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(54) Title: DIRECTLY COMPRESSIBLE TRICALCIUM PHOSPHATE

(57) Abstract: A compressible tricalcium phosphate agglomerate comprises tricalcium phosphate particles, each having an outer surface, and a binder comprising a polyvinylpyrrolidone, carageenan, or a guar gum, supported on at least a portion of the outer surface of at least a portion of the tricalcium phosphate particles.

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DIRECTLY COMPRESSIBLE TRICALCIUM PHOSPHATE

Field of the Invention

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This invention relates to tricalcium phosphate for use in directly compressible tablet formulations.

Background of the Invention

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Tricalcium phosphate is widely used as an excipient in pharmaceutical applications.

Recent studies that establish the value of mineral dietary supplements that supply both calcium and phosphorus has given rise to an interest in making oral dosage forms, such as tablets or caplets and including chewable oral dosage forms such as chewable tablets, wherein calcium phosphate is the main ingredient.

However, attempts to use tricalcium phosphate as the main ingredient in oral dosage forms have resulted in tablets that exhibit an undesirably low hardness. Moreover, chewable tablets made using calcium phosphates exhibit undesirable mouth feel described as "gritty" and or "chalky".

25

What is needed is a way to make oral dosage forms that contain a high relative amount of tricalcium phosphate and that exhibit good properties, including acceptable hardness. A further need is for such tablets, if designed to be chewable tablets, to have acceptable sensory qualities, including good mouthfeel, lack of grittiness, and lack of chalkiness.

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Summary of the Invention

In a first aspect, the present invention is directed to a compressible tricalcium phosphate agglomerate, comprising:

- 5 tricalcium phosphate particles, each having an outer surface, and
a binder comprising a polyvinylpyrrolidone, carageenan, or a guar gum,
supported on at least a portion of the outer surface of at least a portion of
the tricalcium phosphate particles.

- 10 In a second aspect, the present invention is directed to a process for
making a compressible tricalcium phosphate agglomerate, comprising
spray drying an aqueous solution of tricalcium phosphate and a binder
comprising a polyvinylpyrrolidone, carageenan, or a guar gum.

- 15 In a third aspect, the present invention is directed to a directly
compressible calcium dietary supplement composition, comprising, based
on 100 parts by weight ("pbw") of the composition:

- from about 20 to about 80 pbw of an agglomerate, comprising
tricalcium phosphate particles, each having an outer surface, and a binder
20 comprising a polyvinylpyrrolidone, carageenan, or a guar gum, supported
on at least a portion of the outer surface of at least a portion of the
tricalcium phosphate particles,

from about 79 to about 10 pbw of particles of a calcium-containing
material other than the agglomerate,

- 25 from about 0.5 to about 8 pbw of a disintegrant, and
from about 0.5 to about 2 pbw of a lubricant.

- In a fourth aspect, the present invention is directed to a process for
making an oral dosage form of a calcium dietary supplement composition,
30 comprising compressing the above described directly compressible calcium
dietary supplement composition.

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In a fifth aspect, the present invention is directed to an oral dosage form of a calcium dietary supplement composition, made by compressing the above described directly compressible calcium dietary supplement composition.

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Detailed Description of Invention and Preferred Embodiments

Any tricalcium phosphate that meets the specifications of US Pharmacopoeia, Vol. 26 ("USP/NF 26") or the Food Chemical Codex 5th Edition (National Academy of Sciences, Washington, D.C.) ("FCC 5th Ed.") is suitable for use as a component of the agglomerates of the present invention. In one embodiment, the tricalcium phosphate particles exhibit a particle size distribution wherein less than or equal to 2 % by weight ("wt%"), more typically less than or equal to 0.6 wt%, of the particles have a particle size of greater than 140 mesh (about 100 μ m) and less than or equal to 5 wt%, more typically less than or equal to 2 wt%, of the particles have a particle size of less than 325 mesh (about 50 μ m).

As used herein, "binder" means any substance that is capable of rendering the mixture of acidic component and basic component of the composition of the present invention compactable into a solid, coherent mass. Suitable binder compounds include, for example, polyvinylpyrrolidones, guar gum, acacia, tragacanth, gelatin, polysaccharides such as glucose and sucrose, starch, pregelatinized starch, carageenan, and cellulosic materials including methylcellulose and carboxymethylcellulose, as well as hydroxyalkyl cellulose compounds such as hydroxypropyl methylcellulose, hydroxypropyl cellulose and hydroxyethyl cellulose, as well as mixtures of any of the above.

In one embodiment, polyvinyl pyrrolidone is used as the binder. Suitable polyvinylpyrrolidones are those having a number average molecular weight of greater than or equal to about 30,000. In one

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embodiment, the polyvinylpyrrolidone binder has a number average molecular weight (Mw) of about greater than or equal to about 60,000, more typically greater than or equal to about 80,000.

5 In another embodiment, guar gum, a modified guar gum, or a mixture thereof is used as the binder. Guar gum refers to the water soluble fraction of ground endosperms of the leguminous plant *Cyamopsis tetragonolobus*. The gum consists of linear chains of (1,4)-.beta.-D mannopyranosyl units-with α D-galactopyranosyl units attached by (1,6)
10 linkages, with a ratio of D-galactose to D-mannose of about 1:2. Guar gum may take the form of a whitish powder which is dispersible in hot or cold water. Modified guar gums include, for example carboxymethyl guar, carboxymethylhydroxypropyl guar, cationic hydroxypropyl guar, hydroxyalkyl guar, including hydroxyethyl guar, hydroxypropyl guar, hydroxybutyl guar
15 and higher hydroxylalkyl guar, carboxylalkyl guar, including carboxymethyl guar, carboxylpropyl guar, carboxybutyl guar, and higher alkyl carboxy guar. Suitable guar gums are those guar gums and modified guar gums that meet FCC, 5th Edition specifications and form solutions having a sufficiently low viscosity to allow use in a spray drying
20 process. In one embodiment, the guar gum has an average molecular weight of less than or equal to about 2,000,000 daltons, more typically, a number average molecular weight of from about 200,000 daltons to about 2,000 daltons.

25 In one embodiment, the agglomerate of the present invention comprises, based on 100 pbw of the composition:

from about 90 to about 99 pbw, more typically from about 93 to about 98 pbw, and still more typically from about 95 to about 97 pbw, tricalcium phosphate, and

30 from about 10 to about 1 pbw, more typically from about 7 to about 2 pbw, and still more typically from about 5 to about 3 pbw, binder.

- 5 -

The agglomerate of tricalcium phosphate and binder may be made by any suitable agglomeration technique, including agitation agglomeration techniques, such as fluidized bed drying and high shear mixing, pressure
5 agglomeration techniques, such as compression, or spray agglomeration techniques, such as spray drying.

In one embodiment, an agglomerate of tricalcium phosphate and binder is made by spray drying an aqueous solution of calcium phosphate
10 and a binder.

In one embodiment, the agglomerate particles exhibit a particle size distribution wherein less than or equal to 65 percent by weight ("wt%"), more typically 90 wt%, of the particles have a particle size of greater than
15 325 mesh (about 50 μ m) and less than or equal to 10 wt%, more typically 2 wt%, of the particles have a particle size of less than 60 mesh (about 200 μ m).

The agglomerate of tricalcium phosphate and binder may be
20 blended with other ingredients, such as, for example, particles calcium-containing materials, lubricants, disintegrants, and flow agents, in a suitable mixer, to provide the directly compressible tricalcium phosphate composition of the present invention.

25 In one embodiment, the directly compressible calcium dietary supplement composition of the present invention further comprises particles of one or more calcium-containing materials other than the agglomerate of the present invention. Suitable calcium-containing materials include, calcium chelates, such as for example, calcium
30 proteinate, and calcium salts, such as, for example, calcium carbonate, calcium gluconate, calcium citrate, tricalcium phosphate, or dicalcium

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phosphate dihydrate or anhydrous dicalcium phosphate, and calcium citrate maleate.

In a one embodiment, the composition comprises tricalcium
5 phosphate particles that exhibit a particle size distribution wherein less than or equal to 15 wt%, more typically 2.6 wt%, of the particles have a particle size of greater than 40 mesh (about 300 μm) and less than or equal to 5 wt%, more typically 0.9 wt%, of the particles have a particle size of less than 325 mesh (about 50 μm).

10

In one embodiment, the directly compressible calcium dietary supplement composition of the present invention further comprises a lubricant. As used herein, "lubricant" means a substance that reduces friction between the composition of the present invention and the surfaces
15 of the apparatus used to compact the composition into a compressed form. Suitable lubricants include, for example, fatty acids, such as palmitic acid, stearic acid, oleic acid, hydrogenated vegetable oils, triglycerides of fatty acids, metal salts of fatty acids, such as for example, zinc stearate and magnesium stearate, glycols, such as polyethylene glycol, and talc, as well
20 as mixtures thereof. In one embodiment, the lubricant component of the composition of the present invention comprises magnesium stearate.

In one embodiment, composition of the present invention comprises, based on 100 pbw of the composition, from about 0.05 to about 5 pbw,
25 more typically from about 0.1 to about 3 pbw and still more typically from about 0.2 to about 2 pbw of a lubricant.

In one embodiment, the directly compressible calcium dietary supplement composition of the present invention further comprises a
30 disintegrant. As used herein, "disintegrant" means a substance that is substantially insoluble in water, but that is capable of swelling in water. Disintegrants serve to accelerate the disintegration and dissolution in an

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aqueous medium of compressed forms of the composition of the present invention. Any pharmaceutically acceptable compound that is substantially insoluble in water but capable of swelling in water in order to accelerate the disintegration and dissolution in an aqueous medium of compressed dosage forms, e.g., tablets, formed from the composition of the present invention is suitable as the disintegrant of the composition of the present invention. Suitable disintegrants include, for example, sodium carboxymethyl cellulose, starches, microcrystalline cellulose, soy protein, alginic acid, crosslinked polyvinylpyrrolidone, also known as crosslinked povidone, and crosslinked sodium carboxymethylcellulose, also known as croscarmellose sodium, as well as mixtures thereof. In one embodiment, the disintegrant of the composition of the present invention comprises croscarmellose sodium.

15 In one embodiment, the composition of the present invention comprises, based on 100 pbw of the composition, from about 0.05 to about 5, more typically from about 0.1 to about 4 pbw of a disintegrant.

20 In one embodiment, the directly compressible calcium dietary supplement composition comprises based on 100 pbw of the composition: from about 15 to about 75 pbw, more typically from about 30 to about 60 pbw, of an agglomerate according to the present invention, from about 85 to about 25 pbw, more typically from about 70 to about 40 pbw, of particles of a calcium-containing material, typically 25 tricalcium phosphate, other than the agglomerate, from about 0.05 to about 5, more typically from about 0.1 to about 4 pbw, of a disintegrant, and from about 0.05 to about 5 pbw, more typically from about 0.1 to about 3 pbw, and still more typically from about 0.2 to about 2 pbw, of a 30 lubricant.

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The directly compressible calcium dietary supplement composition of the present invention is useful to make finished oral dosage forms, such as, for example, tablets and caplets, by conventional methods, such as for example, using a tablet press, and is resistant to capping.

5

Oral dosage forms of the present invention exhibit high hardness, low friability and good disintegration properties. Chewable tablet dosage forms of the present invention exhibit very good mouthfeel and very low chalkiness and grittiness.

10

Hardness, as referred to herein, is measured using a Schleuniger Model 2E Tablet Hardness Tester.

15 In one embodiment, the oral dosage form of the present invention exhibits an hardness of greater than or equal to 15 kilopond ("kp") , more typically, from about 20 to about 30 kp, even more typically from about 24 to about 28 kp.

20 In another embodiment, the oral dosage form of the present invention is a chewable tablet exhibits a hardness of greater than or equal to 10 kp, more typically, from about 12 to about 22 kp, even more typically from about 14 to 16 kp.

25 Friability, as referred to herein, is measured according to US Pharmacopoeia 1216 Tablet Friability test (USP 25) and is expressed as an attrition rate. In one embodiment, the oral dosage form of the present invention exhibits a friability of less than 1%, more typically less than about 0.6%, even more typically less than about 0.2%.

30 As referred to herein, "disintegration" is measured according to US Pharmacopoeia test method number 701 (USP 26) and is expressed as the time, in seconds, that is required for a tablet to disintegrate into smaller

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fragments that pass through a test screen when immersed in water at 37 +/- 2 degrees C using the specified apparatus. In one embodiment, the oral dosage form of the present invention exhibits a disintegration of 90 seconds, more typically less than 60 seconds.

5

As used herein, the term "capping" means the loss of physical integrity of the tablet by separation of a tablet fragment or lamination of the tablet body after compression.

10 Examples 1-3

The compressible tricalcium phosphate agglomerates of Examples 1 - 3 were each made by spray drying a slurry comprising, on the basis of 100 pbw of slurry, 33.6 pbw tricalcium phosphate ("TCP") particles, 64.2 pbw water, and 2.2 pbw of one of three binders that is, polyvinyl pyrrolidone K30 ("PVP30"), polyvinyl pyrrolidone K90 ("PVP90"), or guar gum.

15

The spray drying was conducted in a Niro Mobile Minor laboratory scale spray drier using the following conditions:

Damper	100% open
Atomizer	Turbine
Air pressure	4 kg/cm ²
Heat	Setting II
Timer	100%

20

The particle size distributions for the tricalcium phosphate particles and for each of the agglomerates are set forth below in Table I.

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Table I

Example #		(TCP alone)	Ex. 1	Ex. 2	Ex. 3
Binder		--	PVP30	PVP90	Guar
Flow rate (g/s)			19.7	37.3	22.3
Bulk density (g/ml)		0.391	0.512	0.436	0.463
Tap density (g/ml)		0.536	0.640	0.545	0.634
Particle size (% cumulative retain)					
US Mesh	(μm)				
60		0	0.1	0.1	0.1
80		0.1	0.1	0.1	0.1
100		0.1	0.1	0.1	0.1
140		65.6	0.1	0.1	0.1
200		85.6	0.1	0.1	0.1
270		96.8	7.2	4	22.8
325		98.4	14.4	12	36
Pan	--	100	100	100	100

Examples 1B-3B and Comparative Example C1B

5 The agglomerates of Examples 1-3 were mixed with tricalcium phosphate, a disintegrant (AC-DI-SOL, manufactured by FMC Biopolymer Inc.), and a lubricant (magnesium stearate) in the relative amounts. (each given as pbw ingredient/100 pbw formulation) set forth below in Table II to

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make the directly compressible formulations of Comparative Example C1B, and Examples 1B, 2B, and 3B.

Table II

	CEx.C1B	EX. 1B	Ex. 2B	Ex.3B
TCP	97.47	82.36	82.36	82.36
TCP-C (Ex. 1)	--	15.11	--	--
TCP-C (Ex. 2)	--	--	15.11	--
TCP-C (Ex. 3)	--	--	---	15.11
disintegrant (AC-DI-SOL)	2.02	2.02	2.02	2.02
Magnesium stearate	0.51	0.51	0.51	0.51
Total	100	100	100	100

5

Examples 1C-3C and Comparative Example C1C

The directly compressible compositions of Comparative Example C1B and Examples 1B, 2B, and 3B were each compressed in 0.312" x 0.750" cylindrical molds in a tablet press (Manesty Betapress) to make the tablets of Comparative Example C1C and Examples 1C, 2C and 3C.

10

The hardness of the tablets was measured using a Schleuniger Model 2E Tablet Hardness Tester and is expressed in kiloponds (kp).

15

The friability of the tablets was measured according to US Pharmacopoeia 1216 Tablet Friability test (USP 25) and is expressed as % attrition.

20

The disintegration of the tablets was measured according to US Pharmacopoeia test method number 701 (USP 26) and is expressed as the time, in seconds, that is required for a tablet to disintegrate into smaller

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fragments that pass through a test screen when immersed in water at 37 +/- 2 degrees C using the specified apparatus.

- 5 The tableting conditions, % capping, and tablet properties, that is, thickness, hardness, friability, and disintegration, for each of Comparative Example C1C and Examples 1C, 2C, and 3C, each under several different tableting conditions are set forth below in Tables III-VI.

Table III

Comparative Example C1C				
Preload (lb)	400	800	800	800
Force (tons)	1.5	2.0	2.5	3.0
Ejection Force (lb)	80	-	-	-
Tablet Properties				
Weight (mg)	1361	1363	1362	
Hardness (kp)	6.6	10.0	10.3	--
Thickness (in)	0.303	0.295	0.291	--
Friability (%)	--	--	--	--
Capping (%)	0	1	98	--

10

Table IV

Example 1C				
Preload (lb)	400	800	800	800
Force (tons)	1.5	2.0	2.5	3.0
Ejection Force (lb)	--	--	--	--
Tablet Properties				
Weight (mg)	1356	1375	1385	1395
Hardness (kp)	7.9	10.9	13.2	16.5
Thickness (in)	0.303	0.300	0.293	0.289
Friability (%)	--	--	--	--
Capping (%)	0	0	0	1

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Table V

Example 2C				
Preload (lb)	400	800	800	800
Force (tons)	1.5	2.0	2.5	3.0
Ejection Force (lb)	--	100	100	100
Tablet Properties				
Weight (mg)	--	1361	1358	1358
Hardness (kp)	--	11.9	14.4	19.0
Thickness (in)	--	0.299	0.284	0.283
Friability (%)	--	0.23	0.16	0.14
Capping (%)	--	0	0	0
Disintegration (s)	--	31	33	38

Table VI

Example 3C				
Preload (lb)	400	800	800	800
Force (tons)	1.5	2.0	2.5	3.0
Ejection Force (lb)	--	100	100	100
Tablet Properties				
Weight (mg)	--	1361	1362	1364
Hardness (kp)	--	11.1	14.6	17.0
Thickness (in)	--	0.303	0.291	0.287
Friability (%)	--	0.25	0.16	0.13
Capping (%)	--	0	0	0
Disintegration (s)	--	32	41	46

5

The results show increased hardness of tablets comprising the tricalcium phosphate agglomerate of the present invention, compared to analogous tablets made with conventional tricalcium phosphate.

EXAMPLE 4

The directly compressible composition of Example 4A was by
5 mixing:

45.41 pbw of an agglomerate made according to the process
described above in Example 3,
47.68 pbw TRI-TABTM tricalcium phosphate (Rhodia Inc.) ,
4.01 additional binder (carboxymethyl cellulose (PH102) FMC
10 Corp.),
0.17 pbw Vitamin D₃ 100,
2.02 pbw disintegrant ("AC-DI-SOL", FMC Corp.),
0.24 pbw sodium lauryl sulfate, NF 21(SLS, Stepanol WA-100
(Stepan Corp.)), and
15 0.48 pbw lubricant (magnesium stearate).

The mixture of Example 4A was compressed according in a tablet
press (Manesty Betapress) using 0.312" x 0.750" caplet punches to make
the caplets of Example 4B.

20

The hardness, thickness, friability, capping, and disintegration
performance of the caplets of Example 4B were each tested according to
the methods set forth above in Examples 1C-3C and Comparative Example
C1C. The tableting conditions and test results are set forth below in
25 TABLE V.

TABLE V

Example 4B					
Force (tons)	1.0	1.5	2.0	2.5	3.0
Ejection Force (lb)	70	100	120	140	160
Tablet Properties					
Weight (mg)	1414	1412	1415	1413	1413
Hardness (kp)	14.7	19.9	27.3	28.8	31.8
Thickness (in)	0.331	0.316	0.304	0.296	0.290
Friability (%)	0.355	0.247	0.195	0.176	0.177
Capping (%)	0	0	0	0	0
Disintegration (s)	25	34	38	42	46

5 EXAMPLE 5

The chewable tablets of Example 5, each nominally 5/8" in diameter, 0.3" thick and 2000 mg in weight, were made by compressing a mixture of:
 42.59 pbw of an agglomerate made according to the procedure set
 10 forth above for Example 1,
 51.69 pbw of an additional binder (Xylitab 200 (Danisco)),
 1.74 pbw flavoring (SD Cherry N&A (Virginia Dare)),
 1.74 pbw Prosweet #875 (Virginia Dare)
 0.16 pbw AspartameTM (Searle), and
 15 2.06 pbw magnesium stearate.
 in a tablet press ("D" Express Press) using 5/8" round flat faced tooling.

The tablets of Example 5 exhibited a hardness of 12.5 kp, measured as set forth above in Examples 1C-3C and Comparative Example C1C.
 20

The tablets of Example 5 were found to exhibit minimal grittiness and chalky taste in an informal taste test.

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Claims:

1. A compressible tricalcium phosphate agglomerate, comprising:
tricalcium phosphate particles, each having an outer surface, and a binder
5 comprising a polyvinylpyrrolidone, carageenan, or a guar gum, supported on at
least a portion of the outer surface of at least a portion of the tricalcium
phosphate particles.
2. The agglomerate of claim 1, wherein the binder comprises polyvinyl
10 pyrrolidone having a number average molecular weight of greater than or
equal to about 30,000.
3. The agglomerate of claim 1, wherein the binder comprises guar gum, a
modified guar gum or a mixture thereof..
15
4. The agglomerate of claim 1, wherein the agglomerate comprises, based
on 100 pbw of the agglomerate:
from about 90 to about 99 pbw tricalcium phosphate, and
from about 10 to about 1 pbw binder.
20
5. The agglomerate of claim 1, wherein the agglomerate is in the form of
particles that exhibit a particle size distribution wherein less than or equal to 65
percent by weight of the particles have a particle size of greater than 325
mesh and less than or equal to 10 wt% of the particles have a particle size of
25 less than 60 mesh.
6. A process for making a compressible tricalcium phosphate
agglomerate, comprising spray drying an aqueous solution of tricalcium
phosphate and a binder comprising a polyvinylpyrrolidone, carageenan, or a
30 guar gum.

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7. A directly compressible calcium dietary supplement composition, comprising, based on 100 parts by weight ("pbw") of the composition:
from about 20 to about 80 pbw of an agglomerate, comprising tricalcium
5 phosphate particles, each having an outer surface, and a binder comprising a polyvinylpyrrolidone, carageenan, or a guar gum, supported on at least a portion of the outer surface of at least a portion of the tricalcium phosphate particles,
from about 79 to about 10 pbw of particles of one or more calcium-
10 containing materials other than the agglomerate,
from about 0.5 to about 8 pbw of a disintegrant, and
from about 0.5 to about 2 pbw of a lubricant.
8. The composition of claim 7, wherein the particles of one or more
15 calcium-containing materials other than the agglomerate are selected from calcium chelates, calcium salts, and mixtures thereof.
9. The composition of claim 7, wherein the particles of one or more
calcium-containing materials other than the agglomerate comprise tricalcium
20 phosphate particles that exhibit a particle size distribution wherein less than or equal to 15 percent by weight of the particles have a particle size of greater than 40 mesh and less than or equal to 5 percent by weight of the particles have a particle size of less than 325 mesh.
- 25 10. The composition of claim 7, wherein the lubricant is selected from fatty acid, hydrogenated vegetable oils, triglycerides of fatty acids, metal salts of fatty acids, glycols, talc, and mixtures thereof.
- 30 11. The composition of claim 7, wherein the disintegrant is selected from sodium carboxymethyl cellulose, starches, microcrystalline cellulose, soy

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protein, alginic acid, crosslinked polyvinylpyrrolidone, crosslinked sodium carboxymethylcellulose and mixtures thereof

12. A process for making an oral dosage form of a calcium dietary
5 supplement composition, comprising compressing the directly compressible calcium dietary supplement composition of claim 7.

13. An oral dosage form of a calcium dietary supplement composition,
made by compressing the composition of claim 7.

10

14. The oral dosage form of claim 13, wherein the oral dosage form exhibits an hardness of greater than or equal to 10 kilopond,

15. The oral dosage form of claim 13, wherein the oral dosage form exhibits
15 an hardness of greater than or equal to 15 kilopond.

16. The oral dosage form of claim 13, wherein the oral dosage form exhibits a friability of less than 1%.

20 17. The oral dosage form of claim 13, wherein the oral dosage form exhibits a disintegration time, measured according to US Pharmacopoeia test method number 701 (USP 26), of less than 90 seconds.