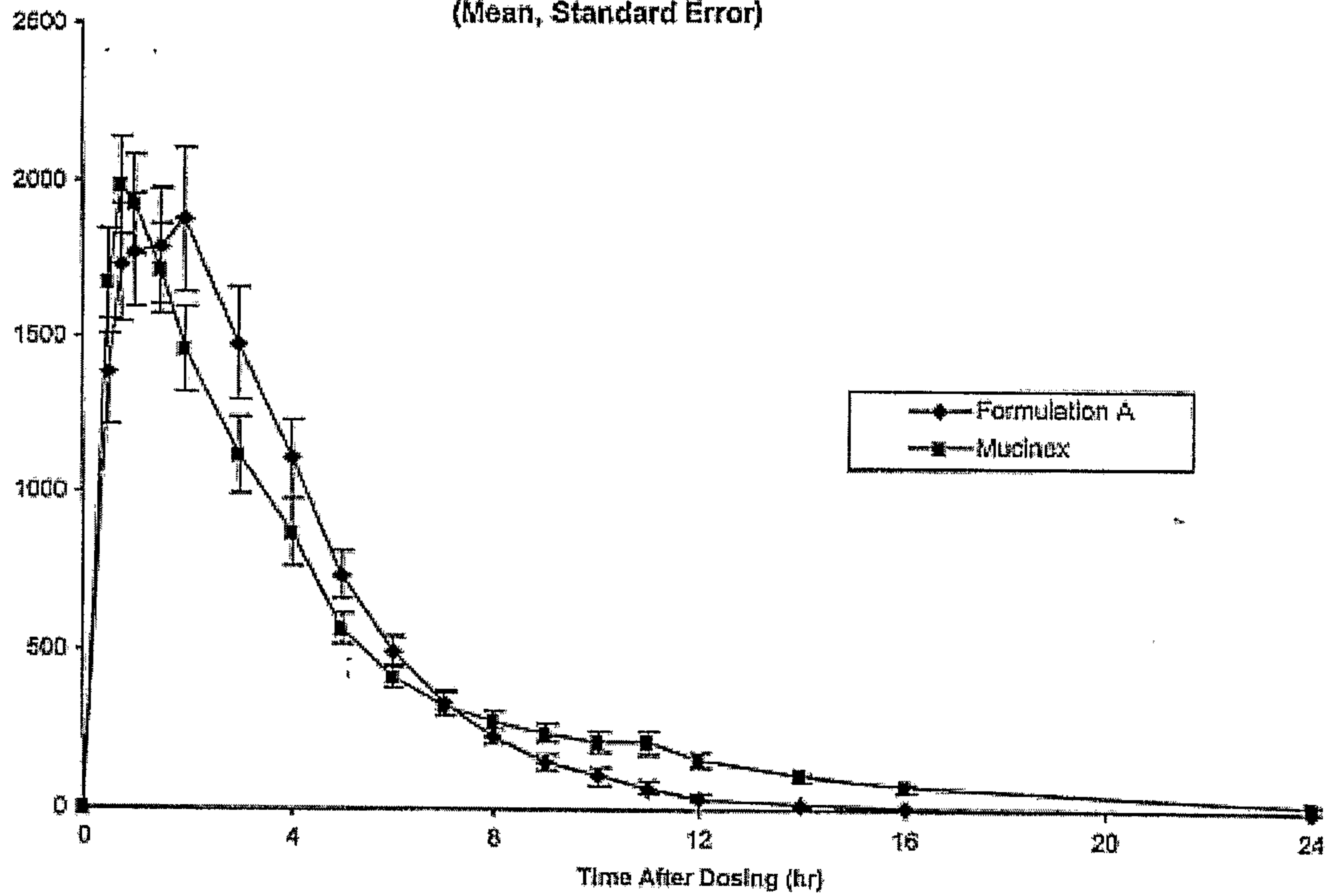


Mucinex™ D mean pseudoephedrine HCL dissolution profiles for various clinical batches used in the bioavailability studies with associated dissolution specifications.

33 / 45

Figure 33

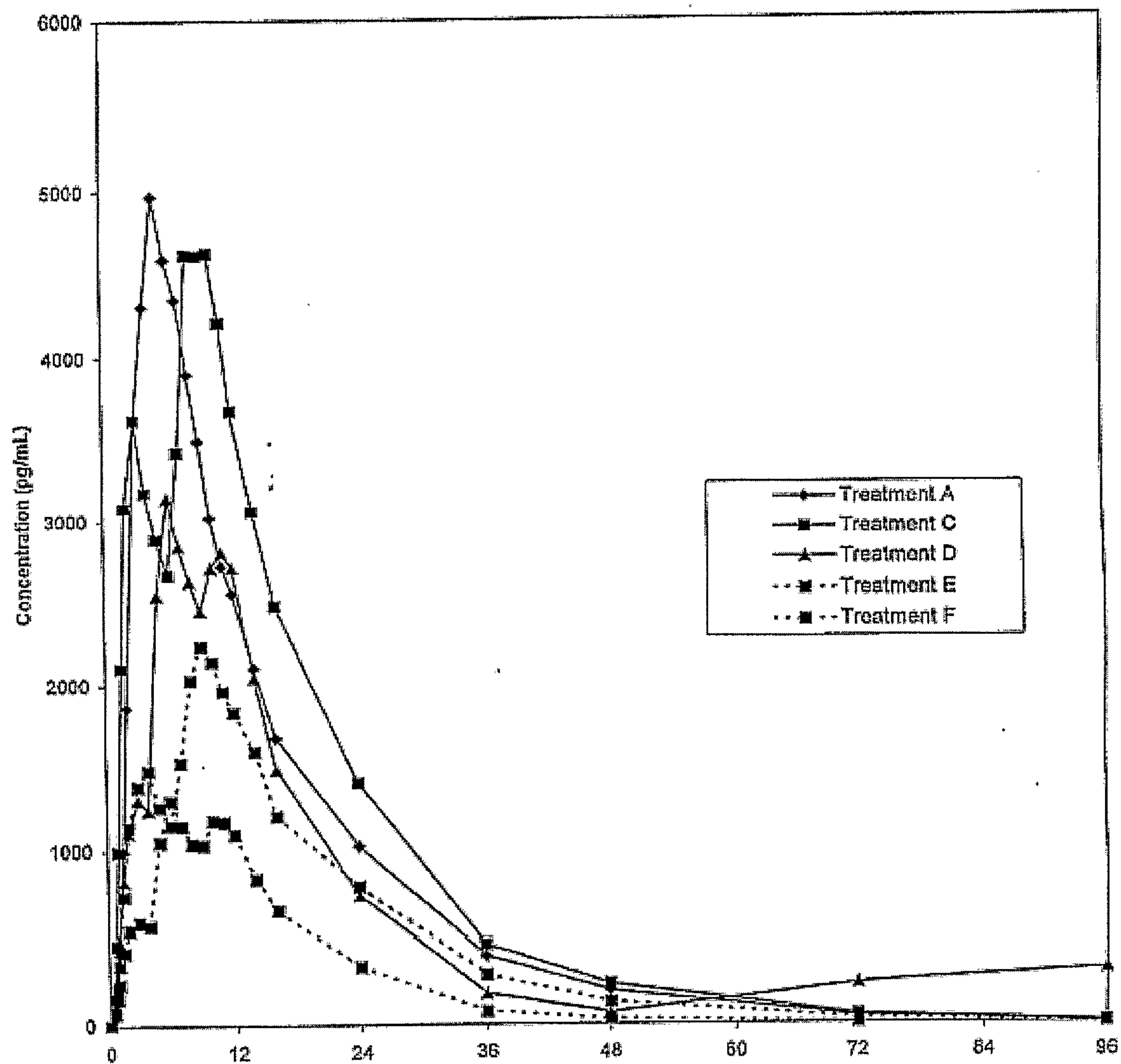
Guaifenesin Plasma Concentrations Following the Administration of 1200 mg Guaifenesin with or without the Co-Administration of 60 mg Dextromethorphan Hydrobromide to Normal Volunteers (Mean, Standard Error)



34 / 45

Figure 34

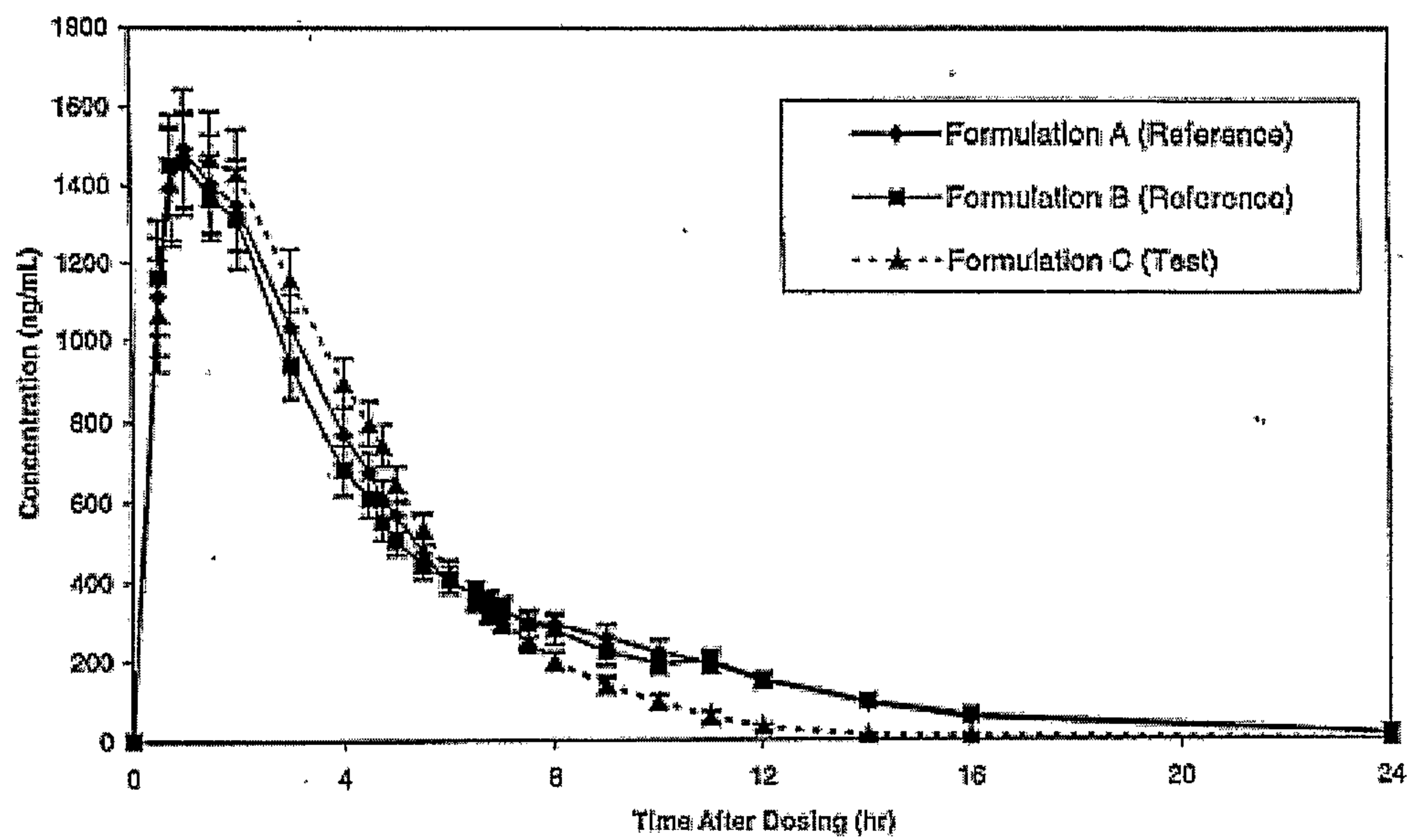
Mean Dextromethorphan Plasma Concentrations Following the Administration of Dextromethorphan Hydrobromide in Different Formulations, Doses and Dosing Regimens



35 / 45

Figure 35

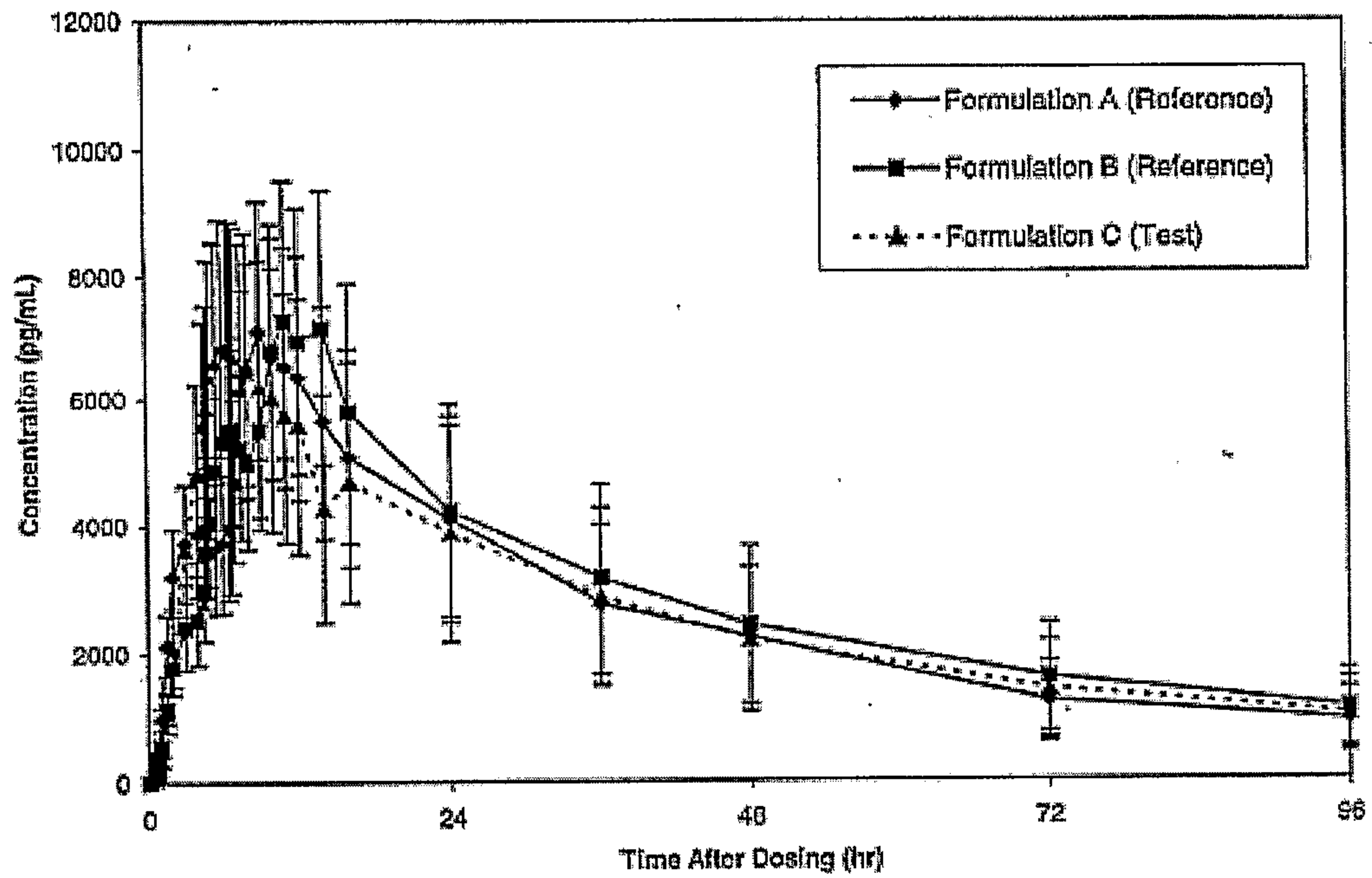
Plasma Guafenesin Concentrations Following the Administration of 1200 mg Guafenesin Along with 60 Dextromethorphan Hydrobromide in Three Different Formulations to Normal Volunteers (Mean, Standard Error)



36 / 45

Figure 36

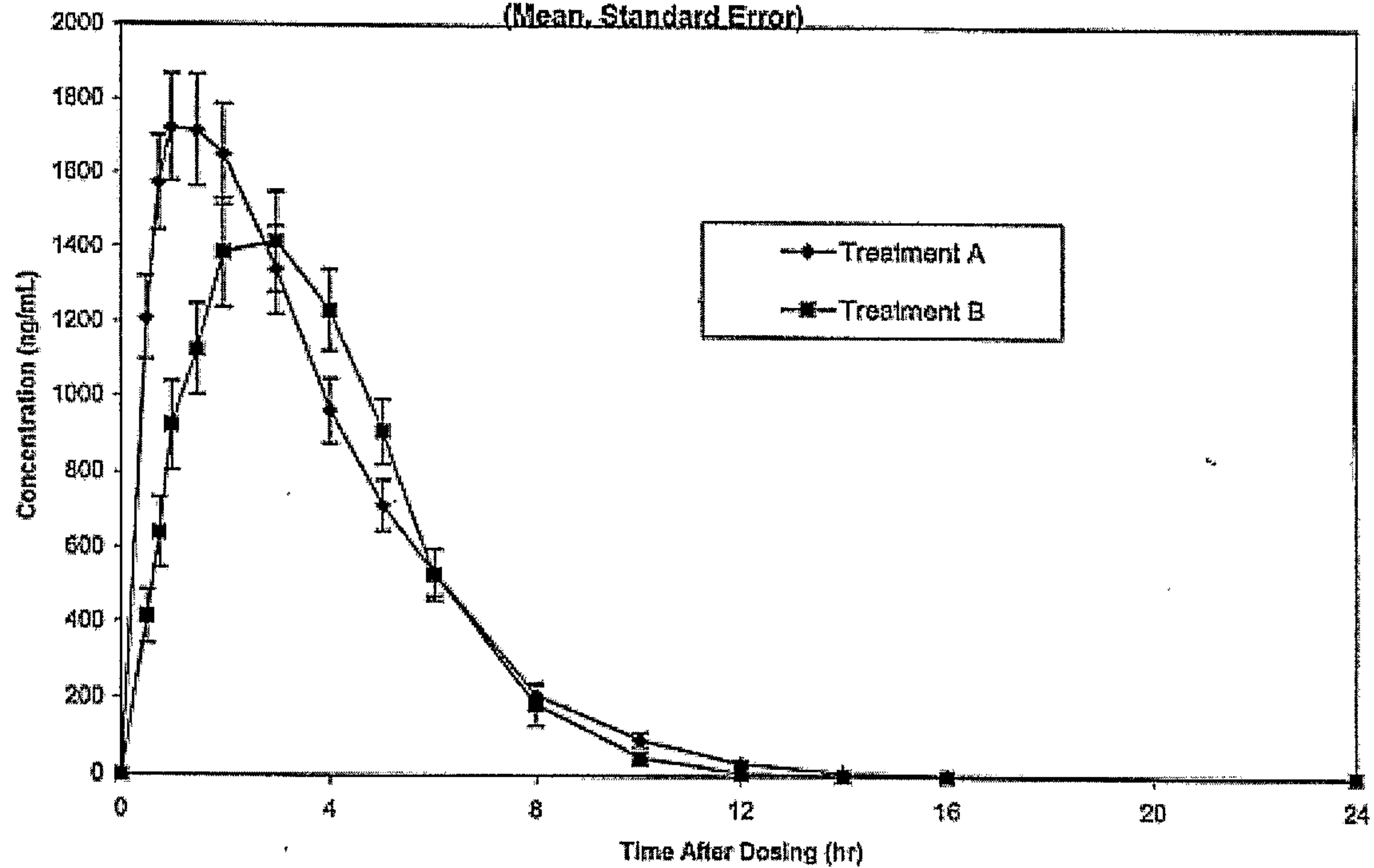
Dextromethorphan Plasma Concentrations Following the Administration of 60 mg Dextromethorphan Hydrobromide at Three Different Rates to Normal Volunteers (Mean, Standard Error)



37 / 45

Figure 37

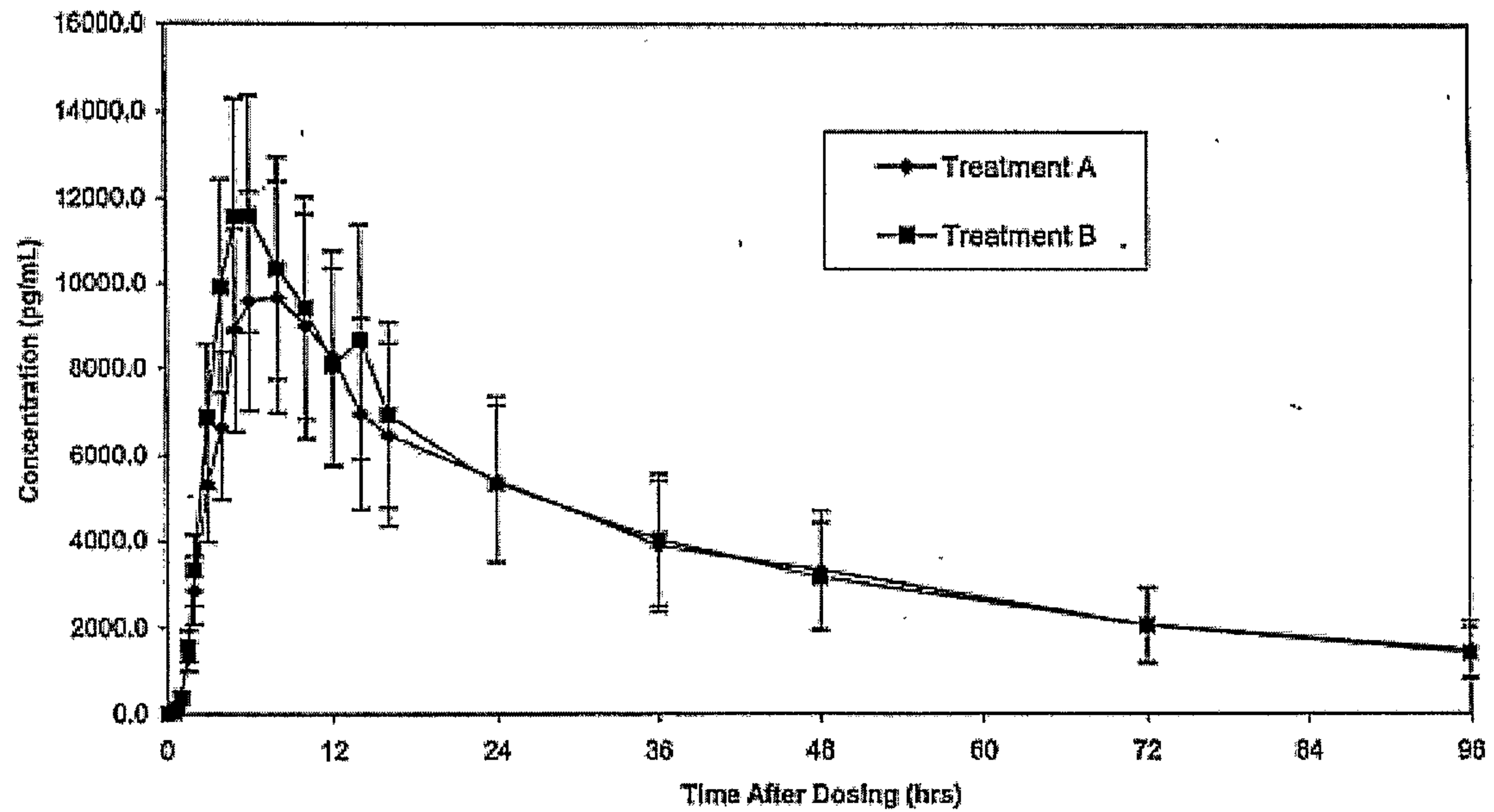
Plasma Guafenesin Concentrations Following the Administration of 1200 mg Guafenesin and 60 mg Dextromethorphan in an Experimental Formulation to Normal Volunteers Under Fed and Fasted Conditions
(Mean, Standard Error)



38 / 45

Figure 38

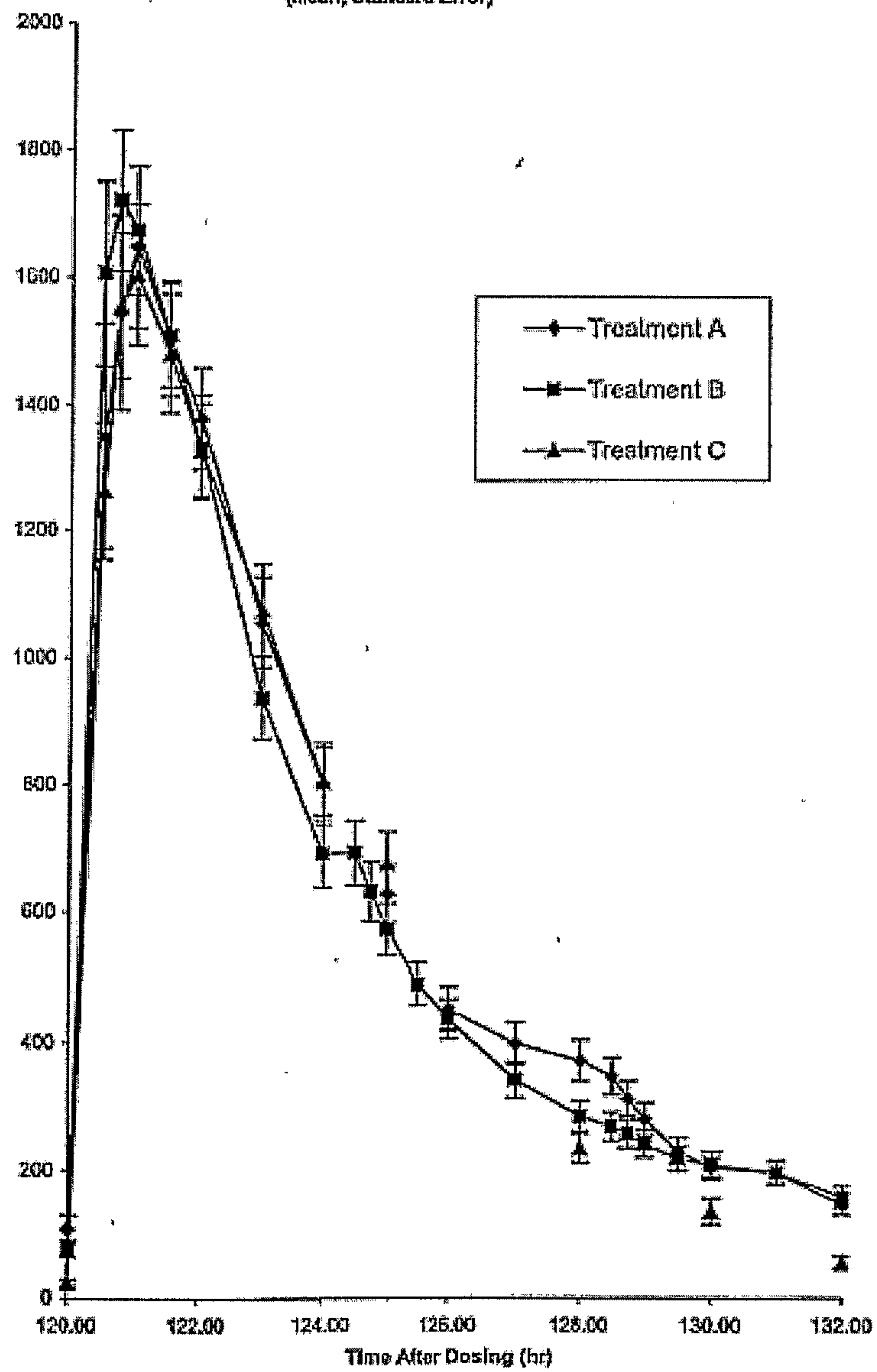
Plasma Dextromethorphan Concentrations Following the Administration of 60 mg Dextromethorphan Hydrobromide and 1200 mg Guaifenesin to Normal Volunteers in the Fed and Fasted Conditions (Mean, Standard Error)



39 / 45

Figure 39

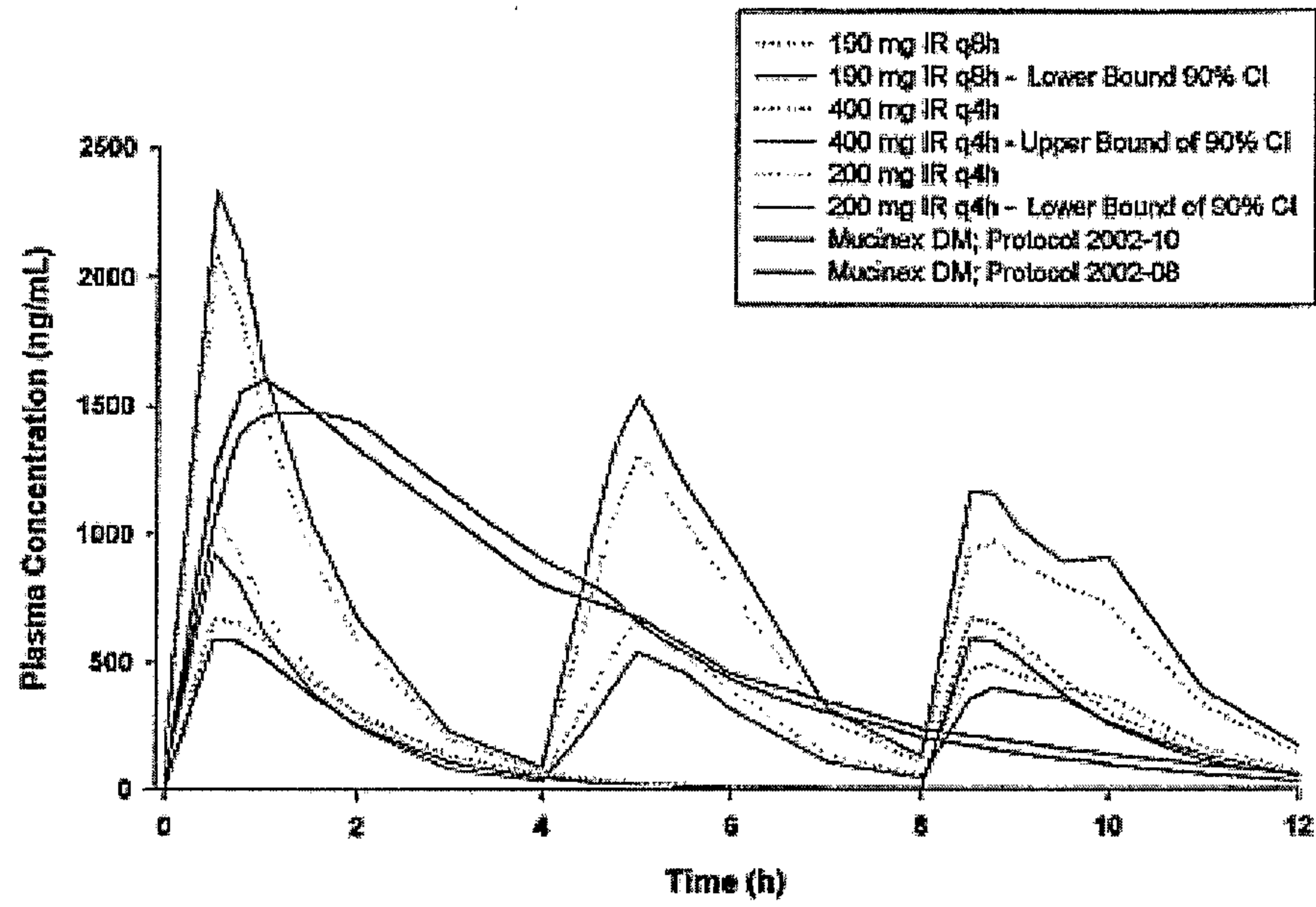
Steady-State Plasma Concentrations of Guafenesin Following the Multiple Dose Administration of 1200 mg Guafenesin in Different Formulations to Normal Volunteers. (Mean, Standard Error)



40 / 45

Figure 40

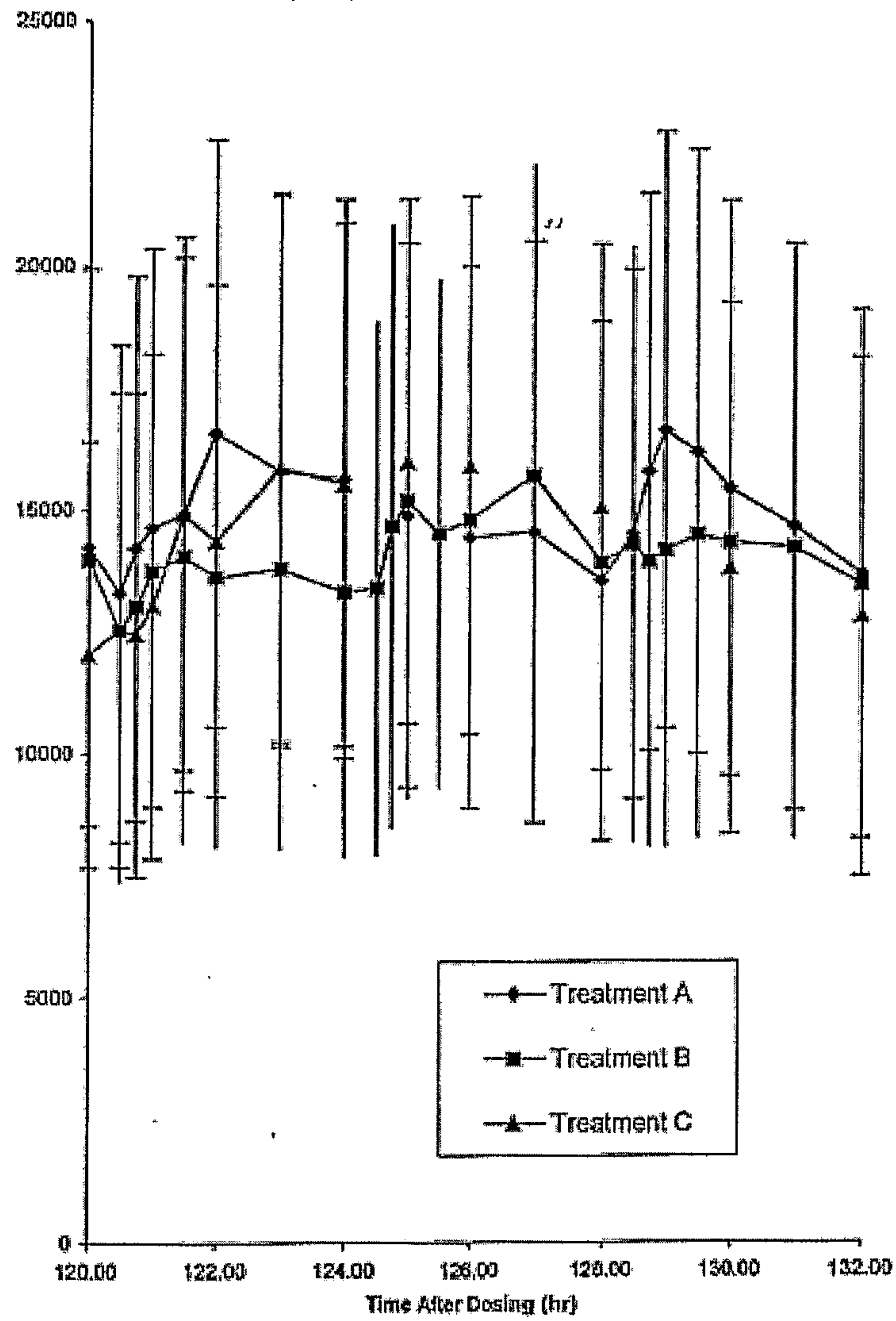
Mean Steady-State Guaifenesin Plasma Concentration-Time Profiles



41 / 45

Figure 41

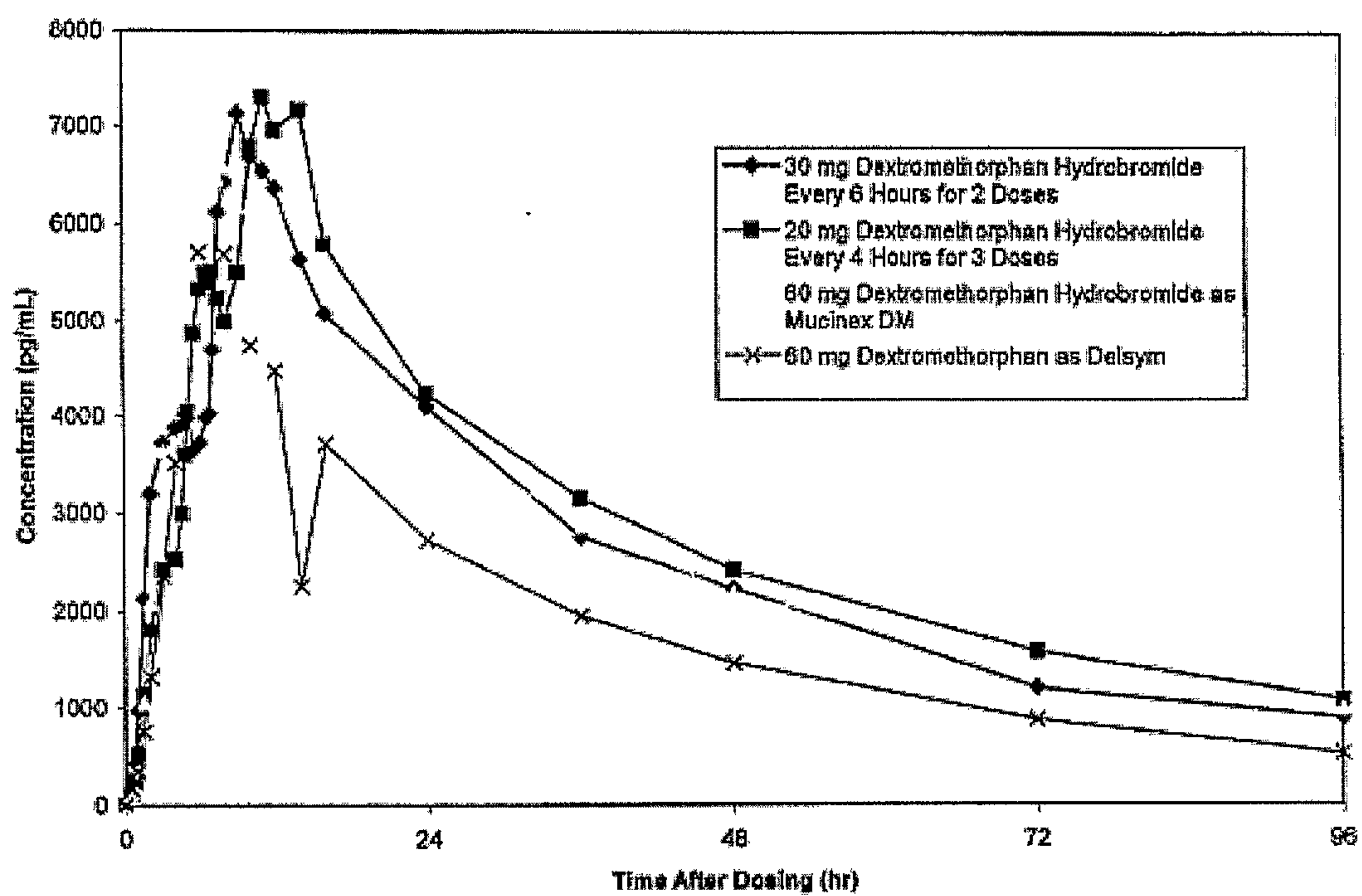
Steady-State Plasma Concentrations of Dextromethorphan Following the Multiple Dose Administration of 60 mg Dextromethorphan Hydrobromide in Different Formulations and/or Different Dosage Rates to Normal Volunteers:
(Mean, Standard Error)



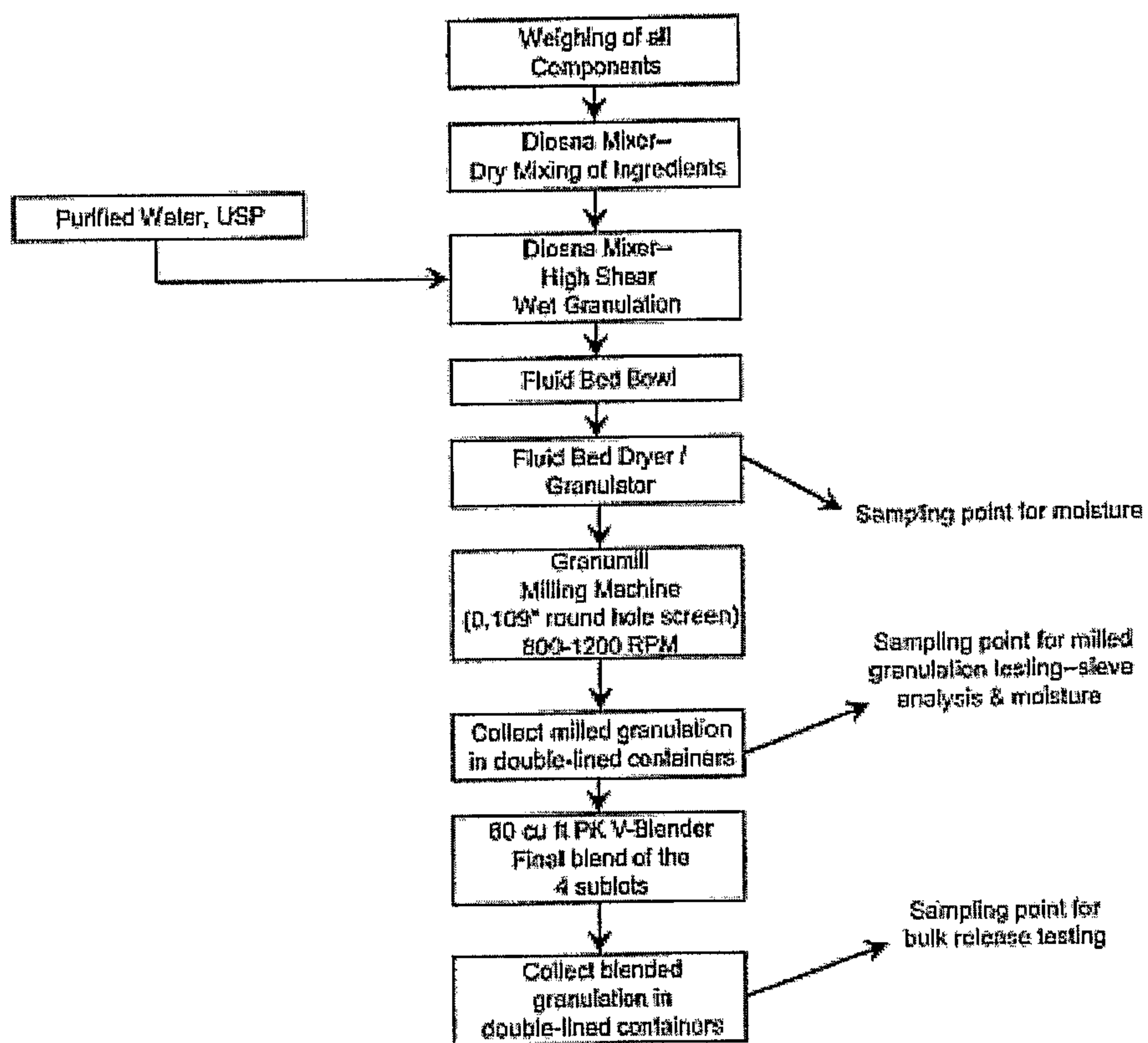
42 / 45

Figure 42

Dextromethorphan Plasma Concentrations Following the Administration of 60 mg Dextromethorphan Hydrobromide in Different Formulations and Dosage Rates to Normal Volunteers



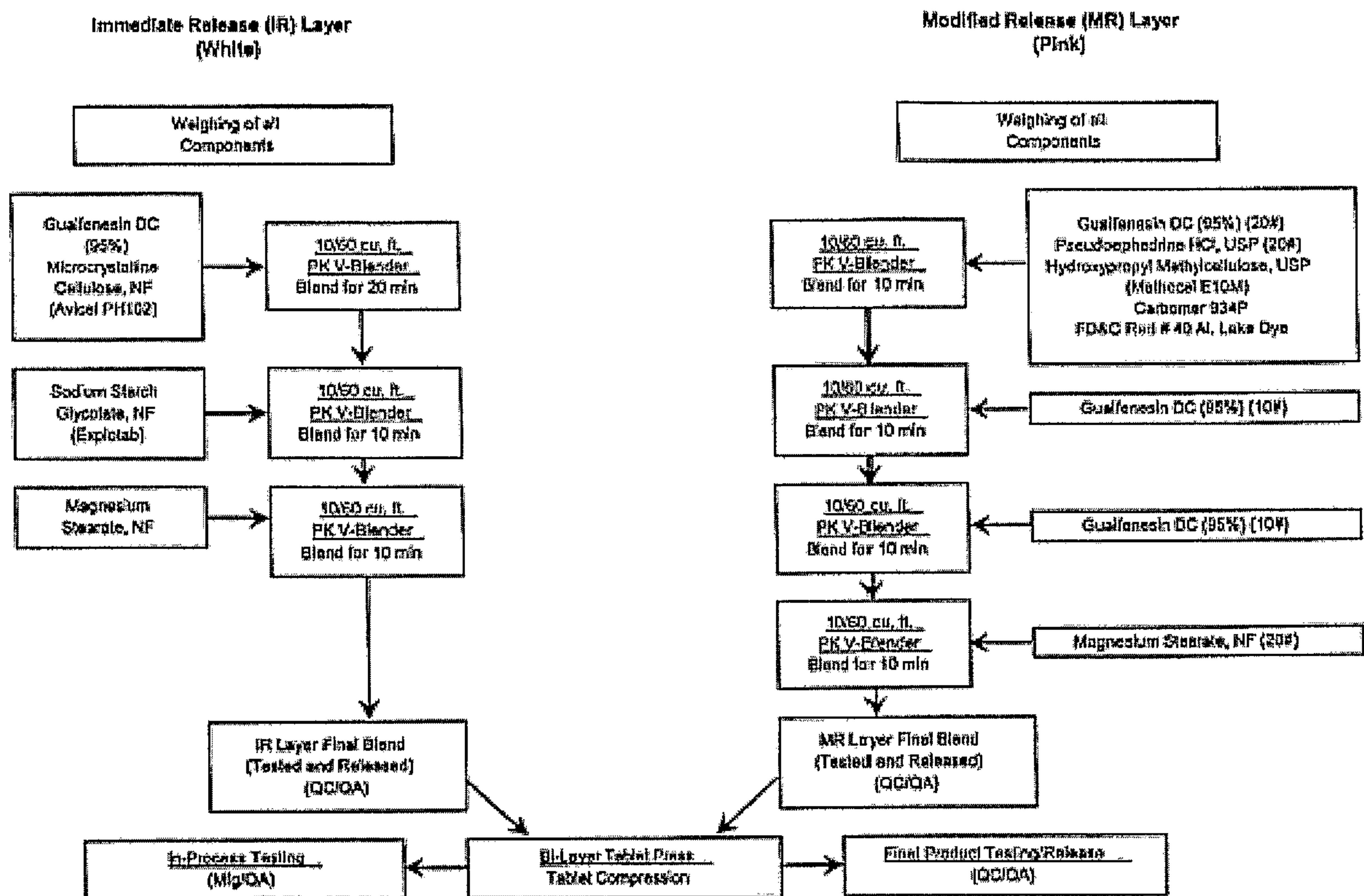
43 / 45

Figure 43**Process Flow Diagram for the Manufacture of Gualfenesin DC (95%)**

44 / 45

Figure 44

Process Flow Diagram for Guafenesin/Pseudoephedrine (1200/120mg Tablets)



**Immediate Release (IR) Layer
(White)**

Modified Release (MR) Layer
(Orange)

