Emerging Freeze-Drying Process Development and Scale-up Issues

Bhishma R Honarao
Department of Management Studies
Amity University
Dubai, UAE
honaraobhishma786@gmail.com

***Abstract*— Albeit a few rules do exist for stop evaporating process advancement and scale, there are as yet various issues that require extra consideration. The goal of this survey article is to examine some rising procedure advancement and scale-up issue with accentuation on impact of burden condition and freeze drying in novel compartment frameworks, for example, syringes, Lyoguard plate, ampoules, and 96-well plates. Understanding the warmth and mass exchange under various burden conditions and for freeze-drying in these novel compartment frameworks will help in building up a hearty freeze-drying process, which is likewise simpler to scale-up. Further innovative work needs in these rising regions have likewise been tended to. While deliberate rules have been created to address a considerable lot of these scale-up issues, there stay numerous issues that require extra consideration. The point of this audit article is to address the new rising stop evaporating process advancement and scale issues. In this study, glass syringes were suspended through a plexiglas holder. A relatively lower degree of super cooling and hence lower product resistance were found for product in syringes. In agreement with an earlier report, a decrease in sublimation rate with increasing chamber pressure was observed, but the syringe heat transfer coefficient was found to be independent of pressure. The dominant mode of heat transfer was demonstrated to be via radiation. For radiation heat transfer, the scale-up issue is not as severe since the contribution from radiation heat transfer can be estimated from the geometric view factor to the emissivity of the surfaces. Also, in this second study, significant differences were observed for freezing drying in a syringe compared to a vial.**

***Index Terms*— Drying method, food, fruit, vegetable, sun drying, solar drying, osmotic dehydration, freeze drying.**

I. INTRODUCTION

Freeze- drying is broadly used to change over arrangements of shaky materials into strong structure by evacuating the dissolvable, generally water, to improve the long haul stockpiling strength. Freeze drying is frequently seen as a troublesome procedure to structure and scale-up from research facility to assembling. The focal point of this survey section is to address the absolute most significant stop evaporating process advancement and scale gives that have gone generally overlooked or if nothing else have been given insufficient acknowledgment and consideration.

In freeze drying, the watery arrangement is filled into the vials and put onto the temperature-controlled racks of the stop dryer. The rack temperature is brought down to around −40°C, more often than not in a few stages, which results in the change of a large portion of the water into ice. During this solidifying step, a portion of the medications and excipients may likewise take shape. Be that as it may, much of the time the solute stays indistinct in the stop concentrated state. Ordinarily, the measure of unfrozen water in the indistinct stage is about 20% (1). When the material has totally cemented, the vacuum siphon is gone on to empty the item chamber. Normally the chamber weight is kept up somewhere in the range of 50 and 200 mTorr with the end goal that the chamber weight is well beneath the vapor weight of ice at the objective item temperature, bringing about high sublimation rate. Next, the rack temperature is raised to encourage sublimation of ice. This progression is alluded to as essential drying, wherein water is expelled by sublimation of ice. During essential drying, item temperature is kept up underneath the most extreme reasonable item temperature, which is the breakdown temperature for a nebulous solute or the eutectic temperature for a crystalline solute. Drying over the most extreme admissible temperature brings about loss of cake structure which further outcomes in dismissal of the whole cluster because of absence of pharmaceutical style. In the last advance, alluded to as auxiliary drying, the vast majority of the unfrozen water is evacuated by desorption at raised rack temperature with the chamber still under vacuum. The leftover water content toward the finish of optional drying is about 1% (2).

The freeze-drying procedure is an issue in coupled warmth and mass exchange, and warmth and mass exchange issues must be perceived to accomplish procedure control and improvement. The freeze-drying process parameters (i.e., rack temperature, incline rate, and chamber weight) are generally dictated by an experimentation approach, which results in non-ideal procedures with long handling occasions and scale-up issues. Each and every progression of the freeze drying procedure displays a one of a kind procedure improvement and scale-up test. The ice nucleation temperature during the solidifying step decides the size and morphology of the ice gems. The ice precious stones are expelled by sublimation during essential drying abandoning a permeable cake, which is much of the time a "layout" of the ice gem structure. In an ongoing report, the particular surface zone of the dried cake was appeared to connect with the level of super cooling, which

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is the temperature contrast between the balance the point of solidification and the temperature at which ice initially nucleates in the arrangement (3). The level of super cooling relies upon the nearness of particulate issue in the arrangement (i.e., low level of super cooling in a research center condition contrasted with class 100 in assembling) and effects both essential and auxiliary drying. A higher level of super cooling brings about quicker auxiliary drying and longer essential drying time, as a higher level of super cooling brings about littler pore size (i.e., higher explicit surface region) and thus higher item opposition. Along these lines, controlling the level of super cooling presents process advancement challenges not just in the lab dryer due to interval contrasts in drying rate (because of a non-uniform ice nucleation temperature), however it likewise introduces a scale-up test because of contrasts in ice nucleation temperature among research facility and assembling scale (4).

A definitive goal of the freeze-drying procedure is to keep up item quality which is reliable inside the clump as well as from bunch to cluster. Thus, the item temperature turns into a basic item quality property during freeze drying. Reliable item quality is guaranteed when the item has a similar warm history inside the cluster, from bunch to clump and furthermore between lab scale, pilot scale, and generation scale dryers. Since freeze drying is a costly procedure with a normally long handling time, a key target during freeze drying process advancement is to improve process financial matters by lessening the process duration (i.e., expanding throughput). Since the essential drying step is the longest of all the three stages, streamlining of the essential drying time is typically the concentration in the business.

The hypothesis of warmth and mass exchange during freeze drying is settled and a few procedure advancement and scale-up issues are all around tended to in the writing. During essential drying, atypical radiation impacts emerge from the dividers to the entryway of the dryer that keep running at a higher temperature than the rack set point (5). Therefore, the vials on the edge heavenly quicker and keep running at higher temperatures than wrap up of the vials. Additionally, contrasts in warmth and mass exchange execution between stop dryers may happen because of natural plan contrasts (6). During essential drying, the rack surface temperature isn't really uniform, and there could be hot and cold spots on the rack surface that should be distinguished. The mean vial warmth move coefficient might be fundamentally extraordinary between various dryers relying upon the emissivity of the surfaces (rack, dividers, and entryway). Additionally, contingent upon the dryer configuration, there are contrasts in most extreme sublimation rate bolstered by the stop dryer and the base feasible chamber weight (6,7).

II. Literature Review

EFFECT OF LOAD ON FREEZE-DRYING PROCESS DESIGN

The dryer burden condition is a significant procedure variable during stop evaporating process advancement and scale. A full dryer burden is characterized as vials possessing basically all accessible rack surface region. There are a few motivations to run a dryer under fractional burden conditions. For the most part, deficient dynamic pharmaceutical fixing (API) is accessible right off the bat in the assembling history, so to meet the prompt creation needs solidify drying is done under halfway burden conditions.

Under incomplete burden conditions, one may never see the potential for dryer over-burden (i.e., stifled stream or condenser over-burden) during a high warmth and mass motion solidify drying process. In this way, under fractional burden, the procedure runs well, however under full burden condition dryer over-burden happens with loss of chamber weight control. Incomplete burden may likewise bring about the rack surface temperature running somewhat higher than under full burden condition. Also, as the heap on a given rack diminishes, a more noteworthy part of the vials become edge vials (i.e., vials encountering higher warmth move from the dividers to the entryway of the dryer). Thus, the general warmth move to the clump increments (i.e., mean vial warmth move coefficient expands, item temperature increments and drying time diminishes). Finally, there could be a heap condition where the quantity of vials on the rack isn't adequate to keep up the molar transition of water a lot higher than the molar motion of nitrogen, and the gas organization in the chamber changes from 100% water vapor to a critical degree of nitrogen. The gas creation in the chamber is significant since the warmth move by means of gas conduction relies upon the warm conductivity of the gas. In the event that the gas organization were 100% nitrogen, the general vial warmth move coefficient diminishes (by generally 30%) in many applications, item temperature diminishes and henceforth drying time increments.

The impact of burden condition on basic procedure parameters, for example, item temperature and drying time, on a lab scale, pilot scale, and a clinical scale dryer has been as of late explored (8). In going from full burden to fractional burden condition, drying time diminished and item temperature expanded. The radiation impact was accounted for to be the prevailing reason for these patterns as the portion of edge vials expanded at lower burden conditions. Subsequently, the freeze drying cycle may should be balanced (i.e., rack temperature or chamber weight is changed) to accomplish a similar item temperature profile and drying times under various burden conditions.

Freeze-Drying in Syringes

In the past few decades there has been great advancement in the field of freeze-drying in terms of process development and scale-up knowledge. The freeze-drying process which was once designed by “trial and error” methods may now be designed based on a sound understanding of the formulation characteristics and fundamentals of heat and mass transfer. Progress has also been made in the container closure systems used for freeze-drying. Traditionally, the product is freeze-dried in a glass vial. The freeze-dried product is reconstituted with a diluent and administered using a syringe. Current market needs demand alternate packaging for many emerging biopharmaceutical drug products. Thus, many freeze-dried

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products are now supplied in dual chamber syringes or cartridges . The freeze-dried product is in one chamber and the diluent is in the other chamber. Typically, the product is freeze-dried first and then a stopper is pushed into the syringe barrel to separate the two chambers and then the diluent is filled in the other chamber. Reconstitution is quickly and conveniently achieved at the push of the plunger. Prefilled syringes are much convenient from the end user perspective to run less risk of sterility compromise since they do not require several steps before administration. Also, the dosing is more accurate compared to vials and hence requires less overfill compared to vials.

Freeze-drying in these novel container systems poses a unique challenge to freeze-drying process development and scale-up. Glass vials are widely used and are well characterized in terms of heat and mass transfer during freeze-drying. However, there are few reports in the literature describing heat and mass transfer for freeze-drying in syringes. In a recent publication, it has been reported that there is no freezing difference between the vial and the syringe. Homogeneous ice crystal morphology was achieved because of uniform cooling. During primary drying, the sublimation rate decreased with increasing chamber pressure and, as expected, sublimation rate increased with increasing shelf temperature. The overall heat transfer coefficient increased with increasing gas temperature, and hence it was concluded that the major mode of heat transfer for syringes suspended above the shelf is via gas convection. Lastly, no significant differences were observed for drying in a syringe as compared to a vial in terms of sublimation rate.

However, these results are in sharp contradiction to another report. In this study, glass syringes were suspended through a plexiglas holder. A relatively lower degree of super cooling and hence lower product resistance were found for product in syringes. In agreement with an earlier report, a decrease in sublimation rate with increasing chamber pressure was observed, but the syringe heat transfer coefficient was found to be independent of pressure. The dominant mode of heat transfer was demonstrated to be via radiation. This difference with the earlier study is important since if gas convection were the dominant mode of heat transfer, one might expect a severe scale-up challenge since the gas flow dynamics in the drying chamber would likely vary with the size and geometry of the freeze-dryer. For radiation heat transfer, the scale-up issue is not as severe since the contribution from radiation heat transfer can be estimated from the geometric view factor to the emissivity of the surfaces. Also, in this second study, significant differences were observed for freezing drying in a syringe compared to a vial.

Additionally, an improved holder system, which was custom designed from an aluminum (Al) block, was also investigated for freeze-drying in syringes. The syringes were placed inside holes drilled in the Al block. Heat transfer from the shelf to the Al block as well as from the Al block to the syringes was via all three modes: gas conduction, contact conduction, and radiation. With the Al block, heat transfer was greatly improved relative to the plexiglas holder. However, under the same conditions of shelf temperature and chamber pressure, the product temperature was lower and the drying time was longer when compared to freeze-drying in vials.

Bulk Freeze-Drying

Since numerous biopharmaceutical API's are not steady in arrangements they are regularly solidify dried. Normally, metal plate (treated steel) are utilized for mass freeze drying .

III. Research Methodology

Although a few rules do exist for stop evaporating process advancement and scale, there are as yet various issues that require extra consideration. The target of this audit article is to talk about some rising procedure improvement and scale-up issue with accentuation on impact of burden condition and freeze drying in novel holder frameworks, for example, syringes, Lyoguard plate, ampoules, and 96-well plates. Understanding the warmth and mass exchange under various burden conditions and for freeze drying in these novel compartment frameworks will help in building up a vigorous freeze drying process which is likewise simpler to scale-up. Further innovative work needs in these developing zones have likewise been tended to. Descriptive research design suits the research need. (17)

IV. Analysis and Finding

Freeze drying is a costly and tedious procedure, and of the three stages the essential drying step during freeze drying is ordinarily the longest and subsequently is commonly the concentration in industry for procedure improvement. During essential drying, heat is moved from the rack to the item, and ice sublimes from the solidified arrangement deserting the dry layer. In this manner, the coupled warmth and mass exchange relationship administers the essential drying venture of the freeze drying process. The standards behind the freeze drying procedure are presently surely known and hearty hypothetical models which can precisely anticipate item temperature, lingering water, glass change temperature, and essential drying time have been created. A few hypothetical models are accounted for in the writing that portrays the freeze drying process . There are contrasts between these models, for example, suspicions with respect to the geometry of the ice sublimation interface, introductory conditions, limit conditions, and a few other essential presumptions. By the by, palatable understanding is watched, during essential drying, between hypothetically determined procedure parameters, (for example, drying time and item temperature) with those decided tentatively for different regularly utilized excipients. With hypothetical displaying, one can foresee position of the ice sublimation interface, dampness appropriation, and the glass change temperature in the dried layer, which is hard to get tentatively. These hypothetical models can be utilized to foresee the impact of different procedure parameters (rack temperature, slope rate, chamber weight, sublimation rate, and drying time) on basic item quality traits (item temperature, leftover water). Such a methodology helps in making the

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structure space wherein the procedure will work with no issues and simultaneously meet the item details . Additionally, hypothetical displaying limits the quantity of analyses required during procedure improvement and scale-up. Be that as it may, tests are required! A methodical portrayal of the detailing and the holder conclusion framework is required to get the estimations of info parameters for these models. Further, it would consistently be reasonable to approve the hypothetical counts by examinations among hypothesis and test for a subset of the setups of intrigue.

V. Conclusion

Contrasts do exist in warmth and mass exchange contingent upon the heap condition, dryer plan, and the compartment conclusion framework. These distinctions should be contemplated during procedure advancement and scale-up to get a similar item temperature history all through the drying procedure free of the dryer scale. Additionally, it is essential to comprehend the restrictions of the stop dryer (i.e., least attainable chamber weight, most extreme sublimation). The compartment conclusion framework is another significant procedure variable in freeze-drying. Aside from the portrayal of connection between the item and the holder conclusion framework, what is significant for stop evaporating process advancement and scale. It is the best possible choice and portrayal of warmth and mass exchange in these compartment conclusion frameworks, which could be essentially not quite the same as the customarily utilized glass vial. The item may neglect to meet the ideal determinations whenever fixed process duration from a lab scale dryer is utilized on a pilot or creation scale dryer. In this way, the freeze drying cycle should be balanced by changes in rack temperature or chamber weight when the procedure is scaled-up from research center to pilot and at last to creation scale. The procedure ought to be planned dependent on sound standards of warmth and mass exchange instead of an experimentation approach. The fundamental material science is surely known, and this comprehension ought to be adequately utilized in Quality by Design programs. From the end client point of view, prefilled syringes are favored over vials, yet it must be perceived that a procedure enhanced for vials will for the most part not be upgraded for syringes. Customarily tempered steel plate have been utilized for mass freeze drying. Be that as it may, Lyoguard plate and holders do offer the benefit of item regulation and perhaps at the same time give focal points in reproducibility of warmth move, since tempered steel skillet are dependent upon genuine distorting with proceeded with use. Likewise, contingent upon the last application, solidify drying might be completed in other compartment conclusion frameworks, for example, ampoules and 96-well plates. For long haul stockpiling of organic guidelines, vials with fitting plugs appear to be in any event as successful as the ampoules. Ultimately, the hypothetical models for freeze drying are helpful apparatuses that use the fundamental information of warmth and mass exchange in freeze drying to give a comprehension of the impact of different procedure parameters on the basic item quality properties.

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