



(86) Date de dépôt PCT/PCT Filing Date: 2010/10/22
(87) Date publication PCT/PCT Publication Date: 2011/04/28
(45) Date de délivrance/Issue Date: 2020/05/12
(85) Entrée phase nationale/National Entry: 2012/04/23
(86) N° demande PCT/PCT Application No.: IB 2010/002854
(87) N° publication PCT/PCT Publication No.: 2011/048493
(30) Priorités/Priorities: 2009/10/23 (US61/254,293);
2009/10/23 (US61/254,291); 2009/10/23 (US61/254,296)

(51) Cl.Int./Int.Cl. A61K 9/48 (2006.01),
A61K 31/557 (2006.01), A61K 9/107 (2006.01),
A61K 9/40 (2006.01)

(72) Inventeurs/Inventors:
KLAIVENESS, JO ERIK JOHNSRUD, NO;
BERGE, GUNNAR, NO;
HUSTVEDT, SVEIN OLAF, NO;
OLESEN, PREBEN HOULBERG, DK;
MUELLERTZ, ANETTE, DK

(73) Propriétaire/Owner:
PRONOVA BIOPHARMA NORGE AS, NO

(74) Agent: BLAKE, CASSELS & GRAYDON LLP

(54) Titre : CAPSULES OU COMPRIMES ENROBES D'UN MELANGE OLEAGINEUX D'ACIDES GRAS

(54) Title: COATED CAPSULES AND TABLETS OF A FATTY ACID OIL MIXTURE

(57) Abrégé/Abstract:

Compositions comprising a fatty acid oil mixture and at least one free fatty acid in a coated capsule or a coated tablet form suitable for oral administration, and methods of use thereof, are disclosed. Further disclosed are preconcentrates comprising a fatty acid oil mixture, at least one surfactant, and optionally at least one free fatty acid, in a coated capsule or a coated tablet form, and methods of use thereof. The preconcentrates are capable of forming a self-nanoemulsifying drug delivery system (SNEDDS), a self-microemulsifying drug delivery system (SMEDDS), or self-emulsifying drug delivery systems (SEDDS) in an aqueous solution.

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property Organization

International Bureau

(43) International Publication Date
28 April 2011 (28.04.2011)(10) International Publication Number
WO 2011/048493 A1

(51) International Patent Classification:

<i>A61K 9/48</i> (2006.01)	<i>A61K 9/107</i> (2006.01)
<i>A23L 1/30</i> (2006.01)	<i>A61K 9/40</i> (2006.01)
<i>A61K 31/557</i> (2006.01)	

havn NV (DK). **MÜLLERTZ, Anette** [DK/DK]; Høstvej 11, DK-2920 Charlottenlund (DK).

(21) International Application Number:

PCT/IB2010/002854

(22) International Filing Date:

22 October 2010 (22.10.2010)

(25) Filing Language:

English

(26) Publication Language:

English

(30) Priority Data:

61/254,296	23 October 2009 (23.10.2009)	US
61/254,291	23 October 2009 (23.10.2009)	US
61/254,293	23 October 2009 (23.10.2009)	US

(81) Designated States (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM, AO, AT, AU, AZ, BA, BB, BG, BH, BR, BW, BY, BZ, CA, CH, CL, CN, CO, CR, CU, CZ, DE, DK, DM, DO, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN, HR, HU, ID, IL, IN, IS, JP, KE, KG, KM, KN, KP, KR, KZ, LA, LC, LK, LR, LS, LT, LU, LY, MA, MD, ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PE, PG, PH, PL, PT, RO, RS, RU, SC, SD, SE, SG, SK, SL, SM, ST, SV, SY, TH, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

(84) Designated States (unless otherwise indicated, for every kind of regional protection available): ARIPO (BW, GH, GM, KE, LR, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European (AL, AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU, LV, MC, MK, MT, NL, NO, PL, PT, RO, RS, SE, SI, SK, SM, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

Published:

— with international search report (Art. 21(3))

**WO 2011/048493 A1**

(54) Title: COATED CAPSULES AND TABLETS OF A FATTY ACID OIL MIXTURE

(57) **Abstract:** Compositions comprising a fatty acid oil mixture and at least one free fatty acid in a coated capsule or a coated tablet form suitable for oral administration, and methods of use thereof, are disclosed. Further disclosed are preconcentrates comprising a fatty acid oil mixture, at least one surfactant, and optionally at least one free fatty acid, in a coated capsule or a coated tablet form, and methods of use thereof. The preconcentrates are capable of forming a self-nanoemulsifying drug delivery system (SNEDDS), a self-microemulsifying drug delivery system (SMEDDS), or self-emulsifying drug delivery systems (SEDDS) in an aqueous solution.

COATED CAPSULES AND TABLETS OF A FATTY ACID OIL MIXTURE

[001] This application claims priority to U.S. Provisional Application No. 61/254,291, filed on October 23, 2009, U.S. Provisional Application No. 61/254,293, filed on October 23, 2009, and U.S. Provisional Application No. 61/254,296, filed on October 23, 2009.

[002] The present disclosure is generally directed to compositions and preconcentrates comprising a fatty acid oil mixture in a coated capsule or a coated tablet form suitable for oral administration, and methods of use thereof. The capsules and tablets presently disclosed may be administered to a subject for therapeutic treatment and/or regulation of at least one health problem including, for example, irregular plasma lipid levels, cardiovascular functions, immune functions, visual functions, insulin action, neuronal development, hypertriglyceridemia, hypercholesterolemia, mixed dyslipidemia, heart failure, and post myocardial infarction (MI).

[003] In humans, cholesterol and triglycerides are part of lipoprotein complexes in the bloodstream and can be separated via ultracentrifugation into high-density lipoprotein (HDL), intermediate-density lipoprotein (IDL), low-density lipoprotein (LDL), and very-low-density lipoprotein (VLDL) fractions. Cholesterol and triglycerides are synthesized in the liver, incorporated into VLDL, and released into the plasma. High levels of total cholesterol (total-C), LDL-C, and apolipoprotein B (a membrane complex for LDL-C and VLDL-C) promote human atherosclerosis and decreased levels of HDL-C and its transport complex; apolipoprotein A is also associated with the development of atherosclerosis. Furthermore, cardiovascular morbidity and mortality in humans can vary directly with the level of total-C and LDL-C and inversely with the level of HDL-C. In addition, research suggests that non-HDL cholesterol is an indicator of hypertriglyceridemia, vascular disease, atherosclerotic disease, and related conditions. In fact, NCEP ATP III specifies non-HDL cholesterol reduction as a treatment objective.

[004] Omega-3 fatty acids may regulate plasma lipid levels, cardiovascular and immune functions, insulin action, and neuronal development, and visual function. Marine oils, also commonly referred to as fish oils, are a source of omega-3 fatty acids, including eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), have been found to regulate lipid metabolism. Plant-based oils and microbial oils are

also sources of omega-3 fatty acids. Omega-3 fatty acids may have beneficial effects on the risk factors for cardiovascular diseases, for example hypertension and hypertriglyceridemia, and on the coagulation factor VII phospholipid complex activity. Omega-3 fatty acids may also lower serum triglycerides, increase serum HDL cholesterol, lower systolic and diastolic blood pressure and/or pulse rate, and may lower the activity of the blood coagulation factor VII-phospholipid complex. Further, omega-3 fatty acids are generally well-tolerated, without giving rise to severe side effects.

[005] Several formulations of omega-3 fatty acids have been developed. For example, one form of omega-3 fatty acid oil mixture is a concentrate of primary omega-3, long chain, polyunsaturated fatty acids from fish oil containing DHA and EPA, such as sold under the trademark Omacor® / Lovaza™ / Zodin® / Seacor®. See, for example, U.S. Patent Nos. 5,502,077, 5,656,667, 5,698,594, and 7,732,488. In particular, each 1000 mg capsule of Lovaza™ contains at least 90% omega-3 ethyl ester fatty acids (84% EPA/DHA); approximately 465 mg EPA ethyl ester and approximately 375 mg DHA ethyl ester.

[006] However, evidence suggests that long chain fatty acids and alcohols of up to at least C₂₄ are reversibly interconverted. Enzyme systems exist in the liver, fibroblasts, and the brain that convert fatty alcohols to fatty acids. In some tissues, fatty acids can be reduced back to alcohols. The carboxylic acid functional group of fatty acid molecules targets binding, but this ionizable group may hinder the molecule from crossing the cell membranes, such as of the intestinal wall. As a result, carboxylic acid functional groups are often protected as esters. The ester is less polar than the carboxylic acid, and may more easily cross the fatty cell membranes. Once in the bloodstream, the ester can be hydrolyzed back to the free carboxylic acid by enzyme esterase in the blood. It may be possible that the plasma enzymes do not hydrolyze the ester fast enough, however, and that the conversion of ester to free carboxylic acid predominantly takes place in the liver. Ethyl esters of polyunsaturated fatty can also be hydrolyzed to free carboxylic acids *in vivo*.

[007] Thus, there remains a need in the art for compositions and/or methods to improve the release and enhance solubilization, digestion, bioavailability and/or absorption of omega-3 fatty acids *in vivo*, while maintaining the ability to cross cell membranes.

[008] It is to be understood that both the foregoing general description and the following detailed description are exemplary and explanatory only and are not restrictive of the present disclosure, as claimed.

[009] The present disclosure is directed to a pharmaceutical composition in a gelatin capsule or a tablet form comprising: a fatty acid oil mixture comprising at least 75% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in a form chosen from ethyl ester and triglyceride; and at least one free fatty acid; wherein the gelatin capsule or the tablet comprises at least one coating.

[010] The present disclosure is also directed to a food supplement or nutritional supplement composition in a gelatin capsule or a tablet form comprising: a fatty acid oil mixture comprising from about 25% to about 75% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in a form chosen from ethyl ester and triglyceride; and at least one free fatty acid; wherein the gelatin capsule or the tablet comprises at least one coating.

[011] The present disclosure is also directed to pharmaceutical preconcentrate a gelatin capsule or a tablet form comprising: a fatty acid oil mixture comprising at least 75% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in a form chosen from ethyl ester, triglyceride; at least one free fatty acid; and at least one surfactant; wherein the gelatin capsule or the tablet comprises at least one coating.

[012] The present disclosure is also directed to a pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprising: from about 45% to about 55% by weight, relative to the weight of the preconcentrate, of a fatty acid oil mixture comprising from about 80% to about 88% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA) by weight of the fatty acid oil mixture, wherein the EPA and DHA are in ethyl ester form; from about 10% to about 15% by weight, relative to the weight of the preconcentrate, of at least one free fatty acid comprising from about 80% to about 88% EPA and DHA, by weight of the at least one free fatty acid, wherein the EPA and DHA are in free fatty acid form; and from about 30% to about 40% by weight, relative to the weight of the preconcentrate, of at least one surfactant

chosen from polysorbate 20; wherein the gelatin capsule or the tablet comprises at least one coating.

[013] The present disclosure is also directed to a pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprising: from about 45% to about 55% by weight, relative to the weight of the preconcentrate, of a fatty acid oil mixture comprising from about 80% to about 88% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA) by weight of the fatty acid oil mixture, wherein the EPA and DHA are in ethyl ester form; from about 10% to about 15% by weight, relative to the weight of the preconcentrate, of at least one free fatty acid chosen from oleic acid; and from about 30% to about 40% by weight, relative to the weight of the preconcentrate, of at least one surfactant chosen from polysorbate 20; wherein the gelatin capsule or the tablet comprises at least one coating.

[014] The present disclosure is also directed to a pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprising: from about 65% to about 75% by weight, relative to the weight of the preconcentrate, of a fatty acid oil mixture comprising from about 80% to about 88% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA) by weight of the fatty acid oil mixture, wherein the EPA and DHA are in ethyl ester form; from about 15% to about 20% by weight, relative to the weight of the preconcentrate, of at least one free fatty acid chosen from oleic acid; and from about 10% to about 15% by weight, relative to the weight of the preconcentrate, of at least one surfactant chosen from polysorbate 20; wherein the gelatin capsule or the tablet comprises at least one coating.

[015] The present disclosure is also directed to a pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprising: from about 45% to about 55% by weight, relative to the weight of the preconcentrate, of a fatty acid oil mixture comprising from about 80% to about 88% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA) by weight of the fatty acid oil mixture, wherein the EPA and DHA are in ethyl ester form; from about 10% to about 15% by weight, relative to the weight of the preconcentrate, of at least one free fatty acid comprising from about 80% to about 88% EPA and DHA, by weight of the at least one free fatty acid, wherein the EPA and DHA are in free fatty acid form; and from about 40% to about 50% by weight, relative to the weight of the preconcentrate, of at least two

surfactants chosen from polysorbate 20 and lecithin; wherein the gelatin capsule or the tablet comprises at least one coating.

[016] The present disclosure is also directed to a pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprising: a fatty acid oil mixture comprising at least 75% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in free acid form; and at least one surfactant; wherein the gelatin capsule or the tablet comprises at least one coating.

[017] The present disclosure is also directed to a pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprising: from about 60% to about 70% by weight, relative to the weight of the preconcentrate, of a fatty acid oil mixture comprising from about 80% to about 88% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in free acid form; and from about 30% to about 40% by weight, relative to the weight of the preconcentrate, of at least two surfactants chosen from polysorbate 20 and lecithin; wherein the gelatin capsule or the tablet comprises at least one coating.

[018] The present disclosure is also directed to a pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprising: a fatty acid oil mixture comprising at least 75% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in a form chosen from ethyl ester and triglyceride; and at least one surfactant; wherein the gelatin capsule or the tablet comprises at least one coating.

[019] The present disclosure is also directed to a pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprising: from about 75% to about 85% by weight, relative to the weight of the preconcentrate, of a fatty acid oil mixture comprising from about 80% to about 88% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA) by weight of the fatty acid oil mixture, wherein the EPA and DHA are in ethyl ester form; and from about 15% to about 25% by weight, relative to the weight of the preconcentrate, of at least one surfactant chosen from polysorbate 80; wherein the gelatin capsule or the tablet comprises at least one coating.

[020] The present disclosure is also directed to a food supplement or nutritional supplement preconcentrate in a gelatin capsule or a tablet form comprising: a fatty acid oil mixture comprising from about 25% to about 75% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in a form chosen from ethyl ester and triglyceride; at least one free fatty acid; and at least one surfactant; wherein the gelatin capsule or the tablet comprises at least one coating.

[021] The present disclosure is also directed to a food supplement preconcentrate or nutritional supplement preconcentrate in a gelatin capsule or a tablet form comprising: a fatty acid oil mixture comprising from about 25% to about 75% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in free acid form; and at least one surfactant; wherein the gelatin capsule or the tablet comprises at least one coating.

[022] The present disclosure is also directed to a food supplement preconcentrate or nutritional supplement preconcentrate in a gelatin capsule or a tablet form comprising: a fatty acid oil mixture comprising from about 25% to about 75% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in a form chosen from ethyl ester and triglyceride; and at least one surfactant; and wherein the gelatin capsule or the tablet comprises at least one coating.

[023] The present disclosure is also directed to a pharmaceutical composition in a gelatin capsule or a tablet form comprising a fatty acid oil mixture comprising at least 75% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in a form chosen from ethyl ester and triglyceride, and at least one free fatty acid, wherein the gelatin capsule or the tablet comprises at least one coating, for the treatment of at least one health problem chosen from irregular plasma lipid levels, cardiovascular functions, immune functions, visual functions, insulin action, neuronal development, heart failure, and post myocardial infarction.

[024] The present disclosure is also directed to a pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprising a fatty acid oil mixture comprising at least 75% eicosapentaenoic acid (EPA) and docosahexaenoic acid

(DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in a form chosen from ethyl ester and triglyceride, at least one free fatty acid, and at least one surfactant, wherein the gelatin capsule or the tablet comprises at least one coating, for the treatment of at least one health problem chosen from irregular plasma lipid levels, cardiovascular functions, immune functions, visual functions, insulin action, neuronal development, heart failure, and post myocardial infarction.

[025] The present disclosure is also directed to a self-nanoemulsifying drug delivery system (SNEDDS), self-microemulsifying drug delivery system (SMEDDS), or self-emulsifying drug delivery system (SEDDS) comprising a pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprising: a fatty acid oil mixture comprising at least 75% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in a form chosen from ethyl ester and triglyceride, at least one free fatty acid, and at least one surfactant, wherein the gelatin capsule or the tablet comprises at least one coating, and wherein the preconcentrate forms an emulsion in an aqueous solution, for the treatment of at least one health problem chosen from irregular plasma lipid levels, cardiovascular functions, immune functions, visual functions, insulin action, neuronal development, heart failure, and post myocardial infarction.

[026] The present disclosure is also directed to a pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprising a fatty acid oil mixture comprising at least 75% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in free acid form and at least one surfactant, wherein the gelatin capsule or the tablet comprises at least one coating, for the treatment of at least one health problem chosen from irregular plasma lipid levels, cardiovascular functions, immune functions, visual functions, insulin action, neuronal development, heart failure, and post myocardial infarction.

[027] The present disclosure is also directed to a self-nanoemulsifying drug delivery system (SNEDDS), self-microemulsifying drug delivery system (SMEDDS), or self-emulsifying drug delivery system (SEDDS) comprising a pharmaceutical preconcentrate comprising: a fatty acid oil mixture comprising at least 75% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in free acid form and at least one

surfactant, wherein the gelatin capsule or the tablet comprises at least one coating, and wherein the preconcentrate forms an emulsion in an aqueous solution, for the treatment of at least one health problem chosen from irregular plasma lipid levels, cardiovascular functions, immune functions, visual functions, insulin action, neuronal development, heart failure, and post myocardial infarction.

[028] The present disclosure is also directed to a pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprising a fatty acid oil mixture comprising at least 75% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in a form chosen from ethyl ester and triglyceride and at least one surfactant, wherein the gelatin capsule or the tablet comprises at least one coating, for the treatment of at least one health problem chosen from irregular plasma lipid levels, cardiovascular functions, immune functions, visual functions, insulin action, neuronal development, heart failure, and post myocardial infarction.

[029] The present disclosure is also directed to a self-nanoemulsifying drug delivery system (SNEDDS), self-microemulsifying drug delivery system (SMEDDS), or self-emulsifying drug delivery system (SEDDS) comprising a pharmaceutical preconcentrate comprising: a fatty acid oil mixture comprising at least 75% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in a form chosen from ethyl ester and triglyceride, and at least one surfactant, wherein the gelatin capsule or the tablet comprises at least one coating, and wherein the preconcentrate forms an emulsion in an aqueous solution, for the treatment of at least one health problem chosen from irregular plasma lipid levels, cardiovascular functions, immune functions, visual functions, insulin action, neuronal development, heart failure, and post myocardial infarction.

BRIEF DESCRIPTION OF THE DRAWINGS

[030] FIG 1 shows the viscosity of preconcentrates A-L.

[031] FIG 2 shows the average particle size distribution for preconcentrates A-F, I, and J in gastric media and intestinal media.

[032] FIG 3 shows the read out from the Malvern zetasizer for four consecutive measurements on preconcentrate A in gastric media.

[033] FIG 4 shows the read out from the Malvern zetasizer for four consecutive measurements on preconcentrate B in gastric media.

[034] FIG 5 shows the read out from the Malvern zetasizer for four consecutive measurements on preconcentrate C in gastric media.

[035] FIG 6 shows the read out from the Malvern zetasizer for four consecutive measurements on preconcentrate D in gastric media.

[036] FIG 7 shows the read out from the Malvern zetasizer for four consecutive measurements on preconcentrate E in gastric media.

[037] FIG 8 shows the read out from the Malvern zetasizer for four consecutive measurements on preconcentrate F in gastric media.

[038] FIG 9 shows the read out from the Malvern zetasizer for four consecutive measurements on preconcentrate I in gastric media.

[039] FIG 10 shows the read out from the Malvern zetasizer for four consecutive measurements on preconcentrate J in gastric media.

[040] FIG 11 shows the read out from the Malvern zetasizer for four consecutive measurements on preconcentrate A in intestinal media.

[041] FIG 12 shows the read out from the Malvern zetasizer for four consecutive measurements on preconcentrate B in intestinal media.

[042] FIG 13 shows the read out from the Malvern zetasizer for four consecutive measurements on preconcentrate C in intestinal media.

[043] FIG 14 shows the read out from the Malvern zetasizer for four consecutive measurements on preconcentrate D in intestinal media.

[044] FIG 15 shows the read out from the Malvern zetasizer for four consecutive measurements on preconcentrate E in intestinal media.

[045] FIG 16 shows the read out from the Malvern zetasizer for four consecutive measurements on preconcentrate F in intestinal media.

[046] FIG 17 shows the read out from the Malvern zetasizer for four consecutive measurements on preconcentrate I in intestinal media.

[047] FIG 18 shows the read out from the Malvern zetasizer for four consecutive measurements on preconcentrate J in intestinal media.

[048] FIG 19 shows the disappearance of EPA-EE and DHA-EE and the appearance of EPA-FA and DHA-FA during lipolysis of Omacor®.

[049] FIG 20 shows the percent recovery of EPA + DHA at different time-points for Omacor®.

[050] FIG 21 shows the percent lipolysis of EPA-EE, DHA-EE and total K85EE at different time points for Omacor®.

[051] FIG 22 shows the disappearance of EPA-EE and DHA-EE and the appearance of EPA-FA and DHA-FA during lipolysis of preconcentrate A.

[052] FIG 23 shows the percent recovery of EPA + DHA at different time-points for preconcentrate A.

[053] FIG 24 shows the percent lipolysis of EPA-EE, DHA-EE and total K85EE at different time points for preconcentrate A.

[054] FIG 25 shows the disappearance of EPA-EE and DHA-EE and the appearance of EPA-FA and DHA-FA during lipolysis of preconcentrate B.

[055] FIG 26 shows the percent recovery of EPA + DHA at different time-points for preconcentrate B.

[056] FIG 27 shows the percent lipolysis of EPA-EE, DHA-EE and total K85EE at different time points for preconcentrate B.

[057] FIG 28 shows the disappearance of EPA-EE and DHA-EE and the appearance of EPA-FA and DHA-FA during lipolysis of preconcentrate C.

[058] FIG 29 shows the percent recovery of EPA + DHA at different time-points for preconcentrate C.

[059] FIG 30 shows the percent lipolysis of EPA-EE, DHA-EE and total K85EE at different time points for preconcentrate C.

[060] FIG 31 shows the disappearance of EPA-EE and DHA-EE and the appearance of EPA-FA and DHA-FA during lipolysis of preconcentrate D.

[061] FIG 32 shows the percent recovery of EPA + DHA at different time-points for preconcentrate D.

[062] FIG 33 shows the percent lipolysis of EPA-EE, DHA-EE and total K85EE at different time points for preconcentrate D.

[063] FIG 34 shows the disappearance of EPA-EE and DHA-EE and the appearance of EPA-FA and DHA-FA during lipolysis of preconcentrate E.

[064] FIG 35 shows the percent recovery of EPA + DHA at different time-points for preconcentrate E.

[065] FIG 36 shows the percent lipolysis of EPA-EE, DHA-EE and total K85EE at different time points for preconcentrate E.

[066] FIG 37 shows the plasma concentration versus time profile of the total lipid concentration of EPA for Example 14.

[067] FIG 38 shows EPA blood serum level over time following the administration of coated and uncoated tablets as described in Example 22.

[068] FIG 39 shows DHA blood serum level over time following the administration of coated and uncoated tablets as described in Example 22.

DESCRIPTION

[069] Particular aspects of the disclosure are described in greater detail below. The terms and definitions as used in the present application and as clarified herein are intended to represent the meaning within the present disclosure.

[070] The singular forms "a," "an," and "the" include plural reference unless the context dictates otherwise.

[071] The terms "approximately" and "about" mean to be nearly the same as a referenced number or value. As used herein, the terms "approximately" and "about" should be generally understood to encompass $\pm 10\%$ of a specified amount, frequency or value.

[072] The terms "administer," "administration" or "administering" as used herein refer to (1) providing, giving, dosing and/or prescribing by either a health practitioner or his authorized agent or under his direction a composition according to the disclosure, and (2) putting into, taking or consuming by the patient or person himself or herself, a composition according to the disclosure.

[073] The present disclosure provides for pharmaceutical and supplement compositions comprising a fatty acid oil mixture and at least one free fatty acid formulated as capsules, e.g., gelatin capsules, and tablets that may be coated.

[074] Also disclosed herein are preconcentrates comprising a fatty acid oil mixture and at least one surfactant. In some embodiments, the preconcentrates comprise a fatty acid oil mixture, at least one free fatty acid, and at least one

surfactant. The preconcentrates of the present disclosure can produce dispersions of low or very low mean particle size when mixed with an aqueous medium. Such dispersions can be characterized as nanoemulsions, microemulsions, or emulsions. For example, upon delivery, the preconcentrates are thought to produce dispersions with gastric or other physiological fluids generating self-nanoemulsifying drug delivery systems (SNEDDS), self-microemulsifying drug delivery systems (SMEDDS), or self-emulsifying drug delivery systems (SEDDS).

Fatty acid oil mixture

[075] Compositions of the present disclosure comprise at least one fatty acid oil mixture. The fatty acid oil mixture comprises eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA). As used herein, the term "fatty acid oil mixture" includes fatty acids, such as unsaturated (e.g., monounsaturated, polyunsaturated) or saturated fatty acids, as well as pharmaceutically-acceptable esters, free acids, mono-, di- and triglycerides, derivatives, conjugates, precursors, salts, and mixtures thereof. In some embodiments, the fatty acid oil mixture comprises fatty acids, such as omega-3 fatty acids, in a form chosen from ethyl ester and triglyceride. In other embodiments, the fatty acids of the fatty acid oil mixture are in free acid form.

[076] The term "omega-3 fatty acids" includes natural and synthetic omega-3 fatty acids, as well as pharmaceutically-acceptable esters, free acids, triglycerides, derivatives, conjugates (see, e.g., Zaloga et al., U.S. Patent Application Publication No. 2004/0254357, and Horrobin et al., U.S. Patent No. 6,245,811),

precursors, salts, and mixtures thereof. Examples of omega-3 fatty acid oils include, but are not limited to, omega-3 polyunsaturated, long-chain fatty acids such as eicosapentaenoic acid (EPA), docosahexaenoic acid (DHA), α -linolenic acid (ALA), heneicosapentaenoic acid (HPA), docosapentaenoic acid (DPA), eicosatetraenoic acid (ETA), eicosatrienoic acid (ETE), and octadecatetraenoic acid (i.e., stearidonic acid, STA); esters of omega-3 fatty acids with glycerol such as mono-, di- and triglycerides; and esters of the omega-3 fatty acids and a primary, secondary and/or tertiary alcohol, such as, for example, fatty acid methyl esters and fatty acid ethyl esters. The omega-3 fatty acids, esters, triglycerides, derivatives, conjugates, precursors, salts and/or mixtures thereof according to the present disclosure can be used in their pure form and/or as a

component of an oil, for example, as marine oil (e.g., fish oil and purified fish oil concentrates), algae oils, microbial oils and plant-based oils.

[077] In some embodiments of the present disclosure, the fatty acid oil mixture comprises EPA and DHA. Further for example, in some embodiments, the fatty acid oil mixture comprises EPA and DHA in a form chosen from ethyl ester and triglyceride. In other embodiments, the fatty acid oil mixture comprises EPA and DHA in free acid form.

[078] The fatty acid oil mixture of the present disclosure may further comprise at least one fatty acid other than EPA and DHA. Examples of such fatty acids include, but are not limited to, omega-3 fatty acids other than EPA and DHA and omega-6 fatty acids. For example, in some embodiments of the present disclosure, the fatty acid oil mixture comprises at least one fatty acid other than EPA and DHA chosen from α -linolenic acid (ALA), heneicosapentaenoic acid (HPA), docosapentaenoic acid (DPA), eicosatetraenoic acid (ETA), eicosatrienoic acid (ETE), and stearidonic acid (STA). In some embodiments, the at least one fatty acid other than EPA and DHA is chosen from linoleic acid, gamma-linolenic acid (GLA), arachidonic acid (AA), docosapentaenoic acid (i.e., osbond acid), and mixtures thereof. In some embodiments, the at least one fatty acid other than EPA and DHA is in a form chosen from ethyl ester and triglyceride. In other embodiments, the at least one fatty acid other than EPA and DHA is in free acid form.

[079] Examples of further fatty acids, or mixtures thereof (fatty acid oil mixtures) encompassed by the present disclosure include, but are not limited to, the fatty acids defined in the European Pharmacopoeia Omega-3 Ethyl Esters 90 and purified marine oils, for example, the European Pharmacopoeia Omega-3 acid Triglycerides, the European Pharmacopoeia Omega-3 acid Ethyl Esters 60, the European Pharmacopoeia Fish Oil Rich in Omega-3 Acids monograph, and/or for instance, the USP fish oil monograph.

[080] Commercial examples of fatty acid oil mixtures comprising different fatty acids suitable for the present disclosure include, but are not limited to: IncromegaTM omega-3 marine oil concentrates such as IncromegaTM TG7010 SR, IncromegaTM E7010 SR, IncromegaTM TG6015, IncromegaTM EPA500TG SR, IncromegaTM E400200 SR, IncromegaTM E4010, IncromegaTM DHA700TG SR, IncromegaTM DHA700E SR, IncromegaTM DHA500TG SR, IncromegaTM TG3322 SR,

Incromega™ E3322 SR, Incromega™ TG3322, Incromega™ E3322, Incromega™ Trio TG/EE (Croda International PLC, Yorkshire, England); EPAX2050TG, EPAX5500EE, EPAX5500TG, EPAX5000EE, EPAX5000TG, EPAX6000EE, EPAX6000TG, EPAX6000FA, EPAX6500EE, EPAX6500TG, EPAX4510TG, EPAX1050TG, EPAX6015TG/EE, EPAX4020TG, and EPAX4020EE (EPAX is a wholly-owned subsidiary of Norwegian company Austevoll Seafood ASA); Omacor® / Lovaza™ / Zodin® / Seacor® finished pharmaceutical product, K85EE, and AGP 103 (Pronova BioPharma Norge AS); MEG-3® EPA/DHA fish oil concentrates (Ocean Nutrition Canada); DHA FNO "Functional Nutritional Oil" and DHA CL "Clear Liquid" (Lonza); Superba™ Krill Oil (Aker); omega-3 products comprising DHA produced by Martek; Neptune krill oil (Neptune); cod-liver oil products and anti-reflux fish oil concentrate (TG) produced by Møllers; Lysi Omega-3 Fish oil; Seven Seas Triomega® Cod Liver Oil Blend (Seven Seas); Fri Flyt Omega-3 (Vesterålens); and Epadel (Mochida). Those commercial embodiments provide for various omega-3 fatty acids, combinations, and other components as a result of the transesterification process or method of preparation in order to obtain the omega-3 fatty acid(s) from various sources, such as marine, algae, microbial, and plant-based sources.

[081] The fatty acid oil mixture according to the present disclosure may be derived from animal oils and/or non-animal oils. In some embodiments of the present disclosure, the fatty acid oil mixture is derived from at least one oil chosen from marine oil, algae oil, plant-based oil, and microbial oil. Marine oils include, for example, fish oil, krill oil, and lipid composition derived from fish. Plant-based oils include, for example, flaxseed oil, canola oil, mustard seed oil, and soybean oil. Microbial oils include, for example, products by Martek. In at least one embodiment of the present disclosure, the fatty acid oil mixture is derived from a marine oil, such as a fish oil. In at least one embodiment, the marine oil is a purified fish oil.

[082] In some embodiments of the present disclosure, the fatty acids, such as omega-3 fatty acids, of the fatty acid oil mixture are esterified, such as alkyl esters. The alkyl esters may include, but are not limited to, ethyl, methyl, propyl, and butyl esters, and mixtures thereof. In other embodiments, the fatty acids are chosen from mono-, di-, and triglycerides.

[083] In some embodiments, the fatty acid oil mixture is obtained by a transesterification of the body oil of a fat fish species coming from, for example,

anchovy or tuna oil, and subsequent physico-chemical purification processes, including urea fractionation followed by molecular distillation. In some embodiments, the crude oil mixture may also be subjected to a stripping process for decreasing the amount of environmental pollutants and/or cholesterol before the transesterification.

[084] In another embodiment, the fatty acid oil mixture is obtained by using supercritical CO₂ extraction or chromatography techniques, for example, to up-concentrate primary EPA and DHA from fish oil concentrates. Commercial embodiments of fatty acids in ethyl triglyceride form encompassed by the present disclosure include, but are not limited to, K85TG (Pronova BioPharma Norge AS). Commercial embodiments of fatty acids in ethyl ester form encompassed by the present disclosure include, but are not limited to, K85EE (Pronova BioPharma Norge AS).

[085] In another embodiment, the fatty acid oil mixture is obtained by hydrolyzing a fatty acid oil mixture in ethyl ester form. Commercial embodiments of fatty acids in free acid form encompassed by the present disclosure include, but are not limited to, K85FA (Pronova BioPharma Norge AS).

[086] In some embodiments of the present disclosure, at least one of the omega-3 fatty acids of the fatty acid oil mixture has a *cis* configuration. Examples include, but are not limited to, (all-Z)-9,12,15-octadecatrienoic acid (ALA), (all-Z)-6,9,12,15-octadecatetraenoic acid (STA), (all-Z)-11,14,17-eicosatrienoic acid (ETE), (all-Z)-5,8,11,14,17-eicosapentaenoic acid (EPA), (all-Z)-4,7,10,13,16,19-docosahexaenoic acid (DHA), (all-Z)-8,11,14,17-eicosatetraenoic acid (ETA), (all-Z)-7,10,13,16,19-docosapentaenoic acid (DPA), (all-Z)-6,9,12,15,19-heneicosapentaenoic acid (HPA); (all-Z)-5,8,11,14-eicosatetraenoic acid, (all-Z)-4,7,10,13,16-docosapentaenoic acid (osbond acid), (all-Z)-9,12-octadecadienoic acid (linoleic acid), (all-Z)-5,8,11,14-eicosatetraenoic acid (AA), (all-Z)-6,9,12-octadecatrienoic acid (GLA); (Z)-9-octadecenoic acid (oleic acid), 13(Z)-docosenoic acid (erucic acid), (R-(Z))-12-hydroxy-9-octadecenoic acid (ricinoleic acid).

[087] In some embodiments of the present disclosure, the weight ratio of EPA:DHA of the fatty acid oil mixture ranges from about 1:10 to about 10:1, from about 1:8 to about 8:1, from about 1:6 to about 6:1, from about 1:5 to about 5:1, from about 1:4 to about 4:1, from about 1:3 to about 3:1, or from about 1:2 to 2 about :1. In at least one embodiment, the weight ratio of EPA:DHA of the fatty acid oil mixture

ranges from about 1:2 to about 2:1. In at least one embodiment, the weight ratio of EPA:DHA of the fatty acid oil mixture ranges from about 1:1 to about 2:1. In at least one embodiment, the weight ratio of EPA:DHA of the fatty acid oil mixture ranges from about 1.2 to about 1.3.

[088] In some embodiments of the present disclosure, the compositions and/or preconcentrates comprise one or more fatty acids, or mixtures thereof, in free acid form. Without being bound by theory, it is believed that fatty acids in free acid form may enhance or improve lipolysis in the body. For example, the addition of at least one fatty acid in free acid form may enhance or improve interconversion of fatty acid esters and/or triglycerides to the free fatty acid form for efficient uptake. Free fatty acids may, for example, provide for enhanced or improved hydrolysis, solubility, bioavailability, absorption, or any combinations thereof of fatty acids *in vivo*.

[089] Examples of free fatty acids include, but are not limited to, polyunsaturated fatty acids such as EPA, DHA, α -linolenic acid (ALA), heicosapentaenoic acid (HPA), docosapentaenoic acid (DPA), eicosatetraenoic acid (ETA), eicosatrienoic acid (ETE), stearidonic acid (STA), linoleic acid, gamma-linolenic acid (GLA), arachidonic acid (AA), osbond acid, oleic acid, ricinoleic acid, erucic acid, and mixtures thereof, in free acid form.

[090] In some embodiments of the present disclosure, the compositions comprise a fatty acid oil mixture in a form chosen from ethyl ester and triglyceride and at least one free fatty acid, such as at least one free fatty acid comprising at least 80% omega-3 fatty acids by weight of the at least one free fatty acid, such as at least 90% omega-3 fatty acids by weight of the at least one free fatty acid. In some embodiments, the compositions comprise a fatty acid oil mixture in a form chosen from ethyl ester and triglyceride and at least one free fatty acid is chosen from oleic acid, ricinoleic acid, linoleic acid, and erucic acid. In one embodiment, the at least one free fatty acid comprises oleic acid or linoleic acid.

[091] In some embodiments, the at least one free fatty acid comprises at least 75% EPA and DHA by weight of the at least one free fatty acid. For example, in some embodiments, the at least one free fatty acid comprises at least 80% by weight, at least 85% by weight, at least 90% by weight, or at least 95% EPA and DHA, by weight of the at least one free fatty acid. In some embodiments, the at least one free fatty acid comprises about 80% EPA and DHA by weight of the at least one

free fatty acid, such as about 85%, about 90%, about 95%, or any number in between, by weight of the at least one free fatty acid. The at least one free fatty acid can be used in a pure form and/or as a component of an oil, for example, as marine oil (e.g., fish oil and purified fish oil concentrates), microbial oil and plant-based oils.

[092] In some embodiments, the at least one free fatty acid comprises from about 75% to about 95% EPA and DHA by weight of the at least one free fatty acid, such as from about 75% to about 90%, from about 75% to about 85%, from about 75% to about 80%, from about 80% to about 95%, from about 80% to about 90%, from about 80% to about 85%, from about 85% to about 95%, from about 85% to about 90%, and further for example, from about 90% to about 95% by weight of the at least one free fatty acid, or any number in between. In at least one embodiment, the at least one free fatty acid comprises from about 80% to about 85% EPA and DHA, by weight of the at least one free fatty acid, such as from about 80% to about 88% EPA and DHA by weight, such as about 84%, by weight of the at least one free fatty acid.

Pharmaceutical

[093] In some embodiments of the present disclosure, the fatty acid oil mixture acts as an active pharmaceutical ingredient (API). In some embodiments, the fatty acid oil mixture is present in a pharmaceutically-acceptable amount. As used herein, the term "pharmaceutically-effective amount" means an amount sufficient to treat, e.g., reduce and/or alleviate the effects, symptoms, etc., at least one health problem in a subject in need thereof. In at least some embodiments of the present disclosure, the fatty acid oil mixture does not comprise an additional active agent.

[094] Where the composition is a pharmaceutical composition, the fatty acid oil mixture comprises at least 75% EPA and DHA by weight of the fatty acid oil mixture. For example, in one embodiment, the fatty acid oil mixture comprises at least 80% EPA and DHA by weight of the fatty acid oil mixture, such as at least 85%, at least 90%, or at least 95%, by weight of the fatty acid oil mixture. In some embodiments, the fatty acid oil mixture comprises about 80% EPA and DHA by weight of the fatty acid oil mixture, such as about 85%, about 90%, about 95%, or any number in between, by weight of the fatty acid oil mixture.

[095] For example, in some embodiments, the fatty acid oil mixture comprises from about 75% to about 95% EPA and DHA by weight of the fatty acid oil mixture, such as from about 75% to about 90%, from about 75% to about 88%, from about 75% to about 85%, from about 75% to about 80%, from about 80% to about 95%, from about 80% to about 90%, from about 80% to about 85%, from about 85% to about 95%, from about 85% to about 90%, and further for example, from about 90% to about 95% EPA and DHA, by weight of the fatty acid oil mixture, or any number in between. In at least one embodiment, the fatty acid oil mixture comprises from about 80% to about 85% EPA and DHA, by weight of the fatty acid oil mixture, such as from about 80% to about 88%, such as about 84%, by weight of the fatty acid oil mixture.

[096] In some embodiments, the fatty acid oil mixture comprises at least 95% of EPA or DHA, or EPA and DHA, by weight of the fatty acid oil mixture.

[097] In a further embodiment, the fatty acid oil mixture may comprise other omega-3 fatty acids. For example, the present disclosure encompasses at least 90% omega-3 fatty acids, by weight of the fatty acid oil mixture.

[098] In one embodiment, for example, the fatty acid oil mixture comprises from about 75% to about 88% EPA and DHA, by weight of the fatty acid oil mixture, wherein the fatty acid oil mixture comprises at least 90% of omega-3 fatty acids, by weight of the fatty acid oil mixture.

[099] In another embodiment, the fatty acid oil mixture comprises from about 75% to about 88% EPA and DHA, by weight of the fatty acid oil mixture, wherein the fatty acid oil mixture comprises at least 90% of omega-3 fatty acids, by weight of the fatty acid oil mixture, and wherein the fatty acid oil mixture comprises α -linolenic acid (ALA).

[0100] In one embodiment, the fatty acid oil mixture comprises from about 80% to about 88% EPA and DHA by weight of the fatty acid oil mixture, and further comprises docosapentaenoic acid (DPA).

[0101] In another embodiment, the fatty acid oil mixture comprises from about 80% to about 88% EPA and DHA by weight of the fatty acid oil mixture, and further comprises from about 1% to about 4% (all-Z omega-3)-6,9,12,15,18-heneicosapentaenoic acid (HPA), by weight of the fatty acid oil mixture.

[0102] In another embodiment, the fatty acid oil mixture comprises from about 80% to about 88% EPA and DHA by weight of the fatty acid oil mixture; and from 1% to about 4% fatty acids other than EPA and DHA, by weight of the fatty acid oil mixture, wherein the fatty acids other than EPA and DHA have C₂₀, C₂₁, or C₂₂ carbon atoms.

[0103] In one embodiment, the fatty acid oil mixture may comprise K85EE or AGP 103 (Pronova BioPharma Norge AS). In another embodiment, the fatty acid oil mixture may comprise K85TG (Pronova BioPharma Norge AS). In yet another embodiment, the fatty acid oil mixture may comprise K85FA (BioPharma Norge AS).

[0104] In some embodiments of the present disclosure, the pharmaceutical compositions provide for enhanced bioavailability, such as greater than about 40% increase in bioavailability, such as, about 80% increase.

EPA and DHA products

[0105] In at least one embodiment, the fatty acid oil mixture comprises at least 75% EPA and DHA by weight of the fatty acid oil mixture, of which at least 95% is EPA. In another embodiment, the fatty acid oil mixture comprises at least 80% EPA and DHA by weight of the fatty acid oil mixture, of which at least 95% is EPA. In yet another embodiment, the fatty acid oil mixture comprises at least 90% EPA and DHA by weight of the fatty acid oil mixture, of which at least 95% is EPA.

[0106] In another embodiment, the fatty acid oil mixture comprises at least 75% EPA and DHA by weight of the fatty acid oil mixture, of which at least 95% is DHA. For example, in one embodiment, the fatty acid oil mixture comprises at least 80% EPA and DHA by weight of the fatty acid oil mixture, of which at least 95% is DHA. In another embodiment, the fatty acid oil mixture comprises at least 90% EPA and DHA by weight of the fatty acid oil mixture, of which at least 95% is DHA.

Supplement

[0107] The present disclosure further provides a food supplement or a nutritional supplement comprising a fatty acid oil mixture, wherein the fatty acid oil mixture comprises less than 75% EPA and DHA by weight of the fatty acid oil mixture. In some embodiments, for example, the fatty acid oil mixture comprises less than 70% EPA and DHA by weight of the fatty acid oil mixture, such as less than 65%, less than 60%, less than 55%, less than 50%, less than 45%, less than 40%, or even less than 35% by weight of the fatty acid oil mixture.

[0108] In some embodiments, the fatty acid oil mixture comprises from about 25% to about 75% EPA and DHA by weight of the fatty acid oil mixture, such as from about 30% to about 75%, from about 30% to about 70%, from about 30% to about 65%, from about 30% to about 55%, from about 30% to about 50%, from about 30% to about 45%, from about 30% to about 40%, and further for example, from about 30% to about 35% EPA and DHA, by weight of the fatty acid oil mixture.

Surfactant / Preconcentrate

[0109] The present disclosure provides for a preconcentrate composition, wherein the term "preconcentrate" refers to a composition comprising at least a fatty acid oil mixture and at least one surfactant. In some embodiments, for example, the preconcentrate comprises a fatty acid oil mixture in a form chosen from ethyl ester and triglyceride, at least one free fatty acid, and at least one surfactant. In other embodiments, the preconcentrate comprises a fatty acid oil mixture in free acid form and at least one surfactant. In still other embodiments, the preconcentrate comprises a fatty acid oil mixture in a form chosen from ethyl ester and triglyceride and at least one surfactant.

[0110] A surfactant may, for example, lower the surface tension of a liquid or the surface tension between two liquids. For example, surfactants according to the present disclosure may lower the surface tension between the fatty acid oil mixture and an aqueous solution.

[0111] Chemically speaking, surfactants are molecules with at least one hydrophilic part and at least one hydrophobic (i.e., lipophilic) part. Surfactant properties may be reflected in the hydrophilic-lipophilic balance (HLB) value of the surfactant, wherein the HLB value is a measure of the degree of hydrophilic versus lipophilic properties of a surfactant. The HLB value normally ranges from 0 to 20, where a HLB value of 0 represents high hydrophilic character, and a HLB of 20 represents high lipophilic character. Surfactants are often used in combination with other surfactants, wherein the HLB values are additive. The HLB value of surfactant mixtures may be calculated as follows:

$$\text{HLB}_A \text{ (fraction of surfactant A)} + \text{HLB}_B \text{ (fraction of surfactant B)} = \text{HLB}_{A+B \text{ mixture}}$$

[0112] Surfactants are generally classified as ionic surfactants, e.g., anionic or cationic surfactants, and nonionic surfactants. If the surfactant contains two

oppositely charged groups, the surfactant is named a zwitterionic surfactant. Other types of surfactants include, for example, phospholipids.

[0113] In at least one embodiment of the present disclosure, the composition comprises at least one surfactant chosen from nonionic, anionic, cationic, and zwitterionic surfactants.

[0114] Non-limiting examples of nonionic surfactants suitable for the present disclosure are mentioned below.

[0115] Pluronic® surfactants are nonionic copolymers composed of a central hydrophobic polymer (polyoxypropylene(poly(propylene oxide))) with a hydrophilic polymer (polyoxyethylene(poly(ethylene oxide))) on each side. Various commercially-available Pluronic® products are listed in Table 1.

Table 1: Examples of Pluronic® surfactants.

	Type	Average Molecular Weight (D)	HLB Value
Pluronic® L-31	Non-ionic	1100	1.0-7.0
Pluronic® L-35	Non-ionic	1900	18.0-23.0
Pluronic® L-61	Non-ionic	2000	1.0-7.0
Pluronic® L-81	Non-ionic	2800	1.0-7.0
Pluronic® L-64	Non-ionic	2900	12.0-18.0
Pluronic® L-121	Non-ionic	4400	1.0-7.0
Pluronic® P-123	Non-ionic	5800	7-9
Pluronic® F-68	Non-ionic	8400	> 24
Pluronic® F-108	Non-ionic	14600	> 24

[0116] Brij® are nonionic surfactants comprising polyethylene ethers. Various commercially-available Brij® products are listed in Table 2.

Table 2: Examples of Brij® surfactants.

	Type	Compound	HLB Value

Brij® 30	Non-ionic	Polyoxyethylene(4) lauryl ether	9.7
Brij® 35	Non-ionic	Polyoxyethylene (23) lauryl ether	16.9
Brij® 52	Non-ionic	Polyoxyethylene (2) cetyl ether	5.3
Brij® 56	Non-ionic	Polyoxyethylene (10) cetyl ether	12.9
Brij® 58	Non-ionic	Polyoxyethylene (20) cetyl ether	15.7
Brij® 72	Non-ionic	Polyoxyethylene (2) stearyl ether	4.9
Brij® 76	Non-ionic	Polyoxyethylene (10) stearyl ether	12.4
Brij® 78	Non-ionic	Polyoxyethylene (20) stearyl ether	15.3
Brij® 92V	Non-ionic	Polyoxyethylene (2) oleyl ether	4.9
Brij® 93	Non-ionic	Polyoxyethylene (2) oleyl ether	4
Brij® 96V	Non-ionic	Polyethylene glycol oleyl ether	12.4
Brij® 97	Non-ionic	Polyoxyethylene (10) oleyl ether	12
Brij® 98	Non-ionic	Polyoxyethylene (20) oleyl ether	15.3
Brij® 700	Non-ionic	Polyoxyethylene (100) stearyl ether	18

[0117] Span® are nonionic surfactants comprising sorbitan esters. Span® is available from different sources including Aldrich. Various commercially-available Span® products are listed in Table 3.

Table 3: Examples of Span® surfactants.

	Type	Compound	HLB Value
Span® 20	Non-ionic	sorbitan monolaurate	8.6
Span® 40	Non-ionic	sorbitan monopalmitate	6.7
Span® 60	Non-ionic	sorbitan monostearate	4.7
Span® 65	Non-ionic	sorbitan tristearate	2.1
Span® 80	Non-ionic	sorbitan monooleate	4.3

Span® 85	Non-ionic	Sorbitan trioleate	1.8
----------	-----------	--------------------	-----

[0118] Tween® (polysorbates) are nonionic surfactants comprising polyoxyethylene sorbitan esters. Various commercially-available Tween® products are listed in Table 4.

Table 4: Examples of Tween® surfactants.

	Type	Compound	HLB Value
Tween® 20	Non-ionic	polyoxyethylene (20) sorbitan monolaurate	16.0
Tween® 40	Non-ionic	polyoxyethylene (20) sorbitan monopalmitate	15.6
Tween® 60	Non-ionic	polyoxyethylene sorbitan monostearate	14.9
Tween® 65	Non-ionic	polyoxyethylene sorbitan tristearate	10.5
Tween® 80	Non-ionic	polyoxyethylene(20)sorbitan monooleate	15.0
Tween® 85	Non-ionic	polyoxyethylene sorbane trioleate	11.0

[0119] Myrj® are nonionic surfactants comprising polyoxyethylene fatty acid esters. Various commercially-available Myrj® products are listed in Table 5.

Table 5: Examples of Myrj® surfactants.

	Type	Compound	HLB Value
Myrj® 45	Non-ionic	polyoxyethylene monostearate	11.1
Myrj® 49	Non-ionic	polyoxyethylene	15.0

		monostearate	
Myrij® 52	Non-ionic	polyoxyethylene monostearate	16.9
Myrij® 53	Non-ionic	polyoxyethylene monostearate	17.9

[0120] Cremophor® are nonionic surfactants. Various commercially-available Cremophor® products are listed in Table 6.

Table 6: Examples of Cremophor® surfactants.

	Type	Compound	HLB Value
Cremophor® REL	Non-ionic	polyoxyethylated castor oil	2-14
Cremophor® RH40	Non-ionic	hydrogenated polyoxyethylated castor oil	14-16
Cremophor® RH60	Non-ionic	hydrogenated polyoxyethylated castor oil	15-17
Cremophor® RO	Non-ionic	hydrogenated polyoxyethylated castor oil	16.1

[0121] According to the present disclosure, other exemplary nonionic surfactants include, but are not limited to, diacetyl monoglycerides, diethylene glycol monopalmitostearate, ethylene glycol monopalmitostearate, glycetyl behenate, glycetyl distearate, glycetyl monolinoleate, glycetyl mono-oleate, glycetyl monostearate, macrogol cetostearyl ether such as cetomacrogol 1000 and polyoxy 20 cetostearyl ether, macrogol 15 hydroxystearate, macrogol lauril ethers such as laureth 4 and lauromacrogol 400, macrogol monomethyl ethers, macrogol oleyl ethers such as polyoxyl 10 oleyl ether, macrogol stearates such as polyoxyl 40 stearate, menfegol, mono and diglycerides, nonoxinols such as nonoxinol-9, nonoxinol-10 and nonoxinol-11, octoxinols such as octoxinol 9 and oxtoxinol 10, polyoxamers such as polyoxalene, polyoxamer 188, polyoxamer 407, polyoxyl castor oil such as polyoxyl 35 castor oil, polyoxyl hydrogenated castor oil such as polyoxyl 40 hydrogenated castor oil, propylene glycol diacetate, propylene glycol laurates

such as propylene glycol dilaurate and propylene glycol monolaurate. Further examples include propylene glycol monopalmitostearate, quillaia, sorbitan esters, and sucrose esters.

[0122] Anionic surfactants suitable for the present disclosure include, for example, salts of perfluorocarboxylic acids and perfluorosulphonic acid, alkyl sulphate salts such as sodium dodecyl sulphate and ammonium lauryl sulphate, sulphate ethers such as sodium lauryl ether sulphate, and alkyl benzene sulphonate salts.

[0123] Cationic surfactants suitable for the present disclosure include, for example, quaternary ammonium compounds such as benzalkonium chloride, cetylpyridinium chlorides, benzethonium chlorides, and cetyl trimethylammonium bromides or other trimethylalkylammonium salts.

[0124] Zwitterionic surfactants include, but are limited to, for example dodecyl betaines, coco amphoglycinates and cocamidopropyl betaines.

[0125] In some embodiments of the present disclosure, the surfactant may comprise a phospholipid, derivative thereof, or analogue thereof. Such surfactants may, for example, be chosen from natural, synthetic, and semisynthetic phospholipids, derivatives thereof, and analogues thereof. Exemplary phospholipids surfactants include phosphatidylcholines with saturated, unsaturated and/or polyunsaturated lipids such as dioleoylphosphatidylcholine, dipentadecanoylphosphatidylcholine, dilauroylphosphatidylcholine, dimyristoylphosphatidylcholine, dipalmitoylphosphatidylcholine, distearoylphosphatidylcholine, di-eicopentenoyl(EPA)choline, didocosahexaenoyl(DHA)choline, phosphatidylethanolamines, phosphatidylglycerols, phosphatidylserines and phosphatidylinositols. Other exemplary phospholipid surfactants include soybean lecithin, egg lecithin, dioleyl phosphatidylcholine, distearoyl phosphatidyl glycerol, PEG-ylated phospholipids, and dimyristoyl phosphatidylcholine.

[0126] Phospholipids may be "natural" or from a marine origin chosen from, e.g. phosphatidylcholine, phosphatidylethanolamine, phosphatidylserine and phosphatidylinositol. The fatty acid moiety may be chosen from 14:0, 16:0, 16: 1n-7, 18:0, 18:1n-9, 18:1n-7, 18:2n-6, 18:3n-3, 18:4n-3, 20:4n-6, 20:5n-3, 22:5n-3 and

22:6n-3, or any combinations thereof. In one embodiment, the fatty acid moiety is chosen from palmitic acid, EPA and DHA.

[0127] Other exemplary surfactants suitable for the present disclosure are listed in Table 7.

Table 7: Other surfactants

Surfactant	Type	HBL Value
Ethylene glycol distearate	Nonionic	1.5
Glyceryl monostearate	Nonionic	3.3
Propylene glycol monostearate	Nonionic	3.4
Glyceryl monostearate	Nonionic	3.8
Diethylene glycol monolaurate	Nonionic	6.1
Acacia	Anionic	8.0
Cetrimonium bromide	Cationic	23.3
Cetylpyridinium chloride	Cationic	26.0
Polyoxamer 188	Nonionic	29.0
Sodium lauryl sulphate	Anionic	40

[0128] In some embodiments of the present disclosure, the at least one surfactant does not comprise Labrasol, Cremophor RH40, or the combination of Cremophor and Tween-80.

[0129] In some embodiments, the at least one surfactant has a hydrophilic-lipophilic balance (HLB) of less than about 10, such as less than about 9, or less than about 8.

[0130] The weight ratio of EPA and DHA to the at least one surfactant may range depending on the choice of surfactant(s), the EPA to DHA ratio, and the overall formulation. In some embodiments of the present disclosure, the weight ratio of EPA and DHA : surfactant ranges from about 10:5 to about 10:0.001, from about 10:4 to about 10:0.005, from about 10:3 to about 10:0.01, from about 10:2 to about 0.015, from about 10:2 to about 10:0.02, or from about 10:15 to about 10:0.03.

Co-surfactant

[0131] In some embodiments, the preconcentrates of the present disclosure further comprise at least one co-surfactant. As used herein the term "co-surfactant" means a substance added to, e.g., the preconcentrate in combination with the at least one surfactant to affect, e.g., increase or enhance, emulsification and/or stability of the preconcentrate, for example to aid in forming an emulsion. In some embodiments, the at least one co-surfactant is hydrophilic.

[0132] Examples of co-surfactants suitable for the present disclosure include, but are not limited to, short chain alcohols comprising from 1 to 6 carbons (e.g., ethanol), benzyl alcohol, alkane diols and triols (e.g., propylene glycol, glycerol, polyethylene glycols such as PEG and PEG 400), glycol ethers such as tetraglycol and glycofurool (e.g., tetrahydrofurfuryl PEG ether), pyrrolidine derivatives such as N-methyl pyrrolidone (e.g., Pharmasolve®) and 2-pyrrolidone (e.g., Soluphor® P), and bile salts, for example sodium deoxycholate. Further examples include ethyl oleate.

[0133] In some embodiments, the at least one co-surfactant comprises from about 1% to about 10%, by weight relative to the weight of the preconcentrate.

Solvent

[0134] In some embodiments, the compositions and/or preconcentrates further comprise at least one solvent. Hydrophilic solvents suitable for the present disclosure include, but are not limited to, alcohols, including water-miscible alcohols, such as absolute ethanol and/or glycerol, and glycols, for example glycols obtainable from an oxide such as ethylene oxide, such as 1,2-propylene glycol. Other non-limiting examples include polyols, such as polyalkylene glycol, e.g., poly(C₂₋₃)alkylene glycol such as polyethylene glycol.

[0135] In some embodiments of the present disclosure, the preconcentrate comprises at least one substance that acts both as a co-surfactant and a solvent, for example an alcohol such as ethanol. In other embodiments, the preconcentrate comprises at least one co-surfactant and at least one solvent that are different substances. For example, in some embodiments the preconcentrate comprises ethanol as the co-surfactant and glycerol as the solvent.

Superdisintegrant

[0136] In some embodiments of the present disclosure, the compositions and/or preconcentrates may comprise at least one superdisintegrant.

Superdisintegrants may, for example, improve disintegrant efficiency resulting in

decreased use levels in comparison to traditional disintegrants. Examples of superdisintegrants include, but are not limited to, crosscarmelose (a crosslinked cellulose), crospovidone (a crosslinked polymer), sodium starch glycolate (a crosslinked starch), and soy polysaccharides. Commercial examples of superdisintegrants include Kollidon® (BASF), Polyplasdone® XL (ISP), and Ac-Di-Sol (FMC BioPolymer).

[0137] The compositions and/or preconcentrates may comprise from about 1% to about 25% of at least one superdisintegrant by weight, such as from about 1% to about 20% by weight, or from about 1% to about 15% by weight of the composition and/or preconcentrate. In some embodiments, the compositions and/or preconcentrates comprising at least one superdisintegrant are in a tablet form.

[0138] In some embodiments, the weight ratio of fatty acid oil mixture:surfactant of the preconcentrate ranges from about 1:1 to about 10:1, from about 1:1 to about 8:1, from 1:1 to about 7:1, from 1:1 to about 6:1, from 1:1 to about 5:1, from 1:1 to about 4:1, from 1:1 to about 3:1, or from 1:1 to about 2:1.

[0139] In some embodiments, the at least one surfactant comprises from about 5% to about 55%, by weight relative to the total weight of the preconcentrate. For example, in some embodiments, the at least one surfactant comprises from about 5% to about 35%, from about 10% to about 35%, from about 15% to about 35%, from about 15% to about 30%, or from about 20% to about 30%, by weight, relative to the total weight of the preconcentrate.

SNEDDS/SMEDDS/SEDDS

[0140] The preconcentrate of the present disclosure may be in a form of a self-nanoemulsifying drug delivery system (SNEDDS), a self-microemulsifying drug delivery system (SMEDDS), or a self emulsifying drug delivery system (SEDDS), wherein the preconcentrate forms an emulsion in an aqueous solution.

[0141] Without being bound by theory, it is believed that the preconcentrate forms a SNEDDS, SMEDDS, and/or SEDDS upon contact with gastric and/or intestinal media in the body, wherein the preconcentrate forms an emulsion comprising micelle particles. The emulsion may, for example, provide for increased or improved stability of the fatty acids for uptake in the body and/or provide increased or improved surface area for absorption. SNEDDS/SMEDDS/SEDDS may thus

provide for enhanced or improved hydrolysis, solubility, bioavailability, absorption, or any combinations thereof of fatty acids *in vivo*.

[0142] Generally, known SNEDDS/SMEDDS/SEDDS formulations comprise ~10 mg of a drug and ~500 mg of surfactants/co-surfactants. The SNEDDS/SMEDDS/SEDDS presently disclosed may have the opposite relationship, i.e., the amount of fatty acid oil mixture comprising the active pharmaceutical ingredient (API) is greater than the amount of surfactant.

[0143] The SNEDDS/SMEDDS/SEDDS presently disclosed may comprise a particle size (i.e., particle diameter) ranging from about 5 nm to about 10 μm . For example, in some embodiments, the particle size ranges from about 5 nm to about 1 μm , such as from about 50 nm to about 750 nm, from about 100 nm to about 500 nm, or from about 150 nm to about 350 nm.

Excipients

[0144] The compositions, preconcentrates, and/or SNEDDS/SMEDDS/SEDDS presently disclosed may further comprise at least one non-active pharmaceutical ingredient, e.g., excipient. Non-active ingredients may solubilize, suspend, thicken, dilute, emulsify, stabilize, preserve, protect, color, flavor, and/or fashion active ingredients into an applicable and efficacious preparation, such that it may be safe, convenient, and/or otherwise acceptable for use. The at least one non-active ingredient may be chosen from colloidal silicon dioxide, crospovidone, lactose monohydrate, lecithin, microcrystalline cellulose, polyvinyl alcohol, povidone, sodium lauryl sulfate, sodium stearyl fumarate, talc, titanium dioxide, and xanthum gum.

[0145] The compositions, preconcentrates, and/or SNEDDS/SMEDDS/SEDDS presently disclosed may further comprise at least one antioxidant. Examples of antioxidants suitable for the present disclosure include, but are not limited to, α -tocopherol (vitamin E), calcium disodium EDTA, alpha tocoferyl acetates, butylhydroxytoluenes (BHT), and butylhydroxyanisoles (BHA).

Forms

[0146] The compositions and/or preconcentrates presently disclosed may be administered, e.g., in capsule, tablet, sachet, or any other form suitable for drug delivery. The dosage form can be of any shape suitable for oral administration, such as spherical, oval, ellipsoidal, cube-shaped, regular, and/or irregular shaped. The

dosage forms can be prepared according to processes known in the art and can include one or more additional pharmaceutically-acceptable excipients as discussed above.

[0147] In some embodiments of the present disclosure, the compositions and/or preconcentrates are in a capsule or a tablet form. The capsule wall-forming material may comprise, for example, gelatin or polysaccharides other than alginate. In at least one embodiment, the capsule is a gelatin capsule. The capsules may be hard capsules or soft capsules.

[0148] When the dosage form is in the form of tablets, the tablets may be, for example, disintegrating tablets, fast dissolving tablets, effervescent tablets, fast melt tablets, and/or mini-tablets. Tablet formulations are described, for example, in patent publication WO 2006/000229. In some embodiments of the present disclosure, the tablets comprise Neusilin (e.g., magnesium aluminometasilicate).

[0149] The capsules and/or tablets of the present disclosure may comprise at least one coating. Such coatings can delay the release of the capsule or tablet (e.g., release of EPA and/or DHA) for a predetermined period. For example, the at least one coating may allow the dosage form to pass through the stomach without being subjected to stomach acid or digestive juices to provide for delayed release of EPA and/or DHA outside of the stomach. In some embodiments, the capsules and/or tablets release less than 30% of the total EPA and/or DHA in the stomach, such as less than 25%, less than 20%, less than 15%, or less than 10%.

[0150] In some embodiments, the at least one coating is chosen from enteric coatings, sub-layers, top-layers, and combinations thereof. The term "sub-layer" as used herein means a coating layer located between the capsule wall material (e.g., gelatin wall) or the tablet surface and an enteric coating. The term "top-layer" as used herein means a coating layer over an enteric coating covering the capsule wall material or the tablet surface. The chemical composition of sub-layers and top-layers may vary depending upon the overall composition of the capsule or tablet. Typical materials for the sub-layers and top-layers presently disclosed include film-forming agents such as polysaccharides, for example hydroxypropyl methyl cellulose.

[0151] In embodiments of the present disclosure, the capsules and/or tablets comprise at least one enteric coating. In some embodiments, the capsules and/or tablets comprise at least one enteric coating and at least one top-layer over the at

least one enteric coating. In other embodiments, the capsules and/or tablets comprise at least one enteric coating and at least one sub-layer between the capsule wall or the tablet surface and the at least one enteric coating. In still other embodiments, the capsules and/or tablets comprise at least one enteric coating, at least one sub-layer between the capsule wall or the tablet surface, and at least one top-layer over the at least one enteric coating. In some embodiments, at least one of the sub-layer(s) and/or top-layer(s) comprises hydroxypropyl methyl cellulose.

[0152] In some embodiments, the at least one sub-layer comprises a sealant. Suitable sealants may comprise, for example, permeable or soluble agents such as hydroxypropyl methyl cellulose, hydroxypropyl cellulose, hydroxypropyl ethylcellulose, and xanthan gum. Other agents can be added to improve the processability of the sealant or barrier layer. Such agents include talc, colloidal silica, polyvinyl alcohol, titanium dioxide, micronized silica, fumed silica, glycerol monostearate, magnesium trisilicate and magnesium stearate, or a mixture thereof. The sealant or barrier layer can be applied from solution (e.g., aqueous) or suspension using any known means, such as a fluidized bed coater (e.g., Wurster coating) or pan coating system. Suitable sealants or barriers include, for example, Opadry® products such as Opadry® II available from Colorcon.

[0153] In some embodiments, the at least one coating is pH-independent. Coatings with pH-independent profiles generally erode or dissolve away after a predetermined period, and the period is generally directly proportional to the thickness of the coating. In other embodiments, the at least one coating is pH-dependent. Coatings with pH-dependent profiles can generally maintain their integrity while in the acid pH of the stomach, but erode or dissolve upon entering the more basic upper intestine. In some embodiments, the at least one coating is insoluble at a pH below about 5 and soluble at a pH above about 6.

[0154] Examples of coating materials suitable for the present disclosure include, but are not limited to, gelatin, film-forming agents, polymers, and copolymers. Examples of polymers and copolymers include, but are not limited to, acrylate-based polymers and copolymers (e.g., methacrylic acid, copolymers between methacrylic acid and methyl methacrylate, copolymers between methacrylic acid and methyl acrylate, copolymers between metacrylic acid and ethyl methacrylate, and copolymers between metacrylic acid and ethyl acrylate) and

polysaccharide and/or cellulose-based polymers and copolymers (e.g., cellulose acetate phthalate, hydroxypropyl methyl cellulose phthalate, and hydroxypropyl methyl cellulose acetate succinate). Others polymers include, for example, polyvinyl acetate phthalate. Additional materials suitable for the at least one coating include pharmaceutically acceptable acidic compounds that may not dissolve at the low pH in the stomach, but may dissolve at higher pH in the lower part of the gastrointestinal system.

[0155] Commerically-available examples of polymers suitable for the present disclosure include EUDRAGIT® products from Evonik. EUDRAGIT® polymers are polymeric lacquer substances based on acrylates and/or methacrylates, and may be pH-independent or pH-dependent.

[0156] For example, EUDRAGIT® RL and EUDRAGIT® RS are acrylic resins comprising copolymers of acrylic and methacrylic acid esters with a low content of quaternary ammonium groups. The ammonium groups are present as salts and give rise to permeability of the lacquer films. EUDRAGIT® RL and EUDRAGIT® RS are freely permeable (RL) and slightly permeable (RS), respectively, independent of pH. The polymers swell in water and digestive juices, in a pH-independent manner. In the swollen state, they are permeable to water and to dissolved active compounds. Specific examples include EUDRAGIT® RL 30D, EUDRAGIT® RL PO, EUDRAGIT® RL 100, EUDRAGIT® RL 12,5, EUDRAGIT® RS 30D, EUDRAGIT® RS PO, EUDRAGIT® RS 100, and EUDRAGIT® RS 12,5. Additional examples of pH-independent polymers include EUDRAGIT® E 100, EUDRAGIT® E 12,5, and EUDRAGIT® E PO. In at least one embodiment of the present disclosure, the at least one coating comprises EUDRAGIT® RS 30D.

[0157] Further, for example, EUDRAGIT® L and EUDRAGIT® S are anionic polymers synthesized from methacrylic acid and methacrylic acid methyl ester. They are insoluble in acids and pure water, and become soluble in neutral to weakly alkaline conditions. The permeability of EUDRAGIT® L and EUDRAGIT S is pH dependent. Above pH 5.0, the polymers become increasingly permeable. Specific examples include EUDRAGIT® L100-55, EUDRAGIT® L30D-55, EUDRAGIT® L100, EUDRAGIT® L100 12,5, EUDRAGIT® S100, EUDRAGIT® S12,5, and EUDRAGIT® FS 30D. Additional examples of pH-dependent polymers include EUDRAGIT® E100,

EUDRAGIT® E 12,5, and EUDRAGIT® PO. In at least one embodiment of the present disclosure, the at least one coating comprises EUDRAGIT® L100-55.

[0158] The at least one coating may comprise at least one plasticizer.

Plasticizers may, for example to improve the mechanical properties of pH-sensitive materials of the at least one coating. Suitable plasticizers include, but are not limited to, triethyl citrate, triacetin, polyethylene glycols, propylene glycol, phthalates, sorbitol and glycerin. The amount of plasticizer may vary depending upon the chemical composition of the at least one coating and the chemical composition and size of the capsule or tablet. In some embodiments, for example, the amount of plasticizer ranges from about 10% to about 60% by weight of the at least one coating.

[0159] The amount of coating material or thickness of the at least one coating may vary depending upon the chemical compositions and number of different coating layers, and chemical composition, size, and shape of the capsule or the tablet.

Generally speaking, the coating should be sufficient thick to prevent substantial release of EPA and/or DHA in the stomach, but also not contribute significantly to the capsule or tablet size. In some embodiments of the present disclosure, the thickness of the at least one coating ranges from about 10 microns to about 2 mm, such as from about 20 microns to about 1 mm. In some embodiments, the at least one coating comprises from about 1% to about 50% of the dry capsule wall-forming material (e.g., gelatin).

[0160] The capsules according to the present disclosure may be manufactured in low oxygen conditions to inhibit oxidation during the manufacturing process. The capsules may be prepared, for example, by direct encapsulation using standard methods known in the art. Examples of such methods include, but are not limited to, simple coacervation methods (see, e.g., ES 2009346, EP 0052510, and EP 0346879), complex coacervation methods (see, e.g., GB 1393805), double emulsion methods (see, e.g., U.S. 4,652,441), simple emulsion methods (see, e.g., U.S. 5,445,832), and solvent evaporation methods (see, e.g., GB 2209937). Those methods may, for example, provide for continuous processing and flexibility of batch size. The present disclosure further provides for coating pre-prepared capsules (e.g., gelatin capsules comprising a fatty acid oil mixture). The coating of pre-prepared capsules may be performed, for example, by spraying such as using spray drying

techniques or spraying into a coating pan comprising preformed capsules, or by dipping capsules into coating solutions.

[0161] In some embodiments of the present disclosure, the capsule fill content ranges from about 0.400 g to about 1.600 g. For example, in some embodiments, the capsule fill content ranges from about 0.400 g to about 1.300 g, from about 0.600 g to about 1.200 g, from about 0.600 g to about 0.800 g, from about 0.800 g to about 1.000, from about 1.000 g to about 1.200 g, or any amount in between. For example, in some embodiments the capsule fill content is about 0.600 g, about 0.800 g, about 1.000 g, or about 1.200 g.

[0162] In some embodiments of the present disclosure, the compositions and/or preconcentrates comprise from about 300 mg to about 400 mg of DHA, such as about 375 mg. In some embodiment, the compositions and/or preconcentrates comprise from about 400 mg to about 500 mg of EPA, such as about 465 mg. In one embodiment, for example, the compositions and/or preconcentrates comprise about 375 mg of DHA and about 465 mg of EPA.

Methods or Uses

[0163] The present disclosure further encompasses methods of treating and/or regulating at least one health problem in a subject in need thereof. The compositions and preconcentrates presently disclosed may be administered, e.g., in capsule, tablet or any other suitable form for drug delivery, to a subject for therapeutic treatment and/or regulation of at least one health problem including, for example, irregular plasma lipid levels, cardiovascular functions, immune functions, visual functions, insulin action, neuronal development, heart failure, and post myocardial infarction. In some embodiments, the at least one health problem is chosen from mixed dyslipidemia, dyslipidemia, hypertriglyceridemia, hypercholesterolemia, heart failure, and post-myocardial infarction.

[0164] In one embodiment, the present disclosure provides for a method of treating at least one health problem in a subject in need thereof, comprising administering to the subject a pharmaceutical composition in a gelatin capsule or a tablet form comprising a pharmaceutically-effective amount of a fatty acid oil mixture comprising at least 75% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in a form chosen from ethyl ester and triglyceride; and at least one free fatty acid; wherein the

gelatin or the tablet comprises at least one coating. In some embodiments, the method treats at least one of elevated triglyceride levels, non-HDL cholesterol levels, LDL cholesterol levels and/or VLDL cholesterol levels. For example, the method may reduce triglyceride levels from about 30% to about 80%, such as from about 40% to about 70%, from about 40% to about 60%, or from about 30% to about 50%, in a subject with elevated triglyceride levels.

[0165] In another embodiment, the present disclosure provides for a method of regulating at least one health problem in a subject in need thereof, comprising administering to the subject administering to the subject a supplement composition in a gelatin capsule or a tablet form comprising: a fatty acid oil mixture comprising from about 25% to about 75% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in a form chosen from ethyl ester and triglyceride; and at least one free fatty acid; wherein the gelatin capsule or the tablet comprises at least one coating, and wherein the at least one health problem is chosen from irregular plasma lipid levels, cardiovascular functions, immune functions, visual functions, insulin action, neuronal development, heart failure, and post myocardial infarction.

[0166] The present disclosure further provides for a method for enhancing at least one parameter chosen from hydrolysis, solubility, bioavailability, absorption, and combinations thereof of EPA and/or DHA. The bioavailability may be increased, for example, by at least 40%, such as by about 80% or by at least 85%.

[0167] In one embodiment, the method for enhancing at least one parameter chosen from hydrolysis, solubility, bioavailability, absorption, and combinations thereof of EPA and/or DHA comprises: combining a fatty acid oil mixture comprising EPA and DHA in a form chosen from ethyl ester and triglyceride; and at least one free fatty acid in a gelatin capsule or a tablet form, wherein the gelatin capsule or the tablet comprises at least one coating.

[0168] In another embodiment, the method for enhancing at least one parameter chosen from hydrolysis, solubility, bioavailability, absorption, and combinations thereof of EPA and/or DHA comprises: combining a fatty acid oil mixture comprising EPA and DHA in a form chosen from ethyl ester and triglyceride; at least one free fatty acid; and at least one surfactant in a gelatin capsule or a tablet form, wherein the gelatin capsule or the tablet comprises at least one coating.

[0169] In another embodiment, the method for enhancing at least one parameter chosen from hydrolysis, solubility, bioavailability, absorption, and combinations thereof of EPA and/or DHA comprises: combining a fatty acid oil mixture comprising EPA and DHA in free acid form and at least one free fatty acid in a gelatin capsule or a tablet form, wherein the gelatin capsule or the tablet comprises at least one coating.

[0170] In yet another embodiment, the method for enhancing at least one parameter chosen from hydrolysis, solubility, bioavailability, absorption, and combinations thereof of EPA and/or DHA comprises: combining a fatty acid oil mixture comprising EPA and DHA in a form chosen from ethyl ester and triglyceride and at least one surfactant in a gelatin capsule or a tablet form, wherein the gelatin capsule or the tablet comprises at least one coating.

[0171] The preconcentrates presently disclosed can form a self-nanoemulsifying drug delivery system (SNEDDS), self-microemulsifying drug delivery system (SMEDDS), or self-emulsifying drug delivery system (SEDDS) in an aqueous solution in the methods presently disclosed.

[0172] In some embodiments of the present disclosure, the pharmaceutical or supplement compositions, or pharmaceutical or supplement preconcentrates may be administered to a subject in need thereof to treat and/or regulate at least one health problem.

[0173] In some embodiments, the preconcentrates of the present disclosure form a self-nanoemulsifying drug delivery system (SNEDDS), a self-microemulsifying drug delivery system (SMEDDS), or a self-emulsifying drug delivery system (SEDDS) in an aqueous solution. In some embodiments, the aqueous solution is gastric media and/or intestinal media.

[0174] The total daily dosage of the fatty acid oil mixture may range from about 0.600 g to about 6.000 g. For example, in some embodiments, the total dosage of the fatty acid oil mixture ranges from about 0.800 g to about 4.000 g, from about 1.000 g to about 4.000 g, from about 0.5000 g to about 4.000 g, from about 0.250 g to about 2.000 g, from about 0.400 g to about 2.000 g, or from about 1.000 g to about 2.000 g. In one embodiment, the fatty acid oil mixture is chosen from K85EE and AGP 103 fatty acid oil compositions. In another embodiment, the fatty acid oil mixture comprises K85FA.

[0175] The administration may be oral or any other form of administration that provides a dosage of fatty acids, e.g., omega-3 fatty acids, to a subject, such as a human. For example, the compositions and preconcentrates presently disclosed may be administered as capsules and/or tablets in from 1 to 10 dosages, such as from 1 to 4 times a day, such as once, twice, three times, or four times per day, and further for example, once, twice or three times per day.

Formulations

[0176] In some embodiments of the present disclosure, the preconcentrate is a pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprising a fatty acid oil mixture comprising at least 75% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in a form chosen from ethyl ester and triglyceride; at least one free fatty acid; and at least one surfactant, wherein the gelatin capsule or the tablet comprises at least one coating.

[0177] In one embodiment, the pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprises: a fatty acid oil mixture comprising at least 95% of EPA ethyl ester, DHA ethyl ester, or mixtures thereof, by weight of the fatty acid oil mixture; at least one free fatty acid chosen from linoleic, α -linolenic acid (ALA), γ -linoleic acid (GLA), and oleic acid; and at least one surfactant chosen from polysorbate 20, polysorbate 80, and mixtures thereof, wherein the gelatin capsule or the tablet comprises at least one coating.

[0178] In another embodiment, the pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprises: a fatty acid oil mixture comprising from about 80% to about 88% EPA and DHA by weight of the fatty acid oil mixture, wherein the EPA and DHA are in ethyl ester form; at least one free fatty acid comprising oleic acid; and at least one surfactant chosen from polysorbate 20, polysorbate 80, and mixtures thereof; wherein the at least one surfactant comprises less than 40%, by weight relative to the weight of the preconcentrate, and wherein the gelatin capsule or the tablet comprises at least one coating.

[0179] In another embodiment, the pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprises: a fatty acid oil mixture comprising from about 80% to about 88% EPA and DHA by weight of the fatty acid oil mixture, wherein the EPA and DHA are in ethyl ester form; at least one free fatty acid

comprising linoleic acid; and at least one surfactant chosen from polysorbate 20, polysorbate 80, and mixtures thereof; wherein the at least one surfactant comprises less than 35%, by weight relative the weight of the preconcentrate, and wherein the gelatin capsule or the tablet comprises at least one coating.

[0180] In another embodiment, the pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprises: a fatty acid oil mixture comprising from about 80% to about 88% EPA and DHA by weight of the fatty acid oil mixture, wherein the EPA and DHA are in ethyl ester form; at least one free fatty acid comprising from about 80% to about 88% EPA and DHA, by weight of the at least one free fatty acid, wherein the EPA and DHA are in free acid form; and at least one surfactant chosen from polysorbate 20, polysorbate 80, and mixtures thereof, wherein the gelatin capsule or the tablet comprises at least one coating. For example, the pharmaceutical preconcentrate may comprise K85EE as the fatty acid oil mixture, K85FA as the at least one free fatty acid, and at least one surfactant chosen from polysorbate 20, polysorbate 80, and mixtures thereof.

[0181] In another embodiment, the pharmaceutical preconcentrate may comprise K85EE as the fatty acid oil mixture, K85FA as the at least one free fatty acid, and at least one surfactant chosen from polysorbate 20 or polysorbate 80, wherein the [K85EE]:[Tween]:[K85FA] ranges from e.g. about 5:2:0.5 to 5:4:2. In a further embodiment, the ration between [K85EE]:[Tween]:[K85FA] is about [4-5]:[3-4]:[1-1.5].

[0182] In another embodiment, minimum of about 5-10% up to maximum of about 50% of fatty acid oil mixture comprising from about 80% to about 88% EPA and DHA by weight of the fatty acid oil mixture, wherein the EPA and DHA are in ethyl ester form, is substituted by a free fatty acid chosen from a K85-FA composition (corresponding to a K85-FA fatty acid profile achieved by hydrolyzing a K85-EE fatty acid ethyl ester composition) EPA, DPA, DHA, and combinations thereof. For example, the EPA-EE and DHA-EE content from 400 mg/g to 840 mg/g of total fatty acid oil mixture is replaced by 40 to 440 mg/g Free fatty acid chosen from a K85-FA composition.

[0183] In other embodiments, the preconcentrate in a gelatin capsule or a tablet form is a food supplement or nutritional supplement preconcentrate comprising a fatty acid oil mixture comprising from about 25% to about 75% eicosapentaenoic

acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in a form chosen from ethyl ester and triglyceride; at least one free fatty acid; and at least one surfactant, wherein the gelatin capsule or the tablet comprises at least one coating.

[0184] In some embodiments of the present disclosure, the preconcentrate is a pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprising a fatty acid oil mixture comprising at least 75% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in free fatty acid form; and at least one surfactant, wherein the gelatin capsule or the tablet comprises at least one coating.

[0185] In one embodiment, for example, the pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprises: a fatty acid oil mixture comprising from about 80% to about 88% EPA and DHA by weight of the fatty acid oil mixture, wherein the EPA and DHA are in free acid form; and at least one surfactant chosen from polysorbate 20, polysorbate 80, and mixtures thereof, wherein the gelatin capsule or the tablet comprises at least one coating.

[0186] In one embodiment, the pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprises: a fatty acid oil mixture comprising from about 80% to about 88% EPA and DHA by weight of the fatty acid oil mixture, wherein the EPA and DHA are in free acid form; and at least one surfactant chosen from polysorbate 20, polysorbate 80, and mixtures thereof; wherein the at least one surfactant comprises less than 40%, by weight relative to the weight of the preconcentrate, and wherein the gelatin capsule or the tablet comprises at least one coating.

[0187] In another embodiment, for example, the pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprises: a fatty acid oil mixture comprising from about 80% to about 88% EPA and DHA by weight of the fatty acid oil mixture, wherein the EPA and DHA are in free acid form, and oleic acid; and at least one surfactant chosen from polysorbate 20, polysorbate 80, and mixtures thereof; wherein the at least one surfactant comprises less than 40%, by weight relative to the weight of the preconcentrate, and , wherein the gelatin capsule or the tablet comprises at least one coating.

[0188] In another embodiment, the pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprises: a fatty acid oil mixture comprising from about 80% to about 88% EPA and DHA by weight of the fatty acid oil mixture, wherein the EPA and DHA are in free acid form, and α -linoleic acid; and at least one surfactant chosen from polysorbate 20, polysorbate 80, and mixtures thereof; wherein the at least one surfactant comprises less than 35%, by weight relative the weight of the preconcentrate, and , wherein the gelatin capsule or the tablet comprises at least one coating.

[0189] In another embodiment, the pharmaceutical pre-concentrate in a gelatin capsule or a tablet form comprises a K85FA fatty acid oil mixture and at least one surfactant chosen from polysorbate 20 and polysorbate 80, wherein the gelatin capsule or the tablet comprises at least one coating.

[0190] In other embodiments, the preconcentrate is a food supplement preconcentrate or nutritional supplement preconcentrate in a gelatin capsule or a tablet form comprising a fatty acid oil mixture comprising from about 25% to about 75% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in free acid form; and at least one surfactant, wherein the gelatin capsule or the tablet comprises at least one coating.

[0191] In some embodiments of the present disclosure, the preconcentrate is a pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprising a fatty acid oil mixture comprising at least 75% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in a form chosen from ethyl ester and triglyceride; and at least one surfactant, wherein the gelatin capsule or the tablet comprises at least one coating.

[0192] In one embodiment, the pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprises: a fatty acid oil mixture comprising at least 95% of EPA ethyl ester, DHA ethyl ester, or mixtures thereof, by weight of the fatty acid oil mixture; and a least one surfactant chosen from polysorbate 20, polysorbate 80, and mixtures thereof, wherein the gelatin capsule or the tablet comprises at least one coating.

[0193] In another embodiment, the pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprises: a fatty acid oil mixture comprising from

about 80% to about 88% EPA and DHA by weight of the fatty acid oil mixture, wherein the EPA and DHA are in ethyl ester form; and at least one surfactant chosen from polysorbate 20, polysorbate 80, and mixtures thereof; wherein the at least one surfactant comprises less than 40%, by weight relative to the weight of the preconcentrate, wherein the gelatin capsule or the tablet comprises at least one coating.

[0194] In another embodiment, the pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprises: a fatty acid oil mixture comprising from about 80% to about 88% EPA and DHA by weight of the fatty acid oil mixture, wherein the EPA and DHA are in ethyl ester form; and at least one surfactant chosen from polysorbate 20, polysorbate 80, and mixtures thereof; wherein the at least one surfactant comprises less than 35%, by weight relative the weight of the preconcentrate, wherein the gelatin capsule or the tablet comprises at least one coating.

[0195] In some embodiments, for example, the pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprises K85EE as the fatty acid oil mixture, and at least one surfactant chosen from polysorbate 20, polysorbate 80, and mixtures thereof, wherein the gelatin capsule or the tablet comprises at least one coating.

[0196] In another embodiment, the pharmaceutical preconcentrate in a gelatin capsule or a tablet form comprises a fatty acid oil mixture comprising from about 80% to about 88% EPA and DHA, by weight of the fatty acid oil mixture, wherein the EPA and DHA are in ethyl ester form; at least one surfactant chosen from polysorbate 80; and at least one co-surfactant comprising ethanol, and wherein the gelatin capsule or the tablet comprises at least one coating.

[0197] In other embodiments, the preconcentrate is a food supplement preconcentrate or nutritional supplement preconcentrate in a gelatin capsule or a tablet form comprising a fatty acid oil mixture comprising from about 25% to about 75% EPA and DHA, by weight of the fatty acid oil mixture, wherein the EPA and DHA are in a form chosen from ethyl ester and triglyceride; and at least one surfactant, and , wherein the gelatin capsule or the tablet comprises at least one coating.

[0198] The following examples are intended to illustrate the present disclosure without, however, being limiting in nature. It is understood that the skilled

artisan will envision additional embodiments consistent with the disclosure provided herein.

EXAMPLES

[0199] **Example 1: Preconcentrates**

[0200] Different preconcentrates were prepared as described in Table 9. To prepare the preconcentrates, the components were mixed according to the schemes identified below on a weight to weight basis. The preconcentrates were visually inspected after mixing and again after being stored for 24 hours at room temperature. Under the Preconcentrate heading, a "clear" designation represents a transparent homogenous mixture; an "unclear" designation represents a nonhomogenous mixture, where some turbidity can be observed by visual inspection. The degree of turbidity was not determined.

[0201] All clear preconcentrates were emulsified in gastric media, by adding gastric media (2 ml) to approximately 100 mg of the preconcentrate. The composition of the gastric media is shown in Table 8.

Table 8: Composition of Gastric Media.

Gastric Media	
Bile salts, Porcine (mM)	0.08
Lechitin(mM)	0.02
Sodium chloride (mM)	34.2
Pepsin (mg/ml)	0.1
pH	1.6 (adjust with 1 M HCl)
Osmolarity(mOsm/kg)	120

[0202] The outcome of the emulsification was recorded approximately 3 hours after mixing. A majority of the preconcentrates formed milky emulsions immediately after mixing. Emulsions that stayed milky and homogenous after 3 hours are described as "milky," under the Emulsion heading. Emulsions that

separated or became nonhomogenous or where oil drops were observed are described as "separates," under the Emulsion heading.

[0203] Selected emulsions were further characterized by determining the particle size. Particle size was measured using a Malvern Zetasizer (Malvern Instrument, Worcestershire, UK) with particle size measuring range of 0.5 - 6000 nm and Zeta potential of particle range of 3 nm - 10 μ m. The particle size was measured in triplicate. The K85EE (EE = ethyl ester) fatty acid composition used herein is sold in a gelatin capsule and branded primarily under the trademarks LovazaTM or Omacor[®].

Table 9: Preconcentrates.

No	K85-EE (mg)	Tween-20 (mg)	Oleic Acid (mg)	Total vol. (mg)	Ratio	Pre-conc.	Emulsion	Particle Size (nm)
1	451.4	234.3	99	784.7	57:29:12	Unclear	-	-
2	448.8	299.7	53.8	802.3	55:37:6	Unclear	-	-
3	451.2	324.7	24.7	800.6	56:40:3	Unclear	-	-
10	400	300	100	800	50:37:12	Clear	Milky	271
11	404	298	97	799	50:37:12	Clear	Milky	-
12	500	300	217	1017	49:29:21	Clear	Separates	-
13	398	300	99	797	49:37:12	Clear	Milky	257
14	399	252	98	749	53:33:13	Clear	Separates	226
15	400	204	102	706	56:28:14	Clear	Separates	199
21	450	198	133	781	57:25:17	Clear	Separates	-
23	549	204	169	922	59:22:18	Clear	Separates	-
24	600	200	178	978	61:20:18	Clear	Separates	-
26	453	214	121	788	57:27:15	Clear	Separates	-
27	456	220	121	797	57:27:15	Clear	Separates	-
28	452	228	144	824	54:27:17	Clear	Separates	-
29	448	230	122	800	56:28:15	Clear	Separates	-
30	452	242	124	818	55:29:15	Clear	Separates	-

31	449	251	124	824	54:30:15	Clear	Milky	-
32	448	260	123	831	53:31:14	Clear	Separates	-
33	452	270	121	843	53:32:14	Clear	Separates	-
34	449	281	123	853	52:32:14	Clear	Separates	-
35	448	290	121	859	52:33:14	Clear	Separates	-

No .	K85-EE (mg)	Tween-20 (mg)	Ricinoleic Acid (mg)	Total Vol. (mg)	Ratio	Pre-conc.	Emulsion	Particle Size (nm)
36	402	298	98	798	50:37:12	Clear	Milky	277
37	402	250	100	752	53:33:13	Clear	Milky	268
38	400	200	100	700	57:28:14	Unclear	-	-
39	450	250	100	800	56:31:12	Clear	Milky	-
43	400	110	100	610	65:18:16	Clear	Separates	-
44	500	270	105	875	57:30:12	Clear	Separates	-
45	505	295	103	903	55:32:11	Clear	Milky	-
46	525	250	143	918	57:27:15	Clear	Separates	-
47	500	252	118	870	57:28:13	Clear	Separates	-
48	297	293	145	735	40:39:19	Clear	Separates	-
49	500	260	127	887	56:29:14	Clear	Separates	-
50	499	285	106	890	56:32:11	Clear	Separates	-
51	403	298	193	894	45:33:21	Clear	Milky	-
52	460	250	90	800	57:31:11	Clear	-	-

No .	K85-EE (mg)	Tween-40 (mg)	Ricinoleic acid (mg)	Total Vol. (mg)	Ratio	Pre-conc.	Emulsion	Particle Size (nm)
53	450	255	98	803	56:31:12	Clear	Milky	237
55	498	220	98	816	61:26:12	Clear	Milky	226
56	505	202	106	813	62:24:13	Clear	Separates	-
57	500	200	100	800	62:25:12	Clear	Separates	-
58	552	152	102	806	68:18:12	Clear	Separates	-

No	K85-EE (mg)	Tween-60 (mg)	Ricinoleic Acid (mg)	Total Vol. (mg)	Ratio	Pre-conc.	Emulsion	Particle Size (nm)
70	500	200	100	800	62:25:12	Clear	Milky	-
71	500	150	100	750	66:20:13	Clear	Separates	-
72	529	180	104	813	65:22:12	Clear	Separates	-
73	518	200	102	820	63:24:12	Clear	Separates	-
No	K85-EE (mg)	Tween-80 (mg)	Ricinoleic Acid (mg)	Total Vol. (mg)	Ratio	Pre-conc.	Emulsion	Particle Size (nm)
54	450	270	105	825	54:32:12	Clear	Separates	-
No	K85-EE (mg)	Cremophor EL (mg)	Ricinoleic Acid (mg)	Total Vol. (mg)	Ratio	Pre-conc.	Emulsion	Particle Size (nm)
40	399.9	300	106.4	806.3	49:37:13	Unclear	-	-
41	400	256.9	137	793.9	50:32:17	Unclear	-	-
No	K85-EE (mg)	Sorbitol (mg)	Ricinoleic Acid (mg)	Total Vol. (mg)	Ratio	Pre-conc.	Emulsion	Particle Size (nm)
42	400	211	104	715	55:29:14	Clear/solid when cooled	-	-

No	K85-EE (mg)	PEG-400 (mg)	Ricinoleic Acid (mg)	Total Vol. (mg)	Ratio	Pre-conc.	Emulsion	Particle Size (nm)
16	399.9	310.2	162.6	872.7	45:35:18	Clear	Separates	-
17	398.3	256.8	157.9	813	48:31:19	Clear	Separates	-
18	402.4	198.7	147.5	748.6	53:26:19	Clear	Separates	-
No	K85-EE (mg)	Tween-20 (mg)	PEG-400 (mg)	Total Vol. (mg)	Ratio	Pre-conc.	Emulsion	Particle Size (nm)
19	398.2	297.9	214.7	910.8	43:32:23	Unclear	-	-
20	403	248.2	145.3	796.5	50:31:18	Unclear	-	-
No	K85-EE (mg)	Tween-20 (mg)	α -Linoleic Acid (mg)	Total Vol. (mg)	Ratio	Pre-conc.	Emulsion	Particle Size (nm)
74	402	300	100	802	50:37:12	Clear	Milky	-
75	454	249	98	801	56:31:12	Slightly dense	Separates	-
76	502	204	103	809	62:25:12	Slightly dense	Separates	-
No	K85-EE (mg)	Tween-40 (mg)	α -Linoleic Acid (mg)	Total Vol. (mg)	Ratio	Pre-conc.	Emulsion	Particle Size (nm)

WO 2011/048493

PCT/IB2010/002854

77	403	299	108	810	49:36:13	Clear / Precipitate	Separates	-
78	456	252	110	818	55:30:13	Clear / Precipitate	Separates	-
79	503	217	103	823	61:26:12	Clear / Precipitate	Separates	-
<hr/>								
No	K85-EE (mg)	Tween-60 (mg)	α -Linoleic Acid (mg)	Total Vol. (mg)	Ratio	Pre-conc.	Emulsion	Particle Size (nm)
80	402	313	104	819	49:38:12	Clear	Separates	-
81	459	205	100	764	60:26:13	Clear	Separates	-
82	498	198	106	802	62:24:13	Clear	Separates	-
<hr/>								
No	K85-EE (mg)	Tween-80 (mg)	α -Linoleic Acid (mg)	Total Vol. (mg)	Ratio	Pre-conc.	Emulsion	Particle Size (nm)
83	407	317	102	826	49:38:12	Clear	Milky	261.3
84	455	256	110	821	55:31:13	Clear	Milky	260.8
85	498	208	102	808	61:25:12	Clear	Milky	274.5
<hr/>								
No	K85-EE (mg)	Tween-20 (mg)	Erucic Acid (mg)	Total Vol. (mg)	Ratio	Pre-conc.	Emulsion	Particle Size (nm)

86	401	300	99	800	50:37:12	Clear	Semi Milky	-
87	451	250	105	806	55:31:13	Clear	Separates	-
88	504	204	102	810	62:25:12	Clear	Separates	-

No	K85- EE (mg)	Tween- 40 (mg)	Erucuc Acid (mg)	Total Vol. (mg)	Ratio	Pre- conc.	Emulsion	Particle Size (nm)
89	401	298	102	801	50:37:12	Clear	Separates	-
90	451	254	99	804	56:31:12	Clear	Separates	-
91	504	219	103	826	61:26:12	Clear	Separates	-

No	K85- EE (mg)	Tween- 60 (mg)	Erucuc Acid (mg)	Total Vol. (mg)	Ratio	Pre- conc.	Emulsion	Particle Size (nm)
92	401	301	104	806	49:37:12	Clear	Separates	-
93	454	267	101	822	55:32:12	Clear	Separates	-
94	497	202	100	799	62:25:12	Clear	Separates	-

No	K85- EE (mg)	Tween- 60 (mg)	Erucuc Acid (mg)	Total Vol. (mg)	Ratio	Pre- conc.	Emulsion	Particle Size (nm)
95	406	298	100	804	50:37:12	Clear	Separates	-
96	450	251	102	803	56:31:12	Clear	Separates	-
97	502	205	122	829	60:24:14	Clear	Separates	-

No	K85- EE (mg)	Tween- 20 (mg)	α - Linolenic acid (mg)	Total Vol. (mg)	Ratio	Pre- conc.	Emulsion	Particle Size (nm)

98	401	308	105	814	49:37:12	Clear	Milky, beginning separation	-
10 2	450	264	108	822	54:32:13	Clear	Milky, beginning separation	-
10 6	501	200	111	812	61:24:13	Clear	Milky, with separation	-
No	K85- EE (mg)	Tween- 40 (mg)	α - Linolenic Acid (mg)	Total Vol. (mg)	Ratio	Pre- conc.	Emulsion	Particle Size (nm)
99	402	302	102	806	49:37:12	Clear	Milky, beginning separation	-
10 3	452	254	101	807	56:31:12	Clear	Milky, with separation	-
10 7	502	206	108	816	61:25:13	Clear	Milky, with separation	-
No	K85- EE (mg)	Tween- 60 (mg)	α - Linolenic Acid (mg)	Total Vol. (mg)	Ratio	Pre- conc.	Emulsion	Particle Size (nm)
10 0	403	303	103	809	49:37:12	Clear	Milky, beginning separation	-
10 4	450	249	102	801	56:31:12	Clear	Milky, with separation	-
10 8	506	200	100	806	62:24:12	Uncle ar	Milky, beginning separation	-

No	K85-EE (mg)	Tween-80 (mg)	α -Linolenic Acid (mg)	Total Vol. (mg)	Ratio	Pre-conc.	Emulsion	Particle Size (nm)
101	403	308	106	817	49:37:12	Clear	Milky, beginning separation	-
105	452	253	102	807	56:31:12	Clear	Milky, with separation	-
109	507	203	112	822	61:24:13	Clear	Milky, with separation	-
No	K85-EE (mg)	Tween-20 (mg)	KE85-FA (mg)	Total Vol. (mg)	Ratio	Pre-conc.	Emulsion	Particle Size (nm)
110	398.5	300.5	98.6	797.6	49:37:12	Clear	Milky (<10min waiting time)	
111	448	245.9	110.4	804.3	55:30:13	Unclear	-	-
112	498.3	197.9	106.2	802.4	62:24:13	Unclear	-	-
No	K85-EE (mg)	Tween-40 (mg)	KE85-FA (mg)	Total Vol. (mg)	Ratio	Pre-conc.	Emulsion	Particle Size (nm)
113	405.7	303.7	105.8	815.2	49:37:12	Clear	Milky (<10min waiting time)	-

11 4	452.8	261.6	101.8	816.2	55:32:12	Clear	Milky (<10min waiting time)	-
11 5	499	212.2	114.7	825.9	60:25:13	Clear	Milky (<10min waiting time)	-
No .	K85- EE (mg)	Tween- 60 (mg)	KE85-FA (mg)	Total Vol. (mg)	Ratio	Pre- conc.	Emulsion	Particle Size (nm)
11 6	395	296.2	100	791.2	49:37:12	Clear	Milky (<10min waiting time)	-
11 7	450.3	253.1	98.2	801.6	56:31:12	Clear	Milky (<10min waiting time)	-
11 8	500.8	206	105.7	812.5	61:25:13	Clear	Milky (<10min waiting time)	-
No .	K85- EE (mg)	Tween- 80 (mg)	KE85-FA (mg)	Total Vol. (mg)	Ratio	Pre- conc.	Emulsion	Particle Size (nm)
11 9	402	308.3	100.8	811.1	49:38:12	Clear	Milky, sticky (<10min waiting time)	-

12 0	456.6	260.3	103.5	820.4	55:31:12	Clear	Milky, sticky (<10min waiting time)	-
12 1	502.3	202.2	104	808.5	62:25:12	Clear	Milky, sticky (<10min waiting time)	-

[0204] Of the preconcentrates prepared, formulation number 85 facilitated a load of 60% K85EE into the preconcentrate and gave a stable emulsion in gastric media with a particle size determined to be about 275 nm. Attempts to prepare preconcentrates with saturated fatty acids, stearic acid and decanoic acid failed. Although homogenous preconcentrates could be obtained by heating, a precipitation of stearic acid or decanoic acid was observed upon cooling of the preconcentrate to room temperature.

[0205] **Example 2: Additional Preconcentrates**

[0206] Additional preconcentrates were prepared to determine an optimized amount of surfactant with K85EE and K85FA. The preconcentrates described in Table 10 were prepared as provided in Example 1. The preconcentrates were visually inspected after mixing and again after being stored for 24 hours at room temperature. Under the Preconcentrate heading, a "clear" designation represents a transparent homogenous mixture; a "turbid" designation represents a nonhomogenous mixture, where some turbidity can be observed by visual inspection. The degree of turbidity was not determined.

Table 10: Additional Preconcentrates.

K85-EE (mg)	Tween20 (mg)	K85FA (mg)	Preconcentrate
107	307	62	Turbid
107	307	76	Turbid

107	307	102	Turbid
107	307	200	Clear
107	307	401	Clear
107	307	803	Clear
107	307	1608	Clear
<hr/>			
26	300	99	Clear
104	300	99	Clear
201	300	99	Clear
316	300	99	Clear
400	300	99	Clear
497	300	99	Turbid
618	300	99	Turbid
<hr/>			
405	42	101	Clear
405	99	101	Clear
405	202	101	Clear
405	299	101	Clear
405	400	101	Clear
405	618	101	Clear
405	1000	101	Clear
<hr/>			
K85-EE (mg)	Tween80 (mg)	K85FA (mg)	Preconcentrate
407	306	57	Clear
407	306	80	Clear
407	306	103	Clear
407	306	202	Clear
407	306	401	Clear
<hr/>			
28	299	101	Clear
57	299	101	Clear
99	299	101	Clear

233	299	101	Clear
316	299	101	Clear
414	299	101	Clear
510	299	101	Clear
569	299	101	Clear
627	299	101	Clear
688	299	101	Clear
769	299	101	Clear
<hr/>			
402	32	106	Clear
402	126	106	Clear
402	229	106	Clear
402	326	106	Clear
402	410	106	Clear
402	997	106	Clear
<hr/>			
K85-EE (mg)	Tween-40 (mg)	K85FA (mg)	Preconcentrate
111	311	59	Turbid
111	311	70	Clear
111	311	95	Clear
111	311	135	Clear
111	311	244	Clear
111	311	798	Clear
111	311	1567	Clear
<hr/>			
30	309	98	Clear
110	309	98	Clear
208	309	98	Clear
322	309	98	Clear
404	309	98	Clear
501	309	98	Turbid

618	309	98	Turbid
408	38	99	Clear
408	105	99	Clear
408	210	99	Clear
408	301	99	Clear
408	398	99	Clear
408	616	99	Clear
408	1001	99	Clear

[0207] **Example 3: Compatibility of Preconcentrates with Solvents**

[0208] The compatibility of solvents and a preconcentrate having a fixed amount of K85EE and Tween-80 were evaluated. The preconcentrates described in Table 11 were prepared as provided in Example 1, but with the addition of the solvent identified below. The preconcentrates were visually inspected after mixing and again after being stored for 24 hours at room temperature. Under the Preconcentrate heading, a "clear" designation represents a transparent homogenous mixture; a "turbid" designation represents a non-homogenous mixture, where some turbidity can be observed by visual inspection. The degree of turbidity was not determined.

Table 11: Compatibility of Solvent and Preconcentrates.

K85-EE (mg)	Tween-80 (mg)	96% ethanol (mg)	96% ethanol (%)	Preconcentrate
400	110	10.7	2.1	Turbid
400	110	18.7	3.5	Turbid
400	110	28.4	5.3	Turbid
400	110	32.1	5.9	Turbid
400	110	45.7	8.2	Turbid
400	110	53.5	9.5	Turbid
400	110	61.5	10.8	Turbid
400	110	69.8	12.0	Turbid

400	110	79.9	13.5	Turbid
400	110	91.3	15.2	Turbid
400	110	102.5	16.7	Turbid
<hr/>				
K85-EE (mg)	Tween-80 (mg)	Propylene glycol (mg)	Propylene glycol (%)	Preconcentrate
400	110	11.1	2.1	Turbid
400	110	16.7	3.2	Turbid
400	110	23.1	4.3	Turbid
400	110	32.9	6.1	Turbid
400	110	41.5	7.5	Turbid
400	110	48.6	8.7	Turbid
400	110	59.9	10.5	Turbid
400	110	72.9	12.5	Turbid
400	110	81.5	13.8	Turbid
400	110	93.5	15.5	Turbid
400	110	104.6	17.0	Turbid
<hr/>				
K85-EE (mg)	Tween-80 (mg)	PEG 300 (mg)	PEG 300 (%)	Preconcentrate
400	110	13.9	2.7	Turbid
400	110	23.7	4.4	Turbid
400	110	35.6	6.5	Turbid
400	110	47.1	8.5	Turbid
400	110	55.0	9.7	Turbid
400	110	68.7	11.9	Turbid
400	110	81.8	13.8	Turbid
400	110	90.3	15.0	Turbid
400	110	104.0	16.9	Turbid
<hr/>				
K85-EE (mg)	Tween-80 (mg)	Benzyl alcohol (mg)	Benzyl alcohol (%)	Preconcentrate

400	110	0	0	Clear
400	110	11.4	2.2	Turbid
400	110	18.1	3.4	Turbid
400	110	30.9	5.7	Clear
400	110	45.5	8.2	Clear
400	110	55.6	9.8	Clear
400	110	66.7	11.6	Clear
400	110	77.4	13.2	Clear
400	110	92.1	15.3	Clear
400	110	99.0	16.3	Clear
<hr/>				
K85-EE (mg)	Tween-80 (mg)	Triacetin (mg)	Triacetin (%)	Preconcentrate
400	110	12.3	2.4	Turbid
400	110	24.3	4.5	Turbid
400	110	35.8	6.6	Turbid
400	110	45.3	8.2	Turbid
400	110	57.0	10.1	Turbid
400	110	68.1	11.8	Turbid
400	110	80.9	13.7	Turbid
400	110	90.0	15.0	Turbid
400	110	101.7	16.6	Turbid
<hr/>				
K85-EE (mg)	Tween-80 (mg)	1-octadecanol 99% (mg)	1-octadecanol 99% (%)	Preconcentrate
400	110	8.6	1.7	Precipitate
<hr/>				
K85-EE (mg)	Tween-80 (mg)	oleyl alcohol 85% (mg)	oleyl alcohol 85% (%)	Preconcentrate
400	100	13.0	2.5	Turbid
400	100	26.5	4.9	Turbid
400	100	37.3	6.8	Turbid

400	100	49.5	8.8	Turbid
400	100	62.6	10.9	Turbid
400	100	77.7	13.2	Turbid
400	100	92.2	15.3	Turbid
400	100	105.7	17.2	Turbid
<hr/>				
K85-EE (mg)	Tween-80 (mg)	1-tetradecanol 97% (mg)	1 tetradecanol 97% (%)	Preconcentrate
400	100	1.7	0.3	Turbid
400	100	10.3	2.0	Turbid
400	100	22.7	4.3	Turbid
400	100	35.8	6.6	Precipitate
<hr/>				
K85-EE (mg)	Tween-80 (mg)	glycerol (mg)	glycerol (%)	Preconcentrate
400	100	17.7	3.4	Turbid
400	100	28.0	5.2	Turbid
400	100	41.7	7.6	Turbid
400	100	52.8	9.4	Turbid
400	100	71.2	12.3	Turbid
400	100	85.4	14.3	Turbid
400	100	92.3	15.3	Turbid
400	100	105.7	17.2	Turbid
<hr/>				
K85-EE (mg)	Tween-80 (mg)	Oleic acid 90 % (mg)	Oleic acid 90% (%)	Preconcentrate
400	100	13.2	2.5	Turbid
400	100	23.9	4.5	Turbid
400	100	31.5	5.8	Turbid
400	100	41.4	7.5	Turbid
400	100	51.8	9.2	Turbid
400	100	65.2	11.3	Clear

400	100	79.8	13.5	Clear
400	100	87.2	14.6	Clear
400	100	102.2	16.7	Clear
<hr/>				
K85-EE (mg)	Tween-80 (mg)	1-docosanol 98% (mg)	1-docosanol 98% (%)	Preconcentrate
400	100	9.6	1.8	Precipitate

[0209] **Example 4: Characterization of Preconcentrates and SNEDDS/SMEDDS/SEDDS**

[0210] Preconcentrates A- L described in Table 12 were prepared as provided in Example 1.

Table 12: Preconcentrates A-L.

Preconcentrate	K85-EE (mg)	Surfactant (mg)	FFA (mg)	Total vol. (mg)	Ratio
A	5002.7	Tween-20 3705.8	Oleic Acid 1307.9	10016.4	49:36:13
B	5004.9	Tween-80 3707.9	Oleic Acid 1302.3	10015.1	49:37:13
C	5003.2	Tween-20 3702.1	Ricoleic acid 1308.1	10013.4	49:36:13
D	5003.5	Tween-80 3703.1	Ricoleic acid 1303.4	10010	49:36:13
E	5000.4	Tween-20 3707.4	Linoleic acid 1305.3	10013.1	49:37:13
F	5001	Tween-80 3706	Linoleic acid 1304.3	10011.3	49:37:13
G	5006.4	Tween-20 3702.1	Erucic acid 1300.2	10008.7	50:36:12
H	5004.3	Tween-80 3704.1	Erucic acid 1303.2	10011.6	49:36:13

I	5002.9	Tween-20 3700.8	α -Linolenic acid 1309.4	10013.1	49:36:13
J	5003.6	Tween-80 3701.6	α -Linolenic acid 1312.1	10017.3	49:36:13
K	5002.9	Tween-20 3700.8	"Pure" EPA- FA+DHA-FA in a ratio close to K85-EE 1309.4	10013.1	49:36:13
L	5002.9	Tween-80 3700.8	"Pure" EPA- FA+DHA-FA in a ratio close to K85-EE 1309.4	10013.1	49:36:13

[0211] From Table 12 above, all preconcentrates appeared clear and homogenous, except for the formulation with erucic acid. As such, the preconcentrates can be mixed in any proportion and these mixtures will still form homogenous and clear preconcentrates.

[0212] Preconcentrates A-L were also screened for compatibility with various solvents. The outcome of this screening is shown in Table 13 below. To 500 mg of preconcentrate, approximately 50 mg of each solvent was added. Preconcentrate A was used for all the solvents. Ethanol was tested in all the preconcentrates. The preconcentrates were visually inspected after mixing and again after being stored for 24 hours at room temperature. Under the Preconcentrate heading, a "clear" designation represents a transparent homogenous mixture; an "unclear" designation represents a nonhomogenous mixture, where some turbidity can be observed by visual inspection. The degree of turbidity was not determined.

Table 13: Preconcentrate Compatibility.

Solvent	Preconcentrate A	Preconcentrate B-L
---------	---------------------	-----------------------

96% Ethanol	Clear	Clear
Benzyl alcohol	Clear	Nd
Propylene glycol	Unclear	Nd
Triacetin	Clear	Nd
PEG 300	Unclear	Nd
Glycerol	Unclear	Nd
1-octadecanol 99%	Clear, but solid	Nd
1-docosanol 98%	Unclear	Nd
Oleyl alcohol 85%	Clear	Nd
1-tetradecanol 97%	Clear	Nd

Nd - Not determined.

[0213] Viscosity can be used as a physical characterization parameter. Viscosity measurements were taken for preconcentrates A-L in triplicate. Generally, the viscosity showed greater sensitivity for the type of fatty acid than for the type of surfactant. FIG 1 graphically illustrates the viscosity of preconcentrates A-L. Although the viscosity measurements cannot distinguish between Tween 20 versus Tween 80, the viscosity can be impacted by the free fatty acid.

[0214] Preconcentrates A-F, I and J were diluted in gastric and intestinal media to form an emulsion (i.e., SNEDDS/SMEDDS/SEDDS). The composition of the gastric media is shown in Table 14, and the composition of the intestinal media is shown in Table 15.

Table 14: Gastric Media

Gastric Media	
Bile salts, Porcine (mM)	0.08
Lechitin (mM)	0.02
Sodium chloride (mM)	34.2
Pepsin (mg/ml)	0.1
pH	1.6 (adjust with 1 M HCl)
Osmolarity (mOsm/kg)	120

Table 15: Intestinal Media

Intestinal Media	
Bile salts, Porcine Bile extract, Sigma 037K0196 (mM)	5
Phospholipids, LIPOID S PC from LIPOID AG (mM)	1.25
Trizma maleate, Sigma Aldrich , T 3128 (mM)	2
Na ⁺ (mM)	150

[0215] Particle size was measured using a Malvern Zetasizer (Malvern Instrument, Worcestershire, UK) with particle size measuring range of 0.5 - 6000 nm and Zeta potential of particle range of 3 nm - 10 μ m. The particle size was measured in triplicate.

[0216] For the gastric media, the emulsions were prepared by adding 1 ml of gastric media to 50 mg of the preconcentrate. Table 16 below provides the particle size measurements for preconcentrates A-F, I and J in the gastric media. The particle size measurements in gastric media are also graphically illustrated in FIG 2.

Table 16: Particle size measurements for preconcentrates A-F, I and J in gastric media.

Preconcentrates	A	B	C	D	E	F	I	J
Size (nm)	269.6	152.1	216.8	271	271.1	287.1	165	244.3
Standard Deviation	29.63	5.141	26.24	15.94	6.208	36.71	15.87	13.67

[0217] For the intestinal media, the emulsions were prepared by adding the gastric media (100 μ l) obtained above to intestinal media (900 μ l). Table 17 below provides the particle size measurements for preconcentrates A-F, I and J in the intestinal media. The particle size measurements in intestinal media are also graphically illustrated in FIG 2.

Table 17: Particle size measurements for preconcentrates A-F, I and J in intestinal media.

Preconcentrates	A	B	C	D	E	F	I	J
Size (nm)	245.9	2314	266.7	332.5	233.9	1891	224.3	1788
Standard Deviation	7.465	2438	35.38	26.63	10.48	1936	13.56	930.5

[0218] As shown in FIG 2, intestinal media has a larger impact on the particle size distribution and particularly, preconcentrates comprising Tween 80. That observation has been visualized in FIGs 3-18. FIGs 3-18 show the read out from the Malvern zetasizer for four consecutive measurements on the same sample of each respective preconcentrate. All the preconcentrates give near to unimodal particle size distributions in gastric media, whereas only preconcentrates comprising Tween 20 stays unimodal when transferred to intestinal media.

[0219] **Example 5: Lipolysis and Solubilization**

[0220] Studies were done to analyze the rate of lipolysis (i.e., hydrolysis) and solubilization for different preconcentrates comprising K85EE and different free fatty acids and surfactants. Specifically, four experiments were designed to determine how the amount of surfactant influences the rate and extent of lipolysis and solubilization. The lipolysis was conducted on SMEDDS formulations comprising K85EE.

[0221] **Materials**

- Bile salts: Porcine Bile extract (Sigma); contains glycine and taurine conjugates of hyodeoxycholic acid and other bile salts.
- Pancreatic lipase, Porcine pancreas (Sigma); contains many enzymes, including amylase, trypsin, lipase, ribonuclease and protease.
- Lechitin: Phospholipids (LIPOID S PC from LIPOID AG)
- Trizma maleate (Sigma Aldrich)
- Tween 20, Molecular Biology Grade (AppliChem Darmstadt), Tween 80 (Fluka)
- α -Linoleic acid (Sigma 60%), Oleic acid (Aldrich 90%)

- K85-EE and K85-FA

[0222] Preconcentrates A-E were prepared as summarized in Table 18.

Table 18: Preconcentrates A-E.

Preconcentrate	Fatty acid oil mixture	Free fatty acid	Surfactant
A	K85EE (400 mg)	oleic acid (100 mg)	Tween 20 (300 mg)
B	K85EE (400 mg)	oleic acid (100 mg)	Tween 20 (75 mg)
C	K85EE (500 mg)	linoleic acid (100 mg)	Tween 80 (200 mg)
D	K85EE (400 mg)	K85FA (100 mg)	Tween 20 (300 mg)
E	K85EE (400 mg)	---	Tween 80 (100 mg)

[0223] Lipolysis general procedure

[0224] The in vitro dynamic lipolysis model developed by Zangenberg et al. (Zangenberg, N.H. et al., *Eur. J. Pharm. Sci.* 14, 237-244, 2001; Zangenberg, N.H., et al., *Eur. J. Pharm. Sci.* 14, 115-122, 2001) was used with slight modifications. The lipolysis was conducted in a thermostated 600 ml jacketed glass vessel in the presence of porcine bile extract, with continuous addition calcium chloride. The lipase source was porcine pancreatin and the hydrolysis was followed by titration with sodium hydroxide solution (1.0 N) using a pH stat (pH 6.5). The initial composition of the lipolysis media is shown in Table 19.

Table 19: Initial composition of lipolysis media.

Substance	Initial Concentration
Pancreatic lipase, Porcine pancreas	800 USP units/ml
Bile salts, Porcine Bile extract	5 mM
Phospholipids, LIPOID S PC from LIPOID AG	1.25 mM
Trizma maleate	2 mM
Na ⁺	150 mM

K85-EE	5.58 mg/ml
--------	------------

[0225] The final volume in all experiments was 300 ml and the calcium dispensing rate during the experiments was 0.045 mmol/min (0.09 ml/min). In all experiments, the amount of K85-EE added corresponds to 5.58 mg/ml.

[0226] To determine the course of K85-EE lipolysis by HPLC, crude samples were withdrawn and acidified with dilute hydrochloric acid. The concentrations of EPA-EE, DHA-EE, EPA-FA and DHA-FA were determined by HPLC in triplicate. Experiments were performed with LC Agilent Technologies 1200 series at a column temperature of 30°C, mobile phase (A) water (0.1% acetic acid) and (B) MeCN (0.1% acetic acid), with gradient: 0 to 8 minutes, from 70% B to 100% B; 8 to 15 minutes, 100 % B; 16 to 16 minutes: from 100 % B to 70% B, 16 to 20 minutes: 70% B. The flow rate was 0.5 ml/min, UV @ 210 nM, injection volume: 5 μ l, and run time: 20 minutes.

[0227] Concentrations of EPA ethyl ester (EPA-EE), DHA ethyl ester (DHA-EE), EPA free acid (EPA-FA), and DHA free acid (DHA-FA) were monitored over time and the rate of lipolysis calculated as shown in Table 20 for comparison with Omacor®.

Table 20: Lipolysis of EPA and DHA ethyl ester in comparison to Omacor®.

	EPA-EE lipolysis (μ g/ml/min)	DHA-EE lipolysis (μ g/ml/min)	% lipolysis K85EE at t=233 min
Omacor®	1.5	2.3	17
A	2.8	4.5	41
B	2.9	3.9	35
C	3.7	5.0	47
D	3.5	5.0	55
E	3.8	4.3	45

[0228] FIGs 19, 22, 25, 28, 31, and 34 graphically illustrate the disappearance of EPA-EE and DHA-EE and the appearance of EPA-FA and DHA-FA

during lipolysis of each respective sample examined. Sample points from 2 minutes to 233 minutes were included in the graphs. In addition, linear regression lines have been included.

[0229] FIGs 20, 23, 26, 29, 32, and 35 provide the percent recovery of EPA + DHA at different time-points for each respective sample examined. Data are given as the sum of EPA-EE, DHA-EE, EPA-FA, and DHA-FA and given as a percentage of theoretical amount 5580 µg/ml.

[0230] FIGs 21, 24, 27, 30, 33, and 36 graphically illustrate the percent lipolysis at different time points for EPA-EE, DHA-EE and total K85EE. Values are calculated relative to the total amount of EPA-EE and DHA-EE determined by HPLC after lipolysis for 2 minutes.

[0231] Example 6: Fatty Acid Oil Mixtures of Pharmaceutical Compositions/Preconcentrates

[0232] Fatty acid oil mixtures of pharmaceutical compositions or preconcentrates, wherein the fatty acid oil mixture is a K85-EE composition are presented in Table 21.

Table 21: Fatty acid oil mixture for pharmaceutical compositions/preconcentrates

Fatty acid oil mixture: 1000 mg K85EE fatty acid oil mixture	Minimum Value	Maximum Value
EPAEE + DHAEE	800 mg/g	880 mg/g
EPA EE	430 mg/g	495 mg/g
DHA EE	347 mg/g	403 mg/g
Total omega-3 EE	>90% (w/w)	

EE = ethyl ester

[0233] Example 7: Tablet Formulations

[0234] Tablets were prepared by immersing the tablet shown in Table 22 in K85EE oil. The mean liquid loading was 160 mg oil/tablet, corresponding to about 72 v/v%. The tablet can also be prepared without a superdisintegrant.

Table 22: Tablet formulation

Tablet composition	Example
Neusilin US	89%
Ac-Di-Sol (croscarmellose sodium) = superdisintegrants	10%
Mg-stearate	1.0%

[0235] **Example 8: Novel K85 Tablet Formulation**

[0236] A tablet formulation is prepared with the components identified in Table 23 by immersing a tablet in a K85EE or AGP oil and an oil in free acid form.

Table 23: K85 tablet formulation

K85 or AGP oil loading per tablet	Minimum	Maximum value
EPA EE and DHA EE	125 mg	600 mg
Free fatty acid oil	2% corresponding to about 2.5 mg	15% corresponding to about 90 mg

[0237] **Example 9: Preparation of SEDDS and SMEDDS**

[0238] The preconcentrate can be prepared by mixing a fatty acid oil mixture together with at least one surfactant and a free fatty acid.

[0239] The preconcentrate can be visually inspected after mixing and again after being stored at 24 hours at room temperature and clear and transparent preconcentrate can be obtained.

[0240] To the preconcentrate can then an aqueous medium be added to form an oil-in-water emulsion. The dispersion rate for the formation of the oil-in-water emulsion can be very fast, less than one minute.

[0241] The microemulsions formed can then be tested regarding hydrolysis, also called lipolysis.

[0242] For example, to determine the course of KE85-EE hydrolysis by HPLC, crude samples can be withdrawn and acidified with dilute hydrochloric acid.

The concentrations of EPA- ethyl ester, DHA ethyl ester, EPA-free fatty acid and DHA-free fatty acid can then determined by HPLC.

[0243] All samples withdrawn from a non-homogenous phase and some variability in recovery can be expected, especially at early time points.

Table 24: Initial concentrations of components in the hydrolysis medium.

Substance	Initial concentration
Pancreatic lipase, Porcine pancreas, Sigma 095K1149	800 USP units/ml
Bile salts, Porcine Bile extract, Sigma 037K0196	5 mM
Phospholipids, LIPOID S PC from LIPOID AG	1.25 mM
Trizma maleate, Sigma Aldrich , T 3128	2 mM
Na ⁺	150 mM
KE85-EE	5.58 mg/ml

[0244] An example HPLC analytical method can include the following parameters:

[0245] Use of a LC-MS manufactured by Agilent Technologies and includes a 1200 Series LC and a 6140 Quadrupole MS running ChemStation® B.04.01 software;

[0246] Column: Eclipse® XDB-C18, 2.1X150 mm, 5µm, Agilent

[0247] Column temperature: 25 °C;

[0248] Mobile Phase: A: water (0.1 %acetic acid), B: MeCN (0.1 % acetic acid);

[0249] Gradient: 0 to 8 min, from 70%B to 100%B, 8 to 15 minutes: 100 % B, from 16 to 16 minutes: from 100 % B to 70% B, 16 to 20 minutes: 70% B;

[0250] Flow rate: 0.5 ml/min;

[0251] UV @ 210 nM;

[0252] Injection volume: 25 µl; and

[0253] Run time: 20 minutes.

[0254] The oil-in-water emulsions can then be further analyzed to determine the particle size of the oil droplets. The particle size can be determined with Malvern

Zetasizer (Malvern Instrument, Worcestershire, UK) having particle size measuring range of 0.6 – 6000 nm and Zeta of particle range of 3nm – 10 μ m.

[0255] Table 25 shows the components that can be included in pharmaceutical compositions and food supplement compositions according to the present disclosure.

Table 25: Sample compositions according to the present disclosure.

	Pharmaceutical composition	Food Supplement composition
Fatty Acid Oil Mixture	K85EE, K85TG or AGP103 drug substance	Commercial up-concentrated oil mixture in EE and/or TG form
Surfactant	Tween®20 or Tween®40	Tween®20 or Tween®40
Free Fatty Acid	(EPA-FA and DHA-FA), EPA-FA or DHA-FA	(EPA-FA+DHA-FA), EPA-FA or DHA-FA
Total Oil Mixture 100% by weight	100% by weight	100% by weight

[0256] Further for example, K85EE omega-3 fatty acid oil and the free fatty acid chosen from K85FA having a EPA:DHA -FA ratio more or less equal to the EPA:DHA -EE ratio in K85EE are exemplified in Table 26.

Table 26: Additional compositions according to the present disclosure.

Total oil mixture content [oil:co-surfactant ratio] in SME DDS/SE DDS Formulations	Fatty Acid Oil Mixture: K85EE	Free Fatty Acid: K85-FA	Free Fatty Acid: EPA-FA or DHA-FA	Free Fatty Acid: EPA and DHA mixture in FA form	Total oil mixture (by weight)
1.)	80-95%		5-20 w%		100 w%
2.)	70-80%		20-30%		100 w%
3.)	50-70%		30-50%		100 w%
4.)	50-60%	40-50%			100 w%

5.)	60-70%	30-40%			100 w%
6.)	70-80%	20-30%			100 w%
7.)	80-95%	5-20%			100 w%
8.)	>80%			<20%	100 w%
9.)	70-80%			20-30%	100 w%
10.)	60-70%			30-40%	100 w%
11.)	50-60%			40-50%	100 w%
12.)	85-95%			5-15% EPA>DHA	100 w%
13.)	80-90%			10-20% EPA>DHA	100 w%
14.)	70-80%			20-30% EPA>DHA	100 w%
15.)	60-70%			30-40% EPA>DHA	100 w%

[0257] Additionally, the total oil mixtures presented above can be mixed with the surfactant Tween®20.

[0258] Further for example, the K85EE mixed fatty acid composition comprises at least 90% omega-3 ethyl ester fatty acids, and wherein the mixed fatty acid composition comprises from about 80% to about 88% eicosapentaenoic acid ethyl ester and docosahexaenoic acid ethyl ester, by weight of the fatty acid composition.

[0259] A collection of ratios between [oil]:[surfactant]:[free fatty acid] (a):b):c) are illustrated in Table 27. For example, a K85EE or AGP103 oil is used together with a surfactant and a co-surfactant in the [K85EE]:[surfactant]:[free fatty acid] ranges from about 4:2:0.5 to 4:4:2. Thus, the range for the surfactant may be from 2 to 4 and the free fatty acid from 0.5 to 2.

[0260] It is also included herein that the K85EE oil mixture presented in Table 27 above can be replaced by a K85TG oil mixture as well as a commercial omega-3 oil concentrate in ethyl ester and/or triglyceride form.

Table 27: SMEDDS formulations with Tween20, K85EE, EPA-FA or DHA-FA.

	K85EE (mg)	Tween20 (mg)	EPA-FA (mg)	DHA-FA (mg)	~K85FA (mg)	200 mg preconcentrate in 10 ml water
A	400	400	100			emulsion
B	400	400		100		emulsion
C	400	300	100			emulsion
D	400	300			100	emulsion

[0261] **Example 10: Pharmaceutical Preconcentrate Composition**

[0262] A pharmaceutical preconcentrate composition was prepared by mixing the following components:

[0263] as the fatty acid oil mixture: K85-EE; in an amount of 10.80 g;

[0264] as the surfactant: Tween-20 (Molecular Biology Grade, AppliChem Darmstadt, A4974,0250 lot 5N004174) in an amount of 7.44 g;

[0265] as the at least one fatty acid: EPA-FA in an amount of 1.53 g; and DHA-FA in an amount of 1.24 g.

[0266] With mixing, a transparent homogenous solution was obtained. The density of the formulation was determined to be 1.02 g/ml. The composition was then filled in vials (vial seize = 4ml) each comprising $1.25 \times 1670 \text{ mg} = 2087 \text{ mg}$ were prepared, flushed with nitrogen and sealed with parafilm.

[0267] **Example 11: In vivo studies in mini-pig**

[0268] Two different formulations were prepared and sent for *in-vivo* testing. Formulation 1 was prepared according to Example 10 by mixing the following components: K85EE, Tween20 EPA-FA and DHA-FA in the specified amounts, and Formulation 2 was OMACOR gelatine capsules.

[0269] The study was performed in 8 male Göttingen SPF minipigs from Ellegaard Göttingen Minipigs ApS. The animals were housed individually in floor pens (1.2 m^2) with sawdust ("Jeluxyl" from Jelu Werk GmbH, Josef Ehrler GmbH & Co KG, Ludwigsmühle, D-73494 Rosenberg, Germany) as bedding.

[0270] Treatment was performed in a cross-over design. The dose was 2 g per animal. The first day of treatment is designated Day 1. Treatment was performed with a wash out period of at least 10 days between each dosing. Blood

samples (n=8) were taken post-dosing. Plasma samples were analysed within 2 weeks for total lipid content of EPA and DHA by a validated LC-MS/MS method. The result presented in FIG 37 shows the plasma concentration versus time profile of the total lipid concentration of EPA, supporting supra- bioavailability (e.g., great than 40%) for the K85 SMEDDS formulation. A similar results has also been shown for the time profile of total lipid concentration of DHA (not shown in FIG 37).

[0271] **Example 12: Pharmaceutical Formulations, SMEDDS, and SEDDS**

[0272] Table 28 illustrates pharmaceutical formulations, SMEDDS, and SEDDS that can be prepared.

Table 28: Pharmaceutical Formulations, SMEDDS, SEDDS

Reference No.	K85FA fatty acid oil mixture	Surfactant or Surfactant System	Second fatty acid mixture is a fish oil ethyl ester concentrate
64	X about 40%	Tween® 20 about 40%	X about 20%
65	X 40%	Tween® 20 40%	Oleic acid EE 20%

[0273] In an embodiment, the surfactant is chosen from among Tween® surfactants, such as 20, 40, 60, 80, and 85. For example, a composition according to the disclosure can include at least one surfactant chosen from Tween® 20 and 40.

[0274] **Example 13: Emulsion/Microemulsion Preconcentrate Formulations**

[0275] The following emulsion/microemulsions preconcentrate formulations according to the disclosure were prepared.

[0276] Pharmaceutical formulation 1: A SEDDS composition

[0277] A pharmaceutical composition was prepared by mixing the following components: Fatty acid oil mixture a) EPA-FA in an amount of 5.5 g and DHA-FA in an amount of 4.5 g (achieving approximately the EPA:DHA ratio in a K85EE or FA fatty acid mixture); b) a second fatty acid mixture in EE form: ethyl oleate: Fluka

75100, 137044 50308P14 in an amount of 5.0 g; and as the surfactant c): Tween® 20, Molecular Biology Grade, AppliChem Darmstadt, A4974,0250 lot 5N004174 in an amount of 10.0 g.

[0278] A transparent homogenous solution was obtained. The density of the formulation was determined to be 1.03 g/ml. The composition was then filled into vials (vial size = 4 ml) each comprising (2450 mg X 1.25) = 3063 mg were prepared, flushed with nitrogen and sealed with parafilm.

[0279] Pharmaceutical formulation 2

[0280] The same formulation as illustrated above was made with Tween® 80, instead of Tween® 20. Thus, mixed fatty acids; EPA-FA (110mg) + DHA-FA (90 mg), ethyl oleate (100mg) and Tween 80 (200mg). A transparent homogenous solution was obtained.

[0281] **Example 14: Emulsions in Pure Water**

[0282] The oil content in one capsule Omacor®, comprising EPA ethyl ester (465 mg), DHA ethyl ester (375 mg) and alpha-tochopherol (4 mg) were mixed in a scintillation vial with various surfactants as shown in Table 29. Water (10 ml) was added at 37 degrees centigrade and the mixture was shaken for 15 seconds using a Vortex mixer. The mixture was observed after 1 minute and after 5 minutes. The visual score for emulsion homogeneity was scored as follows: No emulsion = score 0, emulsion but not homogeneous emulsion= score 1, homogeneous emulsion = score 2.

[0283] The mixture was after mixing also rolled in a roller mixer for 5 minutes. The visual score for this roller test was the same.

Table 29: Emulsions in pure water.

Reference No.	Surfactant(s)	Amount of Surfactant (mg)	Score After Vortex for 1 minute	Score After Vortex 5 minutes	Score Roller Mixer
1	None	0	0	0	0
2	Brij® 30	100	2	2	2
3	Brij® 35	100	2	1	2

4	Brij® 52	100	2	2	2
5	Brij® 58	100	2	1	2
6	Brij® 72	100	2	1	2
7	Brij® 78	100	2	1	2
8	Brij® 92V	100	2	2	2
9	Brij® 93	100	2	2	2
10	Brij® 96V	100	2	2	2
11	Brij® 97	100	2	2	2
12	Brij® 98	100	2	1	2
13	Brij® 700	100	1	1	2
14	Brij® S-10	100	1	1	2
15	Pluronic® L-31	100	1	1	2
16	Pluronic® L-35	100	1	1	2
17	Pluronic® L-81	100	2	2	2
18	Pluronic® L-64	100	2	2	2
19	Pluronic® L-121	100	2	2	2
20	Pluronic® P-123	100	1	1	2
21	Pluronic® F-68	100	0	0	1
22	Pluronic® F-108	100	0	0	1
23	Span® 20	100	2	2	2
24	Span® 60	100	0	0	1
25	Span® 65	100	0	0	0
26	Span® 80	100	1	1	2
27	Span® 85	100	0	0	1
28	Tween® 20	100	2	1	2
29	Tween® 40	100	2	1	2
30	Tween® 60	100	2	1	2
31	Tween® 80	100	2	1	2
32	Alginic Acid	100	1	0	1

33	Alginic Acid sodium salt	100	2	1	1
34	Macrogolglycerol-hydroxystearas 40	100	2	2	2
35	Sodium lauryl sulphate	100	1	1	2
36	1,2-Dipalmitoyl-sn-glycerol ethanolamine	100	0	0	0
37	1-Hexadecanol	100	1	0	0
38	1,2-Dipalmitoy-sn	100	2	1	1
39	Macrogol 400	100	0	0	1
40	Myristic acid sodium salt	100	1	1	1
41	Brij® 52/Macrogolglycerol-hydroxystearas 40	30/20	2	2	2
42	Brij®62/Pluronic®L 64	30/50	2	2	2
43	Span® 20/Pluronic® L64	40/90	2	2	2
44	Macrogol 400/Macrogol-glycerol-hydroxystearas 40	120/60	2	2	2
45	Tween®20/Span® 20	60/60	2	2	2
46	Tween®20/Span® 20/Macrogol 400	90/90/60	2	2	2
47	Span®20/Tween® 20/Brij®97	70/100/40	2	2	2
48	Alginic acid sodium	110/60	2	2	2

	salt/Span®60				
49	Pluronic®F-68/Pluronic®L64/Span®60	20/180/20	2	2	2

[0284] **Example 15: Emulsions in Artificial Gastric Juice**

[0285] The oil content in one capsule OMACOR®, comprising EPA ethyl ester (465 mg), DHA ethyl ester (375 mg) and alpha-tochopherol (4 mg) were mixed in a scintillation vial with various surfactants as shown in Table 30. The experimental set up is the same as described in Example 14 except that that artificial gastric juice without pepsin (European Pharmacopeia 6.0, page 274) was used instead of water.

Table 30: Emulsions in artificial gastric juice

Reference No.	Surfactant(s)	Amount of Surfactant (mg)	Score After Vortex for 1 minute	Score after Vortex for 5 minutes	Score Roller Mixer
50	None	0	0	0	0
51	Brij®52	100	2	1	2
52	Brij®96V	100	2	1	2
53	Pluronic®L64	100	2	2	2
54	Tween®40	100	2	2	2
55	Macrogolglycerol-Hydroxystearas 40	100	2	2	2

[0286] **Example 16: Emulsions in Simulated Intestinal Fluid**

[0287] The oil content in one capsule Omacor®, comprising EPA ethyl ester (465 mg), DHA ethyl ester (375 mg) and alpha-tochopherol (4 mg) were mixed in a scintillation vial with various surfactants as shown in Table 31. The experimental set

up is the same as described in Example 14 except that simulated intestinal fluid pH 6.8 without pancreas powder (European Pharmacopeia 6.0, page 274) was used instead of water.

Table 31: Emulsions in simulated intestinal fluid.

Reference No.	Surfactant(s)	Amount of Surfactant (mg)	Score After Vortex for 1 minute	Score after Vortex for 5 minutes	Score Roller Mixer
56	None	0	0	0	0
57	Brij®52	100	2	2	2
58	Brij®96V	100	2	2	2
59	Pluronic®L64	100	2	2	2
60	Tween®40	100	2	2	2
61	Macrogolglycerol-Hydroxystearas 40	100	2	2	2

[0288] **Example 17: Microscopic Examination of Emulsions**

[0289] Emulsions from Reference No. 52 (gastric juice) of Example 15 and Reference No. 58 (intestinal fluid) of Example 16 were examined under the microscope after 24 hours rolling. Both emulsions were found to be suspensions of oil in water with no tendency to aggregation.

[0290] **Example 18: Pharmaceutical Formulations**

[0291] Table 32 illustrates pharmaceutical formulations that can be prepared.

Table 32: Pharmaceutical Formulations

Reference No.	K85EE or AGP103 Oil Mixture	Surfactant or Surfactant System
64	X	Tween® 20

65	X	Tween® 40
66	X	Tween® 80
67	X	Tween®20 +Tween® 40
68	X	Tween®+Cremphor®
69	X	Tween®+Solutol HS 15

[0292] In an embodiment, the surfactant or combination of surfactants is chosen from Tween® surfactants; Tween® 20, Tween® 40, Tween® 60, Tween® 65, Tween® 80 and Tween® 85.

[0293] In another embodiment, the surfactant is chosen from a combination of a Tween® surfactants and a surfactant chosen from Cremphor®, for instance Tween® 20 and Cremphor EL. Moreover, in a further embodiment, a Tween® 20 and Solutol HS 15 surfactant can be used together as well as Tween® 20 and Tween® 40.

[0294] Fatty acid oil mixtures of pharmaceutical preconcentrates, wherein the fatty acid oil mixture is a K85EE or AGP-103 oil composition are presented in Table 33.

Table 33: Fatty acid oil mixture for pharmaceutical preconcentrates.

Fatty acid oil mixture: 1000 mg K85EE fatty acid oil mixture	Minimum Value	Maximum Value
EPAEE + DHAEE	800 mg/g	880 mg/g
EPA EE	430 mg/g	495 mg/g
DHA EE	347 mg/g	403 mg/g
Total omega-3 EE	>90% (w/w)	

EE = ethyl ester

[0295] Example 19: Additional Emulsions in Artificial Gastric Juice and Simulated Intestinal Fluid

[0296] Preconcentrates 1-23 were prepared with EPA/DHA ethyl ester (1000 mg K85EE) and various surfactants and surfactant mixtures as shown in Table 34. Emulsions were prepared in both gastric juice and simulated intestinal fluid as

described in Examples 15 and 16. Results were the same for emulsions in artificial gastric juice and simulated intestinal fluid, and appear in Table 34.

Table 34: Emulsions in artificial gastric juice and simulated intestinal fluid.

Reference No.	Surfactant(s)	Amount of Surfactant (mg)	Score After Vortex for 1 minute	Score After Vortex 5 minutes	Score Roller Mixer
1	Cremophor® EL	20	2	1	2
2	Cremophor® EL	80	2	1	2
3	Cremophor® EL	100	2	1	2
4	Cremophor® EL	150	2	2	2
5	Cremophor® EL	200	2	2	2
6	Cremophor® EL	250	2	2	2
7	Cremophor® EL	300	2	2	2
8	Cremophor® EL	400	2	2	2
9	Cremophor® EL	500	2	2	2
10	Cremophor® EL	600	2	2	2
11	Cremophor® EL	700	2	2	2
12	Cremophor® EL	800	2	2	2
13	Cremophor® EL	900	2	2	2
14	Cremophor® EL	1000	2	2	2
15	Cremophor® EL	1200	2	2	2
16	Cremophor® EL Tween® 60	150 100	2	2	1
17	Cremophor® EL Brij® 30 Span® 85	40 20 20	2	2	2

18	Cremophor® EL	5	2	1	2
19	Cremophor® EL Tween® 80	60 70	2	1	2
20	Macrogolglyceroli Hydroxystearas 40	60	2	1	2
21	Macrogolglyceroli Hydroxystearas 40 Span® 20 Polysorbate 20	90 30 50	2	1	2
22	Macrogolglyceroli Hydroxystearas 40 Brij® 93 Polysorbate 20	60 30 60	2	1	2
23	Cremophor® EL Pluronic® F68 Brij® 92V Polysorbate 20	60 30 30 20	2	2	2

[0297] Emulsions 4-15 prepared in both artificial gastric juice and simulated intestinal fluid were homogenous (milky) for several hours when standing . Emulsions 1-3 separated somewhat after preparation (i.e., after several hours of standing). Microscopy of Emulsions 1-15 showed that the average particle size was less than 100 micrometers. Homogenization treatment (UltraRurrax(IKA)) of Emulsion 4 for 20 seconds resulted in a substantial increase of formation of small particles (< 10 microns).

[0298] Based on the preconcentrates prepared, a 0.5% non-ionic surfactant (e.g., Cremophor®) can emulsify EPA/DHA ethyl ester in both artificial gastric juice and simulated intestinal fluid. In addition, including more than one surfactant appears to stabilize the emulsion. Further, the particle size can vary depending upon the emulsification method.

[0299] **Example 20: Gelatin capsules coated with cellulose acetate phthalate**

[0300] (A) Gelatin capsules comprising EPA ethyl ester and DHA ethyl ester coated with cellulose acetate phthalate

[0301] Preformed gelatin capsules comprising EPA ethyl ester and DHA ethyl ester (Omacor®, Pfizer, Norway) were coated by a solution of cellulose acetate phthalate (6%) and triethyl citrate (3%) in acetone. The capsules were dried for 24 hour at room temperature. The coating material (cellulose acetate phthalate plus triethyl citrate) on one capsule increased the capsule weight by 15 mg.

[0302] (B) Gelatin capsules comprising EPA ethyl, DHA ethyl ester and Brij® 96V coated with cellulose acetate phthalate

[0303] Preformed gelatin capsules comprising EPA ethyl ester (463 mg), DHA ethyl ester (375 mg), Brij® 96V (60 mg) and tocoferol (4 mg) were coated by a solution of cellulose acetate phthalate (6%) and triethyl citrate (3%) in acetone. The capsules were dried for 24 hour at room temperature.

[0304] **Example 21: Gelatin capsules coated with Eudragit® RS30D**

[0305] (A) Gelatin capsules comprising EPA ethyl ester and DHA ethyl ester coated with Eudragit® RS30D

[0306] Preformed gelatin capsules comprising EPA ethyl ester and DHA ethyl ester (Omacor®, Pfizer, Norway) were coated by an aqueous solution of Euragit® RS30D from Degussa, Germany. The capsules were dried for 24 hour at room temperature.

[0307] (B) Gelatin capsules comprising EPA ethyl ester, DHA ethyl ester and Brij® 96V coated with Eudragit® RS30D

[0308] Preformed gelatin capsules comprising EPA ethyl ester (463 mg), DHA ethyl ester (375 mg), Brij® 96V (60 mg) and tocopherol (4 mg) were coated by an aqueous solution of Euragit® RS30D from Degussa, Germany. The capsules were dried for 24 hour at room temperature.

[0309] **Example 22: Enteric coated tablets**

[0310] Coated tablets were prepared and administered to a animal model (mini-pig) to measure EPA and DHA blood serum levels over time.

[0311] Two tablets were pre-treated as follows:

[0312] Tablet 31: 20% PEG, 10% Ac-Di-Sol® (disintegrant)

[0313] Tablet 32: 20% PEG, 0.5 M KH₂PO₄, 10% Ac-Di-Sol (disintegrant)

[0314] Pre-treatments were performed in a fluid-bed where the solutions were sprayed on Neusilin granules followed by heating and/or compressing the granules and incubation in Nitrogen over night before loading with K85EE oil.

[0315] Tablets were coated with an inner layer of an aqueous PVA sub-coating (Opadry® II) and an outer layer of an aqueous enteric coating (Acyl EZE (Eudragit® L100-55 enteric coating).

[0316] Results for EPA blood serum levels appear in Table 35 and illustrated in FIG 38. Results for DHA blood serum levels appear in Table 36 and illustrated in FIG 39.

Table 35: EPA blood serum levels

EPA	AUC [µg/ml] dose normalised **	AUC difference compared to K85EE oil
Tablet 31	770,2	8 %
Tablet 32	672,0	-6 %
K85EE oil	708,7	reference

**AUC data not baseline corrected.

Table 36: DHA blood serum levels

DHA	AUC [µg/ml] dosenormalised **	AUC difference compared to K85EE oil
Tablet 31	718,1	44 %
Tablet 32	479,4	-4 %
K85EE oil	498,8	reference

**AUC data not baseline corrected.

[0317] The tablets according to the present disclosure may be pre-loaded with a pre-concentrate chosen from a K85EE oil + FFA + at least one surfactant (e.g.

WO 2011/048493

PCT/IB2010/002854

Tween® 20 or Tween® 80), a K85FA oil + at least one surfactant, and K85EE + at least one surfactant.

WHAT IS CLAIMED IS:

1. A preconcentrate comprising:
a fatty acid oil mixture comprising at least 75% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in free acid form; and
at least one nonionic surfactant;
wherein the preconcentrate does not comprise an additional active pharmaceutical ingredient other than the fatty acid oil mixture.
2. The preconcentrate according to claim 1, wherein the preconcentrate comprises from about 300 mg to about 400 mg of DHA and from about 400 mg to about 500 mg of EPA.
3. A preconcentrate comprising:
a fatty acid oil mixture comprising from about 25% to about 75% eicosapentaenoic acid (EPA) and docosahexaenoic acid (DHA), by weight of the fatty acid oil mixture, wherein the EPA and DHA are in free acid form; and
at least one nonionic surfactant;
wherein the preconcentrate does not comprise an active pharmaceutical ingredient.
4. The preconcentrate according to any one of claims 1 and 3, wherein the EPA and DHA are present in the fatty acid oil mixture at a weight ratio ranging from about 1:10 to about 10:1, from about 1:8 to about 8:1, from about 1:7 to about 7:1, from about 1:6 to about 6:1, from about 1:5 to about 5:1, from about 1:4 to about 4:1, from about 1:3 to about 3:1, from about 1:2 to about 2:1, from about 1:1 to about 2:1, or from about 1:2 to about 1:3.
5. The preconcentrate according to any one of claims 1 and 3, further comprising at least one antioxidant.
6. The preconcentrate according to any one of claims 1 and 3, wherein the at least one nonionic surfactant is polysorbate 20, polysorbate 40, polysorbate 60, polysorbate 80, or a mixture thereof.

7. The preconcentrate according to any one of claims 1 and 3, wherein the EPA and DHA are present in the fatty acid oil mixture at a weight ratio ranging from about 1:2 to about 2:1.
8. The preconcentrate according to claim 3, wherein the fatty acid oil mixture comprises from about 30% to about 75% EPA and DHA by weight of the fatty acid oil mixture.
9. The preconcentrate according to claim 3, wherein the fatty acid oil mixture comprises from about 30% to about 70% EPA and DHA by weight of the fatty acid oil mixture.
10. The preconcentrate according to claim 3, wherein the fatty acid oil mixture comprises from about 30% to about 65% EPA and DHA by weight of the fatty acid oil mixture.
11. The preconcentrate according to any one of claims 1 and 3, wherein the at least one nonionic surfactant comprises polysorbate 20 and polysorbate 80.
12. The preconcentrate according to claim 1, wherein the preconcentrate is in a gelatin capsule or a tablet form, and further wherein the gelatin capsule or tablet comprises at least one coating and does not comprise an additional active pharmaceutical ingredient other than the fatty acid oil mixture.
13. The preconcentrate according to claim 12, wherein the preconcentrate comprises from about 300 mg to about 400 mg of DHA and from about 400 mg to about 500 mg of EPA.
14. The preconcentrate according to claim 3, wherein the preconcentrate is in a gelatin capsule or a tablet form, and further wherein the gelatin capsule or tablet comprises at least one coating and does not comprise an active pharmaceutical ingredient.
15. The preconcentrate according to any one of claims 12 and 14, wherein the EPA and DHA are present in the fatty acid oil mixture at a weight ratio ranging from about 1:10 to about 10:1, from about 1:8 to about 8:1, from about 1:7 to about 7:1, from about 1:6 to about 6:1, from about 1:5 to about 5:1, from about 1:4 to about 4:1, from about 1:3 to about 3:1, from about 1:2 to about 2:1, from about 1:1 to about 2:1, or from about 1:2 to about 1:3.

16. The preconcentrate according to any one of claims 12 and 14, further comprising at least one antioxidant.
17. The preconcentrate according to any one of claims 12 and 14, wherein the at least one coating is an enteric coating, a sub-layer, a top-layer, or a combination thereof.
18. The preconcentrate according to any one of claims 12 and 14, wherein the at least one coating comprises at least one enteric coating, at least one enteric coating and at least one top-layer above the enteric coating, or at least one enteric coating and at least one sub-layer between the gelatin capsule wall and the enteric coating.
19. The preconcentrate according to claim 18, wherein the at least one sub-layer comprises a sealant.
20. The preconcentrate according to claim 17, wherein the at least one coating comprises at least one material, wherein the at least one material is gelatin, a film-forming agent, a polymer, a copolymer between methacrylic acid and methyl methacrylate, a copolymer between methacrylic acid and methyl acrylate, a copolymer between methacrylic acid and ethyl methacrylate, a copolymer between methacrylic acid and ethyl acrylate, cellulose acetate phthalate, hydroxypropyl methyl cellulose phthalate, hydroxypropyl methyl cellulose acetate succinate, polyvinyl acetate phthalate, or a mixture thereof.
21. The preconcentrate according to claim 17, wherein the at least one coating is pH-dependent or pH-independent.
22. The preconcentrate according to claim 17, wherein the at least one coating comprises at least one plasticizer, wherein the at least one plasticizer is triethyl citrate, triacetin, polyethylene glycol, propylene glycol, a phthalate, sorbitol, glycerin, or a mixture thereof.
23. The preconcentrate according to claim 17, wherein the gelatin capsule is a hard capsule or a soft capsule.

24. The preconcentrate according to claim 17, wherein the gelatin capsule fill content ranges from about 0.400 g to about 1.300 g, from about 0.600 g to about 1.200 g, or from about 0.800 g to about 1.000 g.
25. The preconcentrate according to claim 17, wherein the gelatin capsule or tablet releases less than 30% of the total EPA and DHA in the stomach.
26. The preconcentrate according to any one of claims 12 and 14, wherein the at least one nonionic surfactant is polysorbate 20, polysorbate 40, polysorbate 60, polysorbate 80, or a mixture thereof.
27. The preconcentrate according to any one of claims 12 and 14, wherein the EPA and DHA are present in the fatty acid oil mixture at a weight ratio ranging from about 1:2 to about 2:1.
28. The preconcentrate according to claim 14, wherein the fatty acid oil mixture comprises from about 30% to about 75% EPA and DHA by weight of the fatty acid oil mixture.
29. The preconcentrate according to claim 14, wherein the fatty acid oil mixture comprises from about 30% to about 70% EPA and DHA by weight of the fatty acid oil mixture.
30. The preconcentrate according to claim 14, wherein the fatty acid oil mixture comprises from about 30% to about 65% EPA and DHA by weight of the fatty acid oil mixture.
31. The preconcentrate according to any one of claims 12 and 14, wherein the at least one nonionic surfactant comprises polysorbate 20 and polysorbate 80.

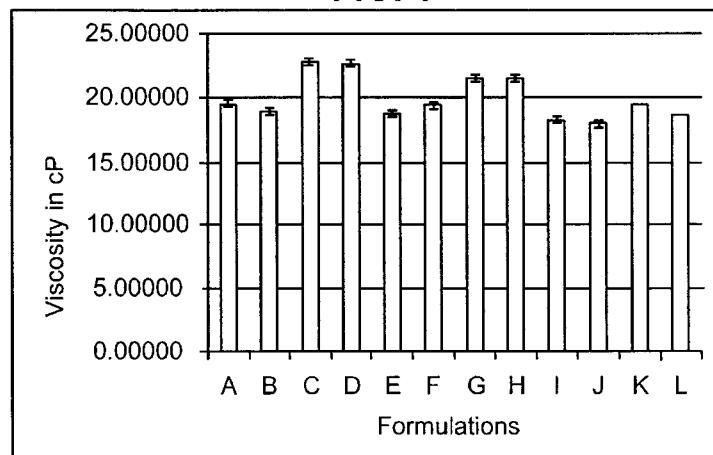
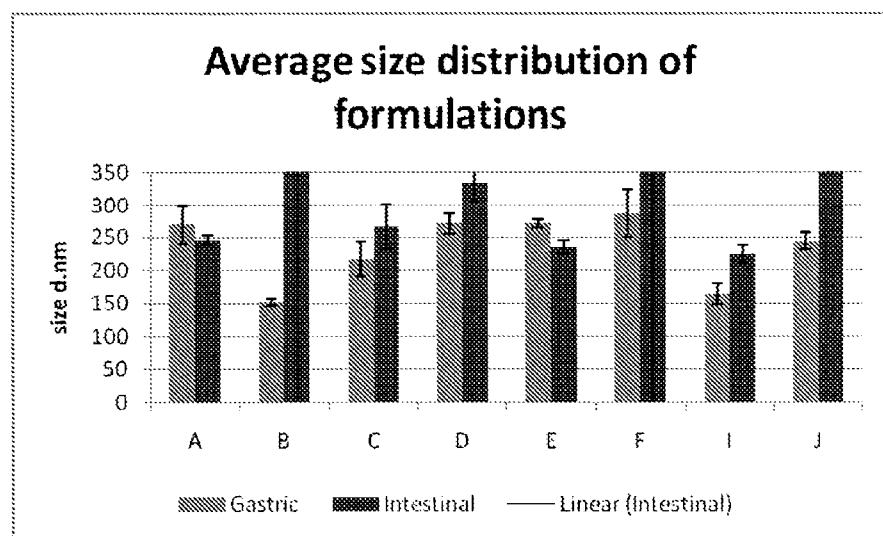
FIG. 1**FIG. 2**

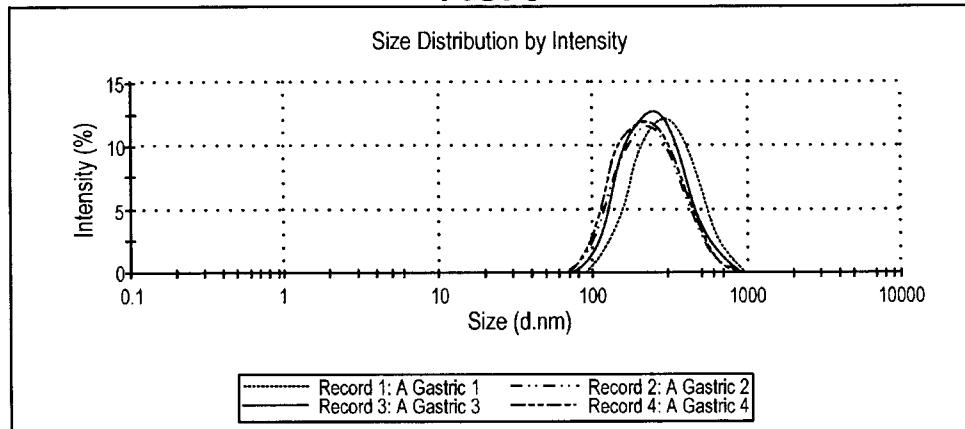
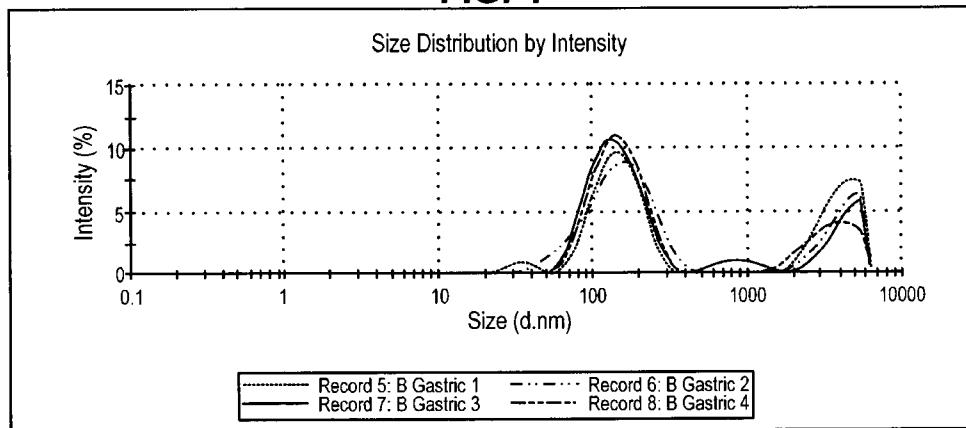
FIG. 3**FIG. 4**

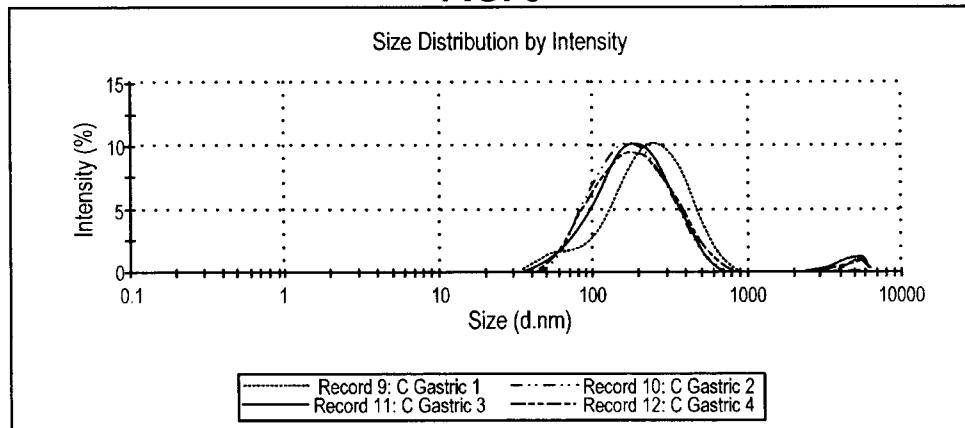
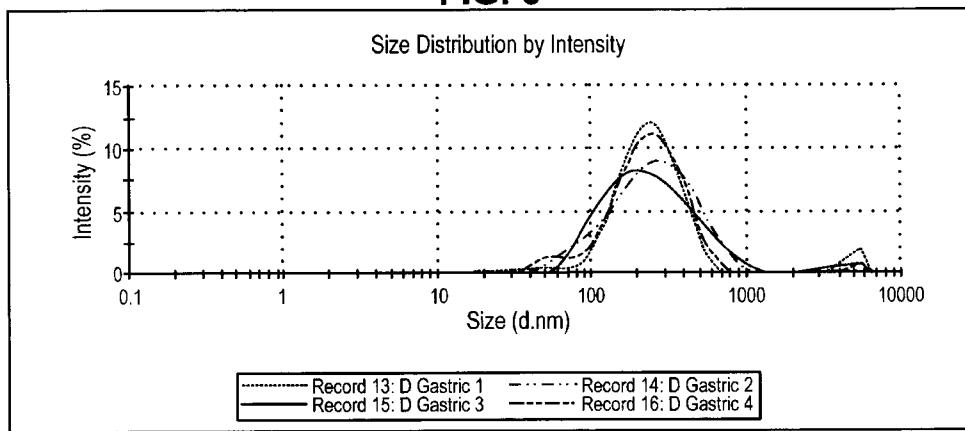
FIG. 5**FIG. 6**

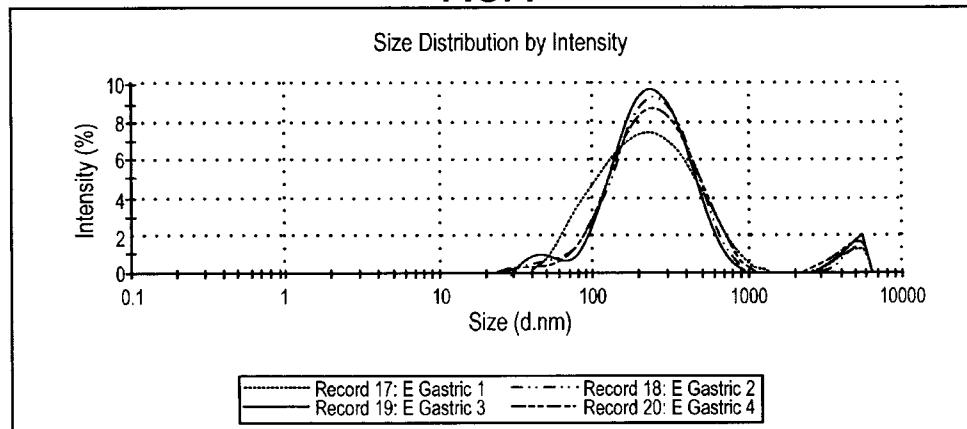
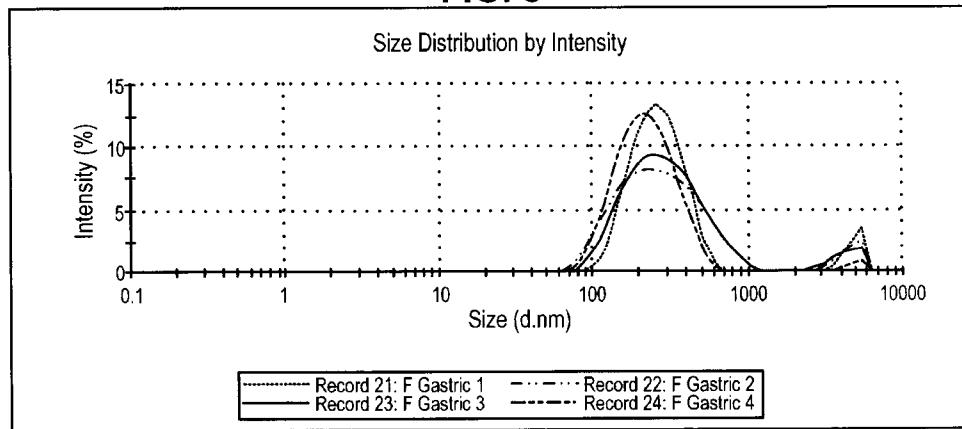
FIG. 7**FIG. 8**

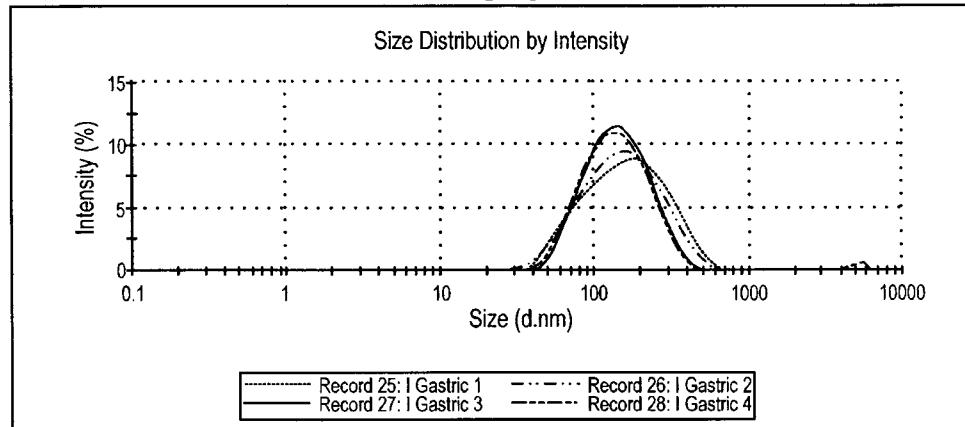
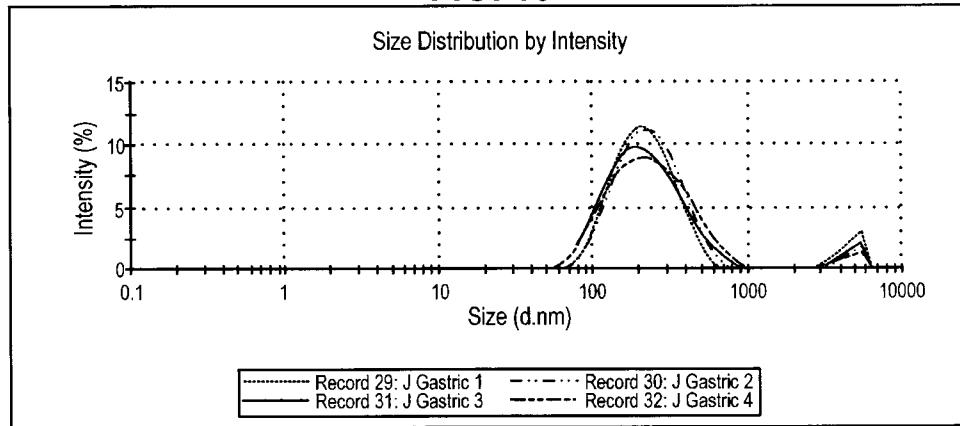
FIG. 9**FIG. 10**

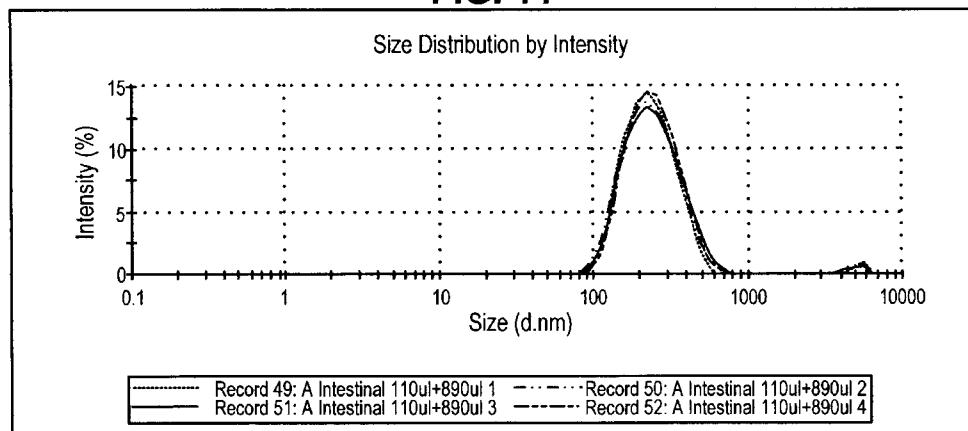
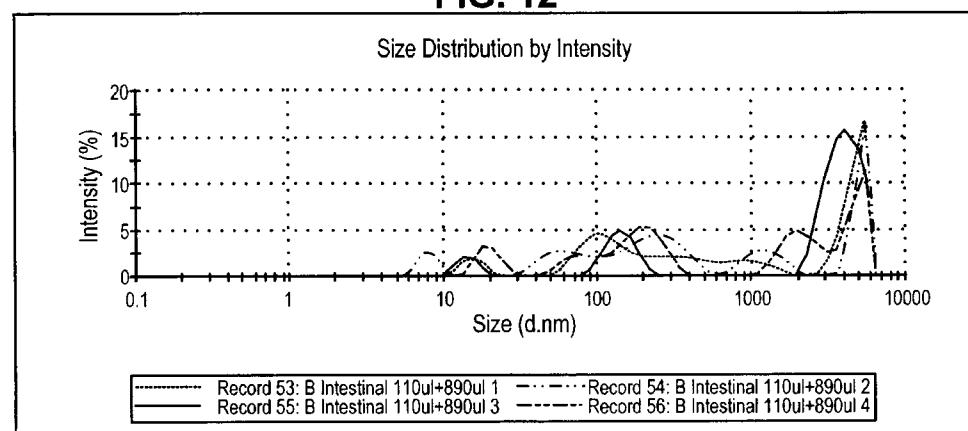
FIG. 11**FIG. 12**

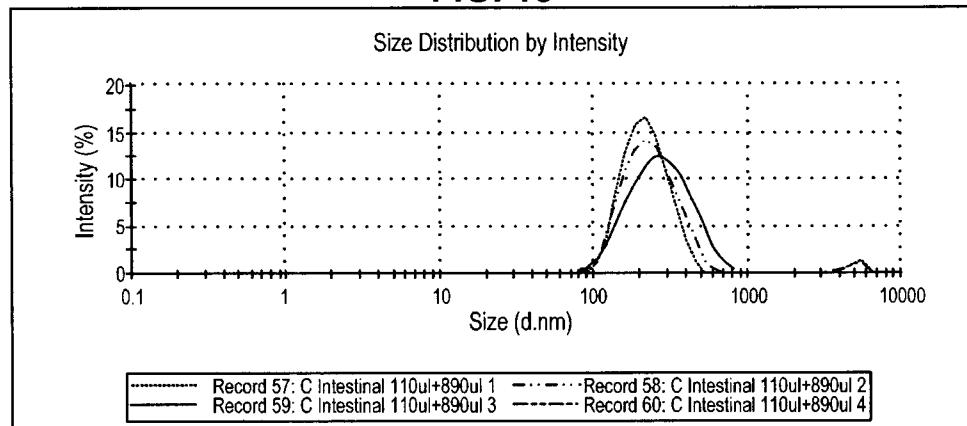
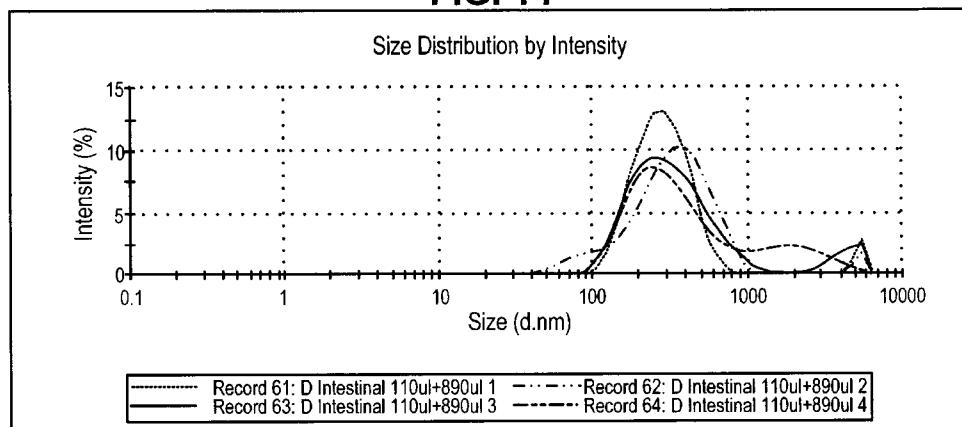
FIG. 13**FIG. 14**

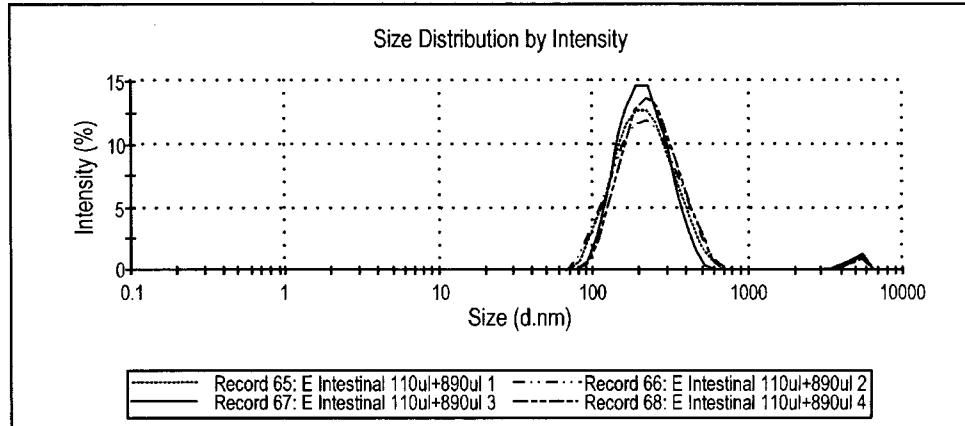
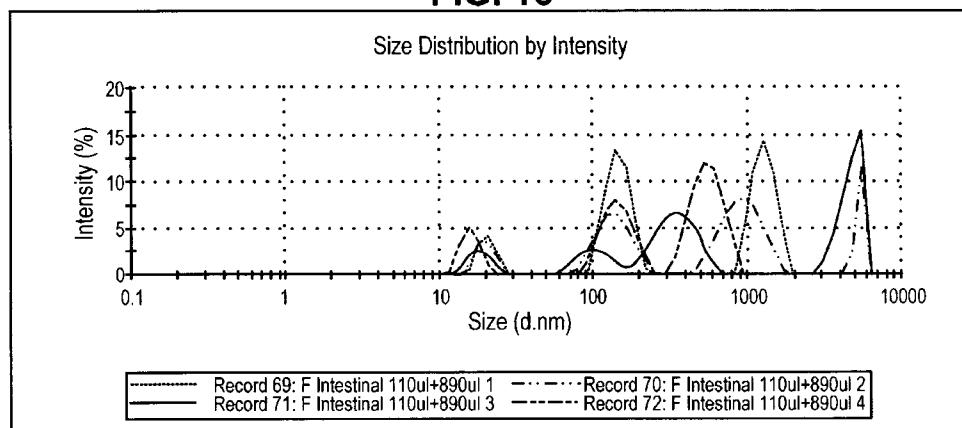
FIG. 15**FIG. 16**

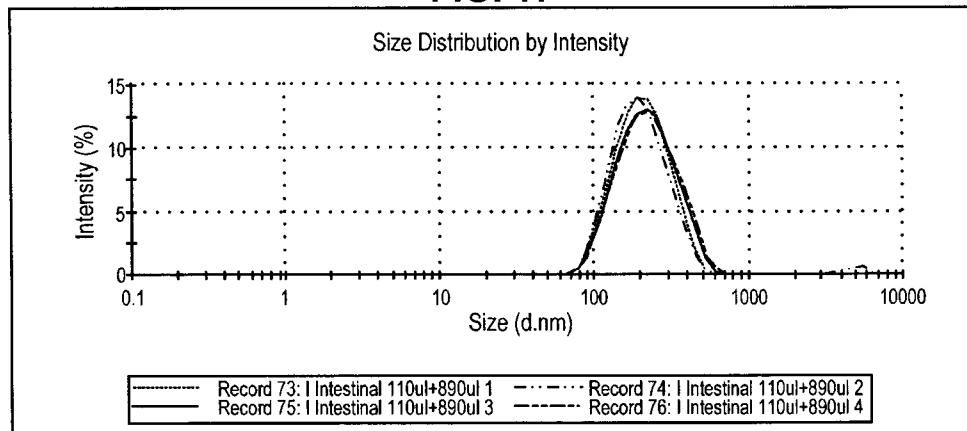
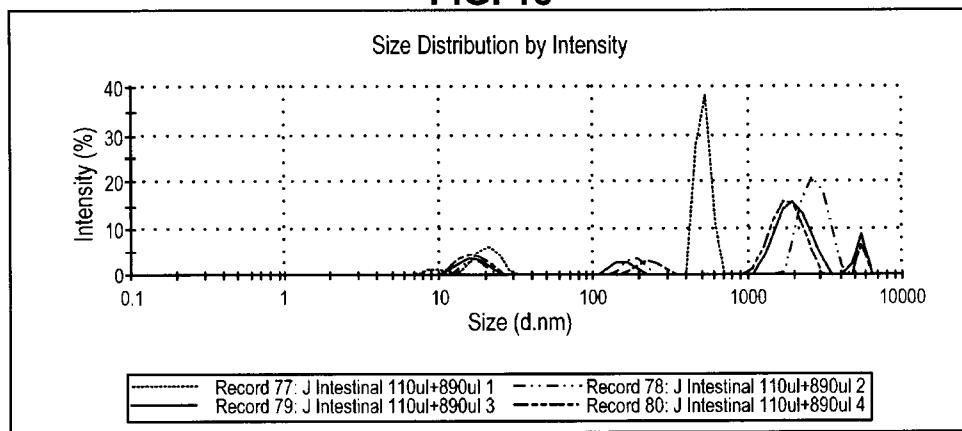
FIG. 17**FIG. 18**

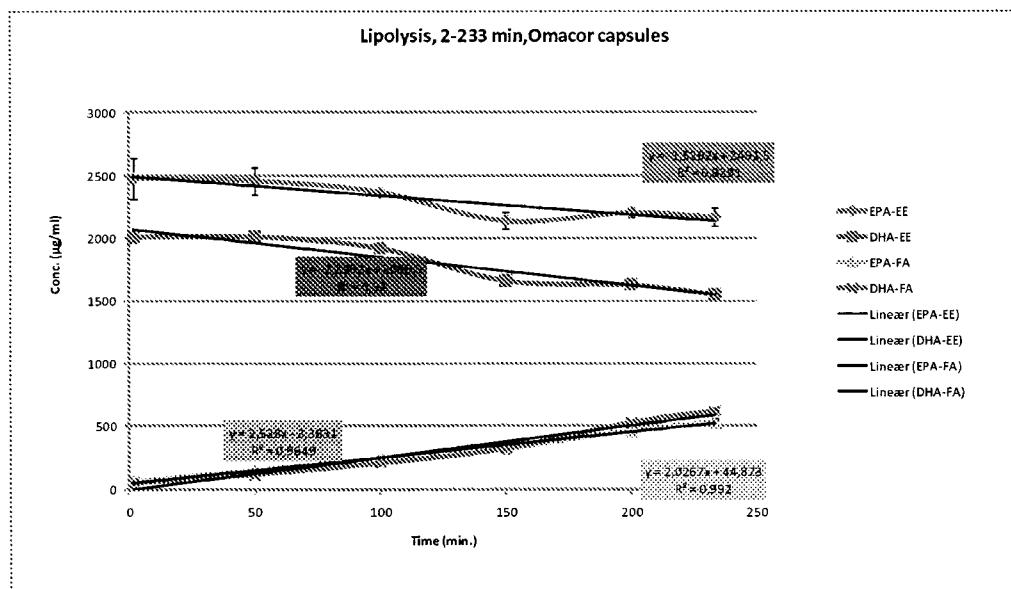
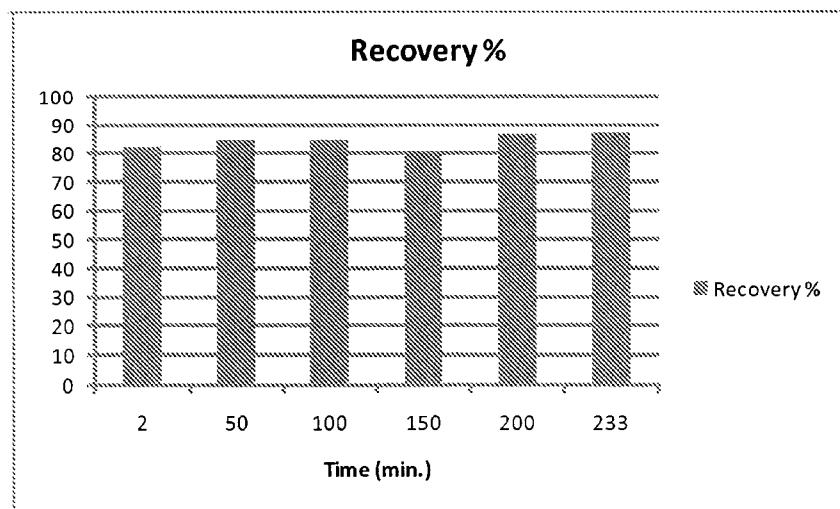
FIG. 19**FIG. 20**

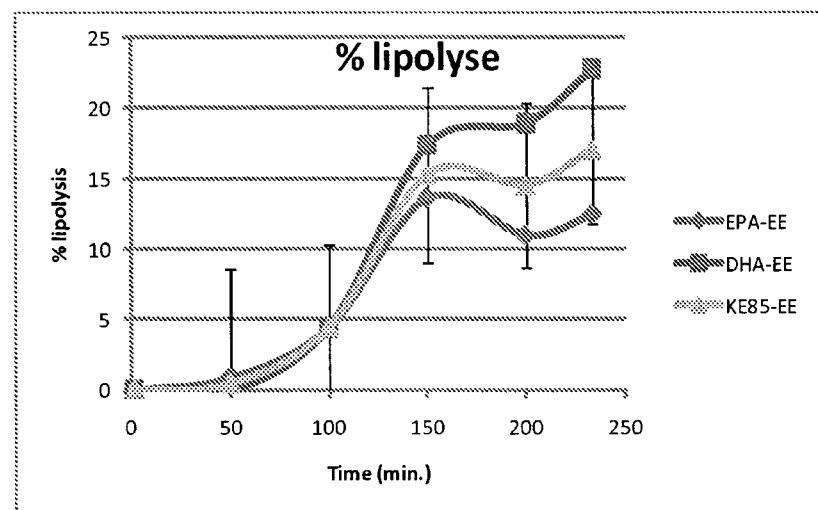
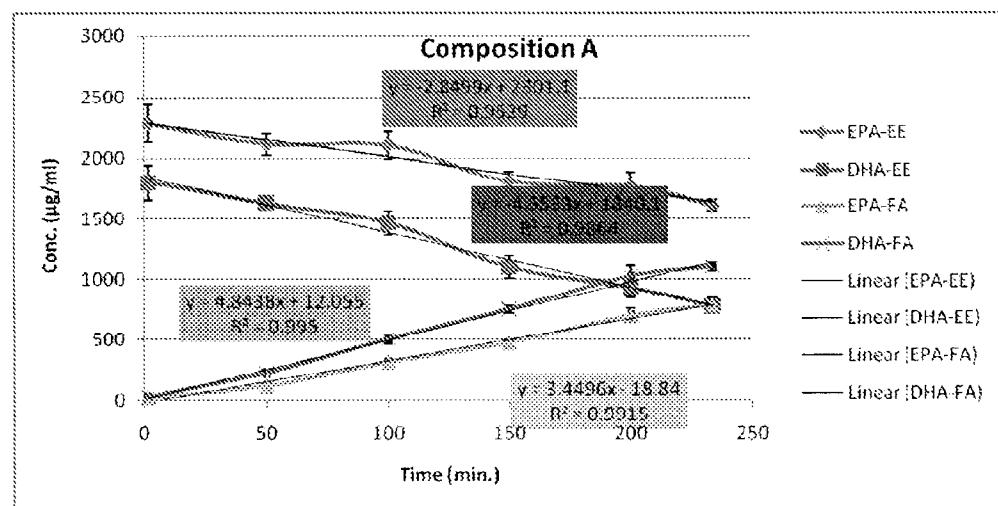
FIG. 21**FIG. 22**

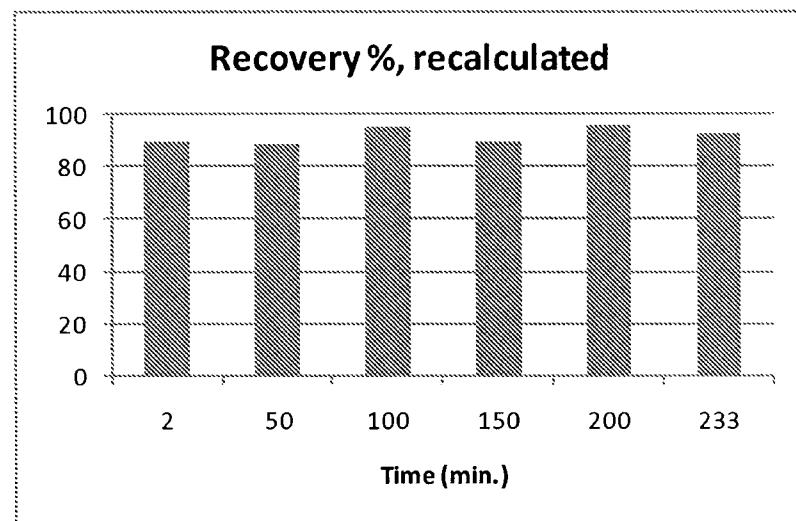
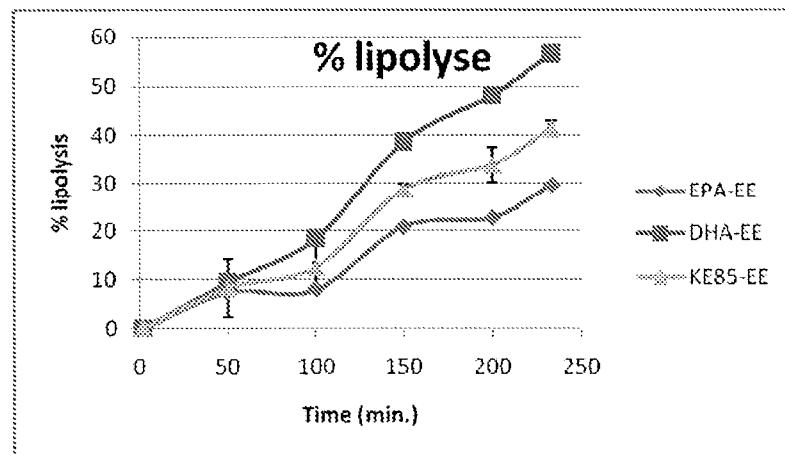
FIG. 23**FIG. 24**

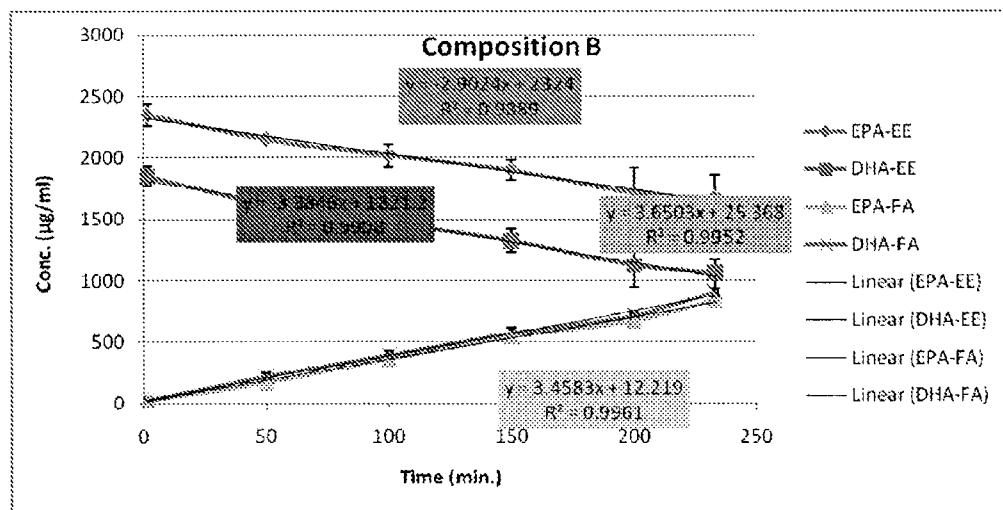
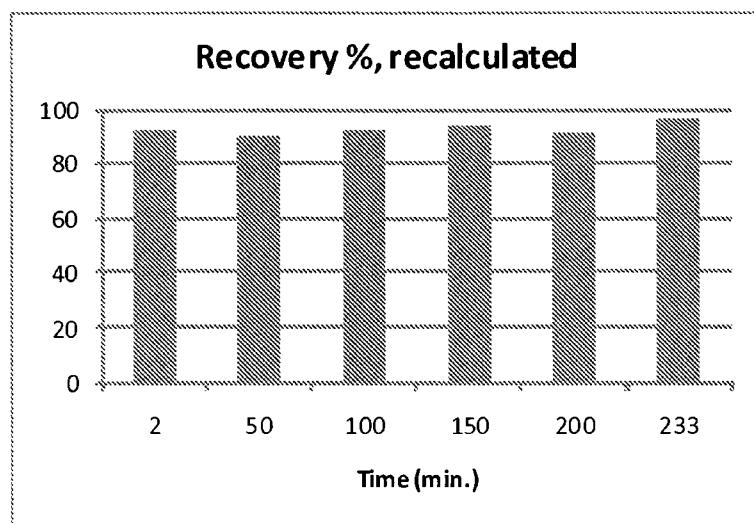
FIG. 25**FIG. 26**

FIG. 27

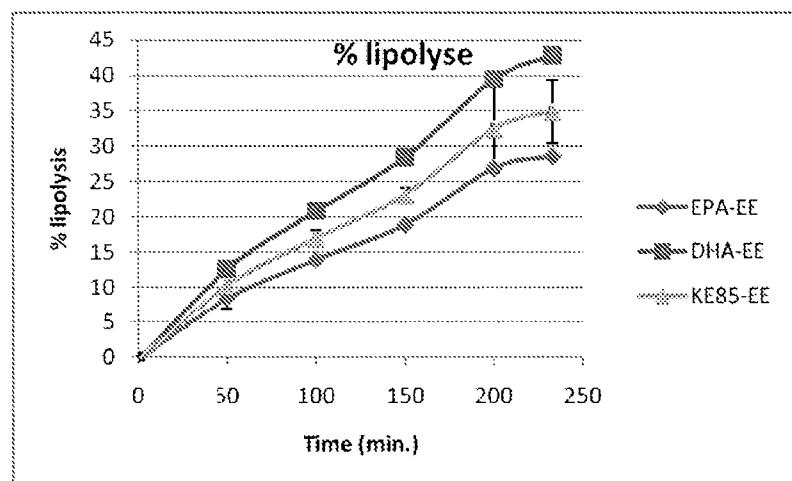


FIG. 28

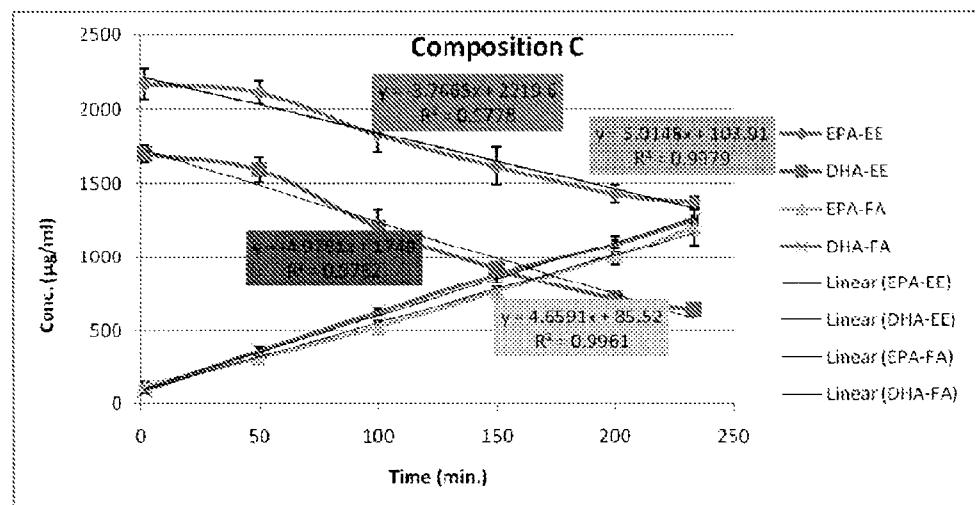


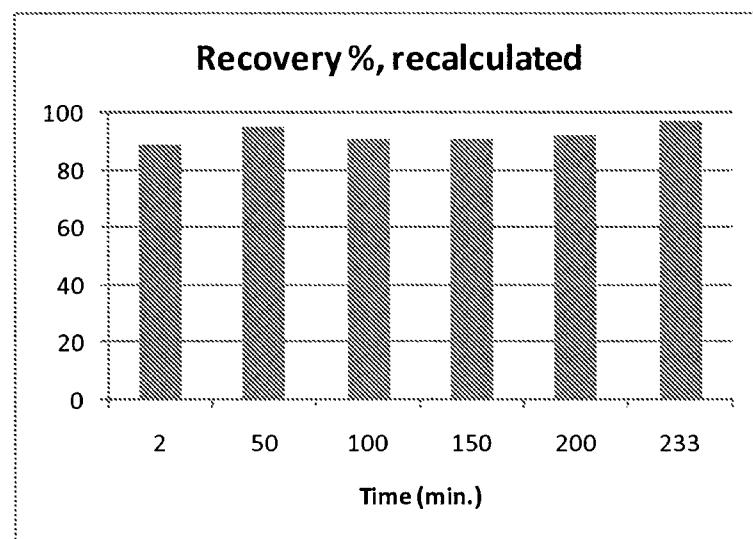
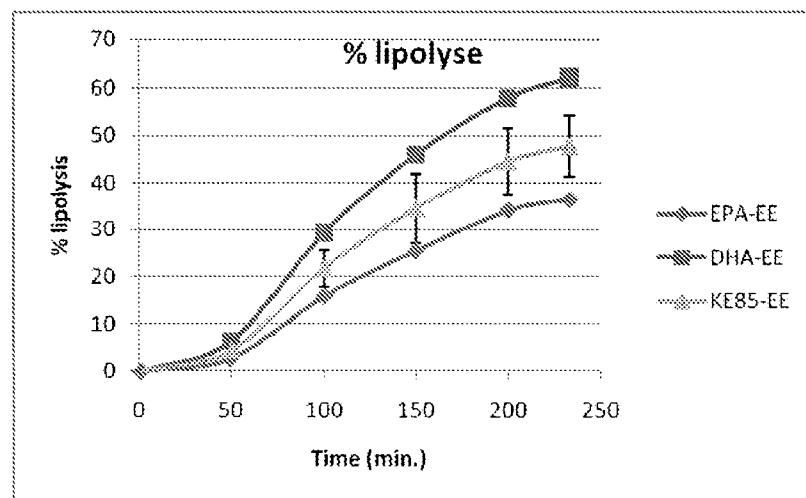
FIG. 29**FIG. 30**

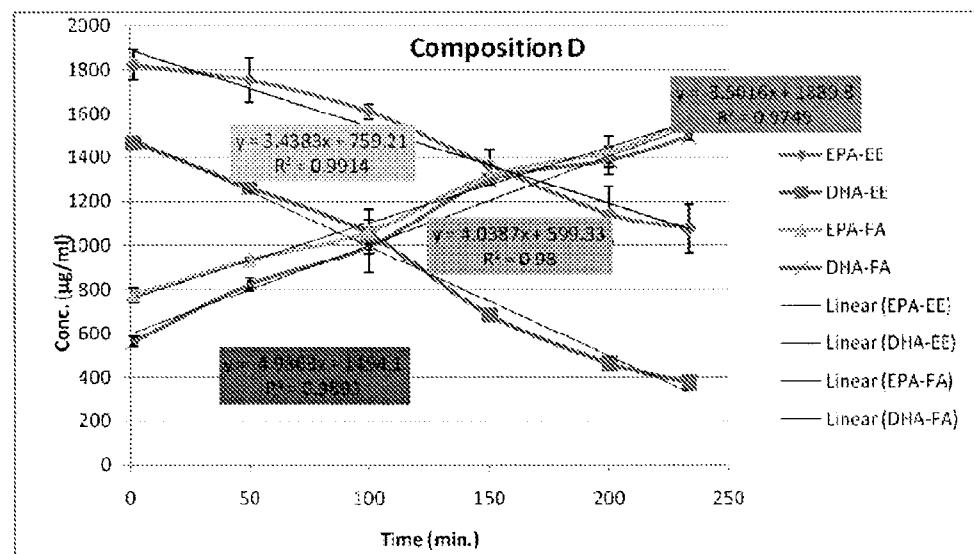
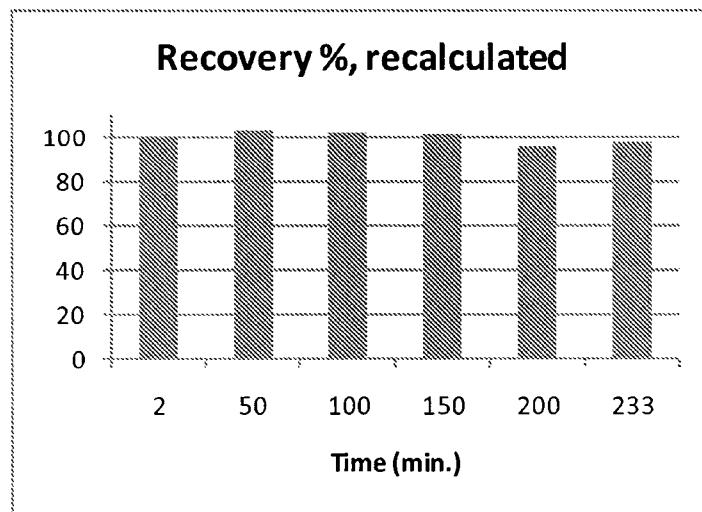
FIG. 31**FIG. 32**

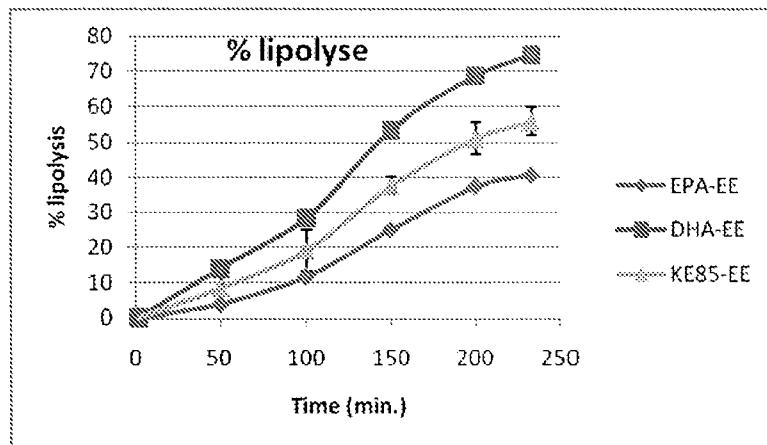
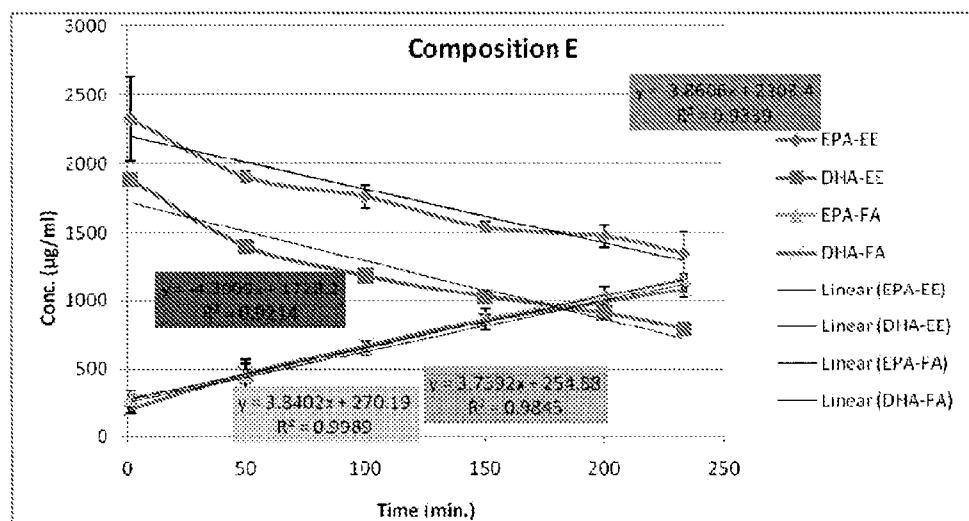
FIG. 33**FIG. 34**

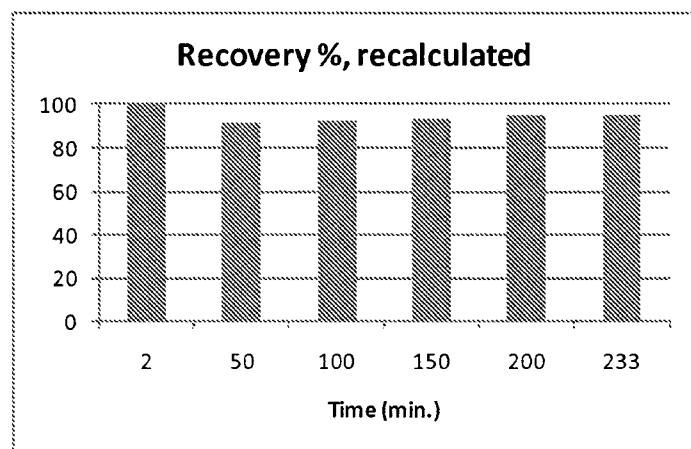
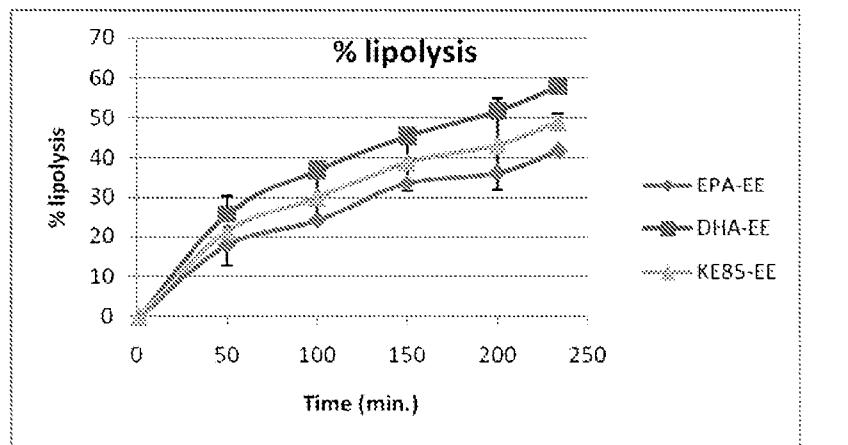
FIG. 35**FIG. 36**

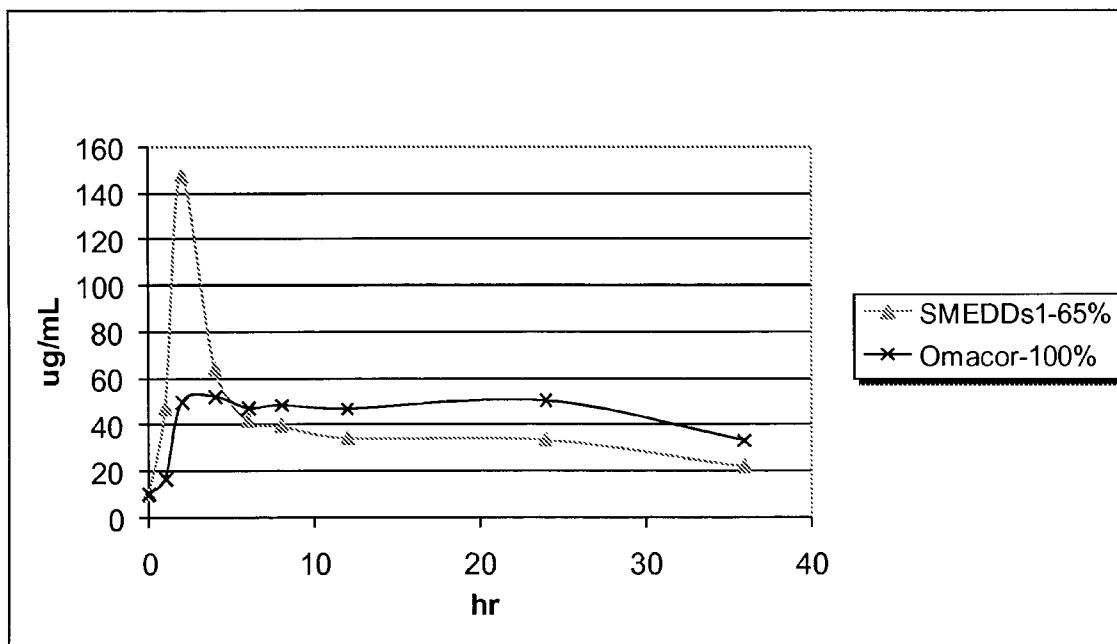
FIG. 37

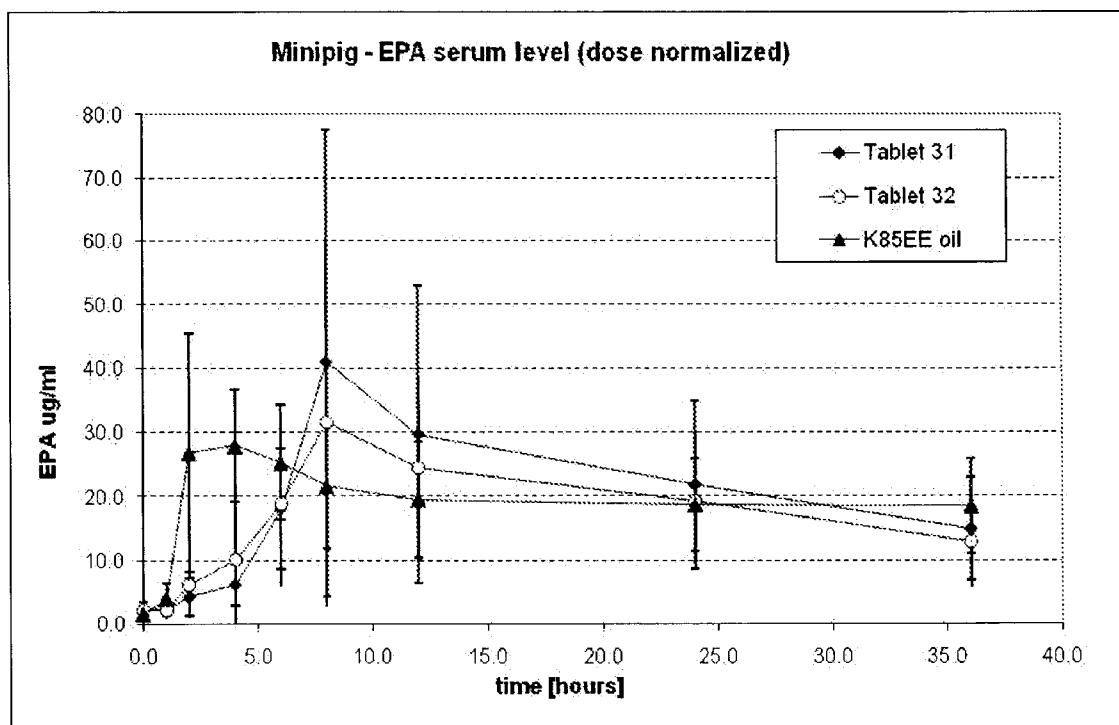
FIG. 38

FIG. 39