

(19) **DANMARK**



Patent- og
Varemærkestyrelsen

(10) **DK/EP 2968155 T3**

(12) **Oversættelse af
europæisk patentskrift**

-
- (51) Int.Cl.: **A 61 K 9/28 (2006.01)** **A 61 K 9/48 (2006.01)** **A 61 K 31/519 (2006.01)**
A 61 P 1/04 (2006.01) **A 61 P 17/06 (2006.01)** **A 61 P 19/02 (2006.01)**
A 61 P 37/06 (2006.01)
- (45) Oversættelsen bekendtgjort den: **2021-04-19**
- (80) Dato for Den Europæiske Patentmyndigheds bekendtgørelse om meddelelse af patentet: **2021-03-03**
- (86) Europæisk ansøgning nr.: **14726410.5**
- (86) Europæisk indleveringsdag: **2014-03-12**
- (87) Den europæiske ansøgnings publiceringsdag: **2016-01-20**
- (86) International ansøgning nr.: **IB2014059689**
- (87) Internationalt publikationsnr.: **WO2014147526**
- (30) Prioritet: **2013-03-16 US 201361802479 P** **2013-08-09 US 201361864059 P**
2014-01-31 US 201461934428 P
- (84) Designerede stater: **AL AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO RS SE SI SK SM TR**
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- (54) Benævnelse: **Orale tofacitinib-doseringsformer med langvarig frigivelse**
- (56) Fremdragne publikationer:
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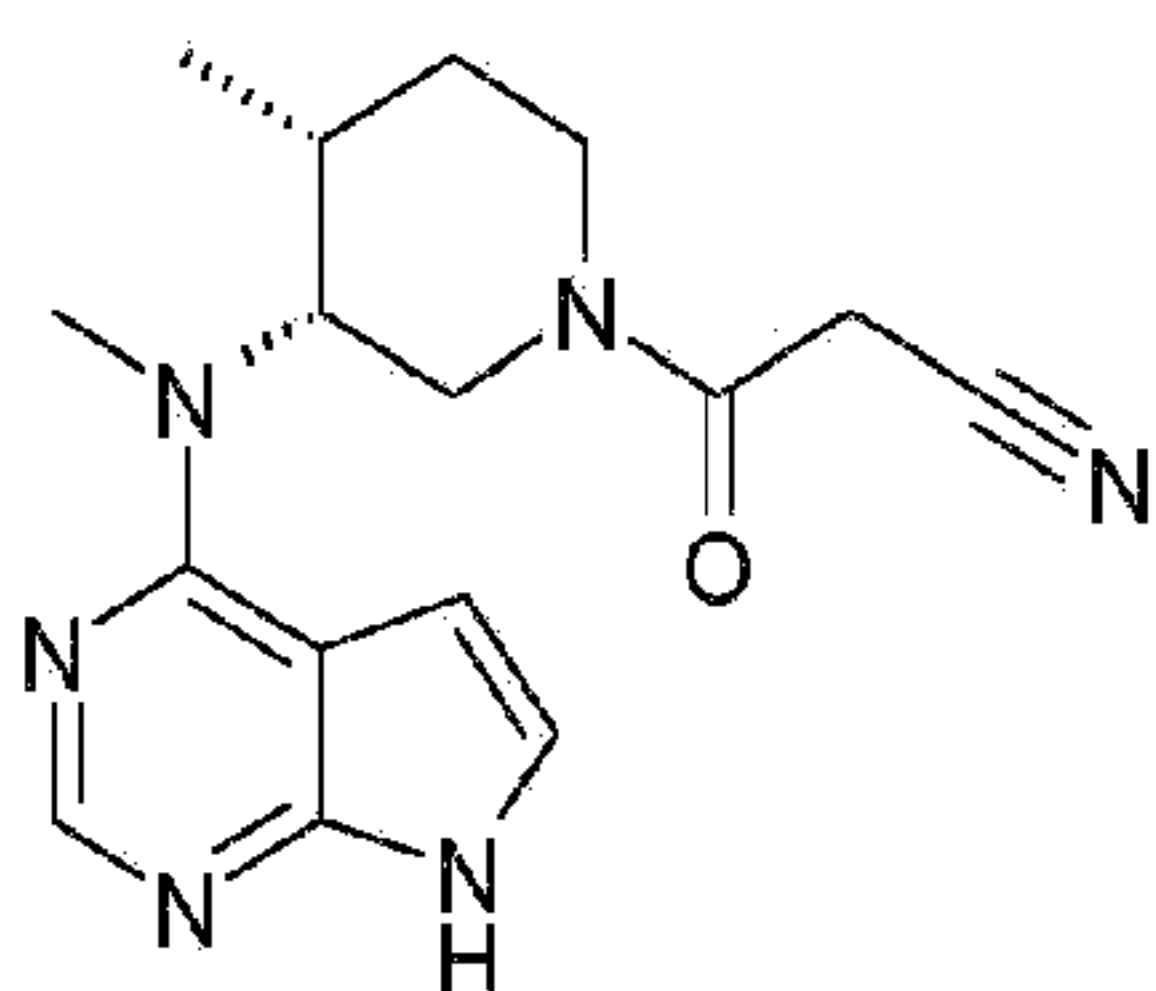
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DESCRIPTION

[0001] The present invention relates to oral sustained release compositions of 3-((3R, 4R)-4-methyl - 3 - [methyl-(7H-pyrrolo[2,3-d]pyrimidin-4-yl)-amino] - piperidin - 1-yl)-3-oxopropionitrile (hereinafter tofacitinib), which is useful as an inhibitor of protein kinases, such as the enzyme Janus Kinase (JAK) and as such are useful therapy as immunosuppressive agents for organ transplants, xeno transplantation, lupus, multiple sclerosis, rheumatoid arthritis, psoriasis, psoriatic arthritis, Type I diabetes and complications from diabetes, cancer, asthma, atopic dermatitis, autoimmune thyroid disorders, ulcerative colitis, ankylosing spondylitis, juvenile idiopathic arthritis Crohn's disease, Alzheimer's disease, Leukemia, and other indications where immunosuppression would be desirable. The invention provides sustained release formulations comprising tofacitinib or pharmaceutically acceptable salts thereof. The formulations described herein have desirable pharmacokinetic characteristics. Examples include AUC, C_{max} , dose-adjusted AUC, dose-adjusted C_{max} , and fed/fasted AUC and C_{max} ratios.

BACKGROUND OF THE INVENTION

[0002] Tofacitinib, 3-((3R, 4R)-4-methyl - 3 - [methyl-(7H-pyrrolo[2,3-d]pyrimidin-4-yl)-amino] - piperidin - 1-yl)-3-oxopropionitrile, has the chemical formula $C_{16}H_{20}N_6O$ and the following structural formula



[0003] The term "tofacitinib" should be understood, unless otherwise indicated herein, to include any pharmaceutically acceptable form and salts of the compound. Tofacitinib may be present in a crystalline or amorphous form. Tofacitinib, salts of tofacitinib, methods for synthesizing tofacitinib, certain polymorphs of tofacitinib, and certain uses of tofacitinib are disclosed in WO01/42246, WO02/096909, and WO03/048162.

[0004] Tofacitinib is generally known to be useful as an inhibitor of protein kinases, such as the enzyme Janus Kinase (JAK) and as such is a useful therapy as immunosuppressive agent for organ transplants, xeno transplantation, lupus multiple sclerosis, rheumatoid arthritis, psoriasis, psoriatic arthritis, Type I diabetes and complications from diabetes, cancer, asthma, atopic dermatitis, autoimmune thyroid disorders, ulcerative colitis, Crohn's disease, Alzheimer's disease, Leukemia and other indications where immunosuppression would be desirable.

[0005] Tofacitinib is being developed as an immediate release tablet form with doses ranging from 5 mg to 10 mg administered BID (two times a day). Tofacitinib, as the citrate salt of tofacitinib, is approved in the US under the brand XELJANZ™. Pharmaceutical dosage forms of tofacitinib are known and described in WO01/42246, WO02/096909, and WO03/048162. In addition, WO2012/100949 purports to describe a modified release formulation of tofacitinib. While WO2012/100949 mentions that tofacitinib might be formulated in a modified release formulation, desirable pharmacokinetic characteristics have not been disclosed.

[0006] While the commercial immediate release tablet dosage form provides efficacious blood levels of tofacitinib to subjects (dictated by the average blood plasma concentration of tofacitinib, C_{ave} , over a 24 hour period), it may be possible to reduce the number of dosings to once daily (QD) with a sustained-release dosage form of tofacitinib while maintaining consistent therapeutic effect, thus enhancing convenience and potentially improving compliance.

[0007] Sustained-release dosage forms are typically designed to provide the longest possible duration of release, to minimize: 1) the fluctuations in blood plasma concentration during the dosing interval (i.e. the ratio of the maximum blood plasma concentration, $C_{max,ss}$, to the minimum blood plasma concentration, $C_{min,ss}$, during the dosing interval), and 2) the amount of drug required to achieve the desired therapeutic effect, for the purpose of improving the safety and tolerability profile. For example, WO2012/100949 purports to describe a modified release formulation of tofacitinib having the advantage that tofacitinib is gradually released over a relatively long period at a uniform concentration, which results in little blood level fluctuation in the patient.

[0008] However, it was surprisingly found that the bioavailability of tofacitinib is reduced as the duration of release is prolonged, thereby requiring increased amounts of tofacitinib to be administered in the sustained release dosage form to provide efficacious blood levels to subjects.

[0009] In addition, the pharmacokinetic profile of the BID immediate release tablets contains periods during a 24 hour time period beneath the IC50 for the JAK1/3 heterodimer signaling ("Drug Holiday"), due to the combination of total drug absorbed and the ratio of the maximum blood plasma concentration, $C_{max,ss}$, to the minimum blood plasma concentration, $C_{min,ss}$, during the dosing interval. Tofacitinib is a selective inhibitor of the Janus kinase (JAK) family of kinases with a high degree of selectivity against other kinases in the human genome. In kinase assays, tofacitinib inhibits JAK1, JAK2, JAK3, and to a lesser extent tyrosine kinase (Tyk2). In cellular settings, where JAK kinases signal in pairs, tofacitinib preferentially inhibits cytokines that signal through JAK3 and/or JAK1 including interleukin (IL)-2, -4, -6, -7, -9, -15, -21, and type I and II interferons. These cytokines are pro-inflammatory and integral to lymphocyte function. Inhibition of their signaling may thus result in modulation of multiple aspects of the immune response. Over inhibition of signaling through JAK3 and/or JAK1 could compromise the body's immune system.

[0010] It was surprisingly found that the drug holiday period of tofacitinib relative to the IC₅₀ for JAK1/3 signaling during a 24 time period is increased as the release duration from a sustained release dosage form is prolonged. As such, sustained release dosage forms, as described in the prior art, containing tofacitinib would not provide drug holiday periods comparable to the PK profile of the BID immediate release tablets, due to the reduced blood plasma concentrations of tofacitinib exhibited by sustained release dosage forms, as described by the prior art. Accordingly, it was surprisingly found that to provide the optimal PK profile (i.e. optimal exposure and optimal $C_{\max,ss}/C_{\min,ss}$ ratio while avoiding elevated levels of the maximum blood plasma concentration) for once-daily administration of tofacitinib, dosage forms with shorter durations of sustained release are preferred. It was also surprisingly found that to minimize the total dose of tofacitinib administered to subjects while providing efficacious blood levels in subjects, dosage forms with shorter durations of sustained release are preferred.

SUMMARY OF THE INVENTION

[0011] The invention is defined by the claims. Any subject-matter falling outside the scope of the claims is provided for information purposes only. The present invention relates to oral sustained release compositions of tofacitinib as defined in the appended claims for the treatment of anti-inflammatory and auto-immune diseases, and especially Rheumatoid Arthritis (RA). Sustained release of tofacitinib is accomplished by the use of osmotic dosage forms.

[0012] The compositions of the present invention are once daily pharmaceutical dosage forms comprising tofacitinib, or a pharmaceutically acceptable salt thereof wherein said dosage forms are sustained release dosage forms, and when administered to a subject achieve a mean area under the plasma concentration versus time curve following administration from about 27 ng-hr/mL per mg of tofacitinib dosed to about 42 ng-hr/mL per mg of tofacitinib dosed and a ratio of geometric mean plasma C_{max} to C_{min} from about 10 to about 100, preferably a ratio of geometric mean plasma C_{max} to C_{min} from about 20 to about 40 and more preferably from about 20 to about 30. The pharmaceutical dosage form may comprise from about 10 mg to about 12 mg of tofacitinib, preferably 11 mg of tofacitinib. The pharmaceutical dosage form may alternatively comprise from about 20 to about 24 mg of tofacitinib, preferably 22 mg of tofacitinib. The pharmaceutical dosage form of the invention, when administered to a subject, also achieves a single, continuous time above about 17 ng/ml from about 6 to about 15 hours and a single, continuous time below about 17 ng/ml from about 9 to about 18 hours over a 24 hour dosing interval. The compositions of the invention may also achieve a single, continuous time above about 17 ng/ml from about 6 to about 9 hours. The compositions of the invention may also achieve a single, continuous time below about 17 ng/ml from about 15 to about 18 hours. The compositions of the invention may also achieve a single, continuous time above about 17 ng/ml from about 11 to about 15 hours. The compositions of the invention may also achieve a single, continuous time below about 17 ng/ml from about 9 to about 13 hours. The pharmaceutical dosage form of the present invention, when administered to a subject, may

achieve a mean maximum plasma concentration (C_{max}) from about 3 ng/mL per mg to about 6 ng/mL per mg of tofacitinib dosed.

[0013] The compositions of the present invention are additionally once daily pharmaceutical dosage forms comprising tofacitinib, or a pharmaceutically acceptable salt thereof, wherein said dosage forms are sustained release dosage forms, and when administered orally to a subject achieve a mean steady-state minimum plasma concentration (C_{min}) less than about 0.3 ng/mL per mg of tofacitinib dosed.

[0014] The compositions of the present invention are once daily pharmaceutical dosage forms comprising tofacitinib, or a pharmaceutically acceptable salt thereof, wherein said dosage forms are sustained release dosage forms, and when administered orally to a subject achieve a mean fed /fasted ratio of the area under the plasma concentration versus time curve of about 0.7 to about 1.4 and a mean fed/fasted ratio of the maximum plasma concentration (C_{max}) of about 0.7 to about 1.4, preferably about 0.8 to about 1.25.

[0015] The present invention provides a pharmaceutical dosage form comprising tofacitinib, or a pharmaceutically acceptable salt thereof, wherein said dosage form is a sustained release dosage form as defined in the appended claims, and when added to a test medium comprising 900 mL of 0.05M pH 6.8 potassium phosphate buffer at 37° C in a standard USP rotating paddle apparatus and the paddles are rotated at 50 rpm, dissolves not more than 30% of the drug in 1 hour, and not less than 35% and not more than 75% of the drug in 2.5 hours and not less than 75% of the tofacitinib in 5 hours; preferably not more than 25% of the drug in 1 hour, and not less than 40% and not more than 70% of the drug in 2.5 hours.

[0016] The compositions of the present invention are pharmaceutical dosage forms comprising tofacitinib, or a pharmaceutically acceptable salt thereof, wherein the dosage forms are sustained release dosage forms and when administered orally to a subject achieve an AUC in the range of 80% to 125% of the AUC of an amount of tofacitinib administered as an immediate release formulation BID and wherein the sustained release dosage forms provide a ratio of geometric mean plasma C_{max} to C_{min} from about 10 to about 100, preferably the AUC may be in the range of 90% to 110% and the ratio of geometric mean plasma concentration C_{max} to C_{min} may be from about 20 to about 40 and more preferably from about 20 to about 30.

[0017] The pharmaceutical dosage forms of the present invention may also achieve a mean plasma C_{max} in the range of 70% to 125% of the mean plasma C_{max} of tofacitinib administered as an immediate release formulation BID at steady state when administered orally to a subject. The pharmaceutical dosage forms of the present invention achieve a drug holiday in the range of 80% to 110% of the drug holiday of tofacitinib administered as an immediate release formulation BID over a 24 hour period when administered orally to a subject. The pharmaceutical dosage forms of the present invention may comprise from about 10 mg to about 12 mg of tofacitinib and the equivalent amount of tofacitinib administered as an immediate release formulation BID is 5 mg, preferably the pharmaceutical dosage form comprises 11 mg of tofacitinib. The pharmaceutical dosage forms of the present invention may

comprise from about 20 mg to about 24 mg of tofacitinib and the equivalent amount of tofacitinib administered as the immediate release formulation BID is 10 mg, preferably the pharmaceutical dosage forms may comprise 22 mg of tofacitinib. The pharmaceutical dosage forms of the present invention achieve the drug holiday from about 15 to about 18 hours over the 24 hour period. The pharmaceutical dosage forms of the present invention may also achieve the drug holiday from about 9 to about 13 hours over the 24 hour period.

[0018] The present invention provides for once daily sustained release pharmaceutical dosage forms comprising a core containing tofacitinib, or a pharmaceutically acceptable salt thereof, and a semi-permeable membrane coating wherein said coating comprises a water-insoluble polymer. The sustained release dosage forms of the present invention deliver tofacitinib primarily by osmotic pressure and consist of an extrudable core system tablet or capsule.

[0019] The water insoluble polymer comprises a cellulose derivative, preferably cellulose acetate. In another embodiment, the coating further comprises a water soluble polymer having an average molecular weight between 2000 and 100,000 daltons. In another embodiment of the present invention said water soluble polymer is selected from the group consisting of water soluble cellulose derivatives, acacia, dextrin, guar gum, maltodextrin, sodium alginate, starch, polyacrylates, and polyvinyl alcohols. In another embodiment, said water soluble cellulose derivatives comprise hydroxypropylcellulose hydroxypropylmethylcellulose or hydroxyethylcellulose.

[0020] In another embodiment, the core comprises a sugar, preferably sorbitol.

[0021] The present invention also provides the compositions according to the appended claims for use in treating an immunological disorder in a subject. The immunological disorder is selected from the group consisting of organ transplants, xeno transplantation, lupus, multiple sclerosis, rheumatoid arthritis, psoriasis, Type I diabetes and complications from diabetes, cancer, asthma, atopic dermatitis, autoimmune thyroid disorders, ulcerative colitis, ankylosing spondylitis, juvenile idiopathic arthritis Crohn's disease, psoriatic arthritis, Alzheimer's disease, and Leukemia, preferably, the immunological disorder is selected from the group consisting of organ transplant, rheumatoid arthritis, psoriasis, psoriatic arthritis, ulcerative colitis, ankylosing spondylitis, juvenile idiopathic arthritis and Crohn's disease. The compositions of the present invention may also be used with one or more additional agents which modulate a mammalian immune system or with anti-inflammatory agents. The additional agent may be selected from the group consisting of a nonbiologic DMARD, methotrexate, glucocorticoid, glucocorticoid receptor agonist, leflunomide, non-steroidal anti-inflammatory drugs, 6-mercaptopurine, azathioprine, sulfasalazine, and 5-aminosalicylate drugs, preferably the additional agent is selected from the group consisting of a nonbiologic DMARD and a glucocorticoid receptor agonist, more preferably the additional agent is methotrexate.

[0022] The term "tofacitinib" should be understood, unless otherwise indicated herein, to include any pharmaceutically acceptable form and salts of the compound. Tofacitinib may be present in crystalline or amorphous form. The compositions of the present invention are

sustained release dosage forms of tofacitinib which enable once a day administration to provide specific pharmacokinetic properties for the purpose of: 1) minimizing the amount of tofacitinib in the sustained release dosage form required to achieve efficacious blood levels in subjects, 2) optimizing the extent of tofacitinib binding to the JAK 1/3 heterodimers (as measured by IC_{50} , which occurs in humans at drug plasma concentrations of about 17 ng/ml or 56 nM as reported in Meyer DM, Jesson MI, Xiong L, et al. Anti-inflammatory activity and neutrophil reduction mediated by the JAK1/JAK3 inhibitor, CP-690,550, in rat adjuvant-induced arthritis J. of Inflammation 102010;7:41), which regulates the immune response, to provide the desired level of efficacy (based on the mean C_{ave}) over a 24-hour dosing interval. The sustained release dosage forms of the present invention achieve the above desired pharmacokinetic properties, and in particular the once daily dosage properties recited above. The sustained release dosage forms of the invention do not significantly alter the pharmacokinetic profile of tofacitinib when administered in the fed state (i.e. exhibits a lack of food effect), as this minimizes deviation from the optimal coverage of JAK 1/3 heterodimers.

[0023] By "sustained release" is meant broadly that tofacitinib is released from an oral dosage form at a rate that is slower than immediate release. Oral dosage form is intended to embrace tablets and capsules. "Sustained release" is intended to embrace an oral composition that consists of either one or a combination of the following:

1. a) a controlled release component alone;
2. b) a delayed release and controlled release component;
3. c) a delayed release and immediate release component

[0024] By "pharmaceutically acceptable form" is meant any pharmaceutically acceptable form, including, solvates, hydrates, isomorphs, polymorphs, co-crystals, pseudomorphs, neutral forms and acid addition salt forms. The pharmaceutically acceptable acid addition salts of tofacitinib are prepared in a conventional manner by treating a solution or suspension of the free base with about one or two chemical equivalents of a pharmaceutically acceptable acid. Conventional concentration and recrystallization techniques are employed in isolating the salts. Illustrative of suitable acids are acetic, lactic, succinic, maleic, tartaric, citric, gluconic, ascorbic, mesylic, tosylic, benzoic, cinnamic, fumaric, sulfuric, phosphoric, hydrochloric, hydrobromic, hydroiodic, sulfamic, sulfonic such as methanesulfonic, benzenesulfonic, and related acids. Some preferred forms of tofacitinib include the free base and tofacitinib citrate.

[0025] The terms "subject", "patient" and "individual" are used interchangeably herein to refer to a vertebrate, preferably a mammal, more preferably a human.

[0026] The "solid oral dosage form" of the present invention is a pharmaceutically-acceptable solid oral dosage form, meaning that the dosage form is safe for administration to humans and all excipients in the dosage form are pharmaceutically-acceptable, in other words safe for human ingestion.

[0027] The term "fasted" as used herein is defined as follows: the dosing state which is defined following an overnight fast (wherein 0 caloric intake has occurred) of at least 10 hours. Subjects may administer the dosage form with 240 mL of water. No food should be allowed for at least 4 hours post-dose. Water may be allowed as desired except for one hour before and after drug administration.

[0028] The term "fed" as used herein is defined as follows: the dosing state which is defined following an overnight fast (wherein 0 caloric intake has occurred) of at least 10 hours, subjects then begin the recommended high fat meal 30 minutes prior to administration of the drug product. Subjects should eat this meal in 30 minutes or less; however the drug product should be administered 30 minutes after the start of the meal. The drug product may be administered with 240 mL of water. No food should be allowed for at least 4 hours post-dose. Water may be allowed as desired except for one hour before and after drug administration. A high fat (approximately 50 percent of the total caloric content of the meal is derived from fat) and high calorie (approximately 3347.4 to 4184 Joules (800 to 1000 calories)) meal should be used as the test meal under the fed condition. This test meal should derive approximately 627.6, 1046, and 2092-2510.4 Joules (150, 250, and 500-600 calories) from protein, carbohydrate and fat respectively. An example test meal would be two eggs fried in butter, two strips of bacon, two slices of toast with butter, four ounces of hash brown potatoes and eight ounces of whole milk.

[0029] The calculation of the mean area under the serum concentration versus time curve (AUC) is a well-known procedure in the pharmaceutical arts and is described, for example, in Welling, "Pharmacokinetics Processes and Mathematics," ACS Monograph 185 (1986). AUC as used herein includes area under the concentration-time curve from time zero extrapolated to infinite time following single dose or the area under the concentration-time curve from time zero to time of the end of dosing interval following steady state/multiple dose. In addition, the calculations for C_{max} , $C_{min,ss}$, T_{max} , and elimination half-life ($t_{1/2}$), are also known to this of ordinary skill in the art and is described, for example, in Shargel, Wu-Pong, and Yu, Applied Biopharmaceutics and Pharmacokinetics (2005). To determine the mean fed/fast ratio, the individual ratio of the mean area under the plasma concentration versus time curve of tofacitinib (e.g. AUC_{0-inf}) in the fed state to the mean area under the plasma concentration versus time curve of tofacitinib (e.g. AUC_{0-inf}) in the fasted state is first calculated, and then the corresponding individual ratios are averaged together. In this way, it is the average of each corresponding individual's ratio which is determined.

[0030] "Dissolution Test 1" refers to the following test of dosage forms of tofacitinib. The dissolution test is conducted in a standard USP rotating paddle apparatus as disclosed in United States Pharmacopoeia (USP) Dissolution Test Chapter 711, Apparatus 2. Paddles are rotated at 50 rpm and the dosage form is added to 900 mL of 0.05M pH 6.8 potassium phosphate buffer at 37° C. At appropriate times following test initiation (e.g., insertion of the dosage form into the apparatus), filtered aliquots (typically 1.5 mL) from the test medium are analyzed for tofacitinib by high performance liquid chromatography (HPLC). Dissolution results are reported as the percent of the total dose of tofacitinib tested dissolved versus time.

DETAILED DESCRIPTION OF THE INVENTION

[0031] The present invention relates to oral sustained release compositions of tofacitinib for the treatment of anti-inflammatory and auto-immune diseases, and especially Rheumatoid Arthritis (RA). Sustained release of tofacitinib is accomplished by the use of osmotic dosage forms.

Sustained Release - Osmotic Systems

[0032] Tofacitinib is incorporated into osmotic delivery devices or "osmotic pumps" as they are known in the art. Osmotic pumps comprise a core containing an osmotically effective composition surrounded by a semipermeable membrane. The term "semipermeable" in this context means that water can readily diffuse through the membrane, but solutes dissolved in water typically cannot readily diffuse through the membrane relative to the rate of water diffusion through the membrane. In use, when placed in an aqueous environment, the device imbibes water due to the osmotic activity of the core composition. Owing to the semipermeable nature of the surrounding membrane, the contents of the device (including tofacitinib and any excipients) cannot pass through the non-porous regions of the membrane and are driven by osmotic pressure to leave the device through an opening or passageway pre-manufactured into the dosage form or, alternatively, formed in situ in the GI tract as by the bursting of intentionally-incorporated weak points in the coating under the influence of osmotic pressure. The osmotically effective composition includes water-soluble species, which generate a colloidal osmotic pressure, and water-swellaable polymers. Examples of such dosage forms are well known in the art. See, for example, Remington: The Science and Practice of Pharmacy, 21st Edition, 2006 Chapter 47; page 950-1.

[0033] In the compositions of the present invention, tofacitinib is incorporated into a monolithic osmotic delivery device, known as an extrudable core system, such that the tofacitinib-containing composition must include viscosifying polymers and osmotically active agents, and may optionally include solubility enhancing agents and/or antioxidants. The monolithic tablet or capsule is surrounded by a semi-permeable membrane which contains one or more openings which are manufactured into the dosage form through such techniques as laser drilling. The viscosifying polymers suspend or entrain the drug so as to aid in the delivery of the drug through the delivery port(s). While not wishing to be bound by any particular theory, it is believed that upon the imbibition of water into the dosage form, the viscosifying polymer has enough viscosity to allow it to suspend or entrain the drug, while at the same time remaining sufficiently fluid to allow the viscosifying polymer to pass through the delivery port(s) along with the drug. The amount of the viscosifying polymer present in the tofacitinib-containing composition ranges from wt % to 20 wt %, preferably from about 3 wt % to about 15 wt %, and more preferably from about 4 wt % to about 10 wt %. The viscosifying polymer may be a single material or a mixture of materials. Non-crosslinked polyethylene oxide (PEO) and Hydroxyethyl

cellulose (HEC) may be used as the viscosifying polymers. HEC is preferred as the viscosifying polymer. The molecular weight of HEC can be from about 300,000 to about 2,000,000, more preferably from about 700,000 to about 1,500,000.

[0034] The tofacitinib-containing composition also includes osmotically effective solutes, often referred to as "osmogens" or "osmagents." The amount of osmagent present in the tofacitinib-containing composition ranges from 60 wt % to 85 wt %, and most preferably from about 70 wt % to 85 wt %, of the tofacitinib-containing composition. Typical classes of suitable osmagents are water-soluble salts, sugars, organic acids, and other low-molecule-weight organic compounds that are capable of imbibing water to thereby establish an osmotic pressure gradient across the barrier of the surrounding coating. Typical useful salts include magnesium sulfate, magnesium chloride, calcium chloride, sodium chloride, lithium chloride, potassium sulfate, sodium carbonate, sodium sulfite, lithium sulfate, potassium chloride, and sodium sulfate. Preferred salts include sodium chloride and potassium chloride. Preferred organic acids include ascorbic acid, 2-benzene carboxylic acid, benzoic acid, fumaric acid, citric acid, maleic acid, sebacic acid, sorbic acid, adipic acid edetic acid, glutamic acid, toluene sulfonic acid, and tartaric acid. Preferred sugars include mannitol, sucrose, sorbitol, xylitol, lactose, dextrose, and trehalose. A more preferred sugar is sorbitol. The osmagents can be used alone or as a combination of two or more osmagents.

[0035] The tofacitinib-containing composition may further include solubility-enhancing agents or solubilizers that promote the aqueous solubility of the drug, present in an amount ranging from about 0 to about 30 wt % of the tofacitinib-containing composition. Solubilizers useful with tofacitinib include organic acids and organic acid salts, partial glycerides, e.g., less than fully esterified derivatives of glycerin, including glycerides, monoglycerides, diglycerides, glyceride derivatives, polyethylene glycol esters, polypropylene glycol esters, polyhydric alcohol esters, polyoxyethylene ethers, sorbitan esters, polyoxyethylene sorbitan esters, and carbonate salts.

[0036] A preferred class of solubilizers is organic acids. Since tofacitinib is a base which is solubilized by protonation, and since its solubility in an aqueous environment of pH 5 or higher is reduced, it is believed that addition of an organic acid to the Tofacitinib-containing composition assists in solubilization and hence absorption of tofacitinib. Even a slight decrease in the pH of the aqueous solution at high pH results in dramatic increases in the solubility of tofacitinib. Organic acids can also promote stability during storage prior to introduction to a use environment due to their tendency to maintain tofacitinib in a protonated state.

[0037] There are a variety of factors to consider when choosing an appropriate organic acid for use as a solubilizer with tofacitinib in an osmotic dosage form. The acid should not interact adversely with tofacitinib, should have appropriate water solubility, and should provide good manufacturing properties.

[0038] Accordingly, it has been found that a preferred subset of organic acids meeting such criteria consists of citric, succinic, fumaric, adipic, malic and tartaric acids. Citric, malic, and tartaric acid have the advantage of high water solubility and high osmotic pressure. Succinic

and fumaric acid offer a combination of both moderate solubility and moderate osmotic pressure.

[0039] The tofacitinib-containing composition layer and/or the functional rate controlling membrane may optionally contain an antioxidant, such as but not limited to BHT, BHA, sodium metabisulfite, propyl gallate, glycerin, vitamin E Citric Acid or ascorbyl palmitate. The antioxidant may be present in an amount ranging from 0 to 10 wt % of the tofacitinib-containing composition layer and/or the water-swelling composition layer and/or the functional rate controlling membrane. For additional examples of antioxidants, see C.-M. Andersson, A. Hallberg, and T. Hoegberg. Advances in the development of pharmaceutical antioxidants. *Advances in Drug Research*. 28:65-180, 1996.

[0040] The Tofacitinib-containing composition is prepared by mixing the viscosifying polymer and the other excipients to form a uniform blend. To obtain a uniform blend, it is desirable to either wet or dry granulate or dry blend the components using the types of processes known to those skilled in the art.

TABLETING

[0041] The core is prepared by first placing a mixture of the tofacitinib-containing composition into a tablet press and compressed in order to complete formation of the core. Tablet shapes may include any tablet shape known to those skilled in the art. Preferable tablet shapes include SRC (standard round concave), oval, modified oval, capsule, caplet, and almond. More preferable tablet shapes include oval, modified oval, caplet, and capsule.

THE COATING

[0042] Following formation of the core, the semi-permeable coating is applied. The coating should have high water permeability and a high strength, while at the same time be easily fabricated and applied. High water permeability is required to permit water to enter the core in sufficient volume. High strength is required to ensure the coating does not burst when the core swells as it imbibes water, leading to an uncontrolled delivery of the core contents. Finally, the coating must have high reproducibility and yield.

[0043] It is essential that the coating has at least one delivery port in communication with the interior and exterior of the coating for delivery of the tofacitinib-containing composition. Furthermore, the coating must be non-dissolving and non-eroding during release of the tofacitinib-containing composition, generally meaning that it be water-insoluble, such that tofacitinib is substantially entirely delivered through the delivery port(s), in contrast to delivery via permeation through the coating.

[0044] Coatings with these characteristics can be obtained using hydrophilic polymers such as plasticized and unplasticized cellulose esters, ethers, and ester-ethers. Particularly suitable polymers include cellulose acetate (CA), cellulose acetate butyrate (CAB), and ethyl cellulose (EC). One set of polymers are cellulose acetates having acetyl contents of 25 to 42%. One typical polymer is CA having an acetyl content of 39.8%, specifically, CA 398-10 (Eastman Fine Chemicals, Kingsport, Tenn.). CA 398-10 is reported to have an average molecular weight of about 40,000 daltons. Another typical CA having an acetyl content of 39.8% is high molecular weight CA having an average molecular weight greater than about 45,000, and specifically, CA 398-30 (Eastman Fine Chemical) which is reported to have an average molecular weight of 50,000 daltons.

[0045] Coating is conducted in conventional fashion by first forming a coating solution and then coating by dipping, fluidized bed coating, or by pan coating. To accomplish this, a coating solution is formed comprising the polymer and a solvent. Typical solvents useful with the cellulosic polymers above include acetone, methyl acetate, ethyl acetate, isopropyl acetate, n-butyl acetate, methyl isobutyl ketone, methyl propyl ketone, ethylene glycol monoethyl ether, ethylene glycol monoethyl acetate, methylene dichloride, ethylene dichloride, propylene dichloride, nitroethane, nitropropane, tetrachloroethane, 1,4-dioxane, tetrahydrofuran, diglyme, and mixtures thereof. The coating solution typically contains 2 to 15 wt % of the polymer.

[0046] The coating solution may also include pore-formers or non-solvents in any amount as long as the polymer remains soluble at the conditions used to form the coating and as long as the coating remains water permeable and has sufficient strength. Pore-formers and their use in fabricating coatings are described in U.S. Pat. Nos. 5,698,220 and 5,612,059. The term "pore former," as used herein, refers to a material added to the coating solution that has low or no volatility relative to the solvent such that it remains as part of the coating following the coating process but that is sufficiently water swellable or water soluble such that, in the aqueous use environment it provides a water-filled or water-swollen channel or "pore" to allow the passage of water, thereby enhancing the water permeability of the coating. Suitable pore formers include but are not limited to hydroxypropylcellulose (HPC), polyethylene glycol ("PEG"), PVP, and PEO. To obtain a combination of high water permeability and high strength when PEG or HPC are used as a pore former, the weight ratio of CA:PEG or CA:HPC should range from about 6:4 to about 9:1. CA:HPC is a preferred coating composition. Preferred CA:HPC weight ratios should range from 6:4 to 7:3. Preferred CA:PEG weight ratios should range from 6:4 to 7:3.

[0047] The addition of a non-solvent such as water or methanol to the coating solution results in exceptional performance. By "non-solvent" is meant any material added to the coating solution that substantially dissolves in the coating solution and reduces the solubility of the coating polymer or polymers in the solvent. In general, the function of the non-solvent is to impart porosity to the resulting coating. As described below, porous coatings have higher water permeability than an equivalent weight of a coating of the same composition that is not porous and this porosity is indicated by a reduction in the density of the coating (mass/volume). Although not wishing to be bound by any particular mechanism of pore formation, it is generally

believed that addition of a non-solvent imparts porosity to the coating during evaporation of solvent by causing the coating solution to undergo liquid and liquid phase separation prior to solidification. The suitability and amount of a particular candidate material can be evaluated for use as a non-solvent by progressively adding the candidate non-solvent to the coating solution until it becomes cloudy. If this does not occur at any addition level up to about 50 wt % of the coating solution, it generally is not appropriate for use as a non-solvent. When clouding is observed, termed the "cloud point," an appropriate level of non-solvent for maximum porosity is the amount just below the cloud point. For acetone solutions comprising 7 wt % CA and 3 wt % PEG, the cloud point is at about 23 wt % water. When lower porosities are desired, the amount of non-solvent can be reduced as low as desired.

[0048] Suitable non-solvents are any materials that have appreciable solubility in the solvent and that lower the coating polymer solubility in the solvent. The preferred non-solvent depends on the solvent and the coating polymer chosen. In the case of using a volatile polar coating solvent such as acetone, suitable non-solvents include water, glycerol, alcohols such as methanol or ethanol.

[0049] When using CA 398-10, coating solution weight ratios of CA:PEG 3350: water are 2.4:1.6:5, 2.8:1.2:5, 3.2:0.8:5, and 3.6:0.4:5, with the remainder of the solution comprising a solvent such as acetone. Thus, for example, in a solution having a weight ratio of CA:PEG 3350: water of 2.8:1.2:5, CA comprises 2.8 wt % of the solution, PEG 3350 comprises 1.2 wt % of the solution, water comprises 5 wt % of the solution, and acetone comprises the remaining 91 wt %. Likewise, coating solution weight ratios of CA:HPC:water are 1.2:0.8:9.8, 2.4:1.6:19.6, 1.6:0.4:4.9, and 3.2:0.8:9.8, with the remainder of the solution comprising a solvent such as acetone. Thus, for example, in a solution having a weight ratio of CA:HPC:water of 1.2:0.8:10, CA comprises 1.2 wt % of the solution, HPC comprises 0.8 wt % of the solution, water comprises 10 wt % of the solution, and acetone comprises the remaining 88 wt %. Further, coating solution weight ratios of CA:HPC:methanol are 1.8:1.2:19.6, 2.4:1.6:19.6, 1.6:0.4:4.9, and 3.2:0.8:9.8, with the remainder of the solution comprising a solvent such as acetone. Thus, for example, in a solution having a weight ratio of CA:HPC:methanol of 1.8:1.2:19.6, CA comprises 1.8 wt % of the solution, HPC comprises 1.2 wt % of the solution, methanol comprises 19.6 wt % of the solution, and acetone comprises the remaining 77.4 wt %.

[0050] When incorporating antioxidants into the coating solution, a third solvent may be required to ensure good dispersion of the antioxidant into the coating. For example, a CA:PEG:water composition of 2.4:1.6:5 that includes 0.05 wt% wt of the solution requires 5 wt% methanol and 86% acetone.

[0051] Coatings formed from these coating solutions are generally porous. By "porous" is meant that the coating in the dry state has a density less than the density of the same material in a nonporous form. By "nonporous form" is meant a coating material formed by using a coating solution containing no non-solvent, or the minimal amount of non-solvent required to produce a homogeneous coating solution. The dry-state density of the coating can be calculated by dividing the coating weight (determined from the weight gain of the tablets before

and after coating) by the coating volume (calculated by multiplying the coating thickness, as determined by optical or scanning electron microscopy, by the tablet surface area). The porosity of the coating is one of the factors that leads to the combination of high water permeability and high strength of the coating.

[0052] The weight of the coating around the core depends on the composition and porosity of the coating, but generally should be present in an amount ranging from 3 to 30 wt %, based on the weight of the uncoated core. A coating weight of at least about 5 wt % is typically preferred for sufficient strength for reliable performance, although lower coating weights can be used to achieve desired high water imbibing rates and, subsequently, higher release rates of tofacitinib from the dosage form. For tofacitinib-containing dosage forms, a coating weight gain of 5-10% is preferred to achieve the desired release performance.

[0053] While porous coatings based on CA, PEG or HPC, and water or methanol described above translate to excellent results, other pharmaceutically acceptable materials could be used in the coating so long as the coating has the requisite combination of high water permeability, high strength, and ease of fabrication and application. Further, such coatings may be dense, porous, or "asymmetric," having one or more dense layers and one or more porous layers such as those disclosed in U.S. Pat. Nos. 5,612,059 and 5,698,220.

[0054] The coating must also contain at least one delivery port in communication with the interior and exterior of the coating to allow for release of the tablet core contents to the exterior of the dosage form. The delivery port can range in size from about the size of the drug particles, and thus could be as small as 1 to 100 microns in diameter and may be termed pores, up to about 5000 microns in diameter. The shape of the port may be substantially circular, in the form of a slit, or other convenient shape to ease manufacturing and processing. The port(s) may be formed by post-coating mechanical or thermal means or with a beam of light (e.g., a laser), a beam of particles, or other high-energy source, or may be formed in situ by rupture of a small portion of the coating. Such rupture may be controlled by intentionally incorporating a relatively small weak portion into the coating. Delivery ports may also be formed in situ by erosion of a plug of water-soluble material or by rupture of a thinner portion of the coating over an indentation in the core. Delivery ports may be formed by coating the core such that one or more small regions remain uncoated. In addition, the delivery port can be a large number of holes or pores that may be formed during coating, as in the case of asymmetric membrane coatings, described in more detail herein, and of the type disclosed in U.S. Pat. Nos. 5,612,059 and 5,698,220. When the delivery pathways are pores there can be a multitude of such pores that range in size from 1 micron to greater than 100 microns. During operation, one or more of such pores may enlarge under the influence of the hydrostatic pressure generated during operation. The location of the delivery port(s) may be located anywhere on the tablet surface. Preferred locations of the delivery port(s) include the face of the tablet and the tablet band. A more preferred location includes approximately the center of the tablet band for round, SRC-shaped tablets and approximately the center of the tablet band along the major axis and/or approximately the center of the tablet band along the minor axis of the tablet band for capsule, caplet, oval, or modified oval shaped tablets. A most preferred

location of the delivery port(s) is the approximate center of the tablet band along the major axis of the tablet band for capsule, caplet, oval, or modified oval shaped tablets.

[0055] The invention will be illustrated in the following non-limiting examples.

[0056] Examples (1 inch (1") corresponds to 25,4 mm, 1 CFM corresponds to 1,699 m³/h, 1 gallon corresponds to 3,78 l, 1 cc corresponds to 1 ml, 1 dram corresponds to 1,77 g, and 1 psi corresponds to 6,894 KPa).

Example 1. Extrudable Core System Osmotic Tablet

22 mg Tablet Core

[0057] One-half of the batch quantity of sorbitol, 2663.01 grams (also see Table 1 below), was added to a 28L bin. The batch quantity of Copovidone, 420.00 grams, was then added to the 28L bin. The batch quantity of Tofacitinib, 623.98g, was then added to the 28L bin. The batch quantity of Hydroxycellulose, 560.00 grams, was then added to the 28L bin. The remaining one-half of the batch quantity of sorbitol, 2663.01 grams was added to the 28L bin. All of the components were blended in the bin for 15 minutes at 12 +/- 1 RPM.

[0058] The blend was passed through a Comil rotary mill equipped with a 0.032" screen and a round edge impeller running at approximately 950 RPM. The blend was collected in a second 28L bin. The bin contents were blended for 10 minutes at 15 +/- 1 RPM.

[0059] Magnesium stearate, 70g, was passed through an 850-micron mesh screen and was added to the bin and contents were blended for 5.5 minutes at 12 +/- 1 RPM. Final blend was transferred to the hopper of a Fette rotary tablet press. Tablets were compressed using 0.2620" x 0.5240" modified oval tooling, to an average target weight of 400 mg +/- 5%, average target thickness of 5.35 mm +/- 0.05 mm, and a target hardness of 13 kP. Tablets were passed through a deduster and a metal detector.

Table 1

#	Material	Function	Composition (%)	Grams
1	Tofacitinib Citrate	Active	8.914	623.98
2	Sorbitol	Osmagen	76.086	5326.02
3	Hydroxyethylcellulose	Viscosifying Agent	8.000	560.00
4	Kollidon VA 64 (copovidone)	Binder	6.000	420.00
5	Magnesium Stearate	Lubricant	1.000	70.00
	Core Tablet Weight	- - -	100%	7000.00 g

11 mg Tablet Core

[0060] One-half of the batch quantity of sorbitol, 2819.01 grams (also see Table 2 below), was added to a 28L bin. The batch quantity of Copovidone, 420.00 grams, was then added to the 28L bin. The batch quantity of Tofacitinib, 311.99g, was then added to the 28L bin. The batch quantity of Hydroxycellulose, 560.00 grams, was then added to the 28L bin. The remaining one-half of the batch quantity of sorbitol, 2819.0 grams was added to the 28L bin. All of the components were blended in the bin for 15 minutes at 12 +/- 1 RPM.

[0061] The blend was passed through a Comil rotary mill equipped with a 0.032" screen and a round edge impeller running at approximately 950 RPM. The blend was collected in a second 28L bin. The bin contents were blended for 10 minutes at 15 +/- 1 RPM.

[0062] Magnesium stearate, 70g, was passed through a 850-micron mesh screen and was added to the bin and contents were blended for 5.25 minutes at 12 +/- 1 RPM. Final blend was transferred to the hopper of a Fette rotary tablet press. Tablets were compressed using 0.2620" x 0.5240" modified oval tooling, to an average target weight of 400 mg +/- 5%, average target thickness of 5.35 mm +/-0.05 mm, and a target hardness of 15 kP. Tablets were passed through a deduster and a metal detector.

Table 2

#	Material	Function	Composition (%)	Grams
1	Tofacitinib Citrate	Active	4.457	311.99
2	Sorbitol	Osmagen	80.543	5638.01
3	Hydroxyethylcellulose	Viscosifying Agent	8.000	560.00
4	Kollidon VA 64 (copovidone)	Binder	6.000	420.00
5	Magnesium Stearate	Lubricant	1.000	70.00
	Core Tablet Weight	- - -	100%	7000.00 g

Tablet Coating and Drilling

[0063] 4.049-kilogram coating solution was prepared according to the following steps: First, the entire 396.0 grams of water (also see Table 3 below) and 1464.0 grams of acetone were added to a 5-Liter vessel and mixed for 5 minutes. 32.4 grams of hydroxypropyl cellulose were added to the mixture and mixed for 5 minutes. 48.6 grams of cellulose acetate were added to the mixture and mixed for 5 minutes. The remaining 2108 grams of cellulose acetate were added to the mixture and mixed for 3 hours. This procedure created a 2% solids (w/w) solution.

Table 3

Composition of duration 1 coated tablet	% in coating	mg/tablet	coat w/w (%)	Batch Quantity (Grams)
1. Tofacitinib Citrate Tablet Core	---	400	-----	-----
2. Cellulose Acetate (Type 398-10)	1.2%	14.4	3.6	48.6
3. Hydroxypropyl Cellulose (Klucel EF)	0.8%	9.6	2.4	32.4
4. Acetone	88.2%	(1058.4)	-----	3572.0
5. Purified water	9.8%	(117.6)	-----	396.0
Total Weight	100%	424	6.0	4049.0

[0064] 900 grams of the 400 mg weight oval tablets were coated in a Vector LCDS-5 with a 1.5-Liter semi-perforated pan operating at 20 rpm and an airflow of 30 CFM having an exhaust temperature of 40 deg C. The 2% solids (w/w) solution was applied until the wet weight gain reached a level of 6.2%. The tablets were then removed from the coating pan and dried at 40 C for 16 hours

[0065] A single hole (1000 micron) was drilled in the end of the band of the oval tablet. The hole can be drilled either by mechanical means or via laser ablation. A coating of 6% provided the following release in pH 6.8 media, paddles at 50 rpm based on Dissolution test 1 (Table 4):

Table 4

Time (hr)	11 mg tablet % Drug Dissolved	22 mg tablet % Drug Dissolved
1	11	15
2.5	55	61
5	87	92

Example 2. 200 mg Extrudable Core System Osmotic Tablets with Acetone:Methanol Coating Solution

11 mg Tablet Core

[0066] One-half of the batch quantity of sorbitol, 38.014 kilograms (also see Table 5 below), was added to a 300L bin. The batch quantity of Copovidone, 6.00 kilograms, was then added to the 300L bin. The batch quantity of Tofacitinib, 8.914 kilograms, was then added to the 300L bin. The batch quantity of Hydroxycellulose, 8.00 kilograms, was then added to the 300L bin. The remaining one-half of the batch quantity of sorbitol, 38.014 grams was added to the 300L

bin. All materials were added via a vacuum transfer system and passed through a Comil rotary mill equipped with a 0.032" screen and a round edge impeller running at approximately 1400 RPM. All of the components are blended in the bin for 20 minutes at 12 +/- 1 RPM.

[0067] The blend was passed through a Comil rotary mill equipped with a 0.032" screen and a round edge impeller running at approximately 1400 RPM. The blend was collected in a second 300L bin. The bin contents were blended for 20 minutes at 12 +/- 1 RPM.

[0068] Magnesium stearate, 1.00 kilograms, was passed through a 850-micron mesh screen and was added to the bin and contents were blended for 5 minutes at 12 +/- 1 RPM. Tablets were compressed using 0.2080" x 0.4160" modified oval tooling on a Manesty Mark IV rotary tablet press, to an average target weight of 200 mg +/- 5%, average target thickness of 4.17 mm +/- 0.05 mm, and a target hardness of 10 kP. Tablets were passed through a deduster and a metal detector.

Table 5

#	Material	Function	Composition (%)	100 kg Batch
1	Tofacitinib Citrate	Active	8.914	8.914
2	Sorbitol	Osmagen	76.086	76.086
3	Hydroxyethylcellulose	Viscosifying Agent	8.000	8.00
4	Copovidone	Binder	6.000	6.00
5	Magnesium Stearate	Lubricant	1.000	1.00
	Core Tablet Weight	- - -	100%	100.00 kg

22 mg Tablet Core

[0069] One-half of the batch quantity of sorbitol, 33.086 kilograms (also see Table 6 below), was added to a 300L bin. The batch quantity of Colloidal Silicon Dioxide, 1.00 kg, was then added to the 300L bin. The batch quantity of Copovidone, 6.00 kilograms, was then added to the 300L bin. The batch quantity of Tofacitinib, 8.914 kilograms, was then added to the 300L bin. The batch quantity of Hydroxycellulose, 8.00 kilograms, was then added to the 300L bin. The remaining one-half of the batch quantity of sorbitol, 33.086 grams was added to the 300L bin. All materials were added via a vacuum transfer system and passed through a Comil rotary mill equipped with a 0.032" screen and a round edge impeller running at approximately 1400 RPM. All the components were blended in the bin for 20 minutes at 12 +/- 1 RPM.

[0070] The blend was passed through a Comil rotary mill equipped with a 0.032" screen and a round edge impeller running at approximately 1400 RPM. The blend was collected in a second 300L bin. The bin contents were blended for 20 minutes at 12 +/- 1 RPM.

[0071] Magnesium stearate, 1.00 kilograms, was passed through a 850-micron mesh screen

and was added to the bin and contents were blended for 5 minutes at 12 +/- 1 RPM. Tablets were compressed using 0.2080" x 0.4160" modified oval tooling on a Manesty Mark IV rotary tablet press, to an average target weight of 200 mg +/- 5%, average target thickness of 4.17 mm +/- 0.05 mm, and a target hardness of 11 kP. Tablets were passed through a deduster and a metal detector.

Table 6

#	Material	Function	Composition (%)	100 kg Batch
1	Tofacitinib Citrate	Active	17.828	17.828
2	Sorbitol	Osmagen	66.172	66.172
3	Hydroxyethylcellulose	Viscosifying Agent	8.000	8.00
4	Copovidone	Binder	6.000	6.00
5	Colloidal Silicon Dioxide	Glidant	1.000	1.00
6	Magnesium Stearate	Lubricant	1.000	1.00
	Core Tablet Weight	- - -	100%	100.00 kg

[0072] The 750-kilogram coating solution was prepared according to the following steps (see also Table 7): First, the entire 147.0 kilograms of methanol and 580.5 grams of acetone were added to a 250-gallon vessel. 13.5 kilograms of cellulose acetate were added to the mixture. 9.0 kilogram of hydroxypropyl cellulose were added to the mixture. The contents of the container were mixed for 1 hour. This procedure created a 3% solids (w/w) solution.

Table 7

Composition of coated 200 mgW tablet	% in coating	mg/tablet	coat w/w (%)	Batch Quantity (kilograms)
1. Tofacitinib Citrate Tablet Core	---	200	---	-----
2. Cellulose Acetate (Type 398-10)	1.8%	7.9	4.0	13.5
3. Hydroxypropyl Cellulose (Klucel EF)	1.2%	5.3	2.6	9.0
4. Methanol	19.6%	(86.2)	---	147.0
5. Acetone	77.4%	(340.6)	---	580.5
Total Weight	100%	213.2	6.6	750.0

[0073] 250 kilograms of the 200 mg weight oval tablets were coated in a Vector HC-130 operating at 8 rpm and an airflow of 1000 CFM having an exhaust temperature of 28 deg C. The 3% solids (w/w) solution was applied until the wet weight gain reached a level of 6.8%. The tablets were then removed from the coating pan and dried at 45 C for 24 hours.

[0074] A single hole (600 micron) was drilled in the end of the band of the oval tablet. The hole can be drilled either by mechanical means or via laser ablation. A coating of 6.6% provided the following release in pH 6.8 media, paddles at 50 rpm based on Dissolution test 1 (Table 8):

Table 8

Time (hr)	11 mg tablet % Drug Dissolved	22 mg tablet % Drug Dissolved
1	11	10
2.5	55	55
5	85	82

Example 3. 200 mg Extrudable Core System Osmotic Tablets Cellulose Acetate and Polyethylene Glycol Coating Membrane

[0075] 11 mg and 22 mg tofacitinib sustained release tablet cores were prepared as described in Example 2.

[0076] The 1200-gram coating solution was prepared according to the following steps (see also Table 9): First, 60 grams of water and 19.2 grams of polyethylene glycol were added to a 5-liter vessel and stirred until the solution was clear. 60 grams of methanol and 0.504 grams of BHA were added to the solution and stirred until clear. 1031.496 grams of acetone and 28.8 grams of cellulose acetate were added to the mixture. The contents of the container were mixed for 3 hours. This procedure created a 4% solids (w/w) solution.

Table 9

#	Material	Composition (%)	Grams
1	Cellulose Acetate (Type 398-10)	2.400%	28.8
2	Polyethylene Glycol (PEG 3350)	1.600%	19.2
3	Butylated Hydroxyanisole (BHA)	0.042%	0.504
4	Purified Water	5.000%	60.0
5	Methanol	5.000%	60.0
6	Acetone	85.958%	1031.496
		100%	

[0077] 240 grams of the 200 mg weight oval tablets were coated in a Vector LDCS-5 operating at 30 rpm and an airflow of 40 CFM having an exhaust temperature of 28 deg C. The 3% solids (w/w) solution was applied until the wet weight gain reached a level of 9.2%. The tablets were then removed from the coating pan and dried at 40 C for 16 hours.

[0078] A single hole (600 micron) was drilled in the end of the band of the oval tablet. The hole can be drilled either by mechanical means or via laser ablation. A coating of 9% provides the

following release in pH 6.8 media, paddles at 50 rpm based on Dissolution test 1 (Table 10):

Table 10

Time (hr)	11 mg tablet % Drug Dissolved	22 mg tablet % Drug Dissolved
1	28	30
2.5	72	70
5	92	90

Reference Example 4. Hydrophilic matrix controlled release tablet

[0079] The metal surfaces of a 10L bin were pre-coated by adding the batch quantity (also see Table 11 below) 1484.85g of Lactose Fast Flo 316 and blending for 2 minutes at 12 +/- 1 RPM. The batch quantity of Tofacitinib, 171.15g, was added to the 10L bin and folded into the lactose monohydrate. The Tofacitinib container was rinsed with some of the lactose monohydrate from the 10L bin. The batch quantity of Hypromellose, 720g, was added to the 10L bin. All of the components were blended in the bin for 10 minutes at 12 +/- 1 RPM.

[0080] The blend was passed through a Comil rotary mill equipped with a 0.032" screen and a round edge impeller running at approximately 1400 RPM. The blend was collected in a second 10L bin. The bin contents were blended for 10 minutes at 12 +/- 1 RPM.

[0081] Intragranular magnesium stearate, 6g, was added to the bin and blended for 3 minutes at 12 +/- 1 RPM. The lubricated blend was processed through a Gerteis roller compactor equipped with knurled rollers, side rims, and an inline oscillating mill containing a pocket rotor and a 1-mm rasping plate. The target ribbon solid fraction was 0.7 (0.67-0.73) and granules were collected in the initial 10L bin.

[0082] Extragranular magnesium stearate, 18g, was added to the bin and contents were blended for 3 minutes at 12 +/- 1 RPM. Final blend was affixed above a Kilian T-100 rotary tablet press. Tablets were compressed using 13/32" SRC tooling, to an average target weight of 500 mg +/- 5% and a target hardness of 15 kP. Tablets were passed through a deduster and a metal detector.

Table 11

22 mg Tofacitinib hydrophilic matrix tablet composition; Total tablet weight 500 mg			
Ingredient	Function	% Composition	Grams
Tofacitinib Citrate	Active ingredient	7.1%	171.15
Methocel K100LV CR Premium Grade	Polymer, gel former providing controlled release	30%	720.00

22 mg Tofacitinib hydrophilic matrix tablet composition: Total tablet weight 500 mg			
Ingredient	Function	% Composition	Grams
Lactose Monohydrate, Fast Flo 316	Filler	61.9%	1484.85
Magnesium stearate, vegetable grade (IG)	Lubricant	0.25%	6.00
Magnesium stearate, vegetable grade (EG)	Lubricant	0.75%	18.00
Total		100%	2400.00

[0083] The compressed tablets provide the following release in pH 6.8 media, paddles at 50 rpm based on Dissolution test 1 (Table 12).

Table 12

Time (hr)	% Drug Dissolved
1	24
2.5	47
5	76

Reference Example 5. 20 mg Bilayer Osmotic Tablet

[0084] The batch quantities of Tofacitinib and Polyethylene Oxide N80 (see also Table 13) were passed through a 30 mesh screen and added to a 500 cc amber bottle. The blend was mixed for 10 minutes with a Turbula bottle blender. 0.2 grams of magnesium stearate was passed through a 30 mesh screen and added to the bottle of active blend and mixed for 3 minutes.

[0085] The batch quantities of polyethylene oxide (coagulant grade), blue lake dye, and sodium chloride were passed through a 20 or 30 mesh screen and added in that order to a 500 cc bottle. The blend was mixed for 10 minutes with a Turbula bottle blender. 0.5 grams of magnesium stearate was passed through a 30 mesh screen and added to the bottle of sweller layer and mixed for 3 minutes.

[0086] Tablets were compressed using 9-mm standard round convex tooling, to an average target weight of 400 mg +/- 5%, average target thickness of 7 mm +/-0.05 mm, and a target hardness of 15 kP.

Table 13

Active Layer Components:	Grade:	Quantity (mg)/unit:	%	Batch Quantity (grams)
Tofacitinib Citrate		33.333	12.5%	5.0
Polyethylene Oxide WSR N80 Grade	NF	232	87.0%	34.8
Magnesium Stearate ^e	NF/EP	1.333	0.5%	0.2
		266.667	100.0%	40
Sweller Layer Components:	Grade:	Quantity (mg)/unit:	%	Batch Quantity (grams)
Polyethylene Oxide Coagulant Grade ^a	NF	86	64.5%	64.5
Sodium Chloride ^b	USP/EP	46.4	34.8%	34.8
FD&C Blue No2 Lake Dye ^d	Food	0.267	0.2%	0.2
Magnesium Stearate ^e	NF/EP	0.667	0.5%	0.5
		133.333	100.0%	100.0

[0087] The coating solution was prepared according to the following steps (see also Table 14 below): First, the entire 194.6 grams of water and 800 grams of acetone were added to a 5-Liter vessel and mixed for 5 minutes. 24 grams of hydroxypropyl cellulose were added to the mixture and mixed for 5 minutes. 36 grams of cellulose acetate were added to the mixture and mixed for 5 minutes. The remaining 946.3 grams of acetone were added to the mixture and mixed for 3 hours. This procedure created a 3% solids (w/w) solution.

Table 14

Composition of coated tablet	% in coating	mg/tablet 6% wt gain	coat w/w (%)	Batch Quantity (grams)
1. Tofacitinib Citrate Bilayer Core Tablet Core	---	400	-----	-----
2. Cellulose Acetate (Type 398-10)	1.8%	14.4	3.6%	36.0
3. Hydroxypropyl Cellulose (Klucel EF)	1.2%	9.6	2.4%	24.0
4. Acetone	87.3%	(698.4)	-----	1746.3
5. Purified water	9.7%	(77.6)	-----	194.6
Total Weight	100%	424	6%	2000.9

[0088] 250 grams of the 400 mg weight SRC tablets were coated in a Vector LCDS-5 with a 0.5-Liter semi-perforated pan operating at 30 rpm and an airflow of 30 CFM having an exhaust temperature of 40 deg C. The 3% solids (w/w) solution was applied until the wet weight gain reached a level of 6.2%. The tablets were then removed from the coating pan and dried at 40 C for 16 hours

[0089] A single hole (1000 micron) was drilled in the end of the band of the oval tablet. The hole can be drilled either by mechanical means or via laser ablation. The target coating of 6% provided the following release in pH 6.8 media, paddles at 50 rpm based on Dissolution test 1 (Table 15):

Table 15

Time (hr)	6% Weight Gain (% Drug Dissolved)
1	6
2.5	42
5	95

Reference Example 6. 11 mg Bilayer Osmotic Tablet

[0090] The batch quantity of Polyethylene Oxide N80 (active layer) (see also Table 16) was passed through a 30 mesh screen. The large particles that remained on the screen were discarded. Polyethylene Oxide was added to a 500 cc amber bottle and hand blended to coat the inside of the bottle. The batch quantity of Tofacitinib was added and mixed for 10 minutes with a Turbula bottle blender. 1.0 gram of magnesium stearate was added to the bottle of active blend and mixed for 3 minutes.

[0091] The batch quantity of Polyethylene oxide Coagulant grade (sweller layer) and sodium chloride were passed through 30 mesh screen. Polyethylene oxide, the batch quantity of microcrystalline cellulose, the batch quantity of blue lake dye and sodium chloride powder were added in that order to a 950 cc bottle. The blend was mixed for 10 minutes with a Turbula bottle blender. 1.0 gram of magnesium stearate was added to the bottle of sweller layer and mixed for 3 minutes.

[0092] Bilayer tablets are compressed using 9/32 inch standard round convex tooling, to an average target weight of 180.0 mg +/- 5% and an average target thickness of 5.0 mm +/- 0.1 mm.

Table 16

Active Layer Components:	Grade:	Quantity (mg)/unit:	%	Batch Quantity (grams)
Tofacitinib Citrate		17.76	14.80	14.80

Active Layer Components:	Grade:	Quantity (mg)/unit:	%	Batch Quantity (grams)
Polyethylene Oxide WSR N80 Grade ^a	NF	101.04	84.20	84.20
Magnesium Stearate ^e	NF/EP	1.20	1.00	1.00
		120.00	100.00	100.00
Sweller Layer Components:	Grade:	Quantity (mg)/unit:	%	Batch Quantity (grams)
Polyethylene Oxide Coagulant Grade ^a	NF	32.52	54.20	108.40
Microcrystalline Cellulose	PhEur/NF	12.00	20.00	40.00
Sodium Chloride ^b	USP/EP	15.00	25.00	50.00
FD&C Blue No2 Lake Dye ^d	Food	0.18	0.30	0.60
Magnesium Stearate ^e	NF/EP	0.30	0.50	1.00
		60.00	100.0%	200.00

[0093] The coating solution was prepared according to the following steps (see also Table 17): First, 180.0 grams of water was added to 48.6 grams of PEG 3350 in 4L mixing vessel and mixed or swirled by hand until the PEG was entirely dissolved. Secondly, 131.4 g of cellulose acetate was added to the 4L mixing vessel containing the PEG-water solution. The CA was disbursed as a slurry or wet cake. While using the 4L mixing vessel equipped with a rotating impeller, 2,640.0 grams of acetone was added to the PEG-water-CA mixture. The contents of the mixing vessel were agitated until all solids were dissolved.

Table 17

#	Material	Composition (%)	Grams
1	Cellulose Acetate	4.38%	131.4
2	Polyethylene Glycol 3350 with 100 ppm BHT (PEG 3350)	1.62%	48.6
3	Acetone ⁽¹⁾	88.00%	2640.0
4	Purified Water ⁽¹⁾	6.00%	180.0
	Total	100.00%	3000.0
Component		Coating Solution % Wt	mg/tablet
Tofacitinib Core Citrate Bilayer Core Tablet		-	180.00

Coating Composition		
Cellulose Acetate	4.38%	17.08
Polyethylene ppm Glycol 3350 with 100 BHT (PEG 3350)	1.62%	6.32
Acetone ⁽¹⁾	88.00%	343.20
Purified Water ⁽¹⁾	6.00%	23.40
Total	100.00%	203.40
⁽¹⁾ Included for Coating CompositionalPurposes,Not Present in Final Dosage Form		

[0094] 250 grams of the 180 mg bilayer tablet cores were coated in a Vector LCDS-5 with a 0.5 liter fully perforated coating pan operating at 30 rpm and an airflow of 35 CFM having an exhaust temperature of 32 deg C. The 6% solids (w/w) solution was applied until an in-process coating weight gain of 25.2 mg per tablets was achieved. The tablets were then removed from the coating pan and dried at 40 C for 16 hours.

[0095] A single delivery port with a diameter of 1.0 mm was formed through the coating membrane centered on the face of the drug layer side of the bilayer tablet. The delivery port can be formed either by mechanical means or via laser ablation. The target coating level of 23.4 mg or 13% of the target bilayer core weight provided a controlled release drug delivery exhibiting 80% of the drug delivered at 3.5 hours in pH 6.8 media, paddles at 50 rpm based on Dissolution test 1. Additional dissolution data is given in Table 18.

Table 18

Time (hours)	% Release
1.0	13
2.5	55
5.0	96

Reference Example 7. 11 mg Bilayer Osmotic Tablet with antioxidants

[0096] The formulation of Reference Example 7 was made as follows (see also Table 19): Polyethylene oxide N80 was passed through a 30 mesh screen. The large particles of polyethylene oxide N80 that remain on the screen were discarded. Separately, the primary particle size of the sodium metabisulfite and butylated hydroxyanisole was reduced using a mortar and pestle. One-fourth the batch amount of polyethylene oxide was combined with the batch amounts of sodium metabisulfite and butylated hydroxyanisole and added to a 950 cc amber glass bottle and mixed for 5 minutes in a Turbula bottle blender. The remaining polyethylene oxide N80 and batch amount of tofacitinib citrate was added to the 950 cc amber glass bottle and mixed in a Turbula bottle blender for 10 minutes. The blend was passed

through a mini Co-mil using a 0.8 mm screen size to enhance mixing and distribution of components. The blend was then mixed for an additional 10 minutes in a Turbula bottle blender. The batch amount of magnesium stearate was then added to the previous mixture in the 950 cc amber glass bottle and was mixed for 3 minutes in a Turbula bottle blender.

[0097] Polyethylene oxide Coagulant grade and sodium chloride were passed through 30 mesh screen and the large particles that remained on the screen were discarded. Separately, the primary particle size of the sodium metabisulfite and butylated hydroxyanisole was reduced using a mortar and pestle. One-half the batch amount of polyethylene oxide was combined with the batch amounts of sodium metabisulfite and butylated hydroxyanisole and added to a 950 cc amber glass bottle and mixed for 5 minutes in a Turbula bottle blender. The remaining amount of polyethylene oxide Coagulant grade, microcrystalline cellulose, blue lake dye and sodium chloride powder were added in that order to a 950 cc amber glass bottle and mixed for 10 minutes with a Turbula bottle blender. The blend was passed through a mini Co-mil using a 0.8mm screen size to enhance mixing and distribution of components. 1.0 gram of magnesium stearate was added to the bottle and mixed for 3 minutes.

[0098] Bilayer tablets were compressed using 9/32 inch standard round convex tooling, to an average target weight of 180.0 mg +/- 5% and an average target thickness of 5.0 mm +/- 0.1 mm.

Table 19

Active Layer Components	% Weight	Unit Quantity	Batch Quantity
		(mg/tablet)	(grams)
Tofacitinib Citrate	14.80	17.76	29.61
Polyethylene Oxide (Polyox WSR N80)	79.30	95.16	158.59
Sodium Metabisulfite	4.67	5.60	9.33
Butylated Hydroxyanisole	0.23	0.28	0.47
Magnesium Stearate	1.00	1.20	2.00
Total	100.00	120.00	200.00
Sweller Layer Components:	% Weight	Unit Quantity	Batch Quantity
		(mg/tablet)	(grams)
Polyethylene Oxide (Polyox WSR Coagulant)	51.67	31.00	103.33
Microcrystalline Cellulose	20.00	12.00	40.00
Sodium Chloride	25.00	15.00	50.00
Sodium Metabisulfite	2.41	1.45	4.82
Butylated Hydroxyanisole	0.12	0.07	0.24
FD&C Blue No2 Lake	0.30	0.18	0.60
Magnesium Stearate	0.50	0.30	1.00

Sweller Layer Components:	% Weight	Unit Quantity	Batch Quantity
		(mg/tablet)	(grams)
Total	100.00	60.00	200.00

[0099] The coating solution was prepared according to the following steps (see also Table 20): First, 150.0 grams of water was added to 40.5 grams of PEG 3350 in 4L mixing vessel and mixed or swirled by hand until the PEG was entirely dissolved. Secondly, 109.5 g of cellulose acetate was added to the 4L mixing vessel containing the PEG-water solution. The CA was disbursed as a slurry or wet cake. While using the 4L mixing vessel equipped with a rotating impeller, 2198.1 grams of acetone was added to the PEG-water-CA mixture. The contents of the mixing vessel were agitated until all solids are dissolved.

Table 20

#	Material	Composition (%)	Grams
1	Cellulose Acetate	4.38%	109.5
2	Polyethylene Glycol 3350 with 100 ppm BHT (PEG 3350)	1.62%	40.50
3	Sodium Metabisulfite	0.064%	1.60
4	Butylated Hydroxyanisole	0.012%	0.31
5	Acetone ⁽¹⁾	87.92%	2198.1
6	Purified Water ⁽¹⁾	6.00%	150.0
	Total	100.00%	2500.0

[0100] 250 grams of the tofacitinib bilayer tablet cores were coated in a Vector LDCS-5 with a 0.5 liter fully perforated coating pan operating at 30 rpm and an airflow of 35 CFM having an exhaust temperature of 32 deg C. The 6% solids (w/w) solution was applied until an in-process coating weight gain of 25.2 mg per tablets was achieved. The tablets were then removed from the coating pan and dried at 40 C for 16 hours.

[0101] A single delivery port with a diameter of 1.0 mm was formed through the coating membrane centered on the face of the drug layer side of the bilayer tablet. The delivery port was formed either by mechanical means or via laser ablation. The target coating level of 23.7 mg or 13% of the target bilayer core weight provides a controlled release drug delivery corresponding to 80% of the drug delivered at 2.8 hours in pH 6.8 media, paddles at 50 rpm based on Dissolution test 1. Additional dissolution data is given in Table 21.

Table 21

Time (hours)	% Release
1.0	17
2.5	73

Time (hours)	% Release
5.0	98

Reference Example 8. 22 mg Bilayer Osmotic Tablet

[0102] The formulation of Reference Example 8 was made as follows (see also Table 22): The batch quantity of Polyethylene Oxide N80 was passed through a 30 mesh screen. The large particles that remained on the screen were discarded. Polyethylene Oxide N80 was added to a 500 cc amber bottle and hand blended to coat the inside of the bottle. The batch quantity of Tofacitinib was added and mixed for 10 minutes with a Turbula bottle blender. 1.0 gram of magnesium stearate was added to the bottle of active blend and mixed for 3 minutes.

[0103] The batch quantity of Polyethylene oxide Coagulant grade and sodium chloride were passed through 30 mesh screen. Polyethylene oxide, the batch quantity of microcrystalline cellulose, the batch quantity of blue lake dye and sodium chloride powder were added in that order to a 950 cc bottle. The blend was mixed for 10 minutes with a Turbula bottle blender. 1.0 gram of magnesium stearate was added to the bottle of sweller layer and mixed for 3 minutes.

[0104] Tablets were compressed using 5/16 inch standard round convex tooling, to an average target weight of 250.0 mg +/- 5% and an average target thickness of 5.6 mm +/- 0.1 mm.

Table 22

Active Layer Components:	Grade:	Quantity (mg)/unit:	%	Batch Quantity (grams)
Tofacitinib Citrate		35.53	21.28%	21.28
Polyethylene Oxide WSR N80 Grade ^a	NF	129.80	77.72%	77.72
Magnesium Stearate ^e	NF/EP	1.67	1.0%	1.00
		167.00	100.0%	100.00
Sweller Layer Components:	Grade:	Quantity (mg)/unit:		Batch Quantity (grams)
Polyethylene Oxide Coagulant Grade ^a	NF	44.99	54.20	108.40
Microcrystalline Cellulose	PhEur/NF	16.60	20.00	40.00
Sodium Chloride ^b	USP/EP	20.75	25.00	50.00
FD&C Blue No2 Lake Dye ^d	Food	0.25	0.30	0.60
Magnesium Stearate ^e	NF/EP	0.42	0.50	1.00
		83.00	100.0%	200.00

Sweller Layer Components:	Grade:	Quantity (mg)/unit:		Batch Quantity (grams)
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[0105] The coating solution was prepared according to the following steps (see also Table 23): First, 180.0 grams of water was added to 48.6 grams of PEG 3350 in 4L mixing vessel and mixed or swirled by hand until the PEG was entirely dissolved. Secondly, 131.4 g of cellulose acetate was added to the 4L mixing vessel containing the PEG-water solution. The CA was dispersed as a slurry or wet cake. While using the 4L mixing vessel equipped with a rotating impeller, 2,640.0 grams of acetone was added to the PEG-water-CA mixture. The contents of the mixing vessel were agitated until all solids were dissolved.

Table 23

#	Material	Composition (%)	Grams
1	Cellulose Acetate	4.38%	131.4
2	Polyethylene Glycol 3350 with 100 ppm BHT (PEG 3350)	1.62%	48.6
3	Acetone	88.00%	2640.0
4	Purified Water	6.00%	180.0
	Total	100.00%	3000.0
Component		Coaling Solution % Wt	mg/tablet
Tofacitinib Citrate Bilayer Core Tablet Core		-	250.00
Cellulose Acetate		4.38%	20.08
Polyethylene Glycol 3350 with 100 ppm BHT (PEG 3350)		1.62%	7.43
Acetone ⁽¹⁾		88.00%	403.33
Purified Water ⁽¹⁾		6.00%	27.5
Total		100.00%	277.50
⁽¹⁾ Included for Coating Compositional Purposes, Not Present in Final Dosage Form			

[0106] 250 grams of the mg bilayer tablet cores were coated in a Vector LCDS-5 with a 0.5-Liter fully perforated coating pan or drum operating at 30 rpm and an airflow of 35 CFM having an exhaust temperature of 32 deg C. The 6% solids (w/w) solution was applied until an in-process coating weight gain of 30.0 mg per tablets was achieved. The tablets were then removed from the coating pan and dried at 40 C for 16 hours.

[0107] A single delivery port with a diameter of 1.0 mm was formed through the coating membrane centered on the face of the drug layer side of the bilayer tablet. The delivery port can be formed either by mechanical means or via laser ablation. The target coating level of 27.5 mg or 11% of the target bilayer core weight provided a controlled release drug delivery exhibiting 80% of the drug delivered at 3.7 hours in pH 6.8 media, paddles at 50 rpm based on Dissolution test 1. Additional dissolution data is given in Table 24.

Table 24

Time (hours)	% Release
1.0	11
2.5	53
5.0	90

Reference Example 9. 20 mg AMT formulation

[0108] Formulate Reference Example 9 as follows (see also Table 25). Pass the batch quantities of Tofacitinib, Mannitol, Microcrystalline Cellulose, and Dibasic Calcium Phosphate through a 30 mesh screen and add to a 500 cc amber bottle. Mix the blend for 10 minutes with a Turbula bottle blender. Pass 0.3 grams of magnesium stearate through a 30 mesh screen and add to the bottle of active blend and mix for 3 minutes.

[0109] Compress the blend into compacts having a solid fraction of ~0.70. Mill the compacts to form a granulation. Pass 0.2 grams of magnesium stearate through a 30 mesh screen and add to the bottle of active granulation and mix for 3 minutes.

[0110] Compress tablets using 9-mm standard round convex tooling, to an average target weight of 400 mg +/- 5%, average target thickness of 7 mm +/-0.05 mm, and a target hardness of 15 kP.

Table 25

Sweller Layer Components:	Grade:	Quantity (mg)/unit:	%	Batch Quantity (grams)
Tofacitinib Citrate		33.33	8.33%	3.33
Mannitol 2080	NF/EP	140.00	35%	14
Microcrystalline Cellulose	NF/EP	60.00	15%	6
Dibasic Calcium Phosphate	NF/EP	161.67	40.42%	16.17
Magnesium Stearate ^e	NF/EP	3.00	0.75%	0.3
Magnesium Stearate ^e	NF/EP	2.00	0.50%	0.2
		400.00	100.0%	40

[0111] Prepare the coating solution according to the following steps (see also Table 26): First, add 115 grams of water and 150 grams of acetone to a 2-Liter vessel and mix for 5 minutes. Add 12 grams of hydroxypropyl cellulose to the mixture and mix for 5 minutes. Add 28 grams of cellulose acetate to the mixture and mix for 5 minutes. Add the remaining 195 grams of cellulose acetate to the mixture and mixed for 3 hours. This procedure creates a 8% solids (w/w) solution.

Table 26

Composition of duration 1 coated tablet	% in coating	mg/tablet 7.5% wt gain
1. Tofacitinib Citrate Tablet Core	---	400
2. Cellulose Acetate (Type 398-10)	5.6%	21.0
3. Hydroxypropyl Cellulose (Klucel EF)	2.4%	9.0
4. Acetone	69.0%	(258.8)
5. Purified water	23.0%	(86.2)
Total Weight	100%	430

[0112] Coat 250 grams of the 400 mg weight SRC tablets in a Vector LCDS-5 with a 0.5-Liter semi-perforated pan operating at 30 rpm and an airflow of 30 CFM having an exhaust temperature of 40 deg C. Spray the 8% solids (w/w) solution until the wet weight gain reached a level of 7.5%. Remove the tablets from the coating pan and dry at 40 C for 16 hours.

Reference Example 10. 20 mg Bilayer Osmotic Capsule

Pre-mix

[0113] 98.94 grams of polyethylene oxide (Polyox WSR N80 LEO) and 1.06 grams of magnesium stearate were passed through a 30-mesh sieve and added to a 250 ml amber bottle. The blend was mixed using a Turbula mixer (Model T2F) operating at 49 cycles/min for 2 minutes.

Active Layer - 600 mg weight

[0114] 283.71 mg of the Pre-mix was added to a 1 dram glass vial and shaken by hand to pre-coat the inside of the glass vial. 32.57 mg of tofacitinib citrate was passed through a 20 or 30 mesh sieve and added to the 1 dram glass vial. An additional 283.71 mg of the Pre-mix was then added to the 1 dram glass vial. The contents of the glass vial were then blended using a

Turbula mixer (Model T2F) operating at 49 cycles/min for 5 minutes. The blend was then transferred to a Natoli single-station hydraulic tablet press and compressed to a target thickness of 15.6 mm using 5.500" B-type 0.3051" Modified Ball Upper Punch and a 4.755" B-type 0.3051" Flat Face Bevel Edge Lower Punch.

Sweller Layer - 300 mg weight

[0115] The sweller layer for the formulation of Reference Example 10 was made as follows (see also Table 27): The batch quantities of polyethylene oxide Coagulant grade, blue lake dye, sodium chloride and microcrystalline cellulose were passed through a 20 or 30 mesh screen added in that order to a 10-Liter Bin blender. The contents of the blender were mixed for 10 minutes of 12 rpm. The blend was then passed blend through a Comil 197S with a round impeller and 0.055" round screen operating at 1000 rpm. The batch quantity of magnesium stearate was added to the middle of the de-lumped blend in the bin blender. The contents of the blender were mixed for 5 minutes of 12 rpm. The blend was then transferred to a Kilian T-100 rotary tablet press and compressed to a target weight of 300 mg and a target thickness of 6.65 mm using 5.500" B-type 0.3051" Modified Ball Upper Punch and a 4.755" B-type 0.3051" Flat Face Bevel Edge Lower Punch.

Table 27

Component:	Grade:	Quantity (mg)/unit:	%	Batch Quantity (grams)
Polyethylene Oxide Coagulant Grade ^a	NF	154.50	51.5%	2060.00
Sodium Chloride ^b	USP/EP	104.40	34.8%	1392.00
Microcrystalline Cellulose ^c	NF/EP	39.00	13.0%	520.00
FD&C Blue No2 Lake Dye ^d	Food	0.60	0.2%	8.00
Magnesium Stearate ^e	NF/EP	1.50	0.5%	20.00
		300.00	100.0%	4000.00

Capsule Shell

[0116] 2.5 kg of pre-coating solution was prepared by combining 25 grams of polysorbate 80 with 2475 grams of acetone and mixing for 10 minutes or until dissolved to yield a 1% (w/w) solution.

[0117] 15 kg of functional coating solution was prepared according to the following steps (see also Table 28): First, the entire 375 grams of water and 120 grams of PEG 3350 were added to a suitable vessel and mixed. 14,325 grams of acetone were added to the mixture and mixed.

180 grams of cellulose acetate were added to the mixture and mixed until a uniform solution was obtained. This procedure created a 2% solids (w/w) solution.

Table 28

Composition of capsule shells	% in coating	mg in cap	mg in body	Batch Quantity (grams)
1. Cellulose Acetate (Type 398-10)	1.2%	58.5	55.5	180
2. Polyethylene Glycol 3350	0.8%	39.0	37.0	120
3. Acetone	95.5%	(4655.6)	(4416.9)	(14,325)
4. Purified water	2.5%	(121.9)	(115.6)	(375)
Total Weight	100%	97.5	92.5	15,000

[0118] 1 kg of HDPE capsule molds (either caps or bodies) were coated in a Vector LCDS-5 with a 1.5-Liter semi-perforated pan operating at 18 rpm and an airflow of 40 CFM having an exhaust temperature of 40 deg C. After briefly coating the molds with the 1% w/w pre-coating solution, the functional 2% solids (w/w) coating solution was sprayed at a rate of 20 grams/min with an atomizing air pressure of 10 psi and a gun-to-bed distance of 3 inches until the wet weight gain reached a level of 12.5%. The capsule molds were then removed from the coating pan and dried at 40 C for 24 hours. The capsule shells were then removed from the molds and trimmed.

[0119] A single hole (2000 microns) was drilled in the end of the capsule bodies. The hole can be drilled either by mechanical means or via laser ablation Assembly

[0120] The Active Layer was inserted into the half of the capsule shell with the pre-drilled hole. The Sweller Layer was inserted into the same half of the capsule shell, flat side first, to be flushed against the active layer. These components were inserted into the other half of the capsule shell to close the capsule. When prepared and combined in this manner, these components provided the following release in pH 6.8 media, paddles at 50 rpm based on Dissolution test 1 (Table 29)

Table 29

Time (hr)	% Drug Dissolved
1	4
2.5	25
5	65

80% of tofacitinib was dissolved in about 6 hours in Dissolution test 1.

Reference Example 11. 20 mg Bilayer Osmotic Capsule

Pre-mix

[0121] 98.94 grams of polyethylene oxide (Polyox WSR N80 LEO) and 1.06 grams of magnesium stearate were passed through a 30-mesh sieve and added to a 250 ml amber bottle. The blend was mixed using a Turbula mixer (Model T2F) operating at 49 cycles/min for 2 minutes.

Active Layer - 600 mg weight

[0122] 283.71 mg of the Pre-mix was added to a 1 dram glass vial and shaken by hand to pre-coat the inside of the glass vial. 32.57 mg of tofacitinib citrate was passed through a 20 or 30 mesh sieve and added to the 1 dram glass vial. 283.71 mg of the Pre-mix was then added to the 1 dram glass vial. The contents of the glass vial were then blended using a Turbula mixer (Model T2F) operating at 49 cycles/min for 5 minutes. The blend was then transferred to a Natoli single-station hydraulic tablet press and compressed to a target thickness of 15.6 mm using a 5.500" B-type 0.3051" Modified Ball Upper Punch and a 4.755" B-type 0.3051" Flat Face Bevel Edge Lower Punch.

Sweller Layer

[0123] The sweller layer for the formulation of Reference Example 11 was made as follows (see also Table 30). The batch quantities of polyethylene oxide Coagulant grade, blue lake dye, sodium chloride and microcrystalline cellulose were passed through a 20 or 30 mesh screen added in that order to a 10-Liter Bin blender. The contents of the blender were mixed for 10 minutes of 12 rpm. The blend was then passed blend through a Comil 197S with a round impeller and 0.055" round screen operating at 1000 rpm. The batch quantity of magnesium stearate was added to the middle of the de-lumped blend in the bin blender. The contents of the blender were mixed for 5 minutes of 12 rpm. The blend was then transferred to a Kilian T-100 rotary tablet press and compressed to a target weight of 300 mg and a target thickness of 6.65 mm using 5.500" B-type 0.3051" Modified Ball Upper Punch and a 4.755" B-type 0.3051" Flat Face Bevel Edge Lower Punch.

Table 30

Component:	Grade:	Quantity (mg)/unit:	%	Batch Quantity (grams)
Polyethylene Oxide Coagulant Grade ^a	NF	154.50	51.5%	2060.00
Sodium Chloride ^b	USP/EP	104.40	34.8%	1392.00
Microcrystalline Cellulose ^c	NF/EP	39.00	13.0%	520.00
FD&C Blue No2 Lake Dye ^d	Food	0.60	0.2%	8.00

Component:	Grade:	Quantity (mg)/unit:	%	Batch Quantity (grams)
Magnesium Stearate ^e	NF/EP	1.50	0.5%	20.00
		300.00	100.0%	4000.00

Capsule Shell

[0124] 2.5 kg of pre-coating solution was prepared by combining 25 grams of polysorbate 80 with 2475 grams of acetone and mixing for 10 minutes or until dissolved to yield a 1% (w/w) solution.

[0125] 15 kg of functional coating solution was prepared according to the following steps (see also Table 31): First, the 375 grams of water and 61.5 grams of PEG 3350 were added to a suitable vessel and mixed. 14,325 grams of acetone were added to the mixture and mixed. 225 grams of cellulose acetate were added to the mixture and mixed. 13.5 Grams of TEC were added to the mixture and mixed until a uniform solution was obtained. This procedure creates a 2% solids (w/w) solution.

Table 31

Composition of capsule shells	% in coating	mg in cap	mg in body	Batch Quantity (grams)
1. Cellulose Acetate (Type 398-10)	1.50%	73.1	69.38	225
2. Polyethylene Glycol 3350	0.41%	20.0	18.69	61.5
3. Triethyl Citrate (TEC)	0.09%	4.4	4.16	13.5
4. Acetone	95.5%	(4655.6)	(4416.9)	(14,325)
5. Purified water	2.5%	(121.9)	(115.6)	(375)
Total Weight	100%	97.5	92.5	15,000

[0126] 1 kg of HDPE capsule molds (either caps or bodies) were coated in a Vector LCDS-5 with a 1.5-Liter semi-perforated pan operating at 18 rpm and an airflow of 40 CFM having an exhaust temperature of 40 deg C. After briefly coating the molds with the 1% w/w pre-coating solution, the functional 2% solids (w/w) coating solution was sprayed at a rate of 20 grams/min with atomizing air pressure of 10 psi and a gun-to-bed distance of 3 inches until the wet weight gain reached a level of 12.5%. The capsule molds were then removed from the coating pan and dried at 40 C for 24 hours. The capsule shells were then removed from the molds and trimmed.

[0127] A single hole (2000 microns) was drilled in the end of the capsule bodies. The hole can

be drilled either by mechanical means or via laser ablation.

Assembly

[0128] The Active Layer is inserted into the half of the capsule shell with the pre-drilled hole. The Sweller Layer is inserted into the same half of the capsule shell, flat side first, to be flushed against the active layer. These components are inserted into the other half of the capsule shell until the capsule is closed. When prepared and combined in this manner, these components provide the following release in pH 6.8 media, paddles at 50 rpm based on Dissolution test 1 (Table 32).

Table 32

Time (hr)	% Drug Dissolved
1	1
2.5	4
5	21

[0129] 80% of tofacitinib is dissolved in about 14 hours in dissolution method 1.

Reference Example 12. Hydrophilic matrix controlled release tablet

[0130] The metal surfaces of a 10L bin were pre-coated by adding the batch quantity (also see Table 33 below), 963g of Lactose Fast Flo 316 and blending for 2 minute at 12 +/- 1 RPM. The batch quantity of Tofacitinib, 164g was added to the 10L bin and folded into the lactose monohydrate. The Tofacitinib container was rinsed with some of the lactose monohydrate from the 10L bin. The batch quantity of Hypromellose, 1150g, was added to the 10L bin. All of the components were blended in the bin for 10 minutes at 12 +/- 1 RPM.

[0131] The blend was passed through a Comil rotary mill equipped with a 0.032" screen and a round edge impeller running at approximately 1400 RPM. The blend was collected in a second 10L bin. The bin contents were blended for 10 minutes at 12 +/- 1 RPM.

[0132] Intragranular magnesium stearate, 5.75g, was added to the bin and blended for 3 minutes at 12 +/- 1 RPM. The lubricated blend was processed through a Gerteis roller compactor equipped with knurled rollers, side rims, and an inline oscillating mill containing a pocket rotor and a 1-mm rasping plate. The target ribbon solid fraction is 0.7 (0.67-0.73) and granules were collected in the initial 10L bin.

[0133] Extragranular magnesium stearate, 17.25g, was added to the bin and contents were blended for 3 minutes at 12 +/- 1 RPM. Final blend was affixed above a Kilian T-100 rotary

tablet press. Tablets were compressed using 13/32" SRC tooling, to an average target weight of 500 mg +/- 5% and a target hardness of 15 kP. Tablets were passed through a deduster and a metal detector.

Table 33

22 mg Tofacitinib hydrophilic matrix tablet composition: Total tablet weight 500 mg			
Ingredient	Function	% Composition	Grams
Tofacitinib Citrate	Active ingredient	7.1%	164.00
Methocel K100LV CR Premium Grade	Polymer, gel former providing controlled release	50%	1150.00
Lactose Monohydrate, Fast Flo 316	Filler	41.9%	963
Magnesium stearate, vegetable grade (IG)	Lubricant	0.25%	5.75
Magnesium stearate, vegetable grade (EG)	Lubricant	0.75%	17.25
Total		100%	2300.00

[0134] The compressed tablets provide the following release in pH 6.8 media, paddles at 50 rpm based on Dissolution test 1 (Table 34).

Table 34

Time (hr)	% Drug Dissolved
1	16
2.5	32
5	54

Reference Example 13. 10 mg Immediate Release Tablet

[0135]

Table 35: Composition of the formulation of Reference Example 13

Component Name	Grade	Unit Composition (mg)
1. Tofacitinib Citrate	Pharm	16.155
2. Microcrystalline Cellulose	Ph.Eur/NF	245.23
3. Lactose Monohydrate	Ph.Eur/NF	122.615
4. Croscarmellose Sodium	Ph.Eur/NF	12.000
5. Magnesium Stearate	Ph.Eur/NF	1.000

Component Name	Grade	Unit Composition (mg)
6. Magnesium Stearate	Ph.Eur/NF	3.000
TABLET CORE WEIGHT:		400.000
7. Opadry II White (HPMC based)	Pharm	12.000
8. Purified Water	Ph.Eur/USP	(68.000)
Total:		412.000mg

[0136] The tablet formulation of Reference Example 13 is manufactured according to the following process. Components 1 - 4 are combined and processed using a blend-mill-blend procedure. Component 5 is then added to the blend contents and combined using a blending procedure. This lubricated blend is then dry granulated. Component 6 is then added to the dry granulation and combined using a blending procedure. The lubricated granulation is compressed into 400 mg weight tablets using a rotary tablet press. The tablets are then coated using a film coater which sprays a solution containing Components 7 and 8 until 12 mg of coating has been applied to the tablets.

Reference Example 14. 5 mg Immediate Release Tablet

[0137]

Table 36: Composition of the formulation of Reference Example 14

Component Name	Grade	Unit Composition (mg)
1. Tofacitinib Citrate	Pharm	8.078
2. Microcrystalline Cellulose	Ph.Eur/NF	314.615
3. Lactose Monohydrate	Ph.Eur/NF	157.307
4. Croscarmellose Sodium	Ph.Eur/NF	15.000
5. Magnesium Stearate	Ph.Eur/NF	2.500
6. Magnesium Stearate	Ph.Eur/NF	2.500
TABLET CORE WEIGHT:		500.000
7. Opadry II White (HPMC based)	Pharm	20.000
8. Purified Water	Ph.Eur/USP	(113.333)
Total:		520.000mg

[0138] The tablet is manufactured according to the following process. Components 1 - 4 are combined and processed using a blend-mill-blend procedure. Component 5 is then added to the blend contents and combined using a blending procedure. This lubricated blend is then dry granulated. Component 6 is then added to the dry granulation and combined using a blending procedure. The lubricated granulation is compressed into 500 mg weight tablets using a rotary

tablet press. The tablets are then coated using a film coater which sprays a solution containing Components 7 and 8 until 20 mg of coating has been applied to the tablets.

Reference Example 15. Study A

[0139] The relative bioavailability of a single dose of 2 different oral sustained release formulations of 20 mg tofacitinib relative to a single dose of 10 mg tofacitinib immediate release (IR) tablets were performed and the following endpoints for tofacitinib were determined: C_{max}, T_{max}, AUC_{inf}, AUC_{last}. An additional endpoint was determined for the relative bioavailability (%RBA) of tofacitinib for each sustained release formulation relative to the IR formulation.

[0140] The study was a randomized, open-label, single dose, 3-period, 3-treatment, 6-sequence crossover study in 12 healthy male subjects (See Table 36). Subjects received two different sustained release formulations of tofacitinib and the immediate release tablet formulation with a washout period of 3 days between doses. The sustained release formulations were given as a 20 mg single dose and the immediate release formulation was given as two 5 mg tablets in a single dose.

Table 36

Sequence	Period		
	1	2	3
ABC (n=2)	A	B	C
BCA (n=2)	B	C	A
CAB (n=2)	C	A	B
ACB (n=2)	D	E	C
BAC (n=2)	E	A	D
CBA (n=2)	A	E	B
A: Immediate Release Tablet, 10 mg; B: <u>Reference</u> Example 10 bilayer osmotic capsule, 20 mg; C: <u>Reference</u> Example 11 bilayer osmotic capsule, 20 mg;			

Subjects were fasted overnight for at least 8 hours prior to administration of the study drug. On the morning of Day 1 of each period, all subjects received a single oral dose of study drug with 240 mL of water. Subjects were allowed a standardized lunch 4 hours after dose administration.

Dosage Forms Administered:

[0141] Tofacitinib 10 mg Immediate Release Control Tablet (reference): prepared in Reference Example 13.

[0142] Tofacitinib 20 mg bilayer osmotic capsule: prepared in Reference Example 10.

[0143] Tofacitinib 20 mg bilayer osmotic capsule: prepared in Reference Example 11.

[0144] During all study periods, blood samples to provide plasma for pharmacokinetic analysis were collected at periodic time points. PK samples were analyzed using standard validated analytical methods. Dose normalized natural log transformed AUC_{inf} , AUC_{last} and C_{max} are analyzed for tofacitinib using a mixed effect model with sequence, period and treatment as fixed effects and subject within sequence as a random effect. Estimates of the adjusted mean differences (Test-Reference) and corresponding 90% confidence intervals were obtained from the model. The adjusted mean differences and 90% confidence intervals for the differences was exponentiated to provide estimates of the ratio of adjusted geometric means (Test/Reference) and 90% confidence intervals for the ratios. The immediate release control tablet formulation was the Reference treatment and the sustained release formulations were the Test treatments.

[0145] The relative bioavailability of tofacitinib was estimated as the ratio of dose-normalized adjusted geometric means for Test and Reference for AUC_{inf} .

[0146] The PK parameters AUC_{inf} , AUC_{last} , C_{max} , T_{max} , and $t_{1/2}$ were summarized descriptively by treatment and analyte (when applicable). For AUC_{inf} and C_{max} , individual subject parameters were plotted by treatment for each analyte separately (when applicable). Concentrations were listed and summarized descriptively by PK sampling time, treatment and analyte (when applicable). Individual subject, mean and median profiles of the concentration-time data were plotted by treatment and analyte (when applicable). For summary statistics, and mean and median plots by sampling time, the nominal PK sampling time were used, for individual subject plots by time, the actual PK sampling time were used.

[0147] Predicted steady-state values were obtained via the superposition method using the software package WinNonLin (Pharsight Corp). Superposition was used on each individual's pharmacokinetic profile to generate the steady-state pharmacokinetic profile of each individual. The definitions and method of determination of PK parameters are given in Table 37. The results of the study are shown in Table 38.

Table 37

Parameter	Definition	Method of Determination
AUC_{last}	Area under the plasma concentration-time profile from time zero to the time of the last quantifiable concentration (C_{last})	Log-linear trapezoidal method
AUC_{inf}	Area under the plasma concentration-time profile from time zero extrapolated to infinite time	$AUC_{last} + (C_{last}^*/k_{el})$, where C_{last}^* is the predicted plasma concentration at the last quantifiable time point estimated from the log-linear

Parameter	Definition	Method of Determination
		regression analysis.
$AUC_{inf,dn}$	Area under the plasma concentration-time profile from time zero extrapolated to infinite time divided by the dose administered	AUC_{inf}/dose
C_{max}	Maximum plasma concentration	Observed directly from data
$C_{max,dn}$	Maximum plasma divided by the dose administered concentration	C_{max}/dose
T_{max}	Time for C_{max}	Observed directly from data as time of first occurrence
$t_{1/2}$	Terminal elimination half-life	$\text{Loge}(2)/k_{el}$, where k_{el} is the terminal phase rate constant calculated by a linear regression of the log-linear concentration-time curve. Only those data points judged to describe the terminal log-linear decline will be used in the regression.
$C_{min,ss}$	Minimum plasma concentration during the course of one, 24 hour interval once steady-state has been achieved	Observed from steady-state pharmacokinetic profile data, which is calculated from single dose data using the superposition method
$C_{min,dn,ss}$	Minimum plasma concentration during the course of one, 24 hour interval once steady-state has been achieved	$C_{min,ss}/\text{dose}$
$C_{max,ss}$	Maximum plasma concentration during the course of one, 24 hour interval once steady-state has been achieved	Observed from steady-state pharmacokinetic profile data, which is calculated from single dose data using the superposition method
$C_{max,ss}/C_{min,ss}$	Ratio of maximum and minimum plasma concentrations during the course of one, 24 hour interval once steady-state has been achieved	$C_{max,ss}/C_{min,ss}$
Time above 17 ng/ml	Period of time during the course of one, 24 hour interval of steady-state dosing that the plasma	Observed from steady-state pharmacokinetic profile data, which is calculated from single dose data using the superposition method

Parameter	Definition	Method of Determination
	concentration is 17 ng/ml	
Drug holiday (Time below 17 ng/ml)	Period of time during the course of one, 24 hour interval of steady-state dosing that the plasma concentration is below 17 ng/ml	Observed from steady-state pharmacokinetic profile data, which is calculated from single dose data using the superposition method

Table 38

Single Dose PK Parameters	10 mg IR Tablet (Reference)	20 mg Ref. Example 10 Osmotic Capsule (Test)	20 mg Ref. Example 11 Osmotic Capsule (Test)		
C _{max} (ng/ml)	121.5 (30%)	41.8 (24%)	18.2(16%)		
C _{max,dn} (ng/ml/mg)	12.1 (30%)	2.1 (24%)	0.9 (16%)		
AUC _{inf} (ng*hr/ml)	339.5 (17%)	543.6 (23%)	390.2 (38%)		
AUC _{inf,dn} (ng*hr/ml/mg)	34.0 (17%)	27.2 (23%)	18.8 (38%)		
t _{1/2} (hr)	3.35 (13%)	5.84 (23%)	6.07 (53%)		
T _{max} (hr)	0.5 (0.25-2)	5 (4-10)	13 (4-24)		
Dose Normalized C _{max} Ratio (%)	100%	17% (14-20%)	7.5% (6-9%)		
Dose Normalized RBA (%)	100%	80% (65-99%)	55% (45-69%)		
The above values are reported as Geometric mean (% coefficient of variation (CV)) for all except: median (range) for Tmax; arithmetic mean (%CV) for t _{1/2} . The above ratios are presented as geometric mean ratio (90% Confidence Intervals).					
Predicted Steady-State PK	10 mg IR BID (Reference)	20 mg Ref. Example 1 10 Osmotic Capsule QD) (Test)	25 mg Ref. Example 10 Osmotic Capsule QD* (Test)	20 R _{ef} Example 1 Osmotic Capsule QD (Test) mg 11	33 mg Ref. Example 11 Osmotic Capsule QD* (Test)
C _{max,ss} (ng/ml)		46.0	57.5	23.7	39.1
	(30%)	(24%)	(24%)	(30%)	(30%)
C _{min,ss} (ng/ml)		6.1	7.7	9 9.9	16.3
	(39%)	(37%)	(37%)	(76%)	(76%)
C _{min,dn,ss} (ng/ml/mg)	0.19	0.31	0.31	0. 50	0.50
	(39%)	(37%)	(37%)	(76%)	(76%)

$C_{min,ss}$ Ratio (%)	100%	166% (128-215%)	207% (160-268%)	267% (123-581%)	441% (203-958%)
$C_{max,ss}/C_{min,ss}$	34	7.5	7.5	2.4	2.4
Time above 17 ng/ml (hrs)	12.6 (2 x 6.3 hrs)	13.1	15.1	16.9	18.6
Drug holiday (Time below 17 ng/ml) (hrs)_	11.4	10.9	8.9	7.1	5.4
The above parameters are presented as geometric mean (%CV). The above ratios are presented as geometric mean ratio (90% Confidence Intervals). * - necessary dose adjustment to achieve 100% RBA with those durations of modified release					

[0148] The results of this study show that sustained release dosage forms which require 6 hours or longer to release and dissolve 80% of tofacitinib do not meet the desired pharmacokinetic attributes for tofacitinib sustained release dosage forms. Specifically, a sustained release dosage form which requires 6 hours or longer to release and dissolve 80% of tofacitinib, and has the required amount of tofacitinib to provide an equivalent AUC value to the immediate release dosage form, provides a time above 17 ng/ml (the JAK 1/3 receptor IC_{50} value) which is greater than the time above 17 ng/ml for the immediate release dosage form. Further, a sustained release dosage form which requires 14 hours to release and dissolve 80% of tofacitinib has a higher dose-normalized $C_{min,ss}$, a lower dose-normalized AUC, and a low relative bioavailability to the immediate release dosage form, which requires an increase in the drug loading of tofacitinib to have equivalent AUC to the immediate release dosage form. These results support the requirement of a sustained release dosage form of tofacitinib requiring less than 6 hours to release and dissolve 80% of tofacitinib.

Example 16. Study B

[0149] The relative bioavailability of 3 different oral sustained release formulations of 22 mg tofacitinib relative to a single dose of 10 mg tofacitinib immediate release (IR) tablets were performed and the following endpoints for tofacitinib were determined: C_{max} , T_{max} , AUC_{inf} , AUC_{last} . An additional endpoint was determined for the relative bioavailability (%RBA) of tofacitinib for each sustained release formulation relative to the IR formulation.

[0150] The study was a randomized, open-label, single dose, 4-period, 6-treatment, 6-sequence partial crossover study in 30 healthy male subjects (See 39). In the first period, subjects received one of two different sustained release formulations of tofacitinib in the fed state. In the second and third periods, subjects received 2 of three sustained release formulations. In the fourth period, subjects received the immediate release tablet formulation. A washout period of 3 days was used between doses. The three sustained release formulations

are given as a 22 mg single dose and the immediate release formulation is given as two 5 mg tablets in a single dose.

Table 39

Sequence	Period			
	1 (fed)	2 (fasted)	3 (fasted)	4 (fasted)
1 (n=5)	A	C	D	F
2 (n=5)	A	C	E	F
3 (n=5)	B	D	E	F
4 (n=5)	B	D	C	F
5 (n=5)	A	E	C	F
6 (n=5)	B	E	D	F

A: 4-hr Extrudable Core System Tablet, 22 mg, fed state;
B: Reference Example 4 Matrix Tablet, 22 mg, fed state;
C: 4-hr Extrudable Core System Tablet, 22 mg, fasted state;
D: Reference Example 4 Matrix Tablet, 22 mg, fasted state;
E: Reference Example 12 Matrix Tablet, 22 mg, fasted state;
F: Immediate Release Tablet, 2x5 mg, fasted state;

In Period 1, after an overnight fast of at least 8 hours, subjects were administered the standard high-fat FDA breakfast 30 minutes prior to administration of the study drug. Breakfast was consumed within 30 minutes or less. Subjects received either Treatment A or Treatment B administrations 30 minutes (+/-5 minutes) after the initiation of breakfast. No additional food was allowed for at least 4 hours post-dose. Water was withheld for 1 hour pre-dose and 1 hour after the study drug administration. Dosing in Periods 1, 2, and 3 was followed by a minimum washout of 72 hours. The next period of the study (Periods 2, 3, and 4) started immediately following completion of the 72-hour PK sample procedures on Day 4 of the preceding period (Periods 1, 2, and 3 respectively). In Periods 2, 3, and 4, study drug was administered after an overnight fast of at least 8 hours. Food was only allowed after 4 hours post-dose. Water was withheld for 1 hour pre-dose and 1 hour after study drug administration.

Dosage Forms Administered:

[0151] Tofacitinib 5 mg Immediate Release Tablet (reference): prepared in Reference Example 14 above.

[0152] Tofacitinib 22 mg Extrudable Core System Tablet: prepared in Example 1 above.

[0153] Tofacitinib 22 mg Matrix Tablets: prepared in Reference Examples 4 and 12 above.

[0154] During all study periods, blood samples to provide plasma for pharmacokinetic analysis were collected at periodic time points. The study results are provided in Table 40. PK samples were analyzed using standard validated analytical methods. Dose normalized natural log

transformed AUC_{inf} , AUC_{last} and C_{max} was analyzed for tofacitinib using a mixed effect model with sequence, period and treatment as fixed effects and subject within sequence as a random effect. Estimates of the adjusted mean differences (Test-Reference) and corresponding 90% confidence intervals were obtained from the model. The adjusted mean differences and 90% confidence intervals for the differences was exponentiated to provide estimates of the ratio of adjusted geometric means (Test/Reference) and 90% confidence intervals for the ratios. The immediate release control tablet formulation was the Reference treatment and the sustained release formulations were the Test treatments.

[0155] The relative bioavailability of tofacitinib was estimated as the ratio of dose-normalized adjusted geometric means for Test and Reference for AUC_{inf} .

[0156] The PK parameters AUC_{inf} , AUC_{last} , C_{max} , T_{max} , and $t_{1/2}$ are summarized descriptively by treatment and analyte (when applicable). For AUC_{inf} and C_{max} , individual subject parameters were plotted by treatment for each analyte separately (when applicable). Concentrations are listed and summarized descriptively by PK sampling time, treatment and analyte (when applicable). Individual subject, mean and median profiles of the concentration-time data were plotted by treatment and analyte (when applicable). For summary statistics, and mean and median plots by sampling time, the nominal PK sampling time were used, for individual subject plots by time, the actual PK sampling time were used.

[0157] Predicted steady-state values were obtained via the superposition method using the software package WinNonLin (Pharsight Corp). Superposition was used on each individual's pharmacokinetic profile to generate the steady-state pharmacokinetic profile of each individual.

Table 40

Single dose, Bioavailability Evaluation	10 mg IR Tablet (Reference)	22 mg ECS (Test)	22 mg Matrix (Ref. Example 4) (Test)	22 mg Matrix (Ref. Example 12) (Test)
C_{max} (ng/ml)	108 (28%)	101 (28%)	89 (29%)	59 (29%)
$C_{max,dn}$ (ng/ml/mg)	10.8(28%)	4.6 (28%)	4.0 (29%)	2.7 (29%)
AUC_{inf} (ng*hr/ml)	367 (24%)	757 (23%)	781 (27%)	702 (23%)
$AUC_{inf,dn}$ (ng*hr/ml/mg)	36.7 (24%)	34.4 (23%)	35.5 (27%)	31.9(23%)
T_{max} (hr)	0.5 (0.5-4.0)	4.0 (2.0-6.0)	2.5 (1.0-6.0)	3.0 (2.0-4.0)
$t_{1/2}$ (hr)	3.7 (13%)	5.6 (60%)	5.3 (51%)	6.0 (46%)
C_{max} Ratio (%)	100%	92% (82%-104%)	84% (75%-94%)	56% (50%-62%)
Dose Normalized RBA (%)	100%	91% (87%-96%)	97% (92%-101%)	89% (85%-94%)
The above values are reported as Geometric mean (%CV) for all except: median				

Single dose, Bioavailability Evaluation	10 mg IR Tablet (Reference)	22 mg ECS (Test)	22 mg Matrix (Ref. Example 4) (Test)	22 mg Matrix (Ref. Example 12) (Test)
(range) for T _{max} ; arithmetic mean (%CV) for t _{1/2} . The above ratios are presented as geometric mean ratio (90% Confidence Intervals).				
Single Dose, Food Effect	22 mg ECS		22 mg Matrix (Ref. Example 4)	
Evaluation	Fasted (Reference)	Fed (Test)	Fasted (Reference)	Fed (Test)
C _{max} (ng/ml)	101 (28%)	113(20%)	89 (29%)	136 (25%)
AUC _{inf} (ng*hr/ml)	757 (23%)	732 (21%)	781 (27%)	823 (24%)
T _{max} (hr)	4.0 (2.0-6.0)	4.0 (3.0-6.0)	2.5 (1.0-6.0)	3.0 (2.0-6.0)
t _{1/2} (hr)	5.6 (60%)	4.9 (31%)	5.3 (51%)	4.8 (56%)
C _{max} Ratio (%)	100%	113% (100-128%)	100%	153% (135-174%)
RBA (%)	100%	100% (95-106%)	100%	105% (99-110%)
The above values are reported as Geometric mean (%CV) for all except: median (range) for T _{max} ; arithmetic mean (%CV) for t _{1/2} . The above ratios are presented as geometric mean ratio (90% Confidence Intervals).				
Predicted Steady-State PK	10 mg IR BID	22 mg 22 ECS QD	mg Matrix QD (Ref. Example 4)	22 mg Matrix QD (Ref. Example 12)
	Fasted	Fasted	Fasted	Fasted
	(Reference)	(Test)	(Test)	(Test)
C _{max,ss}	112.7	104.5	92.6	66.2
(ng/ml)	(30%)	(30%)	(32%)	(27%)
C _{min,ss}	5.0	3.80	3.31	7.36
(ng/ml)	(66%)	(92%)	(89%)	(60%)
C _{min,dn,ss}	0.25	0.17	0.15	0.33
(ng/ml/mg)	(66%)	(92%)	(89%)	(60%)
C _{min,ss}	100%	74%	64%	159%
Ratio (%)		(59-92%)	(51-81%)	(134-190%)
C _{max,ss} /C _{min,ss}	23	28	28	9
Time above	13.4	13.2	14.1	17.6
17 ng/ml (hrs)	(2 x 6.7 hrs)			
Drug holiday (time below 17 ng/ml) (hrs)	10.6	10.8	9.9	6.4

Predicted Steady-State PK	10 mg IR BID	22 mg 22 ECS QD	mg Matrix QD (Ref. Example 4)	22 mg Matrix QD (Ref. Example 12)
	Fasted	Fasted	Fasted	Fasted
	(Reference)	(Test)	(Test)	(Test)
The above parameters are presented as geometric mean (%CV). The above ratios are presented as geometric mean ratio (90% Confidence Intervals).				

[0158] Sustained-release dosage forms containing 22 mg of tofacitinib which release and dissolve 80% of tofacitinib in 4-5 hours provide dose-proportional pharmacokinetic performance and meet the desired pharmacokinetic claims when dosed in the fasted state. Sustained-release dosage forms containing 22 mg of tofacitinib which release and dissolve 80% of tofacitinib by osmotic pressure in 4 hours provide similar pharmacokinetic performance when administered in both the fed and fasted states. Sustained-release dosage forms containing 22 mg of tofacitinib which release and dissolve 80% of tofacitinib by matrix diffusion and erosion in 5 hours do not provide similar Cmax performance when administered in both the fed and fasted states.

Example 17. Study C

[0159] The relative bioavailability of a single dose of an oral sustained release formulation of 11 mg tofacitinib relative to a single dose of 22 mg tofacitinib sustained release tablets was performed and the following endpoints for tofacitinib are determined: Cmax, Tmax, AUCinf, AUClast. An additional endpoint was determined for the dose normalized relative bioavailability (%RBA) of tofacitinib for the 11 mg sustained release formulations relative to the 22 mg sustained release formulation.

[0160] The study was a randomized, open-label, single dose, 2-period, 2-treatment, 2-sequence crossover study in 20 healthy male subjects (See Table 41). Subjects received two different sustained release formulations of tofacitinib with a washout period of 3 days between doses. The sustained release formulations were given as an 11 or 22 mg single dose.

Table 41

Sequence	Period	
	1	2
AB (n=10)	A	B
BA (n=10)	B	A
A: Extrudable Core System Tablet, 11 mg; prepared in Example 1 above. B: Extrudable Core System Tablet, 22 mg; prepared in Example 1 above. Subjects were fasted overnight for at least 8 hours prior to administration of the study drug. On the morning of Day 1 of each period, all subjects received a single oral dose of		

study drug with 240 mL of water. Subjects were allowed a standardized lunch 4 hours after dose administration.

Dosage Forms Administered:

[0161] Tofacitinib 22 mg Sustained Release dosage forms: prepared in Example 1 above.

[0162] Tofacitinib 11 mg Sustained Release dosage forms: prepared in Example 1 above.

[0163] During all study periods, blood samples to provide plasma for pharmacokinetic analysis were collected at periodic time points. The study results are provided in Table 42. PK samples were analyzed using standard validated analytical methods. Dose normalized natural log transformed AUC_{inf} , AUC_{last} and C_{max} were analyzed for tofacitinib using a mixed effect model with sequence, period and treatment as fixed effects and subject within sequence as a random effect. Estimates of the adjusted mean differences (Test-Reference) and corresponding 90% confidence intervals were obtained from the model. The adjusted mean differences and 90% confidence intervals for the differences was exponentiated to provide estimates of the ratio of adjusted geometric means (Test/Reference) and 90% confidence intervals for the ratios. The 22 mg sustained release formulation was the Reference treatment and the 11 mg sustained release formulation was the Test treatment.

[0164] The relative bioavailability of tofacitinib was estimated as the ratio of dose-normalized adjusted geometric means for Test and Reference for AUC_{inf} .

[0165] The PK parameters AUC_{inf} , AUC_{last} , C_{max} , T_{max} , and $t_{1/2}$ were summarized descriptively by treatment and analyte (when applicable). For AUC_{inf} and C_{max} , individual subject parameters are plotted by treatment for each analyte separately (when applicable). Concentrations were listed and summarized descriptively by PK sampling time, treatment and analyte (when applicable). Individual subject, mean and median profiles of the concentration-time data were plotted by treatment and analyte (when applicable). For summary statistics, and mean and median plots by sampling time, the nominal PK sampling time were used, for individual subject plots by time, the actual PK sampling time were used.

[0166] Predicted steady-state values were obtained via the superposition method using the software package WinNonLin (Pharsight Corp). Superposition was used on each individual's pharmacokinetic profile to generate the steady-state pharmacokinetic profile of each individual.

Table 42

Single Dose PK Parameters	11 mg (Test)	22 mg (Reference)
C_{max} (ng/ml)	42.2 (32%)	84.4 (22%)
$C_{max,dn}$ (ng/ml/mg)	3.84 (32%)	3.84 (22%)

Single Dose PK Parameters	11 mg (Test)	22 mg (Reference)
AUC _{inf} (ng*hr/ml)	315.6 (21%)	645.8 (23%)
AUC _{inf,dn} (ng*hr/ml/mg)	28.7 (21%)	29.4 (23%)
T _{max} (hr)	3.0 (2.0-4.0)	3.0 (2.0-4.0)
t _{1/2} (hr)	6.25 (36%)	7.3 (46%)
C _{max,dn} Ratio (%)	100% (91-110%)	100%
AUC _{inf,dn} Ratio (%)	98% (95-101%)	100%
The above values are reported as Geometric mean (%CV) for all except: median (range) for T _{max} ; arithmetic mean (%CV) for t _{1/2} . The above ratios are presented as geometric mean ratio (90% Confidence Intervals).		
Predicted Steady-State PK	11 mg QD (Test)	22 mg QD (Reference)
C _{max,ss} (ng/ml)	43.6 (35%)	87.6 (25%)
C _{min,ss} (ng/ml)	1.7 (53%)	3.5 (75%)
C _{min,dn,ss} (ng/ml/mg)	0.15 (53%)	0.16 (75%)
C _{min,dn,ss} Ratio (%)	95% (72-125%)	100%
C _{max,ss} /C _{min,ss}	26	25
Time above 17 ng/ml (hrs)	6.6	11.1
Drug holiday (Time below 17 ng/ml) (hrs)	17.4	12.9

The above parameters are presented as geometric mean (%CV). The above ratios are presented as geometric mean ratio (90% Confidence Intervals).

[0167] Sustained-release dosage forms containing 11 mg and 22 mg of tofacitinib which release and dissolve tofacitinib according to the claims (based on dissolution test 1) provide dose-proportional pharmacokinetic performance and meet the desired pharmacokinetic claims.

Example 18 Study D

[0168] The relative bioavailability of 11 mg tofacitinib sustained release tablets relative to a single dose of two, 5 mg tofacitinib immediate release (IR) tablets were performed and the following endpoints for tofacitinib were determined: C_{max}, T_{max}, AUC_{inf}, AUC_{last}. An additional endpoint was determined for the relative bioavailability (%RBA) of tofacitinib for each sustained release formulation relative to the IR formulation.

[0169] The study was a randomized, open-label, single dose, 2-period, 2-treatment, 2-sequence crossover study in 26 healthy subjects (See Table 43). Subjects received either the 11 mg sustained release formulations of tofacitinib citrate or two, 5 mg immediate release formulation of tofacitinib citrate with a washout period of 3 days between doses.

Table 43

Sequence	Period	
	1	2
AB (n=13)	A	B
BA (n=13)	B	A

[0170] A: Extrudable Core System Tablet, 11 mg; prepared as follows:

Table 44

#	Material	Function	Composition (%)	300 kg Batch
1	Tofacitinib Citrate	Active	8.885	26.656
2	Sorbitol	Osmagen	76.115	228.344
3	Hydroxyethylcellulose	Viscosifying Agent	8.000	24.000
4	Copovidone	Binder	6.000	18.000
5	Magnesium Stearate	Lubricant	1.000	3.000
	Core Tablet Weight	---	100%	300.000 kg

[0171] One-half of the batch quantity of sorbitol, 114.172 kilograms, was added to an 800L bin. The batch quantity of Copovidone, 18.000 kilograms, was then added to the 800L bin. The batch quantity of Tofacitinib, 26.656 kilograms, was then added to the 800L bin. The batch quantity of Hydroxycellulose, 24.000 kilograms, was then added to the 800L bin. The remaining one-half of the batch quantity of sorbitol, 114.172 grams was added to the 800L bin. All materials were added via a vacuum transfer system and passed through a Comil rotary mill equipped with a 0.032" screen and a round edge impeller running at approximately 1400 RPM. All of the components are blended in the bin for 20 minutes at 12 +/- 1 RPM.

[0172] The blend was passed through a Comil rotary mill equipped with a 0.032" screen and a round edge impeller running at approximately 1400 RPM. The blend was collected in a second 800L bin. The bin contents were blended for 20 minutes at 12 +/- 1 RPM.

[0173] Magnesium stearate, 3.000 kilograms, was passed through an 850-micron mesh screen and was added to the bin and contents were blended for 5 minutes at 12 +/- 1 RPM. Tablets were compressed using 0.2080" x 0.4160" modified oval tooling on a Manesty Mark IV rotary tablet press, to an average target weight of 200 mg +/- 5%, average target thickness of 4.17 mm +/- 0.05 mm, and a target hardness of 11 kp. Tablets were passed through a deduster and a metal detector.

Table 45

Composition of coated 200 mgW tablet	% in coating	mg/tablet	coat w/w (%)	Batch Quantity (kilograms)
1. Tofacitinib Citrate Tablet Core	---	200	---	-----
2. Cellulose Acetate (Type 398-10)	1.8%	8.4	4.2	13.5
3. Hydroxypropyl Cellulose (Klucel EF)	1.2%	5.6	2.8	9.0
4. Methanol	19.6%	(91.5)	---	147.0
5. Acetone	77.4%	(361.2)	---	580.5
Total Weight	100%	214.0	7.0	750.0

[0174] The 750-kilogram coating solution was prepared according to the following steps. First, the entire 147.0 kilograms of methanol and 580.5 grams of acetone were added to a 250-gallon vessel. 13.5 kilograms of cellulose acetate were added to the mixture. 9.0 kilogram of hydroxypropyl cellulose were added to the mixture. The contents of the container were mixed for 1 hour. This procedure created a 3% solids (w/w) solution.

[0175] 250 kilograms of the 200 mg weight oval tablets were coated in a Vector HC-130 operating at 8 rpm and an airflow of 1500 CFM having an exhaust temperature of 28 deg C. The 3% solids (w/w) solution was applied until the wet weight gain reached a level of 7%. The tablets were then removed from the coating pan and dried at 45 C for 24 hours.

[0176] A single hole (600 micron) was drilled in the end of the band of the oval tablet. The hole can be drilled either by mechanical means or via laser ablation. A coating of 7% provided the following release in pH 6.8 media, paddles at 50 rpm based on Dissolution test 1 (Table 8):

Table 46

Time (hr)	11 mg tablet % Drug Dissolved
1	8
2.5	49
6	89

[0177] B: Tofacitinib 2 x 5 mg Immediate Release Tablet (reference) prepared as follows:
Table 46: Composition of the 5 mg Immediate Release Tablet

Component Name	Grade	Unit Composition (mg)
1. Tofacitinib Citrate	Pharm	8.078
2. Microcrystalline Cellulose	Ph.Eur/NF/JP	122.615
3. Lactose Monohydrate	Ph.Eur/NF/JP	61.307
4. Croscarmellose Sodium	Ph.Eur/NF/JP	6.000

Component Name	Grade	Unit Composition (mg)
5. Magnesium Stearate	Ph.Eur/NF/JP	0.500
6. Magnesium Stearate	Ph.Eur/NF/JP	1.500
TABLET CORE WEIGHT:		200.000
7. Opadry II White (HPMC based)	Pharm	6.000
8. Purified Water	Ph.Eur/USP/JP	(34.000)
Total:		206.000mg

[0178] The tablet is manufactured according to the following process. Components 1 - 4 are combined and processed using a blend-mill-blend procedure. Component 5 is then added to the blend contents and combined using a blending procedure. This lubricated blend is then dry granulated. Component 6 is then added to the dry granulation and combined using a blending procedure. The lubricated granulation is compressed into 200 mg weight tablets using a rotary tablet press. The tablets are then coated using a film coater which sprays a solution containing Components 7 and 8 until 6 mg of coating has been applied to the tablets.

[0179] Subjects were fasted overnight for at least 8 hours prior to administration of the study drug. On the morning of Day 1 of each period, all subjects received a single oral dose of study drug with 240 mL of water. Subjects were allowed a standardized lunch 4 hours after dose administration.

Dosage Forms Administered:

[0180] Tofacitinib 5 mg Immediate Release Tablet (reference): prepared as describe above.

[0181] Tofacitinib 11 mg Sustained Release dosage forms: prepared as described above.

[0182] During all study periods, blood samples to provide plasma for pharmacokinetic analysis were collected at periodic time points. The study results are provided in Table 47. PK samples were analyzed using standard validated analytical methods. Dose normalized natural log transformed AUC_{inf} , AUC_{last} and C_{max} were analyzed for tofacitinib using a mixed effect model with sequence, period and treatment as fixed effects and subject within sequence as a random effect. Estimates of the adjusted mean differences (Test-Reference) and corresponding 90% confidence intervals were obtained from the model. The adjusted mean differences and 90% confidence intervals for the differences was exponentiated to provide estimates of the ratio of adjusted geometric means (Test/Reference) and 90% confidence intervals for the ratios. The 2 x 5 mg immediate release formulation was the Reference treatment and the 11 mg sustained release formulation was the Test treatment.

[0183] The relative bioavailability of tofacitinib was estimated as the ratio of geometric means for Test and Reference for AUC_{inf} .

[0184] The PK parameters AUC_{inf} , AUC_{last} , C_{max} , T_{max} , and $t_{1/2}$ were summarized descriptively by treatment and analyte (when applicable). For AUC_{inf} and C_{max} , individual subject parameters are plotted by treatment for each analyte separately (when applicable). Concentrations were listed and summarized descriptively by PK sampling time, treatment and analyte (when applicable). Individual subject, mean and median profiles of the concentration-time data were plotted by treatment and analyte (when applicable). For summary statistics, and mean and median plots by sampling time, the nominal PK sampling time were used, for individual subject plots by time, the actual PK sampling time were used.

[0185] Predicted steady-state values were obtained via the superposition method using the software package WinNonLin (Pharsight Corp). Superposition was used on each individual's pharmacokinetic profile to generate the steady-state pharmacokinetic profile of each individual.

Table 47

Single Dose PK Parameters	11 mg modified release (Test)	2 x 5 mg immediate release (Reference)
C_{max} (ng/ml)	40.8 (29%)	88.2 (29%)
$C_{max,dn}$ (ng/ml/mg)	3.70 (29%)	8.82 (29%)
AUC_{inf} (ng*hr/ml)	297.5 (23%)	286.3 (20%)
$AUC_{inf,dn}$ (ng*hr/ml/mg)	27.0 (23%)	28.6 (20%)
T_{max} (hr)	3.54 (3.00-6.00)	0.50 (0.50-2.00)
$t_{1/2}$ (hr)	5.705 (41%)	3.413 (18%)
$C_{max(adj)}$ Ratio (%)	92% (85-100%)	100%
AUC_{inf} Ratio (%)	104% (100%-107%)	100%
The above values are reported as Geometric mean (%CV) for all except: median (range) for T_{max} ; arithmetic mean (%CV) for $t_{1/2}$. The above ratios are presented as geometric mean ratio (90% Confidence Intervals).		
Predicted Steady-State PK	11 mg modified release QD (Test)	2 x 5 mg immediate release BID (Reference)
$C_{max,ss}$ (ng/ml)	41.6(31%)	45.0 (28%)
$C_{min,ss}$ (ng/ml)	1.3 (60%)	1.5 (53%)
$C_{min,dn,ss}$ (ng/ml/mg)	0.12 (60%)	0.15 (53%)
$C_{min,dn,ss}$ Ratio (%)	88% (73%-106%)	100%
$C_{max,ss}/C_{min,ss}$	32	30
Time above 17 ng/ml (hrs)	6.3	5.6

Predicted Steady-State PK	11 mg modified release QD (Test)	2 x 5 mg immediate release BID (Reference)
Drug holiday (Time below 17 ng/ml) (hrs)	17.7	18.4

The above parameters are presented as geometric mean (%CV). The above ratios are presented as geometric mean ratio (90% Confidence Intervals).

[0186] Sustained-release dosage forms containing 11 mg of tofacitinib which release and dissolve 80% of tofacitinib in 4-5 hours provide pharmacokinetic performance similar to immediate release dosage forms containing 10 mg of tofacitinib and meet the desired pharmacokinetic claims when dosed in the fasted state.

REFERENCES CITED IN THE DESCRIPTION

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P a t e n t k r a v

- 5 **1.** Farmaceutisk doseringsform til indgivelse en gang dagligt, hvor doseringsformen er en doseringsform med langvarig frigivelse, som omfatter en kerne indeholdende tofacitinib, eller et farmaceutisk acceptabelt salt deraf, og en semipermeabel membrancoating, hvor coatingen omfatter en vandopløselig polymer, som omfatter et cellulosederivat, hvilken doseringsform er en tablet eller kapsel med ekstruderbart kernesystem, der afgiver tofacitinib primært ved hjælp af osmotisk tryk, hvor den tofacitinib-holdige sammensætning indbefatter 10 en mængde af viskositetsforøgende polymerer i området fra 2 vægt-% til 20 vægt-% og en mængde af osmotisk aktive midler i området fra 60 vægt-% til 85 vægt-% af den tofacitinib-holdige sammensætning, og den semipermeable membrancoating indeholder en eller flere åbninger, og når den tilsættes til et testmedium omfattende 900 ml af 0,05 M pH 6,8 kaliumphosphatbuffer 15 ved 37 °C i en standard-USP-indretning med roterende medbringere, og medbringerne roteres ved 50 rpm, opløses ikke mere end 30 % af nævnte tofacitinib på 1 time og ikke mindre end 35 % og ikke mere end 75 % af nævnte tofacitinib på 2,5 time og ikke mindre end 75 % af nævnte tofacitinib på 5 timer.
- 20 **2.** Doseringsform med langvarig frigivelse ifølge krav 1, hvor mængden af viskositetsforøgende polymerer ligger i området fra 4 vægt-% til 10 vægt-% af den tofacitinib-holdige sammensætning.
- 25 **3.** Doseringsform med langvarig frigivelse ifølge krav 1 eller 2, hvor mængden af osmotisk aktive polymerer ligger i området fra 70 vægt-% til 85 vægt-% af den tofacitinib-holdige sammensætning.
- 30 **4.** Doseringsform med langvarig frigivelse ifølge et hvilket som helst af kravene 1 til 3, hvor coatingen forekommer i en mængde fra 3 til 30 vægt-% baseret på vægten af den ikke-coatede kerne.
- 5.** Doseringsform med langvarig frigivelse ifølge krav 1-4 til anvendelse ved behandling af en immunologisk lidelse hos et individ, hvor den immunologiske lidelse er udvalgt fra gruppen bestående af organtransplantation, reumatoid

arthritis, psoriasis, psoriasis arthritis, ulcerøs kolitis, ankyloserende spondylitis, juvenil idiopatisk arthritis og Crohns sygdom.