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**Deformation behavior of crystallized mannitol during compression using a rotary  
tablet press simulator**

Nicolas TARLIER<sup>1,2\*</sup>, Ian SOULAIROL<sup>1,3</sup>, Noelia SANCHEZ-BALLESTER<sup>1</sup>, Gilles BAYLAC<sup>1</sup>,  
Adrien AUBERT<sup>1</sup>, Philippe LEFEVRE<sup>2</sup>, Bernard BATAILLE<sup>1</sup>, Tahmer SHARKAWI<sup>1</sup>.

<sup>1</sup> Institut Charles Gerhardt UMR5253 Equipe MACS, UFR Science Pharmaceutique -  
Université Montpellier, MONTPELLIER

<sup>2</sup> Customer Technical Service Pharma, ROQUETTE FRERES, LESTREM

<sup>3</sup> Department of Pharmacy, CHU Caremeau, Nimes.

\*Corresponding Author: [nicolas.tarlier@roquette.com](mailto:nicolas.tarlier@roquette.com)

ROQUETTE FRERES, Rue de la Haute Loge, 62136 LESTREM – 03 21 63 36 00

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**Abstract:**

Mannitol is commonly used as a pharmaceutical excipient for tablets; the most widely used oral dosage form for drug delivery. For tableting, mannitol is provided in two different forms: native crystals and textured particles. In order to optimize its formulation, a good understanding of the mechanical behavior mechanism of mannitol is necessary. Thus, the aim of this study is to evaluate the deformation mechanism of native mannitol crystals presenting different particle sizes. Pharmaco-technical and compression studies were performed using mannitol with different mean diameters (160  $\mu\text{m}$ , 50  $\mu\text{m}$  and 25  $\mu\text{m}$ ). Lactose (monohydrate) and microcrystalline cellulose were used as brittle and plastic reference materials, respectively. Tableting tests and mathematical models, HECKEL and WALKER, were used to study the deformation mechanism of mannitol ( $\beta$ ). Mean Yield Pressure ( $P_y$ ) and WALKER coefficient ( $W$ ) values showed that the studied crystalline

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