

Contents

Preface	ix		
<hr/>			
1. Introduction to Crystallization Issues	1		
<hr/>			
1.1 Crystal Properties and Polymorphism (Chapters 2 and 3)	2		
1.2 Nucleation and Growth Kinetics (Chapter 4)	3		
1.3 Critical Issues (Chapter 5)	3		
1.4 Mixing and Crystallization (Chapter 6)	4		
1.5 Crystallization Process Options (Chapters 7–10)	4		
1.6 Special Applications (Chapter 11)	9		
1.7 Regulatory Issues	10		
2. Properties	13		
<hr/>			
2.1 Solubility	13		
2.2 Supersaturation, Metastable Zone, and Induction Time	21		
2.3 Oil, Amorphous, and Crystalline States	25		
2.4 Polymorphism	29		
2.5 Solvate	32		
2.6 Solid Compound, Solid Solution, and Solid Mixture	34		
2.7 Inclusion and Occlusion	37		
2.8 Adsorption, Hygroscopicity, and Deliquescence	39		
2.9 Crystal Morphology	42		
2.10 Particle Size Distribution and Surface Area	44		
3. Polymorphism	49		
<hr/>			
3.1 Phase Rule	49		
3.2 Phase Transition	50		
3.3 Examples	52		
Example 3-1 Indomethacin	53		
Example 3-2 Sulindac	55		
Example 3-3 Losartan	57		
Example 3-4 Finasteride	58		
Example 3-5 Ibuprofen Lysinate	61		
Example 3-6 HCl Salt of a Drug Candidate	62		
Example 3-7 Second HCl Salt of a Drug Candidate	66		
Example 3-8 Prednisolone <i>t</i> -Butylacetate	70		
Example 3-9 Phthalylsulfathiazole	74		
3.4 Future Direction	76		
4. Kinetics	77		
<hr/>			
4.1 Supersaturation and Rate Processes	77		
4.2 Nucleation	79		
4.3 Crystal Growth	87		
4.4 Nucleate/Seed Aging and Ostwald Ripening	98		
4.5 Delivered Product: Size Distribution and Morphology	99		
5. Critical Issues in Crystallization Practice	101		
<hr/>			
5.1 Introduction	101		
5.2 Nucleation	101		
5.3 Growth	104		
5.4 Oiling Out, Agglomeration/ Aggregation	106		
5.5 Seeding	110		
5.6 Rate of Generation of Supersaturation	115		
5.7 Summary of Critical Issues	116		
6. Mixing and Crystallization	117		
<hr/>			
6.1 Introduction	117		
6.2 Mixing Considerations	118		

6.3	Mixing Effects on Nucleation	119	Example 9-2	Rejection of Isomeric Impurities of Final Bulk Active Product	185
6.4	Mixing Effects on Crystal Growth	123	Example 9-3	Crystallization of a Pharmaceutical Product with Poor Nucleation and Growth Characteristics	188
6.5	Mixing Scale-up	126	Example 9-4	Impact of Solvent and Supersaturation on Particle Size and Crystal Form	192
6.6	Crystallization Equipment	127	9.2	In-Line Mixing Crystallization	196
Example 6-1		135	Example 9-5	Crystallization of an API Using Impinging Jets	197
7. Cooling Crystallization		137	Example 9-6	Crystallization of a Pharmaceutical Product Candidate Using an Impinging Jet with Recycle	204
7.1	Batch Operation	137	10. Reactive Crystallization		207
7.2	Continuous Operations	143	10.1	Introduction	207
7.3	Process Design—Examples	147	10.2	Control of Particle Size	209
Example 7-1	Intermediate in a Multistep Synthesis	147	10.3	Key Issues in Organic Reactive Crystallization	210
Example 7-2	Pure Crystallization of an API	150	10.4	Scale-up	218
Example 7-3	Crystallization Using the Heel from the Previous Batch as Seed	154	Example 10-1	Reactive Crystallization of an API	218
Example 7-4	Resolution of Ibuprofen Via Stereospecific Crystallization	155	Example 10-2	Reactive Crystallization of an Intermediate	223
Example 7-5	Crystallization of Pure Bulk with Polymorphism	160	Example 10-3	Reactive Crystallization of a Sodium Salt of an API	225
Example 7-6	Continuous Separation of Stereoisomers	161	Example 10-4	Reactive Crystallization of an API	228
8. Evaporative Crystallization		167	10.5	Creation of Fine Particles—In-Line Reactive Crystallization	231
8.1	Introduction	167	11. Special Applications		235
8.2	Solubility Diagrams	167	11.1	Introduction	235
8.3	Factors Affecting Nucleation and Growth	170	11.2	Crystallization with Supercritical Fluids	236
8.4	Scale-up	171	11.3	Ultrasound in Crystallization	237
8.5	Equipment	171	11.4	Computational Fluid Dynamics in Crystallization	238
Example 8-1	Crystallization of a Pharmaceutical Intermediate Salt	175			
Example 8-2	Crystallization of the Sodium Salt of a Drug Candidate	177			
9. Antisolvent Crystallization		179			
9.1	Semibatch Operation	179			
Example 9-1	Crystallization of an Intermediate	184			

Example 11-1	Sterile Crystallization of Imipenem	238	Example 11-5	Freeze Crystallization of Imipenem	255
Example 11-2	Enhanced Selectivity of a Consecutive-Competitive Reaction by Crystallization of the Desired Product During the Reaction	243	Example 11-6	Continuous Separation of Stereoisomers	259
Example 11-3	Applying Solubility to Improve Reaction Selectivity	246	11.5	Strategic Considerations for Development of a New Crystallization Process	272
Example 11-4	Melt Crystallization of Dimethyl Sulfoxide	251	References		279
			Index		285