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(54) Titre : TIMBRE TRANSDERMIQUE  
(54) Title: PATCH

(57) **Abrégé/Abstract:**

The purpose of present invention is to provide a local anesthetic-containing patch that is practical as a pharmaceutical in terms of skin permeability, aggregation power, and adhesiveness. The patch according to the present invention is characterized by having an adhesive agent layer on a support, wherein the adhesive agent layer contains at least a local anesthetic, a thermoplastic elastomer, a higher fatty acid ester, and a fatty acid monoester of a polyhydric alcohol, and the ratio of the higher fatty acid ester with respect to 100 parts by mass of the thermoplastic elastomer is 25-200 parts by mass.



## Abstract

The objective of the present invention is to provide a local anesthetic agent-containing patch having a skin permeability, cohesion force and adhesive property practical as a pharmaceutical product. The patch of the present invention is characterized in comprising a backing layer, and an adhesive layer on the backing layer, wherein the adhesive layer comprises at least a local anesthetic agent, a thermoplastic elastomer, a higher fatty acid ester, and a polyol fatty acid monoester, and a ratio of the higher fatty acid ester to 100 mass parts of the thermoplastic elastomer is 25 mass parts or more and 200 mass parts or less.

PATCH

TECHNICAL FIELD

[0001]

5       The present invention relates to a patch comprising a local anesthetic agent.

TECHNICAL FIELD

[0002]

10       A local anesthetic patch is widely used for relief of pain caused by a medical procedure such as a puncture with an injection needle or an intravenous indwelling needle and a skin minor surgery. For example, a lidocaine tape is commercially available in Japan. The anesthetic effect of a  
15 lidocaine tape is, however, not sufficient.

      In addition, an anesthetic cream containing a mixture of lidocaine and prilocaine as active pharmaceutical ingredients is also commercially available in Japan. A higher anesthetic effect of the cream than that of an anesthetic lidocaine tape  
20 is confirmed (Patent document 1). The cream, however, has problems of a complicated procedure that needs time and efforts. For example, the cream has to be spread so that the cream is thickly applied on the skin, an ODT: occlusive dressing technique using a film or the like is needed, and the  
25 cream has to be cleanly wiped away after use.

      A gel that has a trade name of AMETOP<sup>(R)</sup> and that contains tetracaine as an active ingredient is commercially available in Europe and the United States, and an anesthetic effect thereof is expressed more rapidly than that of an anesthetic  
30 cream. On the one hand, since the gel has to be wiped away

after use similarly to a cream, there is a need to develop a product that can be handled more easily in the medical field.

Thus, a patch is considered to be used. For example, Patent document 2 discloses a transdermally administered drug patch that has less irritation to the skin, that is excellent in a medicinal property and that contains a drug, a transdermal penetration accelerator, an adhesive resin and an additive in an adhesive layer. Patent document 3 discloses a patch that has a sufficient drug solubility property, a transdermal penetration property and a sufficient adhesive property to the skin, that has less irritation to the skin, that contains a drug, a thermoplastic elastomer and a higher fatty acid ester in an adhesive layer, and in which a ratio of the higher fatty acid ester to the thermoplastic elastomer is adjusted and in which a content amount of a tackifier is reduced.

PRIOR ART DOCUMENT

PATENT DOCUMENT

[0003]

Patent document 1: JP S54-101414 A

Patent document 2: JP H6-205839 A

Patent document 3: WO 2017/099246

DISCLOSURE OF THE INVENTION

PROBLEMS TO BE SOLVED BY THE INVENTION

[0004]

A patch containing a drug in an adhesive layer has developed as described above. Nevertheless, though Patent documents 2 and 3 disclose an example of a local anesthetic

agent as a drug to be contained in an adhesive layer, in fact,  
a patch described in Patent document 2 mainly contains a non-  
steroid anti-inflammatory drug such as ketoprofen, a patch  
described in Patent document 3 mainly contains scopolamine as  
5 an anticholinergic drug, donepezil hydrochloride as a  
progression inhibitor of Alzheimer dementia or the like, or a  
non-steroid anti-inflammatory drug, and Patent documents 2 and  
3 do not disclose a specific patch containing a local  
anesthetic agent. In addition, a local anesthetic agent-  
10 containing patch excellent in all of a skin permeability, a  
cohesion force and an adhesive property has not been still  
developed.

Accordingly, the objective of the present invention is to  
provide a local anesthetic agent-containing patch having a  
15 skin permeability, cohesion force and adhesive property  
practical as a pharmaceutical product.

#### MEANS FOR SOLVING THE PROBLEMS

[0005]

20 The inventors of the present invention repeated intensive  
studies in order to solve the above-described problems. As a  
result, the inventors completed the present invention by  
finding that a local anesthetic agent-containing patch having  
an adhesive property and a cohesion force practical as a  
25 pharmaceutical product and a sufficient skin permeability can  
be obtained by adding at least a local anesthetic agent, a  
thermoplastic elastomer, a higher fatty acid ester, and a  
polyol fatty acid monoester in an adhesive layer and  
appropriately adjusting a ratio of the higher fatty acid ester

to the thermoplastic elastomer.

The present invention is hereinafter described.

[0006]

[1] A patch,

5 comprising a backing layer, and an adhesive layer on the backing layer,

wherein the adhesive layer comprises at least a local anesthetic agent, a thermoplastic elastomer, a higher fatty acid ester, and a polyol fatty acid monoester, and

10 a ratio of the higher fatty acid ester to 100 mass parts of the thermoplastic elastomer is 25 mass parts or more and 200 mass parts or less.

[2] The patch according to the above [1], wherein a ratio of the higher fatty acid ester to 100 mass parts of the

15 thermoplastic elastomer is 30 mass parts or more and 150 mass parts or less.

[3] The patch according to the above [1] or [2], wherein a content amount of the higher fatty acid ester in the adhesive layer is 60 mass% or less.

20 [4] The patch according to any one of the above [1] to [3], wherein a carbon number in an ester part of the higher fatty acid ester is 12 or more and 30 or less.

[5] The patch according to any one of the above [1] to [4], wherein the thermoplastic elastomer is a styrene block

25 copolymer.

[6] The patch according to the above [5], wherein the styrene block copolymer is a mixture of a styrene-isoprene-styrene block copolymer and a styrene-isoprene block copolymer.

[7] The patch according to the above [6], wherein a ratio of  
30 the styrene-isoprene block copolymer in the mixture is 50

mass% or more.

[8] The patch according to any one of the above [5] to [7], wherein a viscosity of a 25 mass% toluene solution of the styrene block copolymer at 25°C is 500 mPa·s or more and 2000  
5 mPa·s or less.

[9] The patch according to any one of the above [1] to [8], wherein the adhesive layer comprises 5 mass% or more of a tackifier.

[10] The patch according to any one of the above [1] to [9],  
10 wherein the polyol fatty acid monoester is a propylene glycol fatty acid monoester.

[11] The patch according to any one of the above [1] to [10], wherein the adhesive layer further comprises a higher alcohol.

[12] The patch according to the above [11], wherein a carbon  
15 number of the higher alcohol is 12 or more and 30 or less.

[13] The patch according to the above [11] or [12], wherein the higher alcohol is oleyl alcohol and/or lauryl alcohol.

[14] The patch according to any one of the above [1] to [13], wherein the local anesthetic agent is one or more local  
20 anesthetic agents selected from the group consisting of tetracaine, lidocaine, prilocaine, bupivacaine, mepivacaine, benzocaine, levobupivacaine and ropivacaine.

[15] The patch according to any one of the above [1] to [13], wherein the local anesthetic agent is tetracaine.

25 [16] Use of a local anesthetic agent, a thermoplastic elastomer, a higher fatty acid ester, and a polyol fatty acid monoester for local anesthesia,

wherein an adhesive layer of a patch comprises the local anesthetic agent, the thermoplastic elastomer, the higher  
30 fatty acid ester, and the polyol fatty acid monoester,

the patch comprises the adhesive layer and a backing layer, and the adhesive layer is placed on the backing layer, and

a ratio of the higher fatty acid ester to 100 mass parts of the thermoplastic elastomer is 25 mass parts or more and 200  
5 mass parts or less.

[17] The use according to the above [16], wherein a ratio of the higher fatty acid ester to 100 mass parts of the thermoplastic elastomer is 30 mass parts or more and 150 mass parts or less.

10 [18] The use according to the above [16] or [17], wherein a content amount of the higher fatty acid ester in the adhesive layer is 60 mass% or less.

[19] The use according to any one of the above [16] to [18], wherein a carbon number in an ester part of the higher fatty  
15 acid ester is 12 or more and 30 or less.

[20] The use according to any one of the above [16] to [19], wherein the thermoplastic elastomer is a styrene block copolymer.

[21] The use according to the above [20], wherein the styrene  
20 block copolymer is a mixture of a styrene-isoprene-styrene block copolymer and a styrene-isoprene block copolymer.

[22] The use according to the above [21], wherein a ratio of the styrene-isoprene block copolymer in the mixture is 50 mass% or more.

25 [23] The use according to any one of the above [20] to [22], wherein a viscosity of a 25 mass% toluene solution of the styrene block copolymer at 25°C is 500 mPa·s or more and 2000 mPa·s or less.

[24] The use according to any one of the above [16] to [23],  
30 wherein the adhesive layer comprises 5 mass% or more of a



tackifier.

[25] The use according to any one of the above [16] to [24], wherein the polyol fatty acid monoester is a propylene glycol fatty acid monoester.

5 [26] The use according to any one of the above [16] to [25], wherein the adhesive layer further comprises a higher alcohol.

[27] The use according to the above [26], wherein a carbon number of the higher alcohol is 12 or more and 30 or less.

10 [28] The use according to the above [26] or [27], wherein the higher alcohol is oleyl alcohol and/or lauryl alcohol.

[29] The use according to any one of the above [16] to [28], wherein the local anesthetic agent is one or more local anesthetic agents selected from the group consisting of tetracaine, lidocaine, prilocaine, bupivacaine, mepivacaine,

15 benzocaine, levobupivacaine and ropivacaine.

[30] The use according to any one of the above [16] to [28], wherein the local anesthetic agent is tetracaine.

[31] A local anesthetic method,

comprising the step of applying a patch to a skin,

20 wherein the patch comprises a backing layer, and an adhesive layer on the backing layer,

the adhesive layer comprises at least a local anesthetic agent, a thermoplastic elastomer, a higher fatty acid ester, and a polyol fatty acid monoester, and

25 a ratio of the higher fatty acid ester to 100 mass parts of the thermoplastic elastomer is 25 mass parts or more and 200 mass parts or less.

[32] The local anesthetic method according to the above [31], wherein a ratio of the higher fatty acid ester to 100 mass

30 parts of the thermoplastic elastomer is 30 mass parts or more

and 150 mass parts or less.

[33] The local anesthetic method according to the above [31] or [32], wherein a content amount of the higher fatty acid ester in the adhesive layer is 60 mass% or less.

5 [34] The local anesthetic method according to any one of the above [31] to [33], wherein a carbon number in an ester part of the higher fatty acid ester is 12 or more and 30 or less.

[35] The local anesthetic method according to any one of the above [31] to [34], wherein the thermoplastic elastomer is a  
10 styrene block copolymer.

[36] The local anesthetic method according to the above [35], wherein the styrene block copolymer is a mixture of a styrene-isoprene-styrene block copolymer and a styrene-isoprene block copolymer.

15 [37] The local anesthetic method according to the above [36], wherein a ratio of the styrene-isoprene block copolymer in the mixture is 50 mass% or more.

[38] The local anesthetic method according to any one of the above [35] to [37], wherein a viscosity of a 25 mass% toluene  
20 solution of the styrene block copolymer at 25°C is 500 mPa·s or more and 2000 mPa·s or less.

[39] The local anesthetic method according to any one of the above [31] to [38], wherein the adhesive layer comprises 5 mass% or more of a tackifier.

25 [40] The local anesthetic method according to any one of the above [31] to [39], wherein the polyol fatty acid monoester is a propylene glycol fatty acid monoester.

[41] The local anesthetic method according to any one of the above [31] to [40], wherein the adhesive layer further  
30 comprises a higher alcohol.

[42] The local anesthetic method according to the above [41], wherein a carbon number of the higher alcohol is 12 or more and 30 or less.

[43] The local anesthetic method according to the above [41]  
5 or [42], wherein the higher alcohol is oleyl alcohol and/or lauryl alcohol.

[44] The local anesthetic method according to any one of the above [31] to [43], wherein the local anesthetic agent is one or more local anesthetic agents selected from the group  
10 consisting of tetracaine, lidocaine, prilocaine, bupivacaine, mepivacaine, benzocaine, levobupivacaine and ropivacaine.

[45] The local anesthetic method according to any one of the above [31] to [43], wherein the local anesthetic agent is tetracaine.

15 [46] A local anesthetic method, comprising the step of applying the patch according to any one of the above [1] to [15] to a skin.

#### EFFECT OF THE INVENTION

20 [0007]

The present invention can provide a local anesthetic agent-containing patch having a practical adhesive property and a practical cohesion force as a pharmaceutical product and a sufficient skin permeability.

25

#### MODE FOR CARRYING OUT THE INVENTION

[0008]

An adhesive layer is formed on a backing layer in the patch of the present invention. The "backing layer" is not  
30 particularly restricted in the present invention, and a

backing layer that is widely used for an adhesive sheet for skin application and a percutaneous absorption product may be used. An example of the backing layer includes a stretchable or a non-stretchable woven fabric or non-woven fabric composed of polyethylene, polypropylene, polyethylene terephthalate or the like; a film composed of a polyester such as polyethylene terephthalate, a polyolefin such as polyethylene and polypropylene, polyurethane, ethylene-vinyl acetate copolymer, polyvinyl chloride or the like; a foamed backing layer composed of polyolefin, polyurethane or the like. One of the backing layer may be used alone, or a laminate prepared by laminating a plurality of backing layers may be used. The above-described woven fabric, non-woven fabric, film or the like that constitute the backing layer may contain an antistatic agent to prevent static electricity from accumulating on the backing layer. A non-woven fabric, a woven fabric, or a laminate of a non-woven fabric or a woven fabric and a film may be used as the backing layer for a good anchoring property with an adhesive layer. When a laminate of a film and a non-woven fabric or a woven fabric is used as the backing layer, the non-woven fabric or woven fabric is preferably placed on the side to be contacted with an adhesive layer.

[0009]

A thickness of the film as the backing layer is generally 10  $\mu\text{m}$  or more and 100  $\mu\text{m}$  or less and preferably 15  $\mu\text{m}$  or more and 50  $\mu\text{m}$  or less, and a thickness of the woven fabric, non-woven fabric and foamed backing layer is generally 50  $\mu\text{m}$  or more and 2,000  $\mu\text{m}$  or less and preferably 100  $\mu\text{m}$  or more and 1,000  $\mu\text{m}$  or less.

[0010]

The patch of the present invention may comprise a release liner that is general in this technical field. In other words, the backing layer, an adhesive layer and a release liner may  
 5 be laminated in this order in the patch of the present invention. A glassine paper; a polymer film composed of a polyolefin such as polyethylene and polypropylene, a polyester such as polyethylene terephthalate, and polystyrene; an aluminum film; a foamed polyethylene film and a foamed  
 10 polypropylene film; and a laminate of two or more of the above examples can be used as the release liner. The release liner subjected to silicone processing, fluororesin processing, embossing, hydrophilicizing processing and hydrophobicizing may be also used. A thickness of the release liner is  
 15 generally 10  $\mu\text{m}$  or more and 200  $\mu\text{m}$  or less and preferably 15  $\mu\text{m}$  or more and 150  $\mu\text{m}$  or less.

[0011]

An adhesive layer of the patch according to the present invention comprises at least (a) a local anesthetic agent as a  
 20 drug, (b) a thermoplastic elastomer, (c) a higher fatty acid ester and (d) a polyol fatty acid monoester.

[0012]

(a) Local anesthetic agent

The "local anesthetic agent" usable in the present  
 25 invention means a drug to obtund or erase the target local perception and to relieve a local pain, and is not particularly restricted as long as the local anesthetic agent has a basic skeleton containing an aromatic ring, an alkyl chain and an amino group and has a structure formed by  
 30 connecting the aromatic ring and the alkyl chain through an

ester bond or an amide bond. An example of the local anesthetic agent includes one or more local anesthetic agents selected from the group consisting of tetracaine, lidocaine, prilocaine, bupivacaine, mepivacaine, benzocaine,

5 levobupivacaine and ropivacaine, and the local anesthetic agent is preferably one or more local anesthetic agents selected from the group consisting of tetracaine, lidocaine and prilocaine and more preferably tetracaine.

[0013]

10 The local anesthetic agent usable as a raw material is not particularly restricted and may be a free form or a pharmaceutically acceptable salt. Such a pharmaceutically acceptable salt is not particularly restricted and may be an inorganic salt or an organic salt. Only one kind of the salt  
15 may be used, or two or more kinds of the salts may be used in combination. In addition, a free form and a salt may be mixed to be used. An example of the inorganic salt includes hydrochloride, hydrobromide, nitrate, sulfate and phosphate. An example of the organic salt includes formate, acetate,  
20 trifluoroacetate, propionate, lactate, tartrate, oxalate, fumarate, maleate, citrate, malonate and methanesulfonate. A free form or a hydrochloride is preferred in terms of availability, and a free form is more preferred in terms of dispersibility in an adhesive.

25 [0014]

A content amount of the local anesthetic agent in the adhesive layer of the patch according to the present invention, i.e. a ratio of the local anesthetic to 100 mass% of the total constituent components of the adhesive layer, is  
30 preferably 0.5 mass% or more and 30 mass% or less in terms of

ensuring a dispersibility in the adhesive layer and a good skin permeability. The content ratio is more preferably 1 mass% or more, even more preferably 3 mass% or more, and more preferably 20 mass% or less, even more preferably 15 mass% or less.

[0015]

(b) Thermoplastic elastomer

The "thermoplastic elastomer" used in the present invention means a thermoplastic elastomer that becomes soft and fluid by heat and that returns to a rubbery elastomer by cooling, and is exemplified by various thermoplastic elastomers such as urethane elastomer, acrylate elastomer, styrene elastomer and olefin elastomer. In particular, a styrene thermoplastic elastomer, particularly a styrene block copolymer, is preferably used from the viewpoint of achieving both of sufficient skin adhesiveness and low dermal irritation.

[0016]

An example of the styrene block copolymer as the thermoplastic elastomer specifically includes styrene-butadiene block copolymer, styrene-butadiene-styrene block copolymer, styrene-isoprene block copolymer, styrene-isoprene-styrene block copolymer, styrene-ethylene/butylene block copolymer, styrene-ethylene/butylene-styrene block copolymer, styrene-ethylene/propylene block copolymer, styrene-ethylene/propylene-styrene block copolymer, styrene-isobutylene block copolymer and styrene-isobutylene-styrene block copolymer. The above-described "ethylene/butylene" represents a copolymer block of ethylene and butylene, and the "ethylene/propylene" represents a copolymer block of ethylene

and propylene. One of the styrene block copolymers may be used alone, or two or more may be used in combination.

[0017]

One or more selected from the group consisting of a  
5 styrene-isoprene-styrene block copolymer and a styrene-  
isoprene block copolymer are preferably used and a mixture of  
a styrene-isoprene block copolymer and a styrene-isoprene-  
styrene block copolymer is particularly preferably used among  
the above-described styrene block copolymer from the viewpoint  
10 of the compatibility between a sufficient adhesiveness to the  
akin and a suppression of a remained adhesive due to an  
improved cohesive force in the adhesive layer and additionally  
availability and handleability. A ratio of the styrene-  
isoprene block copolymer in the mixture is preferably 50 mass%  
15 or more, more preferably 60 mass% or more, and preferably 90  
mass% or less, more preferably 80 mass% or less.

[0018]

A content amount of styrene in the styrene-isoprene-styrene  
block copolymer is preferably 5 mass% or more and 60 mass% or  
20 less and more preferably 10 mass% or more and 50 mass% or less  
for the objective of the present invention. In addition, a  
weight average molecular weight of the styrene-isoprene-  
styrene block copolymer measured by a gel permeation  
chromatography (GPC) is preferably 20,000 or more and 500,000  
25 or less and more preferably 30,000 or more and 300,000 or  
less. A content amount of styrene in the styrene-isoprene  
block copolymer is preferably 5 mass% or more and 50 mass% or  
less and more preferably 10 mass% or more and 40 mass% or  
less. In addition, a weight average molecular weight of the  
30 styrene-isoprene block copolymer measured by a gel permeation



chromatography (GPC) is preferably 10,000 or more and 500,000 or less and more preferably 20,000 or more and 300,000 or less.

[0019]

5 A solution viscosity of 25 mass% toluene solution of the styrene block copolymer at 25°C is preferably 500 mPa·s or more and 2000 mPa·s or less from the viewpoint of good balance of an adhesive substance. The viscosity is more preferably 500 mPa·s or more, even more preferably 900 mPa·s or more, and more  
10 preferably 1800 mPa·s or less. The above described "solution viscosity of 25 mass% toluene solution at 25°C" means a value measured on the basis of the viscosity measuring method for styrene-isoprene-styrene block copolymer described in page 395 of "Japanese Pharmaceutical Excipients 2013" published by  
15 Yakuji Nippo.

[0020]

The styrene-isoprene-styrene block copolymer and the styrene-isoprene block copolymer respectively produced by a publically known method may be used. In addition, commercially  
20 available products of the styrene-isoprene-styrene block copolymer and the styrene-isoprene block copolymer that satisfy the above-described characteristics may be used. A mixture of the styrene-isoprene-styrene block copolymer and the styrene-isoprene block copolymer is also commercially  
25 available, and a commercially available product of a mixture containing the styrene-isoprene-styrene block copolymer and the styrene-isoprene block copolymer in the above-described mixing ratio that satisfies the above-described characteristics may be preferably used.

[0021]

An example of the commercially available product of the styrene block copolymer includes "KRATON<sup>(R)</sup> D1111", "KRATON<sup>(R)</sup> D1163", "KRATON<sup>(R)</sup> D1113" and "KRATON<sup>(R)</sup> D1119" manufactured by  
 5 KRATON POLYMERS; "JSR<sup>(R)</sup> SIS5229", "JSR<sup>(R)</sup> SIS5002", "JSR<sup>(R)</sup> SIS5403" and "JSR<sup>(R)</sup> SIS5505" manufactured by JSR; and  
 "Quintac<sup>(R)</sup> 3421", "Quintac<sup>(R)</sup> 3433N", "Quintac<sup>(R)</sup> 3520",  
 "Quintac<sup>(R)</sup> 3450" and "Quintac<sup>(R)</sup> 3270" manufactured by Zeon.  
 Among the above examples, "KRATON<sup>(R)</sup> D1163", "KRATON<sup>(R)</sup> D1113",  
 10 "JSR<sup>(R)</sup> SIS5403", "JSR<sup>(R)</sup> SIS5505", "Quintac<sup>(R)</sup> 3433N" and  
 "Quintac<sup>(R)</sup> 3520" are preferred and "JSR<sup>(R)</sup> SIS5505" and/or  
 "Quintac<sup>(R)</sup> 3520" is particularly preferred from the viewpoint  
 of the mixing ratio and the solution viscosity of the styrene-  
 isoprene-styrene block copolymer and the styrene-isoprene  
 15 block copolymer.

[0022]

A content amount of the thermoplastic elastomer in the adhesive layer, in other words, a ratio of the thermoplastic elastomer to 100 mass% of the total constituent components of  
 20 the adhesive layer, is preferably 20 mass% or more and 70  
 mass% or less. When the ratio is 20 mass% or more, a form of  
 the adhesive layer may be maintained more surely. When the  
 ratio is 70 mass% or less, an adhesive force of the adhesive  
 layer to the skin may be exerted more surely. The content  
 25 amount is more preferably 25 mass% or more, even more  
 preferably 30 mass% or more, and more preferably 65 mass% or  
 less, even more preferably 60 mass% or less.

[0023]

(c) Higher fatty acid ester

30 The "higher fatty acid ester" in the present invention

means a compound formed by an ester bond between a carboxy group of a higher fatty acid and an aliphatic alcohol. The higher fatty acid ester has an effect to appropriately plasticize the thermoplastic elastomer and contributes to an adhesive force. In addition, the higher fatty acid ester contributes to an improvement of a solubility and a suppression of crystal deposition of the local anesthetic agent, since the higher fatty acid ester has an appropriate affinity for the local anesthetic agent.

10 [0024]

The higher fatty acid that constitutes the higher fatty acid ester may be linear or branched. The higher fatty acid may be saturated or unsaturated, and a saturated higher fatty acid is preferred from the view point of a plasticizing effect and a thermal stability of the thermoplastic elastomer. A carbon number of the higher fatty acid is preferably 12 or more, more preferably 14 or more, even more preferably 16 or more, and preferably 30 or less, more preferably 24 or less, even more preferably 20 or less.

20 [0025]

An example of the saturated higher fatty acid includes capric acid (carbon number: 10), lauric acid (carbon number: 12), myristic acid (carbon number: 14), palmitic acid (carbon number: 16), stearic acid (carbon number: 18), isostearic acid (carbon number: 18), arachidic acid (carbon number: 20), behenic acid (carbon number: 22), lignoceric acid (carbon number: 24), cerotic acid (carbon number: 26), montanic acid (carbon number: 28) and melissic acid (carbon number: 30). Myristic acid, palmitic acid and stearic acid are preferred among the above examples.

[0026]

An example of the unsaturated higher fatty acid includes palmitoleic acid (carbon number: 16), oleic acid (carbon number: 18), linoleic acid (carbon number: 18), (9,12,15)-  
 5 linolenic acid (carbon number: 18), (6,9,12)-linolenic acid (carbon number: 18) and eleostearic acid (carbon number: 18). Oleic acid and linoleic acid are preferred among the above examples.

[0027]

10 An aliphatic alcohol that constitutes the higher fatty acid ester is preferably a saturated or unsaturated aliphatic alcohol having a carbon number of 1 or more and 30 or less, and is exemplified by methanol, ethanol, propanol, isopropanol, butanol, hexanol, heptanol, octanol, decanol,  
 15 cetanol, myristyl alcohol, hexyldecanol, oleyl alcohol and octyldodecanol. A carbon number of the aliphatic alcohol corresponds to a carbon number of the ester part of the higher fatty acid ester. A carbon number of the aliphatic alcohol is preferably 12 or more and 30 or less. When the carbon number  
 20 is 12 or more, a plasticizing effect by the aliphatic alcohol may be exerted more surely. On the one hand, when the carbon number is 30 or less, a solubility of the local anesthetic agent may be sufficiently ensured.

[0028]

25 A preferred example of the higher fatty acid ester specifically includes a myristate ester such as isopropyl myristate, ethyl myristate and octyldodecyl myristate; a palmitate ester such as isopropyl palmitate and ethyl palmitate; a stearate ester such as isopropyl stearate; an

oleate ester such as decyl oleate, octyldodecyl oleate and  
oleyl oleate; and a linoleate ester such as ethyl linoleate.  
[0029]

A ratio of the higher fatty acid ester to 100 mass parts of  
5 the thermoplastic elastomer in the adhesive layer is  
preferably 25 mass parts or more and 200 mass parts or less.  
When the ratio is 25 mass parts or more, a good adhesive force  
of the adhesive layer and a solubility of the local anesthetic  
agent may be exerted more surely. When the ratio is 200 mass  
10 parts or less, a form of the adhesive layer may be maintained  
more surely. The ratio is more preferably 30 mass parts or  
more and 150 mass parts or less. A ratio of the higher fatty  
acid ester in the adhesive layer of the patch according to the  
present invention is preferably 10 mass% or more, more  
15 preferably 15 mass% or more, even more preferably 20 mass% or  
more, and preferably 70 mass% or less, more preferably 65  
mass% or less, even more preferably 60 mass% or less for a  
similar reason.

[0030]

20 (d) Polyol fatty acid monoester

The " polyol fatty acid monoester " in the present  
invention means a compound formed by an ester bond between one  
hydroxy group of the polyol and the fatty acid. The polyol  
fatty acid monoester contributes to an improvement of a drug  
25 solubility without extremely decreasing a cohesive force of an  
adhesive base agent and has an effect to accelerate a  
transdermal absorption of the local anesthetic agent,  
particularly tetracaine.

[0031]

30 An example of the polyol that constitutes the polyol fatty

acid monoester includes a diol such as ethylene glycol, propylene glycol and butylene glycol; a trivalent alcohol such as glycerin; and a tetravalent alcohol such as pentaerythritol. The fatty acid that constitutes a propylene glycol fatty acid monoester is preferably a fatty acid having a carbon number of 8 or more and 18 or less, and is exemplified by capric acid, caprylic acid, myristic acid, palmitic acid, stearic acid, isostearic acid, oleic acid and linoleic acid. A preferred specific example of the polyol fatty acid monoester includes propylene glycol monocaprylate and propylene glycol monolaurate.

[0032]

A content amount of the polyol fatty acid monoester in the adhesive layer, in other words, a ratio of the polyol fatty acid monoester to 100 mass% of the total constituent components of the adhesive layer, is preferably 2 mass% or more and 30 mass% or less. When the ratio is 2 mass% or more, a solubility and an absorption enhancement effect of the local anesthetic agent may be improved more surely. When the ratio is 30 mass% or less, a cohesive force and an adhesive force of the adhesive layer may be ensured more surely. The ratio is more preferably 5 mass% or more.

[0033]

A component other than the local anesthetic agent, thermoplastic elastomer, higher fatty acid ester and polyol fatty acid monoester may be added to the adhesive layer of the patch according to the present invention. Such an optional component is not particularly restricted as long as the optional component is a general component to be added in an adhesive layer of a patch, and is exemplified by tackifier,

higher alcohol, solvent, carboxylate salt, lactone, surfactant, filler and crystallization inhibitor.

[0034]

(e) Tackifier

5       The "tackifier" in the present invention means a component to enhance an adhesibility of the adhesive layer, and is not restricted as long as the tackifier is widely used for a general patch, and is exemplified by rosin resin, polyterpene resin, coumarone-indene resin, petroleum resin, terpene resin, 10 terpene-phenol resin and aliphatic cyclic saturated hydrocarbon resin.

[0035]

A content amount of the tackifier in the adhesive layer, in other words, a ratio of the tackifier to 100 mass% of the 15 total constituent components of the adhesive layer, may be appropriately adjusted, and may be preferably adjusted to, for example, 5 mass% or more and 50 mass% or less. When the ratio is 5 mass% or more, the adhesibility needed to obtain a sufficient drug efficacy can be ensured more surely. When the 20 ratio is 50 mass% or less, a decrease of a drug releasing amount and an increase of skin irritation can be inhibited more surely. The ratio is more preferably 7 mass% or more and even more preferably 10 mass% or more.

[0036]

25       (f) Higher alcohol

The "higher alcohol" in the present invention means a component to improve a solubility of the local anesthetic agent in the adhesive layer and a transdermal absorption property of the local anesthetic agent, and is exemplified by 30 a higher saturated aliphatic alcohol that has a carbon number

of about 12 or more and about 30 or less and that is liquid under ordinary temperature, such as lauryl alcohol and isostearyl alcohol; and a higher unsaturated aliphatic alcohol that has a carbon number of about 12 or more and about 30 or less and that is liquid under ordinary temperature, such as oleyl alcohol. The higher alcohol is preferably oleyl alcohol and/or lauryl alcohol from the viewpoint to enhance the effect to improve a solubility of the local anesthetic agent and to improve an effect to enhance a transdermal absorption.

10 [0037]

A content amount of the higher alcohol in the adhesive layer, in other words, a ratio of the higher alcohol to 100 mass% of the total constituent components of the adhesive layer, may be appropriately adjusted, and may be adjusted to, for example, 1 mass% or more and 30 mass% or less. When the ratio is 1 mass% or more, a solubility of the local anesthetic agent in the adhesive layer and a transdermal absorption property of the local anesthetic agent may be improved more surely. When the ratio is 30 mass% or less, a cohesive force and an adhesibility of the adhesive layer may be ensured more surely. The ratio is preferably 3 mass% or more.

[0038]

(g) Solvent

The "solvent" in the present invention means a component that is a liquid under an atmospheric temperature and an atmospheric pressure and that shows an appropriate solubility to an adhesive component. The solvent usable in the present invention is not particularly restricted, and is exemplified by one or more solvents selected from the group consisting of



an ester solvent, an alcohol solvent, an amide solvent and a liquid organic acid.

[0039]

A use amount of the solvent may be appropriately adjusted, and for example, a content amount of the solvent in the adhesive layer, in other words, a ratio of the solvent to 100 mass% of the total constituent components of the adhesive layer, may be adjusted to 0.1 mass% or more and 20 mass% or less and preferably 0.5 mass% or more and 15 mass% or less.

10 [0040]

(g1) Ester solvent

An ester solvent is preferred among the solvent from the viewpoint to improve a solubility of the local anesthetic agent in the adhesive layer and a transdermal absorption property of the local anesthetic agent. An example of the ester solvent includes a diester of a diol and a carboxylic acid, a triglyceride of a medium chain fatty acid, an ester of a multivalent carboxylic acid and a monovalent aliphatic alcohol, and a carbonate ester.

20 [0041]

An example of the diester of diol and carboxylic acid includes a diester prepared from propylene glycol and caprylic acid, capric acid, lauric acid or oleic acid.

[0042]

25 The triglyceride of medium chain fatty acid means a triglyceride composed of an aliphatic acid having a carbon number of 6 or more and 12 or less and glycerin. An example of the aliphatic acid includes caproic acid, caprylic acid, capric acid and lauric acid. A caprylic acid triglyceride, a triglyceride mixture of caprylic acid and capric acid, and a

30

triglyceride mixture of caprylic acid, capric acid and lauric acid that are liquids under an atmospheric temperature may be used in the present invention. In addition, a fat and oil that is liquid under an atmospheric temperature and that contains  
5 much of the above triglycerides may be also used. An example of the fat and oil includes peanut oil, olive oil and castor oil.

[0043]

A commercially available pharmaceutical product may be used  
10 as the triglyceride of medium chain fatty acid that is liquid under an atmospheric temperature or a fat and oil containing the triglyceride of medium chain fatty acid that is liquid under an atmospheric temperature in the present invention.

[0044]

15 An example of the ester of multivalent carboxylic acid and monovalent aliphatic alcohol includes a diester that is composed of a dicarboxylic acid having a carbon number of 2 or more and 12 or less and a monovalent aliphatic alcohol having a carbon number of 1 or more and 20 or less and that is liquid  
20 under an atmospheric temperature. An example of the diester includes an adipate diester that is liquid under an atmospheric temperature, such as diethyl adipate and diisopropyl adipate; and a sebacate diester that is liquid under an atmospheric temperature, such as diethyl sebacate,  
25 diisopropyl sebacate and dioctyldodecyl sebacate.

[0045]

The carbonate ester is exemplified by a cyclic carbonate ester of carbonic acid and a diol having a carbon number of 2 or more and 10 or less, such as ethylene carbonate, propylene

carbonate and vinylene carbonate, and is preferably propylene carbonate.

[0046]

The triglyceride of medium chain fatty acid mixture,  
5 sebacate diester and carbonate ester are preferred and the  
triglyceride mixture of caprylic acid and capric acid, diethyl  
sebacate and propylene carbonate are more preferred among the  
above-described ester solvents.

[0047]

10 (g2) Alcohol solvent

An example of the alcohol solvent includes a multivalent  
alcohol that is liquid under an atmospheric temperature, such  
as ethylene glycol, propylene glycol, glycerin, 1,3-butanediol  
and polyethylene glycol having a molecular weight of 100 or  
15 more and 600 or less; a monoalkyl ether of a multivalent  
alcohol, such as diethylene glycol monoethyl ether; and a  
monofatty acid ester of a multivalent alcohol, such as  
glycerol monolinoleate and glycerol monooleate.

[0048]

20 In particular, one or more alcohol solvents selected from  
the group consisting of ethylene glycol, propylene glycol,  
glycerin, 1,3-butanediol and diethylene glycol monoethyl ether  
are preferred from the viewpoint to improve a solubility of  
the local anesthetic agent.

25 [0049]

(g3) Amide solvent

An example of the amide solvent includes a pyrrolidone such  
as N-methyl-2-pyrrolidone and 2-pyrrolidone; an  
imidazolidinone such as 1,3-dimethyl-2-imidazolidinone; an N-  
30 substituted toluidine such as crotamiton; and an alkane amide

such as formamide, N-methylformamide, N,N-dimethylformamide, N-methylacetamide, N,N-dimethylacetamide and N-methylpropanamide.

[0050]

5       The above-described amide solvent is preferably N-methyl-2-pyrrolidone, crotamiton, N,N-dimethylformamide and N,N-dimethylacetamide and more preferably N-methyl-2-pyrrolidone and/or crotamiton from the viewpoint to improve a solubility, a dispersibility and a transdermal absorption property of the  
10   local anesthetic agent.

[0051]

(g4) Liquid organic acid

An example of the liquid organic acid includes an aliphatic monocarboxylic acid such as acetic acid, propionic acid,  
15   butyric acid, valeric acid, isovaleric acid, caproic acid, enanthic acid (heptanoic acid), caprylic acid and pelargonic acid (nonanoic acid); an aliphatic unsaturated monocarboxylic acid such as oleic acid, linoleic acid, arachidonic acid and docosahexaenoic acid; a hydroxycarboxylic acid such as lactic  
20   acid; a liquid carboxylic acid substituted by an alkoxy group, such as methoxyacetic acid; and a sulfonic acid such as methanesulfonic acid. Lactic acid may be L-lactic acid, D-lactic acid, lactic anhydride or a mixture thereof.

[0052]

25       The liquid organic acid has a function to assist a dissolution of the basic local anesthetic agent and has an effect to enable the local anesthetic agent to be contained in the adhesive layer in a high concentration and to improve a dispersibility and further a transdermal absorption property.  
30   Lactic acid of Japanese Pharmacopoeia grade, oleic acid and

isostearic acid are preferably used and lactic acid of Japanese Pharmacopoeia grade is more preferably used from the above-described viewpoint.

[0053]

5 One or two or more of the liquid organic acids may be selected from the above-described liquid organic acids as needed to be contained in the adhesive layer in the present invention. A content amount of the liquid organic acid in the adhesive layer, in other words, a ratio of the liquid organic  
10 acid to 100 mass% of the total constituent components of the adhesive layer, is preferably 0.1 mass% or more and 20 mass% or less and more preferably 0.5 mass% or more and 15 mass% or less.

[0054]

15 (h) Carboxylate salt

An example of the carboxylate salt mixed in the adhesive layer of the patch according to the present invention includes salts of an aliphatic monocarboxylic acid, an aliphatic cyclic monocarboxylic acid and an aliphatic dicarboxylic acid.

20 [0055]

An example of the aliphatic monocarboxylic acid includes a short chain carboxylic acid having a carbon number of 2 or more and 7 or less, such as acetic acid, butyric acid and hexanoic acid; a medium chain fatty acid having a carbon  
25 number of 8 or more and 11 or less, such as octanoic acid and decanoic acid; a long chain fatty acid having a carbon number of 12 or more, such as myristic acid, stearic acid, isostearic acid and oleic acid; a hydroxy monocarboxylic acid such as glycolic acid, lactic acid, 3-hydroxybutyric acid and mandelic  
30 acid; a monocarboxylic acid substituted by an alkoxy group,

such as methoxyacetic acid; and a keto monocarboxylic acid such as levulinic acid.

[0056]

5 An example of the aliphatic cyclic monocarboxylic acid includes an aliphatic cyclic monocarboxylic acid having a carbon number of 6 or more and 8 or less, such as cyclohexanecarboxylic acid.

[0057]

10 An example of the aliphatic dicarboxylic acid includes sebacic acid, adipic acid, malic acid, maleic acid and fumaric acid.

[0058]

15 An example of the preferred carboxylic acid includes a long chain carboxylic acid having a carbon number of 12 or more and a hydroxy monocarboxylic acid, such as myristic acid, stearic acid, isostearic acid, oleic acid and lactic acid. The carboxylic acid is more preferably oleic acid and/or lactic acid.

[0059]

20 An example of a salt of the carboxylic acid includes an alkali metal salt such as sodium salt and potassium salt; an alkaline earth metal salt such as calcium salt; and an amine salt, and a sodium salt is preferably used from the viewpoint of easy availability, stability and an effect to improve a transdermal absorption property of the local anesthetic agent.

[0060]

(i) Lactone

An example of the lactone includes a 5-membered lactone such as ascorbic acid and isoascorbic acid.

[0061]

The carboxylate salt and/or the lactone is preferably added to the adhesive layer of the patch according to the present invention from the viewpoint of an effect to improve a stability and a transdermal absorption property of the local anesthetic agent, and one or more selected from the group consisting of sodium oleate, sodium lactate, ascorbic acid and isoascorbic acid are preferably added.

[0062]

When the patch of the present invention contains the carboxylate salt and/or the lactone, a content amount thereof in the adhesive layer is not particularly restricted. For example, the content amount to 1 mole of the local anesthetic agent is preferably 0.1 mole or more and 5 mole or less and more preferably 0.2 mole or more and 3 mole or less. When the ratio of the carboxylate salt and/or the lactone to 1 mole of the local anesthetic agent is 0.1 mole or more, a sufficient effect to improve a transdermal absorption property of the local anesthetic agent may be obtained more surely. When the ratio is 5 mole or less, a preparation physical property such as adhesibility may be ensured more surely.

[0063]

(j) Surfactant

Any one of a non-ionic surfactant, an anionic surfactant, a cationic surfactant and an ampholytic surfactant can be used as a surfactant. An example of a non-ionic surfactant includes a polyoxyethylene fatty acid ester such as polyoxyethylene monolaurate; a polyoxyethylene sorbit fatty acid ester such as polyoxyethylene sorbit tetraoleate; a polyoxyethylene sorbitan fatty acid ester such as polyoxyethylene sorbitan monooleate,

polyoxyethylene sorbitan monolaurate and polyoxyethylene sorbitan monopalmitate; a sorbitan fatty acid ester such as sorbitan monolaurate, sorbitan monooleate, sorbitan sesquioleate and sorbitan trioleate; a glycerin fatty acid ester such as glycerin monooleate, polyoxyethylene castor oil derivative and polyoxyethylene hydrogenated castor oil; a polyoxyethylene higher aliphatic alcohol ether such as polyoxyethylene lauryl ether and polyoxyethylene oleyl ether; a polyoxyethylene alkylphenyl ether such as polyoxyethylene nonyl phenyl ether; a polyoxyethylene alkylamino ether such as polyoxyethylene laurylamine and polyoxyethylene oleylamine; and a polyoxyethylene polyoxypropylene copolymer such as Pluronic<sup>(R)</sup> L-31 and Pluronic<sup>(R)</sup> L-44. An example of an anionic surfactant includes a sodium alkylsulfate such as sodium laurylsulfate. An example of a cationic surfactant includes an alkyltrimethylammonium salt and an alkyldimethylammonium salt. An example of an ampholytic surfactant includes an alkyldimethylamine oxide and an alkyl carboxy betain. One kind or two or more kinds of the surfactant may be selected to be used.

[0064]

A non-ionic surfactant that is liquid under an atmospheric temperature is preferred, a sorbitan fatty acid ester that is liquid under an atmospheric temperature is more preferred, and sorbitan monolaurate is even more preferred among a surfactant from the viewpoint to improve a transdermal absorption property of the local anesthetic agent.

[0065]

A content amount of the surfactant in the adhesive layer in the case where the surfactant is used in the present



invention, in other words, a ratio of the surfactant to 100 mass% of the total constituent components of the adhesive layer, is preferably 0.01 mass% or more and 10 mass% or less and more preferably 0.1 mass% or more and 5 mass% or less.

5 [0066]

(k) Antioxidant agent

An example of an antioxidant agent includes dibutylhydroxytoluene, 4-dioxyphenol, tocopherol, a tocopherol ester derivative, ethylenediaminetetraacetic acid disodium  
10 salt, rutin, N,N-dimethylthiourea, L-cysteine, 1-thioglycerol and 2-mercaptobenzimidazole. In particular, dibutylhydroxytoluene is preferred. One antioxidant agent may be used alone or two or more antioxidant agents may be used in combination.

15 [0067]

A content amount of the antioxidant agent is not particularly restricted, and the antioxidant agent may be contained in the range that a high transdermal permeability of the local anesthetic agent and a sufficient cohesive force and  
20 an adhesibility for the patch can be maintained. For example, a content amount of the antioxidant agent in the adhesive layer, in other words, a ratio of the antioxidant agent to 100 mass% of the total constituent components of the adhesive layer, may be adjusted to 10 mass% or less, and is preferably  
25 5 mass% or less and more preferably 2 mass% or less. The antioxidant agent is an optional component, and a content amount of the antioxidant agent in the adhesive layer may be 0 mass%. The lower limit of the content amount is preferably 0.01 mass%.

[0068]

(l) Filler

A filler may be added to control a flexibility of the adhesive layer. An example of the filler includes a silicon  
5 compound such as anhydrous silicic acid, light anhydrous silicic acid and hydrous silicic acid; a cellulose derivative such as ethyl cellulose, methyl cellulose, hydroxypropyl cellulose and hydroxypropylmethylcellulose; a water-soluble polymer such as polyvinyl alcohol; an aluminum compound such  
10 as dried aluminum hydroxide gel and hydrous aluminum silicate; kaolin; and titanium oxide. One filler may be used alone or two or more fillers may be used in combination.

[0069]

A content amount of the filler is not particularly  
15 restricted, and the filler may be added in the range that a high transdermal permeability of the local anesthetic agent and a sufficient cohesive force and an adhesibility for the patch can be maintained. For example, a content amount of the filler in the adhesive layer, in other words, a ratio of the  
20 filler to 100 mass% of the total constituent components of the adhesive layer, may be adjusted to 10 mass% or less, and is preferably 5 mass% or less and more preferably 2 mass% or less. The filler is an optional component, and a content amount of the filler in the adhesive layer may be 0 mass%. The  
25 lower limit of the content amount is preferably 0.01 mass%.

[0070]

(m) Crystallization inhibitor

A crystallization inhibitor may be added to prevent a crystal of the local anesthetic agent from being precipitated  
30 in the adhesive layer. An example of the crystallization

inhibitor includes polyvinylpyrrolidone, vinyl acetate-  
vinylpyrrolidone copolymer and polyvinylcaprolactam-polyvinyl  
acetate-polyethylene glycol graft copolymer. One  
crystallization inhibitor may be used alone, or two or more  
5 crystallization inhibitors may be used in combination.  
[0071]

A content amount of the crystallization inhibitor is not  
particularly restricted, and the crystallization inhibitor may  
be added in the range that an adhesibility for the patch can  
10 be maintained. For example, a content amount of the  
crystallization inhibitor in the adhesive layer, in other  
words, a ratio of the crystallization inhibitor to 100 mass%  
of the total constituent components of the adhesive layer, may  
be adjusted to 0.01 mass% or more and 10 mass% or less, and is  
15 preferably 0.1 mass% or more and 5 mass% or less.  
[0072]

The patch of the present invention can be produced by an  
ordinary method. For example, the patch can be produced by  
mixing the constituent components of the adhesive layer or  
20 dissolving or dispersing the adhesive layer components in a  
low boiling point solvent other than the solvent constituting  
the adhesive layer to prepare a coating liquid for forming the  
adhesive layer, applying the coating liquid on the backing  
layer, and then drying the applied coating liquid. When a  
25 release liner is used, the release liner is pressed on the  
adhesive layer to be laminated. Alternatively, the above-  
described coating liquid is applied on a release liner and  
dried to form the adhesive layer on the release liner, and the  
backing layer is laminated and pressed on the adhesive layer  
30 to be adhered.

[0073]

The low boiling point solvent for the coating liquid is preferably a solvent that can homogeneously dissolve or disperse the adhesive layer components, and is exemplified by  
5 an aromatic hydrocarbon such as toluene; an aliphatic cyclic hydrocarbon such as cyclohexane and methylcyclohexane; an aliphatic hydrocarbon such as hexane and heptane; an ether solvent such as tetrahydrofuran, diethyl ether and t-butyl methyl ether; a ketone solvent such as acetone, methyl ethyl  
10 ketone and methyl isobutyl ketone; an alcohol solvent such as ethanol, propanol and butanol; and an acetate ester solvent such as ethyl acetate, propyl acetate, isopropyl acetate, butyl acetate and isobutyl acetate. One of the solvent may be used alone, or two or more of the solvents may be used in  
15 combination. An aromatic hydrocarbon, an aliphatic cyclic hydrocarbon and an aliphatic hydrocarbon are preferably used alone or in combination, or an aromatic hydrocarbon, an aliphatic hydrocarbon and an acetate ester solvent are preferably used in an appropriate combination, since each of  
20 the constituent components of the adhesive layer can be successfully dissolved.

[0074]

A coating liquid for forming the adhesive layer may be applied using a general coater such as roll coater, die  
25 coater, gravure roll coater, reverse roll coater, kiss-roll coater, dip roll coater, bar coater, knife coater and spray coater. The above coating liquid is preferably dried by heating, for example, at about 40°C or higher and 150°C or lower. A drying temperature, a drying time and a drying method  
30 may be adjusted depending on a used solvent and use amount

thereof. A weight per a unit area of the adhesive layer after drying may be adjusted depending on a needed adhesiveness to the skin and a transdermal absorbability, and the range thereof by which adhesiveness to the skin can be exerted and  
5 by which the adhesive layer can be produced is preferably 10 g/m<sup>2</sup> or more and 1,000 g/m<sup>2</sup> or less, more preferably 20 g/m<sup>2</sup> or more and 800 g/m<sup>2</sup> or less, and even more preferably 30 g/m<sup>2</sup> or more and 600 g/m<sup>2</sup> or less.

[0075]

10 The patch of the present invention may be used similarly to a general patch. For example, when the patch of the present invention contains a release liner, the release liner is peeled to expose the adhesive layer and the adhesive layer is attached on the skin. The number of uses of the patch  
15 according to the present invention may be appropriately adjusted depending on symptom, age, sex or the like of the subject, and 1 sheet or more and 10 sheets or less may be used per one time. An adhesion time per 1 sheet may be also appropriately adjusted and may be adjusted to, for example, 10  
20 minutes or more and 1 hour or less.

[0076]

The patch of the present invention is applied on the skin of an animal. The subject animal is exemplified by a human; livestock such as cow, pig, sheep and goat; and a pet animal  
25 such as dog and cat, and is preferably a human. When the patch is applied on an animal having much hair, the patch may be applied on a shaved part.

[0077]

The present application claims the benefit of the priority  
30 date of Japanese patent application No. 2019-47009 filed on

March 14, 2019. All of the contents of the Japanese patent application No. 2019-47009 filed on March 14, 2019, are incorporated by reference herein.

## 5 EXAMPLES

[0078]

The present invention is hereinafter described in more detail with Examples and Comparative examples and is not restricted thereto.

10 [0079]

Examples 1 to 7, Comparative examples 1 to 6: Production of patch

An amount of each component that constituted an adhesive layer was weighted in accordance with the composition described in Table 1. First, a styrene block copolymer was dissolved in toluene, and then octyldodecyl myristate, propylene glycol monocaprylate, a terpene resin and tetracaine were added thereto. The mixture was mixed and stirred to prepare a coating liquid for forming an adhesive layer.

20 The above coating liquid was applied on a polyethylene terephthalate (PET) film treated by silicone as a release liner and dried in an oven at 50°C for 60 minutes so that the thickness of the adhesive layer after drying became about 400  $\mu\text{m}$ . Then, a PET film as a backing layer was laminated on the surface of the adhesive layer, and the laminate was cut into a size of 15 cm  $\times$  30 cm to obtain a patch.

[0080]

Table 1

		Ex. 1	Ex. 2	Ex. 3	Ex. 4	Ex. 5	Ex. 6	Ex. 7
Tetracaine		4.0	4.0	4.0	4.0	4.0	4.0	4.0
Styrene block copolymer	"Quintac 3520" Zeon Corporation	67.2	64.8	27.0	60.8	25.3	68.8	28.7
Octyldodecyl myristate		16.8	16.2	54.0	15.2	50.7	17.2	57.3
Propylene glycol monocaprylate		5.0	5.0	5.0	10.0	10.0	10.0	10.0
Terpene resin	"PX1150N" YASUHARA CHEMICAL	7.0	10.0	10.0	10.0	10.0	0	0

[0081]

Table 2

		Comparative ex. 1	Comparative ex. 2	Comparative ex. 3	Comparative ex. 4	Comparative ex. 5	Comparative ex. 6
Tetracaine		4.0	4.0	4.0	4.0	4.0	4.0
Styrene block copolymer	"Quintac 3520" Zeon Corporation	23.1	20.3	24.6	71.7	68.8	28.7
Octyldodecyl myristate		57.9	60.8	61.4	14.3	17.2	57.3
Propylene glycol monocaprylate		5.0	5.0	10.0	10.0	0	0
Terpene resin	"PX1150N" YASUHARA CHEMICAL	10.0	10.0	0	0	10.0	10.0

5 [0082]

Test example 1: Evaluation of transdermal permeability

Hair was removed from the abdomen of 5-week-old male Wister rat, and the skin was obtained therefrom. The skin was placed on a vertical Franz diffusion cell (model number "TP-8s" manufactured by Vidrex). The patch prepared in Examples and Comparative examples was cut into a circular form having a diameter of 1.0 cm and adhered on the rat skin in the Franz diffusion cell. The test was conducted using 0.01 mol/L phosphate buffered saline (pH 7.2 to 7.4) having a temperature of 32°C as a buffer. A part of the buffer was taken as a sample after 3 hours from the start of the test, and an amount of the drug that had passed through the rat skin in the buffer was measured by HPLC. A 4% tetracaine gel preparation (trade name: "Ametop<sup>(R)</sup> Gel") was used as a control preparation containing tetracaine and applied on the rat skin in the Franz diffusion cell. Then, the applied preparation was covered with

polyvinylidene chloride film (trade name: "Saran Wrap (registered trademark)" manufactured by Asahi Kasei Home Products) so that the water in the gel was not volatilized. The test emulated occlusive therapy. The amount was measured  
 5 three times per each patch, and an average value of the measurement values was calculated. The result was shown in Tables 3 and 4.

[0083]

Test example 2: Evaluation of cohesion force

10 The cohesion force of the adhesive layer of the patch was evaluated using finger tuck on the basis of the following four criteria. The result was shown in Tables 3 and 4.

3: adhesive residue was not observed at all.

2: adhesive residue was hardly observed, and there was no  
 15 problem.

1: cohesive force was slightly insufficient but there was no problem.

0: adhesive residue and deformation were observed, and cohesive force was remarkably insufficient.

20 [0084]

Test example 3: Evaluation of adhesive force

The adhesive force of the adhesive layer of the patch was evaluated using finger tuck on the basis of the following four criteria. The result was shown in Tables 3 and 4.

25 3: higher adhesive force was shown in comparison with an already-existing local anesthetic patch ("Lidocaine tape YP" manufactured by YUTOKU PHARMACEUTICAL).

2: similar adhesive force was shown to an already-existing local anesthetic patch ("Lidocaine tape YP" manufactured by  
 30 YUTOKU PHARMACEUTICAL).



1: slightly lower adhesive force was shown in comparison with an already-existing local anesthetic patch ("Lidocaine tape YP" manufactured by YUTOKU PHARMACEUTICAL) containing gum adhesive backing layer.

5 0: the patch could not adhered and was remarkably peeled.

[0085]

Table 3

	Ex. 1	Ex. 2	Ex. 3	Ex. 4	Ex. 5	Ex. 6	Ex. 7
Higher fatty acid ester/ thermoplastic elastomer	0.25	0.25	2.0	0.25	2.0	0.25	2.0
Skin permeability of drug (mg/cm <sup>2</sup> )	21.2	37.7	34.7	16.0	58.7	34.4	38.5
Cohesion force	3	3	2	3	2	3	1
Adhesive force	1	2	3	2	3	1	2

[0086]

Table 4

	Comparative ex. 1	Comparative ex. 2	Comparative ex. 3	Comparative ex. 4	Comparative ex. 5	Comparative ex. 6
Higher fatty acid ester/ thermoplastic elastomer	2.5	3.0	2.5	0.20	0.25	2.0
Skin permeability of drug (mg/cm <sup>2</sup> )	-	-	-	-	0.1	5.1
Cohesion force	0	0	0	3	3	3
Adhesive force	-	-	-	0	2	3

10 [0087]

As the results shown in Tables 3 and 4, an adhesibility of the patches of Example 1 and Example 6 was slightly low but was not a problem for actual use, and a cohesive force was good. A cohesive force of the patch of Example 7 was slightly low but an adhesibility was good. All of the patches of Examples 2 to 5 showed an excellent cohesive force and adhesibility.

On the one hand, a ratio of a higher fatty acid ester in the patches of Comparative examples 1 to 3 to a thermoplastic elastomer was too large; as a result, an adhesibility could not be evaluated, since an adhesive layer could not be

maintained due to a too low cohesive force. A ratio of a higher fatty acid ester of the patch of Comparative example 4 to a thermoplastic elastomer was too low; as a result, a cohesive force of the adhesive layer was observed but an adhesibility could not be observed. The patches of Comparative examples 5 and 6 had both of sufficient cohesive force and adhesibility but a transdermal permeability of the drug was not observed, since the patches did not contain a polyol fatty acid monoester.

In addition, Example 4 is compared with Comparative example 5 and Example 5 is compared with Comparative example 6, since ratios of a higher fatty acid ester to a thermoplastic elastomer of the Examples are the same as those of the Comparative examples; as a result, the transdermal permeability of Example 4 was very high as about 160 times to that of Comparative example 5 and the transdermal permeability of Example 5 was very high as about 11.5 times to that of Comparative example 6.

[0088]

Examples 8 to 15, Comparative examples 7 to 9: Production of patch

An amount of each component that constituted the adhesive layer was weighted in accordance with the compositions shown in Tables 5 and 6, and each patch was prepared similarly to the above-describe production method. In addition, a transdermal permeability, a cohesion force and an adhesibility were evaluated similarly to the above. The result is shown in Table 5. With respect to a skin permeability, a ratio to the transdermal permeability measurement value of a 4% tetracaine

gel preparation (trade name: "Ametop<sup>(R)</sup> Gel") as a control preparation is shown.

[0089]

Table 5

		Ex. 8	Ex. 9	Ex. 10	Ex. 11	Ex. 12	Ex. 13	Ex. 14	Ex. 15
Tetracaine		5.3	5.3	5.5	5.5	5.3	5.3	5.3	5.3
Styrene block copolymer	"Quintac 3520" Zeon Corporation	35.0	35.0	—	—	—	—	—	—
Styrene block copolymer	"JSR 5505" JSR	—	—	35.0	35.0	35.0	35.0	31.0	35.0
Octyldodecyl myristate		44.7	34.7	34.5	34.5	34.7	44.7	38.7	34.7
2-Hexyl-1-dodecanol		—	—	—	—	—	—	—	—
Liquid paraffin		—	—	—	—	—	—	—	—
Propylene glycol monocaprylate		10.0	10.0	15.0	10.0	10.0	10.0	10.0	10.0
Propylene glycol dicaprylate		—	—	—	—	—	—	—	—
Oleyl alcohol		5.0	3.0	—	5.0	5.0	5.0	5.0	—
Lauryl alcohol		—	—	—	—	—	—	—	3.0
Diisopropyl adipate		—	2.0	—	—	—	—	—	2.0
Terpene resin	"PX1150N" YASUHARA CHEMICAL	—	10.0	10.0	10.0	10.0	—	10.0	10.0
Ratio of drug skin permeability to control preparation		2.69	3.82	2.20	2.28	2.95	3.48	2.40	3.40
Cohesion force		3	3	3	2	3	3	3	3
Adhesive force		3	3	3	3	3	1	2	1

5 [0090]

Table 6

		Comparative ex. 7	Comparative ex. 8	Comparative ex. 9
Tetracaine		6.0	5.3	5.3
Styrene block copolymer	"Quintac 3520" Zeon Corporation	44.0	35.0	35.0
Styrene block copolymer	"JSR 5505" JSR	—	—	—
Octyldodecyl myristate		—	—	34.7
2-Hexyl-1-dodecanol		22.0	—	—
Liquid paraffin		15.0	34.7	—
Propylene glycol monocaprylate		13.0	10.0	—
Propylene glycol dicaprylate		—	—	10.0
Oleyl alcohol		—	3.0	3.0
Lauryl alcohol		—	—	—
Diisopropyl adipate		—	2.0	2.0
Terpene resin	"PX1150N" YASUHARA CHEMICAL	—	10.0	10.0
Ratio of drug skin permeability to control preparation		1.02	—	0.09
Cohesion force		3	1	2
Adherence property		1	0	3

[0091]

As the results shown in Tables 5 and 6, any patches of Examples 8 to 15 had excellent cohesive force and adhesibility. On the one hand, the patch of Comparative  
5 example 8 did not show adhesibility at all, and transdermal permeability was not conducted, since oozing of the liquid component was observed.

A transdermal permeability of the patches of Examples 8 to 15 and Comparative examples 7 and 9 was evaluated with using a  
10 conventional tetracaine-containing gel preparation (trade name: "Ametop<sup>(R)</sup> Gel") as a control preparation. As a result, a cumulative drug transdermal permeability amount from the patch of Comparative example 7 containing a higher alcohol and liquid paraffin in place of a higher fatty acid ester was  
15 similar to that of the gel preparation. The patch of Comparative example 9 that contained a higher fatty acid but that did not contain a polyol fatty acid monoester hardly showed a drug transdermal permeability. On the one hand, a cumulative drug transdermal permeability amount from the  
20 patches of Examples 8 to 15 were high as two or more times in comparison with that of the conventional gel preparation.

## CLAIMS

1. A patch,  
comprising a backing layer, and an adhesive layer on the backing layer,  
wherein the adhesive layer comprises at least a local anesthetic agent, a thermoplastic elastomer, a higher fatty acid ester, and a polyol fatty acid monoester, and  
a ratio of the higher fatty acid ester to 100 mass parts of the thermoplastic elastomer is 25 mass parts or more and 200 mass parts or less.
2. The patch according to claim 1, wherein a ratio of the higher fatty acid ester to 100 mass parts of the thermoplastic elastomer is 30 mass parts or more and 150 mass parts or less.
3. The patch according to claim 1 or 2, wherein a content amount of the higher fatty acid ester in the adhesive layer is 60 mass% or less.
4. The patch according to any one of claims 1 to 3, wherein a carbon number in an ester part of the higher fatty acid ester is 12 or more and 30 or less.
5. The patch according to any one of claims 1 to 4, wherein the thermoplastic elastomer is a styrene block copolymer.
6. The patch according to claim 5, wherein the styrene block copolymer is a mixture of a styrene-isoprene-styrene block copolymer and a styrene-isoprene block copolymer.

7. The patch according to claim 6, wherein a ratio of the styrene-isoprene block copolymer in the mixture is 50 mass% or more.

8. The patch according to any one of claims 5 to 7, wherein a viscosity of a 25 mass% toluene solution of the styrene block copolymer at 25°C is 500 mPa·s or more and 2000 mPa·s or less.

9. The patch according to any one of claims 1 to 8, wherein the adhesive layer comprises 5 mass% or more of a tackifier.

10. The patch according to any one of claims 1 to 9, wherein the polyol fatty acid monoester is a propylene glycol fatty acid monoester.

11. The patch according to any one of claims 1 to 10, wherein the adhesive layer further comprises a higher alcohol.

12. The patch according to claim 11, wherein a carbon number of the higher alcohol is 12 or more and 30 or less.

13. The patch according to claim 11 or 12, wherein the higher alcohol is oleyl alcohol and/or lauryl alcohol.

14. The patch according to any one of claims 1 to 13, wherein the local anesthetic agent is one or more local anesthetic agents selected from the group consisting of tetracaine, lidocaine, prilocaine, bupivacaine, mepivacaine, benzocaine, levobupivacaine and ropivacaine.

15. The patch according to any one of claims 1 to 13, wherein the local anesthetic agent is tetracaine.