

"اللهم افتح عليّ فتوح العارفين، ووفقني لفهم ما أدرس، واجعل علمي حجة لي لا عليّ."

نصيحة من دكتورة اسراء ومنني كمان ♥، اقرأ المادة مرة ومرتين قبل ما تحفظها عشان تترسخ فماغك اكثر وما تنساها بسرعة صح مضغوطين دايم بس حاول افهم قبل ما تحفظ ما تخلي اسلوبك بالدراسة بس حفظ ... وبس والله 🙏

Mixing

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Credit: Prof. Nizar Al-Zoubi

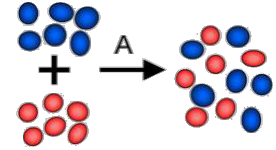
by: Noor Mansour 🙏

1

عملية هدفها جمع مكونين او اكثر غير مختلطين

Mixing

- Mixing may be defined as a unit operation that aims to treat two or more components, initially in an unmixed or partially mixed state, so that each unit (particle, molecule etc.) of the components lies as nearly as possible in contact with a unit of each of the other components.



الاشكال الجيد لاكتبة الي بنسفها في mixing

This may be:

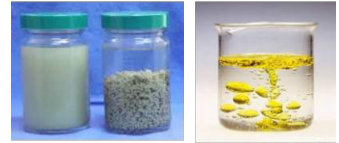
- 1) Mixing of Powdered materials (e.g. tablets, capsules, dry powder inhalers).
- 2) Mixing of miscible liquids (e.g. solutions) or immiscible (e.g. emulsions).
- 3) Mixing of insoluble solid and liquid (e.g. Suspensions).
- 4) Mixing of semisolids or dispersion of particles in semisolids (e.g. pastes and ointments).

2

Mixing

- Types of mixtures:

- 1) **Positive mixtures**: Mixtures that form spontaneously (do not need energy) and irreversibly (when formed do not tend to separate).
تتكون تلقائياً بدون طاقة، ولا ترجع تنفصل بعد الخلط
(e.g. *gases and miscible liquids*)
- 2) **Negative mixtures**: Mixtures that need energy input (work) to form and keep. Once the energy input is stopped they tend to separate.
لا تتكون الا بطاقة خلط، ويتنفصل مباشرة اذا وقف مصدر الطاقة
(e.g. *Suspensions, emulsions and creams*)
- 3) **Neutral mixtures**: Mixtures that do not form spontaneously (i.e they need energy input) but once formed they do not tend to separate.
لازم نعطيهما طاقة ليصير خلط، لكنها لا تنفصل بعد الخلط (مستقرة)
(e.g. *Powder mixtures, pastes and ointments*)



3

The mixing Process

Perfect mixture: The situation in which particles of one component lay as closely as possible in contact with particles of other component.

- It is an ideal situation which is practically impossible. — **ideally** بس مستحيل فعلياً
كل ذرة او جسيم من المادة A لازم يكون ملاصق تماماً لجسيم من المادة B.

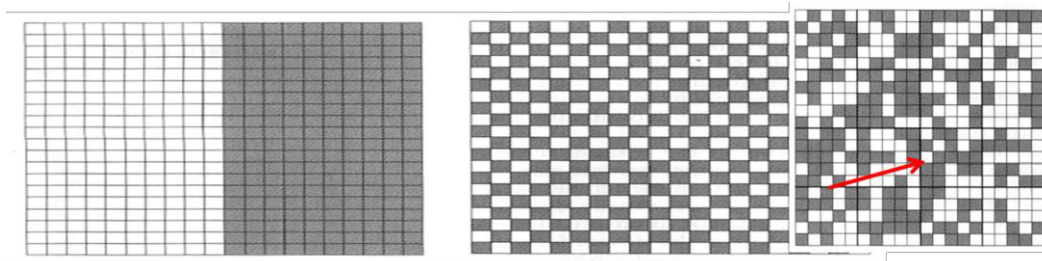
Random mixture: A mixture where the probability of sampling a particular type of particle is the same at all positions and is proportional to the number of such particle on the total mix.

احتمال وجود نوع معين من الجسيمات في اي نقطة من الخليط نفسه في كل مكان ومتناسب مع نسبته الكلية.

يعني لو نسبة المادة الفعالة 10%، المفروض اي عينة صغيرة تسحبها تعطي قريب 10% (طبعاً مش رح يكون نفس النسبة 100% لكنه قريب جداً)

4

The mixing process



Unmixed system
Complete segregation

Mixed Ordered system
Perfect (ideal) mix

Mixed random system

- **Ordered system:** particles are arranged in iterative rule (repetitive pattern) (not random)
- We can consider mixing as vector quantity (spatial orientation and translational velocity of the particles)

5

Ordered system: هو لما الجسيمات ما تكون عشوائية وإنما مرتبة بنمط معين

The mixing Process

- It is the weight/volume of the dosage unit that dictates how closely the mix must be examined/analyzed to ensure it contains the correct dose/concentration.
- This weight/volume is known as the scale of scrutiny and it is the amount of material within which the quality of mixing is important.

كمية العينة التي يجب فحصها لتقييم جودة الخلط

6

The mixing Process

- For example, if the unit dose of tablets is 200 mg (containing 100 mg active drug) then 200 mg sample from the mix needs to be analyzed.

قرص وزنه 200 mg يحتوي على 100 mg مادة فعالة, لازم اختبر 200 mg من المزيج

- The number of particles in scale of scrutiny depends on sample weight, particle size and particle density. العوامل المؤثرة :-

كل ما كانت العينة صغيرة او كانت نسبة المادة الفعالة قليلة يزيد التفاوت بين العينات

✱ كلما قلت نسبة المادة الفعالة ← زادت المشكلة
✱ كلما زاد عدد الجسيمات داخل العينة ← تحسن الخلط
— وهذا السبب ليس يتم تقليل حجم الجسيمات (milling)

Number of particles of a **minor active** constituent present in samples taken from a **1:1000** random powder mix with different numbers of particles in the scale of scrutiny

Sample number	Number of particles in scale of scrutiny		
	1000 قليل	10 000	100 000 كبير
1	1	7	108
2	0	10	91
3	1	15	116
4	2	8	105
5	0	13	84
6	1	10	93
7	1	6	113
8	2	5	92
9	0	12	104
10	1	13	90
Mean	0.9 ~ 1	9.9 ~ 10	99.6 ~ 100
Standard deviation	0.78	3.38	11.18
% CV	86.86 عالي	34.17 وسط	11.23 قليل
Deviation from theoretical content	±100%	±50%	±16%

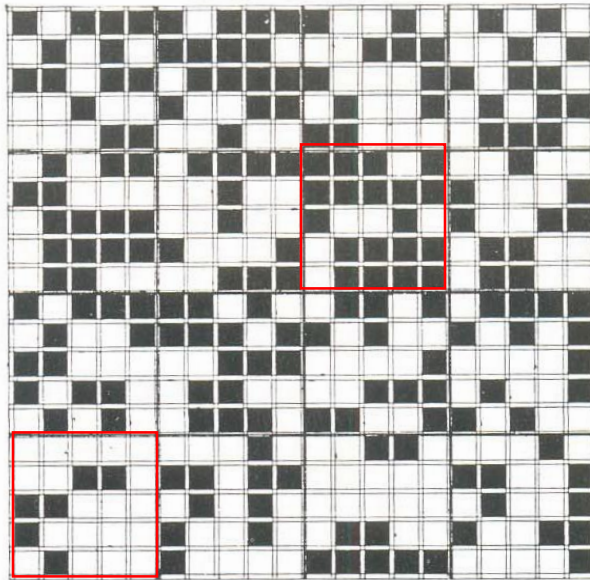
على 1000 particle في الخليط فقيم 1 particle فعالة (minor component)

✱ كل ما زاد عدد الجسيمات في العينة
✓ زادت الدقة
✓ قل الانحراف
✓ تحسن الخلط
✱ كل ما كانت العينة صغيرة
✓ انتشرت عشوائية وسيئة جدًا

لا زاد عدد الجسيمات داخل العينة , النتائج صارت افضل

افضل توزيع

(16) blocks



Theoretical percentage of white particles is 50 %

دفعات الجسيمات البيضاء والبنفسج سوداء

In the total 400 particles (20 * 20) the percentage of white is 51 % (= 102 % of theoretical)

51% white → ما لمع 50 لان الخليط random
49% black → مش perfect

If divided to 16 blocks of 25 particles (5 * 5) the percentage of white is 24.76 % (= 48 - 152 % of theoretical)

24%*200

48%*200

في block 24% و 76%

16 * 25 = 400 particles

9

الخلاصة: لما حجم العينة صغير (25 particles) random mix ما بعطي نتائج ثابتة وكل جزء من الخليط يحتوي نسب مختلفة وبخلي الجرعات مش دقيقة لذلك يجب زيادة عدد الجسيمات الصغيرة داخل الجرعة عن طريق تصغير particle size حتى تحتوي الجرعة على اكبر عدد منهم.

The mixing Process

- Another factor to consider in mixing is the proportion of the active component in the dosage form/scale of scrutiny.



Ratio: 50 %

Total number = 400

Theoretical number of white particles = 200 → 50%

194/200=97%

202/200=101%

198/200=99%

Fig. 32.2 Computer generated mixtures of nominal 50% active ingredient. The numbers in parentheses refer to the number of

11



Ratio: 10 %

Total number = 400

Theoretical number of white particles = 40 → 10 %

42/40=105%

35/40=87.5%

43/40=107.5%

Fig. 32.3 Computer generated mixtures of nominal 10% active ingredient. The numbers in parentheses refer to the number of 'white' particles in each mix, theoretically 40

12

نتائج مستقر

نتائج مستقر

The mixing Process

- The variation in component percentage between different samples taken from a mixture **increases**:
 1. **as the amount (number of particles) in scale of scrutiny decreases.**
 2. **as the proportion of a component in mixture decreases.**

13

The mixing Process

- This indicates that: **low drug %** **المصعب عملية خلط**
 - the **lower the percentage of active ingredient (potent drug)** in mixture, **the more difficult** it is to achieve an acceptably low deviation in active content.
- small particle size** **لتحسين توزيع الدواء**
 - The **more particles are present in dose (scale of scrutiny)** the **lower the deviation** of content → The number of particles can be increased by **decreasing particle size** (This can be done by **milling**).

14

Mathematical treatment of mixing process

- There will be always some variation in the composition of samples taken from random mixtures.
- The aim during formulation and processing is to minimize this variation to acceptable levels by selecting appropriate :
 - scale of scrutiny
 - particle size
 - mixing procedure

15

Mathematical treatment of mixing process

- For random mix, if we consider that particles are all of same size, shape and density then:

$$SD = \sqrt{\frac{p(1-p)}{n}}$$

النسبة المئوية الغلظة $\downarrow$
 n ← عدد الجسيمات في العينة
 (scale of scrutiny)

- **P is the proportion of a component in total mix**

- As p increases, %CV decrease
 $n \text{ increases } \%CV \text{ decrease}$

Example:

$$n = 100\,000, p = 0.5 \Rightarrow SD = 1.58 \times 10^{-3}, \%CV = 0.32\%$$

$$n = 100\,000, p = 0.001 \Rightarrow SD = 9.99 \times 10^{-5}, \%CV = 10\%$$

قليل

كثير

- The scale of scrutiny can be increased by increasing the amount of additives in the mixture but this will lead to a decrease in p .

16

$\uparrow n \downarrow p$

Evaluation of degree of mixing

Needs for monitoring of mixing:

- To follow a mixing process:
 - To indicate the degree of mixing
 - To indicate when sufficient mixing has occurred and determine the suitable mixing time
- To assess the efficiency of a mixer

Sampling طرق سحب العينات

- Scoop sampling
- Thief sampling

17



Unit dose thief sampler

18

Evaluation of degree of mixing

Mixing Index (M)

$$M = \frac{S_R}{S_{ACT}} \rightarrow \text{Random} \rightarrow \text{واقعي}$$
 ← كل طعنة اقرب لـ 1
 كان mixing صالح

S_R : Content standard deviation of random mixture

S_{ACT} : Content standard deviation of mixture under investigation.

- In some cases, it is possible to achieve an acceptable variation in content before obtaining a random mix

19

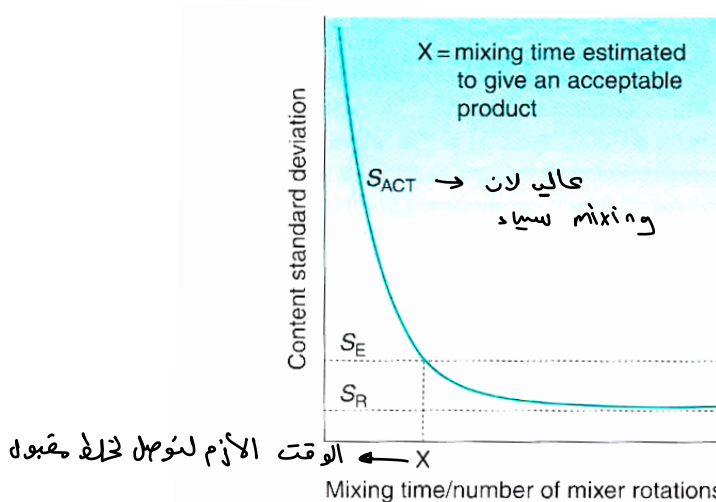


Fig. 12.4 The reduction in mixing time possible if a random mix is not required. S_{ACT} represents the content standard deviation of samples taken from the mix, S_E the estimated acceptable standard deviation and S_R the standard deviation expected from a random mix.

20

Mechanisms of mixing

Powders

There are three main mechanisms for powder mixing:

- a) **Convection** (the transfer of large amount of particles from one part of the powder bed to another). نقل مجموعة كبيرة من الجزيئات معاً

This may occur when a mixer blade or paddle moves through the mix.

This mechanism contributes mainly to macroscopic mixing of powders, but mixing does not occur within the group of particles moving together. يعمل خلط كبير بس ما بخلط الجزيئات الصغيرة مع بعض داخل الطبقة نفسها

زي لما تقليب رز بعلقة- بتقل
عيبة جيرة من فوق لكنت



21

Mechanisms of mixing

Powders

- b) **Shear** (Layer of powder flows over another layer) طبقات تنزلق فوق بعضها

This may occur when some of the material is removed (e.g. by convective mixing) causing powder bed to collapse.



22

Mechanisms of mixing

اهم آلية وتنتج من توسع الفراغات بين الجسيمات وسقوطها عشوائيا

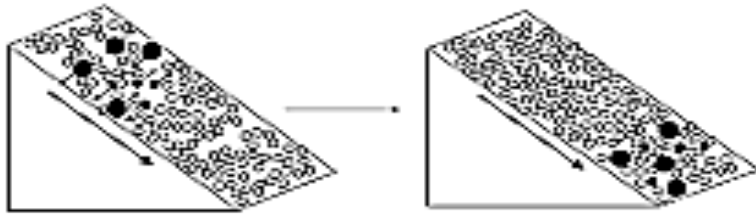
Powders

c) **Diffusion** (mixing of individual particles)

This mechanism is necessary to form true random mixture.

When a powder bed is forced to move or flow it will dilate (the particles become less tightly packed and the voids between them increase).

This allows particles to fall under gravity through the voids created.



23

الباور بتتحرك وتتمدد (dilates) يعني (الفراغات) بتكبر
فالجزيئات الصغيرة بتنزل بينها تحت تأثير الجاذبية الأرضية

آليات خلط السوائل:

Mechanisms of mixing

Liquids

a) **Bulk transport**

نقل كتلة كبيرة من السائل

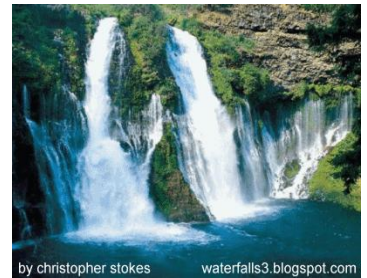
- The movement of a large portion of the material being mixed from one position in the system to another.



b) **Turbulent mixing**

حائل ! شكال الماء →

- The haphazard movement of molecules when forced to move in turbulent manner, which means random fluctuation of the fluid speed and movement direction, so that the fluid has different instantaneous velocities at different locations at the same time.



by christopher stokes

waterfalls3.blogspot.com

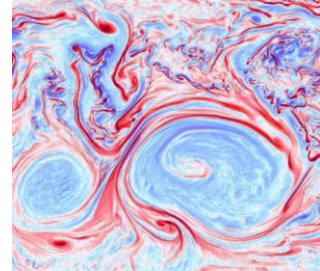
24

حركة عشوائية سريعة للسائل، يتحركوا بسرعات واتجاهات مختلفة بنفس اللحظة

Mechanisms of mixing

Liquids

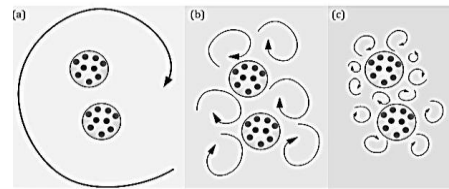
- b) Turbulent mixing الاضطراب دوامات
- It can be seen as a composite of different eddies (small portions of fluid moving as a unit) of various sizes.



The large ones tend to break into smaller and smaller sizes until they are no longer distinguishable.

- Turbulence is a highly effective mechanism for mixing.

كل دوامة تعتبر جزء من السائل يتحرك كوحدة واحدة وفيه دوامات كبيرة وصغيرة، الدوامات الكبيرة بتتكسر لدوامات اصغر واصغر لحد ما تختفي، هذا يؤدي الى mixing سريع وفعال جداً لان حركة الجزيئات تكون قوية وعشوائية.



25

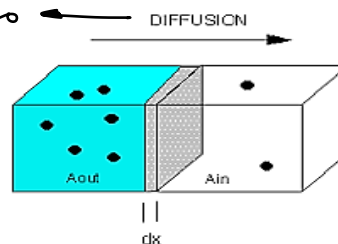
Mechanisms of mixing

Liquids

c) Molecular diffusion

- The molecular diffusion is the primary mechanism responsible for mixing at the molecular level. لانها عملية بطيئة جداً وما يرفع استسهة على الصلابة mixing
- This mechanism produces well mixed liquids if there is sufficient time.
- Considerable time is needed if this is the only mixing mechanism.

من منطقة عالية التركيز إلى المنطقة الأقل تركيز



26

ليس mixing

Powder segregation (demixing)

- Segregation is the opposite effect to mixing, i.e. components tend to separate out (S_{ACT} increases).
- It may cause a random mixture to change to non-random or may be responsible that a random mixture never occurs.
- الفصل
Segregation is more likely to occur if powder bed is subjected to vibration and when the particles have greater flowability.



27

ليس بـ mixing segregation
Segregation can be due to difference in :

1. Particle charge
2. Particle density
3. Particle shape
4. Particle size and size distribution

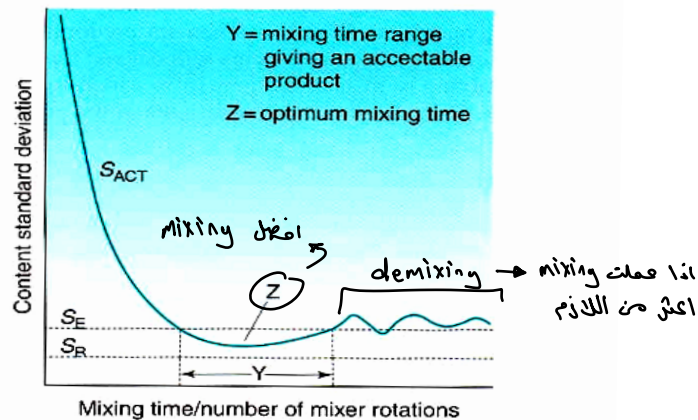


Fig. 12.5 Possible effect of extended mixing time on the content standard deviation of samples taken from a mix prone to segregation. S_{ACT} represents the content standard deviation of samples taken from the mix, S_E the estimated acceptable standard deviation and S_R the standard deviation expected from a random mix.

28

Powder segregation (demixing)

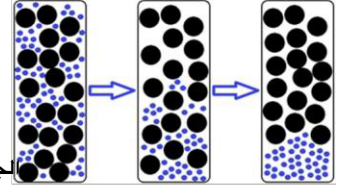
← الكبار بالمعلو الغوقت والعضار بنزلها لاحت

Factors affecting segregation:

1. Particle size

Percolation segregation

(small particles tend to fall through voids between large particles) الجسيمات الصغيرة تنسرب بين الفراغات بين الجسيمات الكبيرة



Trajectory segregation

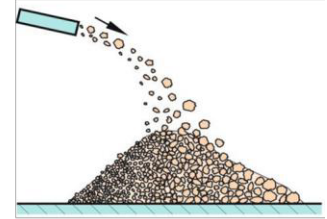
(large particles tend to have greater kinetic energy)

Elutriation segregation (dusting out)

(Air-blown small particles sediment and form a layer over coarse particles)

الجسيمات الصغيرة جداً يرتفع معها الهواء ويتخلل
ملعقة بعدين تسقط على السطح (dusting).

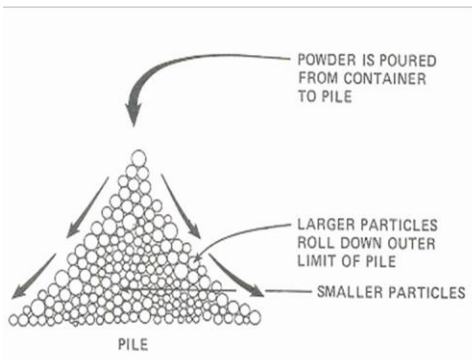
Percolation segregation:



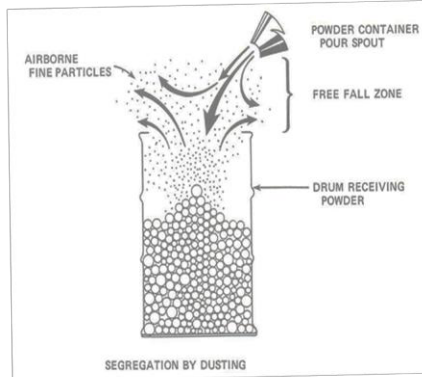
Trajectory
segregation

29

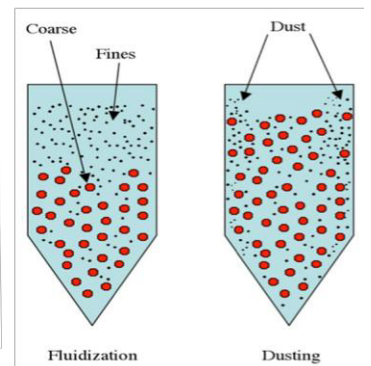
لما اصب الباور من ارتفاع الجسيمات الكبيرة يتمشي
مسافة ابعد والصغيرة تسقط قريب من نقطة السكب .



Trajectory segregation



(Elutriation)



30

Powder segregation (demixing)

Factors affecting segregation:

2. Particle density

الجسيمات الاعلى كثافة تهبط للاسفل
الجسيمات الاقل كثافة تطفو للاعلى

Segregation occurs due to density differences.

3. Particle shape

Spherical particles are easier to be mixed but also to segregate than irregular or needle shaped particles.

الجسيمات الكروية اسهل للخلط لكنها تنفصل بسهولة، الجسيمات غير المنتظمة تتشابه اكثر لذلك تقل الاحتمالية انه يصير لها segregation

31

✱ فرق تقليل مشكلة الفصل بعد mixing ✱

Approaches to solve the problem of segregation

1. Selection of particular size fractions to achieve drug and excipients of the same particle size range.
كلما كانت المكونات بنفس الحجم، قل احتمال الفصل
2. Milling of the components so that their size becomes small and same.
3. Controlled crystallization during production of drug or excipient to give particles of particular size or shape.
4. Selection of excipients which have similar density to the drug.

32

Approaches to solve the problem of segregation

- 5. Granulation of powder mixture.
- 6. Reduce the extent to which the powder mass is subjected to vibration or movement after mixing.
تقليل الاهتزاز او الحركة بعد mixing
- 7. Using equipments where several processes can be carried out without transferring the mix.
بستخدم جهاز بجمع كل العمليات عشان اقلل من نقل الخليط
- 8. Production of an ordered mix.

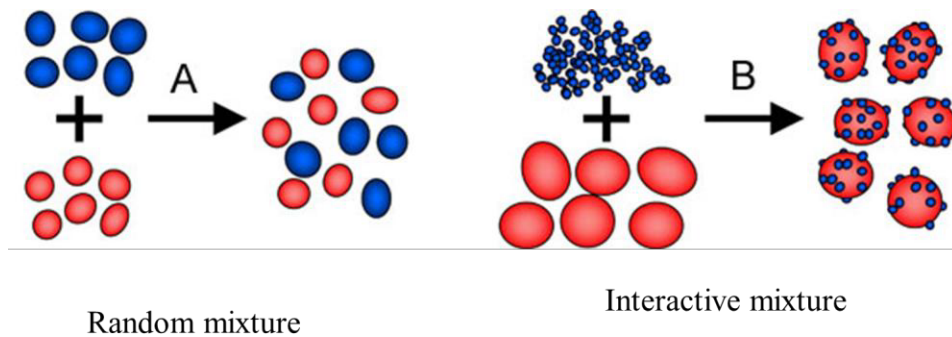
33

Ordered mixing

- It is termed also adhesive or interactive mixing.
- In this case, very small particles may become adsorbed onto the active sites of large particles.
الجسيمات الصغيرة رح تلتصق مع الكبيرة فبصير صعب الانفصال
- This minimizes the segregation between small (adsorbed) particles and large (carrier) particles.
- Ordered mixing is most likely to occur when the adsorbed particles are very small so that the adsorption force is higher than the gravitational force trying to separate the components.

34

قوة الالتصاق اكبر من قوة الجاذبية التي تحاول تفصل الجزيئات



35

Application of ordered mixing

1. **Dry antibiotic formulations** (fine antibiotic powder is blended with and adsorbed onto the surface of large sucrose or sorbitol particles.
2. **Dry powder inhaler formulations**
3. **Direct compression formulations**
4. **Formulation of potent drugs**



36

Segregation in ordered mixes

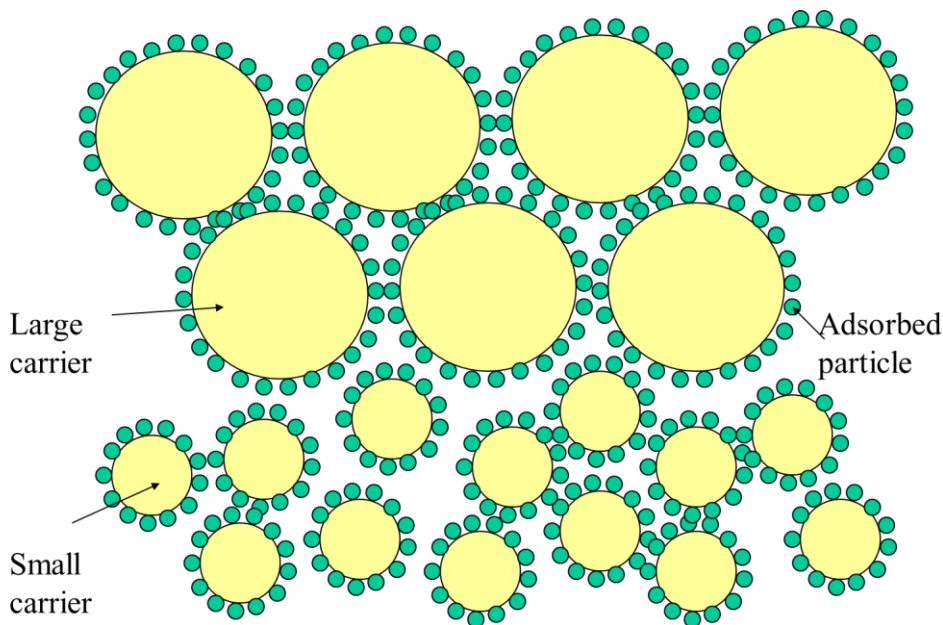
Ordered unit segregation

الأسباب

- The carrier particles vary in size.
- In this case segregation occurs within the carrier particles according to size.
- The small particles have higher specific surface area than the large and so higher content of adsorbed material.

الجسيمات الصغيرة تلتصق أكثر على carries الصغيرة لأنها تملك سطح أكبر

37



Ordered-unit segregation

38

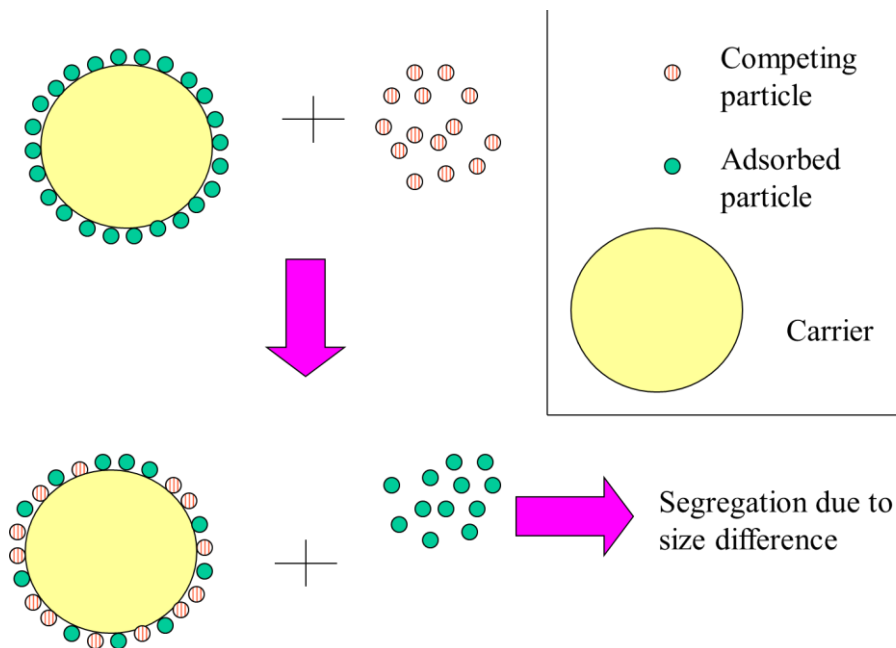
Segregation in ordered mixes

Displacement segregation

- There is competition for the active sites on the carrier.
- This occurs when a component is added to an ordered mixture that competes with the adsorbed material for the site on the carrier and displaces it

لو اضيفت جسيمات جديدة (competing particles) الى الخليط قد تكون هذه الجسيمات:
اقوى في الالتصاق بال carries او تتنافس على نفس active site.
النتيجة:
الجسيم الجديد (displace) الجسيم الاصلي على carries

39



Displacement segregation

40

Segregation in ordered mixes

Saturation segregation

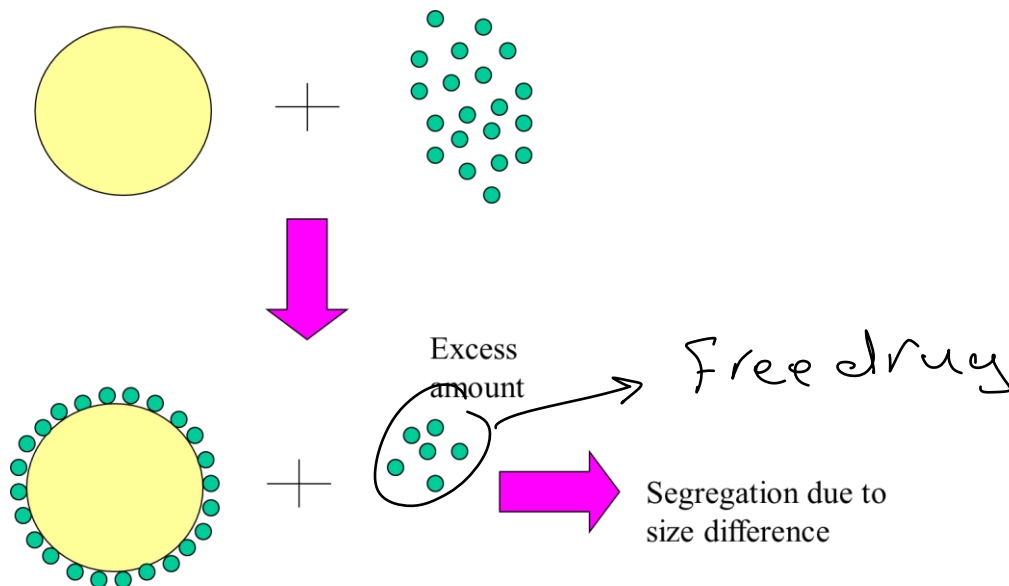
- There are **insufficient carrier particles**

الكمية المضافة من الجزيئات الصغيرة اكبر من قدرة الاسطح

- If the added amount of small-sized material is higher than the capacity of the carrier particles then the excess amount will be free (not adsorbed) and it segregate due to size difference.

الكمية الزائدة تبقى free بسبب saturation

41



Saturation segregation

42

42

Practical considerations in Powder mixing

- When mixing formulations where the proportion of active drug is low, a more even distribution may be obtained by building up the amount of material in the mixture sequentially (geometric dilution).

بنبلش نخلط كمية صغيرة من الدواء مع كمية مساوية من المادة بعدين بنزيد الكمية تدريجياً

- The volume of powder mixture in the mixer should be appropriate. Both overfilling and underfilling may reduce mixing efficiency.

لازم يكون مستوى التعبئة مناسب

- The mixer should produce the mixing mechanism appropriate for the formulation:
 - Potent drugs: diffusion is necessary
 - Cohesive material: shear mixing

43

Practical considerations in Powder mixing

- In order to determine suitable mixing time, the mixing process should be checked by removing and analyzing representative samples after different mixing intervals.

لازم نعمل sampling (اخذ عينات) خلال فترات مختلفة لتحديد الزمن الامثل للخلط

- Static charges may be generated during mixing that result in reduction in diffusive mixing.

قد تتولد كهرباء ساكنة اثناء التحريك وهذا يقلل diffusive mixing

- This is enhanced by low humidity in atmosphere. The mixer should be suitably earthed to dissipate the static charge.

الرطوبة المنخفضة مشكلة لانه الشحنات الساكنة تزيد لذلك يجب ان يكون الخلاط earthing لتفريغ الشحنة الكهربائية

- Vibrations may cause segregation in normal mixes and dislodging of adsorbed particles in ordered mixes.

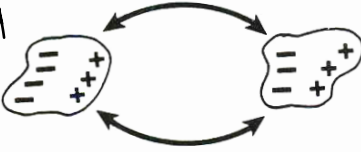
الاهتزاز قد يسبب المشاكل ويعمل segregation

44

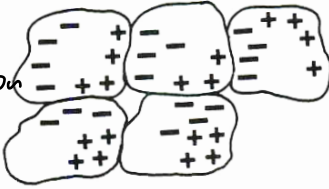
الشحنة متعادلة



اثناء الحركة
والاصطدام



agglomeration



NEUTRAL PARTICLE (electrical charge evenly distributed over particle)

PROCESSING AND/OR DRY PARTICLE MOVEMENT CAUSES POLARIZATION OF FINE PARTICLES (static electric forces)

POLARIZATION CAUSES AGGLOMERATION OF FINE PARTICLES (electrical charges induced by one particle on another van der Waals forces)

Figure 22 Effect of electrical forces on fine particles.

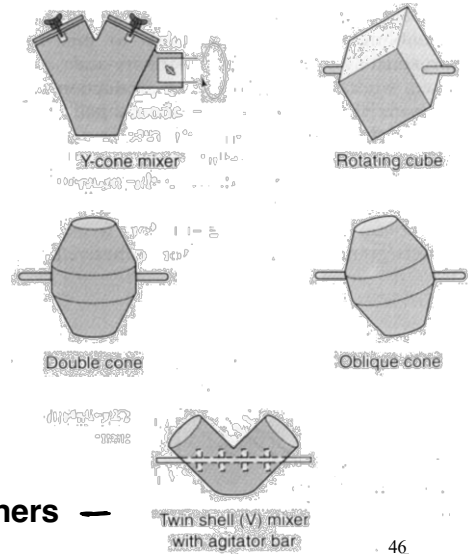
45

المختار بالآلة

Powder mixing equipment

Tumbling mixers

- Mixing containers are mounted so that they can rotate about an axis.
- Commonly used for mixing of free flowing powders and are not suitable for cohesive powders.
- Commonly used for mixing granules with lubricant, glidant and external disintegrant.



containers تتحرك بالدوران حول المحور

مناسبة لل free-flowing powders

غير مناسبة للمساحيق المتماسكة (cohesive) لأنها ما بتعطي shear عالي

46

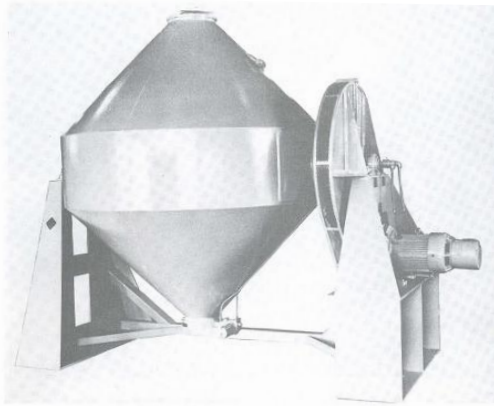


Figure 28 Double-cone blender. (Courtesy of Patterson-Kelley Company, Division of HARSCO Corporation, East Stroudsburg, Pennsylvania.)

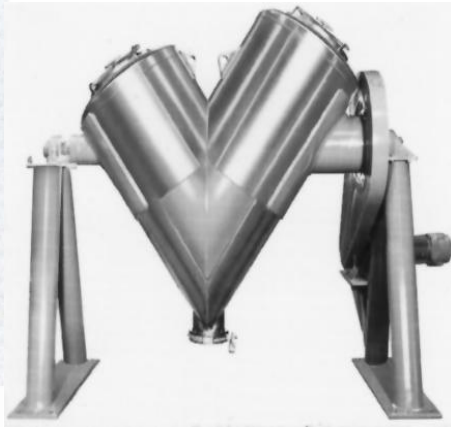


Figure 31 V-shaped blender with agitator mixing assembly. (Courtesy of Gemco, Middlesex, New Jersey.)

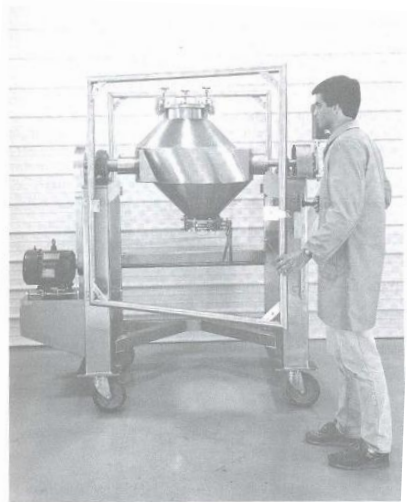
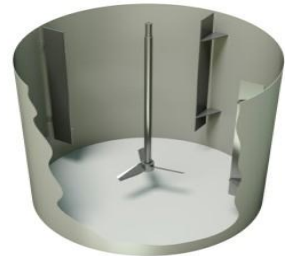


Figure 29 Slant double-cone mixer. (Courtesy Gemco, Middlesex, New Jersey.)

Powder mixing equipment

Tumbling mixers

- The shear mechanism occurs because of velocity gradient produced while diffusion occur through voids produced during powder flow.
- The addition of prongs, baffles or rotating bars helps convective mixing.
- Care about segregation is necessary.



49

shearing mixing: يحدث بسبب اختلاف السرعة بين طبقات المسحوق

diffusion mixing: يحدث عبر الفراغات عند تحرك المساحيق بحرية

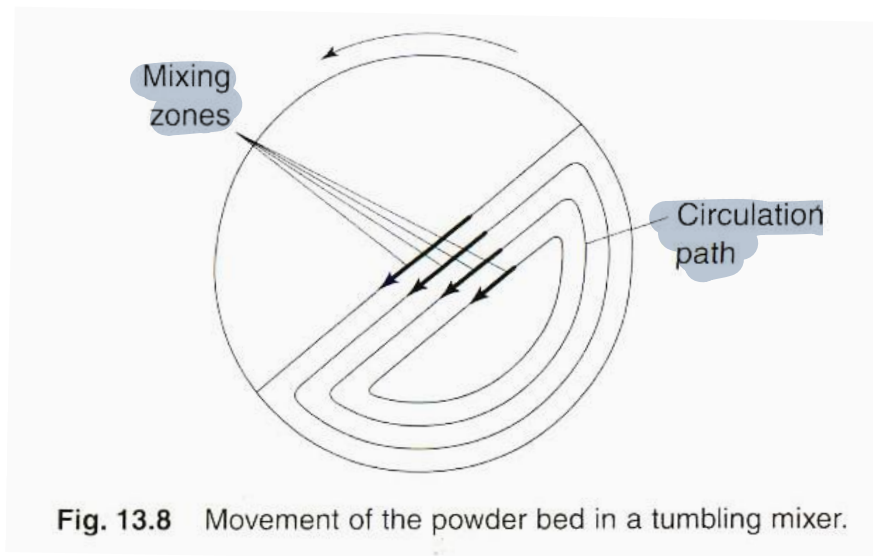


Fig. 13.8 Movement of the powder bed in a tumbling mixer.

50

Powder mixing equipment

Tumbling mixers

السعة

- Capacity ranges from 50 g to 100 kg. → Fill Volume
- The material typically occupies 1/2 to 2/3 of the mixer volume.
- The mixing efficiency depends on speed of rotation. Speed of rotation should be suitable:
 - Very high speed will cause the powder to be held on the mixer walls by centrifugal force.
 - Very low speed will generate insufficient bed expansion and little shear mixing.

51

إذا كانت السرعة عالية جداً : المواد بتلتصق على الجدران بسبب قوة الطرد المركزي وما رح يصير mixing

إذا كانت السرعة منخفضة جداً : ما بصير توسع للطبقة (bed expansion) وال mixing ضعيف

Table 9 Effect of Powder Fill on Blending Time of Double-Cone Blenders^a

نسبة الملاء

Volume percent of blender filled with powder charge	Approximate blend time (minutes) in production-size blenders
50	10
65	14
70	18
75	24
80 ^b	40 ^b

وقت الخلط

← طابليسر و mixing منتظم لأن الحساب أكثر للترية قليلة جداً .

^aBlending done in double-cone blenders and times measured to obtain comparable blends.

^bUniform blend not attainable with this fill level.

Source: Sweitzer, G. R., Blending and Drying Efficiency Double Cone vs. V-Shape, GEMCO, Newark, New Jersey.

52

Powder mixing equipment

Tumbling mixers المعيزان يمكن نقلها بسهولة
تقلل انتقال المواد من وعاء لآخر

- **Intermediate bulk containers (IBCs)** are containers used both as mixing bowl and to either feed the hopper of a tablet or capsule machine or as the hopper itself. ②

- **The Turbula shaker mixer (WAB, Switzerland)** is a more sophisticated form of tumbling mixer that uses inversional motion in addition to the rotational motion leading to more efficient mixing. ③
مرعة انقلابية + دورانية

53

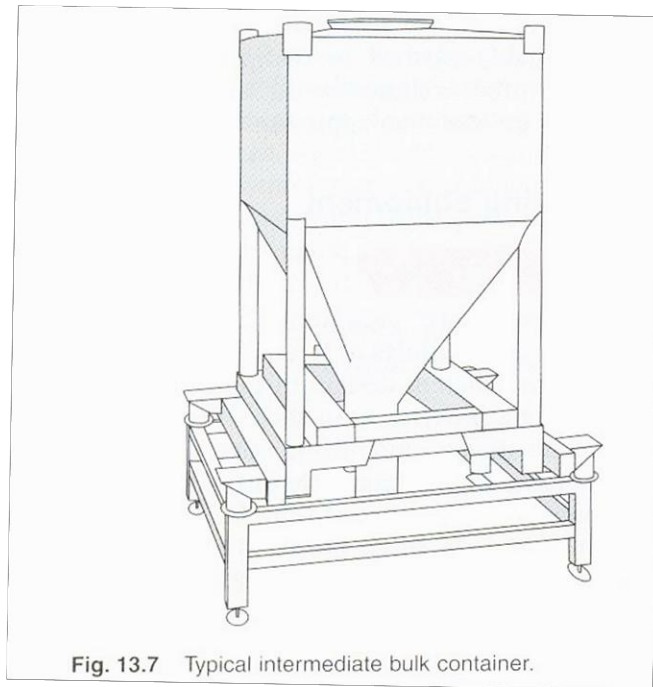


Fig. 13.7 Typical intermediate bulk container.

54

Powder mixing equipment

High speed mixer granulators

موجود في الوسط ودر سرعة عالية

- They are used both for **mixing and granulation**.

- It contains centrally mounted impeller blade that rotate at high speed throwing the material towards the mixing bowl.

① يمنع تكون التكتلات و يقلل حجم الجزيئات

- The side-mounted chopper blade helps in granulation.

- Care if material fractures easily. →

إذا كانت المادة هشة لا تكسر بسهولة

- **Not normally used for blending lubricants.**

غير مناسب للـ Lubricant لأن السرعة العالية قد تكسرها وتغير صفاتها. 55

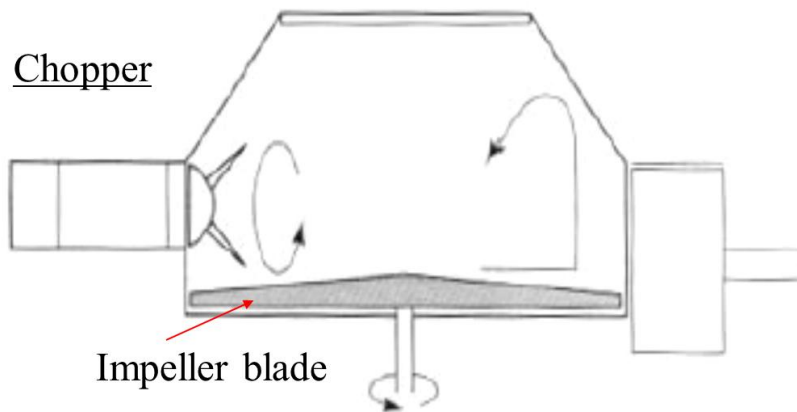


Fig. 13.9 Diagrammatic representation of a high-speed mixer-granulator.

Powder mixing equipment

Agitator mixers → فلاتات تعتمد على الشفرات

- These types of mixers depend on the motion of a blade or paddle though the product, and hence the main mixing mechanism is convection. → آلية الخلط

- There are three main designs of agitator mixers:

- Ribbon mixer
- Planetary (Orbital) mixer
- Nautamixer

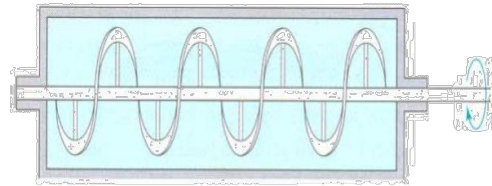


Fig. 12.10 Ribbon agitator powder mixer

57

Powder mixing equipment

Ribbon mixers

شفرات حلزونية

- Mixing is achieved by the rotation of helical blades in a cylindrical tank.

لأنه تترك داخل الاسطوانة، عند دفع المسحوق للخارج و الدافل بشكل مستمر

Advantages

- Suitable for mixing of poorly flowing materials.
- Segregation is less likely to occur than in tumbling mixer →

الانقصال اقل من tumbling mixers

Disadvantages

- Dead spots are difficult to eliminate.

The shearing action caused by movement of the blades may be insufficient to break up drug aggregates.

أما نحن لا نصلح الخلط جيداً

58

الاسم هيلز لان حركة الشفرة بتسبب حركة المزيج. Powder mixing equipment

planetary mixers

- The rotational path of paddle is similar to that of a planet.
- It is used:
 - for mixing powders and semisolids
 - Wet massing (granulation)

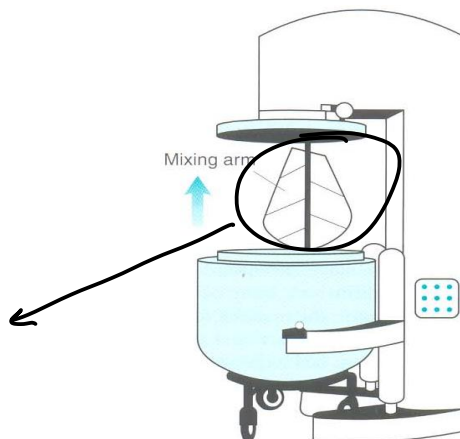


Fig. 12.11 Planetary mixer for powders and semi-solids.

59

rotating element
حول مركز الوعاء
و حول محورها

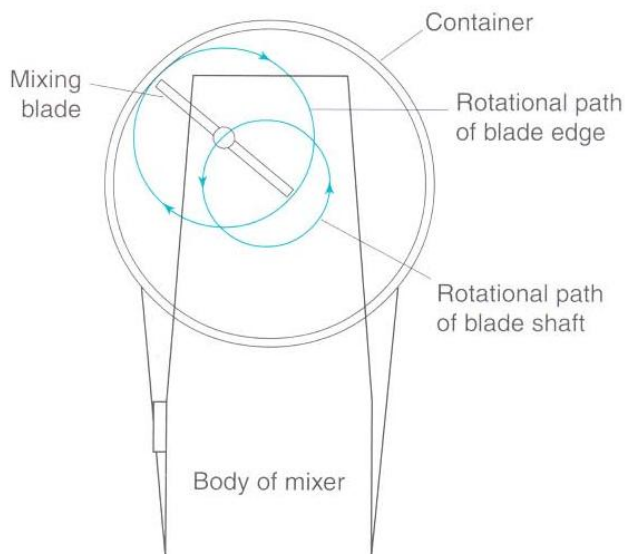


Fig. 12.12 Planetary mixer – top view, showing path of paddle.

60

Powder mixing equipment

Nautamixer

و عاء مخروطي

- It consists of a conical vessel that contains inside a helical conveyor **لولب حلزوني** that conveys the material up to near the top where it cascades back into the mass.
- This mixer combines **convective, shear and diffusion mixing**

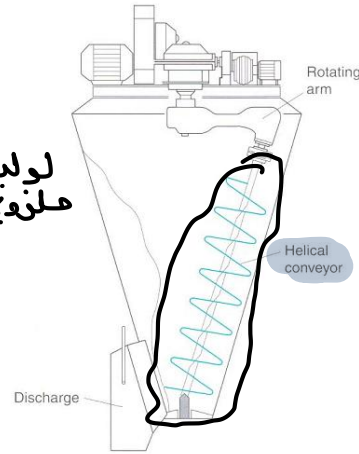


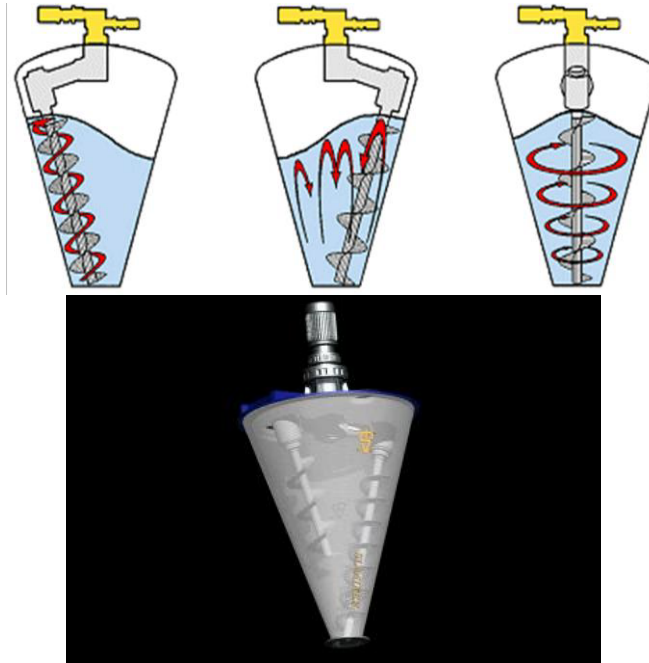
Fig. 12.13 Nautamixer (courtesy of Nautamixer Ltd).



ال **conveys** برفع المواد من اسفل المخروط الى اعلاه، ثم تسقط المواد ثانية بسبب الجاذبية فينتج **mixing (convective+shear+diffusion)**

61

Nautamixer



62

Powder mixing equipment

Fluidized bed mixers

- The fluidized bed equipment is used mainly in:

① - Drying

② Granulation

③ Coating

④

- However it can be used for mixing of powders before granulation.

- Blown air fluidized and mixes the powder. → هواء مضغوط يدفع إلى الأسفل ويرفع الجسيمات ويخليها مخلقة في الهواء (fluidized state)
- Fluidization is very efficient mixing process.
- Diffusion of particles occur. → لان الخلط يكون عشوائيا أكثر

63

Fluidized bed mixers



64

Powder mixing equipment

Continuous mixers

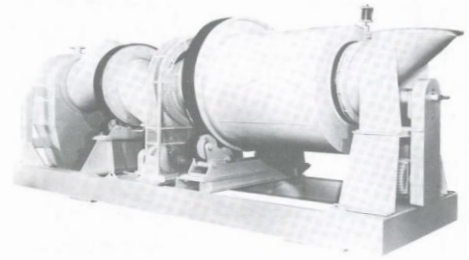
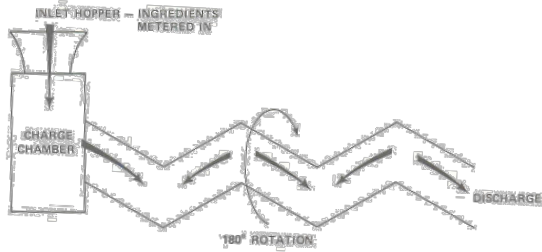


Figure 82 The "Zig Zag" continuous blender. (Courtesy of Patterson-Kelley Company, Division of HARSICO Corporation, East Stroudsburg, Pennsylvania.)

Continues: جهاز خلط مستمر يعني المواد بتدخل من طرف وتتحرك خلال الجهاز وتخرج من الطرف الثاني بعد ما تنخلط.

(Good mixing)

نوع مشهور ← بعد turbulence

Figure 81 Schematic of "Zig Zag" continuous blender. (Courtesy of Patterson-Kelley Company, Division of HARSICO Corporation, East Stroudsburg, Pennsylvania.)

65

Scale-up of powder mixing

- The extent of mixing achieved at a small laboratory scale during development work may not necessarily be mirrored when the same formulation is mixed at a full production scale, even if the same mixer design is used for both.
لما نخلط في المختبر (small scale) وبدنا نكبر الخلطة بالمصنع مش شرط ناخذ نفس نتيجة mixer
- Often, mixing efficiency and the extent of mixing is improved on scale-up owing to increased shear forces.
تتحسن كفاءة الخلط والمدى عند توسيع النطاق بسبب زيادة shearing force
- This is likely to be beneficial in most cases, although when blending lubricants care is needed to avoid overlubrication.

بس بدنا ننتبه في حالة وجود lubricants مثل (mg stearate) لانه الزيادة ممكن تسبب over-lubrication ويعمل ضعف لل hardness و dissolution و compressibility

Scale-up of powder mixing

- The optimum mixing time and conditions should therefore be established and validated at a production scale, so that the appropriate degree of mixing is obtained without segregation, overlubrication or damage to component particles.
- Minimum and maximum mixing times that give a satisfactory product should be determined if appropriate, so that the 'robustness' of the mixing process is established.

لازم نعرفهم في المصنع عشان ما يصير

segregation او over lubrication و ممكن بهر

damage to particles من shear الزايش.

67

Types of mixers used for liquids and suspensions

Propeller (Impeller) mixers

المزعة باتجاه الخارج من المحور الجانبي

- Three basic types of flow may be produced: radial, axial and tangential. → الدوران حول المحور (radial) أو الدوران الجانبي (axial) أو الدوران التانجنتي (tangential)
- Angled blades cause fluid to circulate in both an axial and a radial direction. → more efficient
- The ratio of the diameter of propeller to that of the vessel is 1:10 - 1:20 and it typically rotates at speeds of 1 - 20 rps.

نسبة قطر (propeller) لقطر (vessel)

↓
سرعة الدوران

68

mechanical stirrer
↑

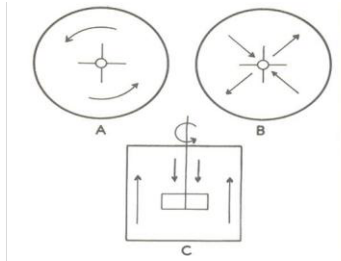
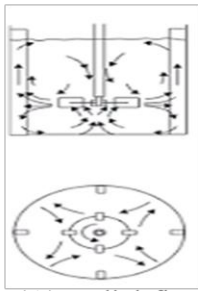
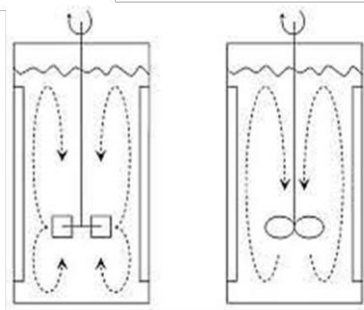


FIG. 1-2. A and B, Diagrammatic representation of cylindric tanks in which tangential and radial flow occur, respectively. C, Side view of a similar tank in which axial flow occurs. These diagrams represent systems in which only one type of flow occurs, in contrast to the usual situation in which two or more of these flow patterns occur simultaneously.



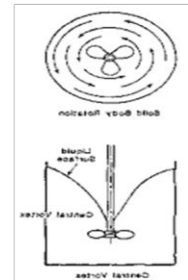
(A) Radial flow

المرعة باتجاه الخارج



(B) axial

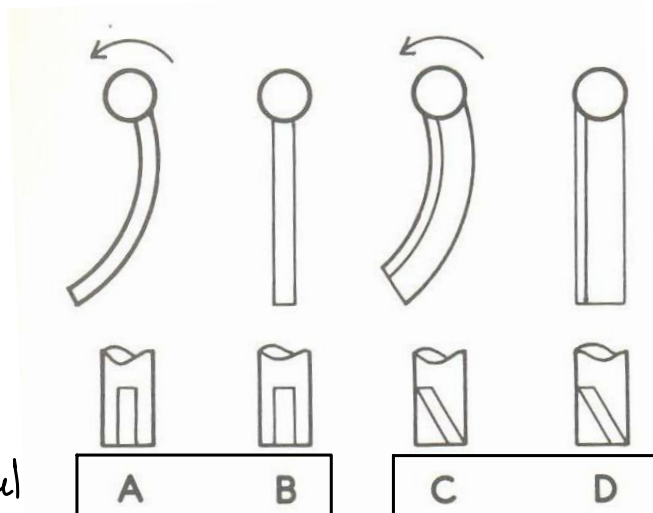
المرعة للأسفل أو
أعلى للأسفل



(C) tangential flow

دوراني

69



Radial

A

B

C

D

radial & axial

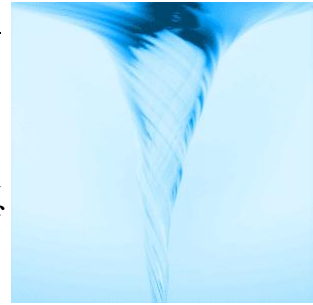
FIG. 1-3. Impeller blade types (only one blade shown), top and side views. A and B, Radial flow design: C and D, mixed radial-axial flow design. For axial pumping, the blade must be set at an incline to the axis of the shaft.

70

Types of mixers used for liquids and suspensions

for low viscosity ← **Propeller (Impeller) mixers**

- A vortex forms when the centrifugal force imparted to the liquid by the propeller blades causes it to back up around the sides of vessel and create a depression at the shaft.



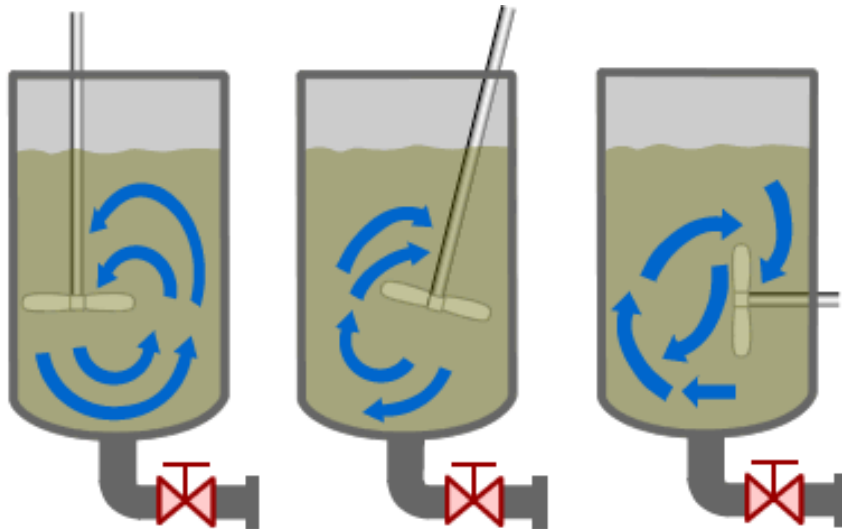
- An ^①off-center mounting of propeller and ^②vertical baffles discourage the formation of vortex.
 كيف نقلل vortex ①+② دوامة

- Propellers are more efficient when they run at high speed in liquids with low viscosity.

↓
solution + suspension

71

mechanical stirrers



72

* الرسم يوضح لنا لماذا نضيف Vertical baffle
كيف يتقلد وعود Vortex.

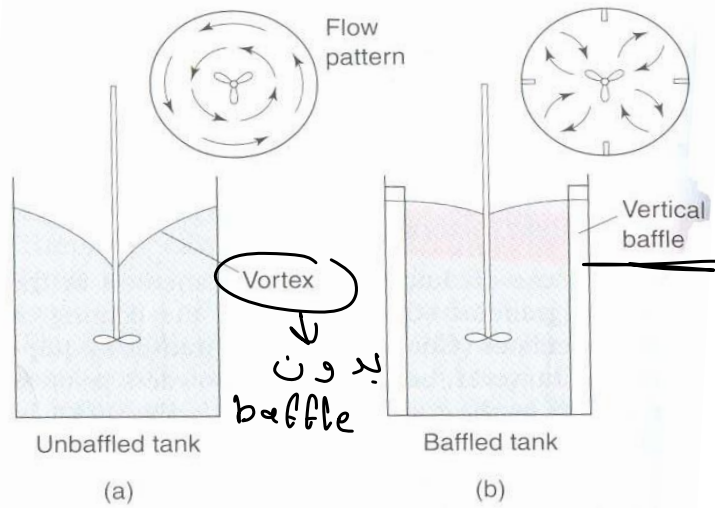


Fig. 13.13 Propeller mixer with (a) un baffled tank and (b) baffled tank.

73

Types of mixers used for liquids and suspensions

Paddle mixers → for more viscosity than propeller

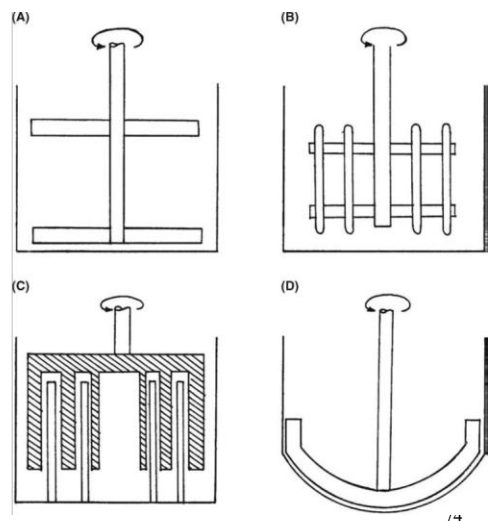
- The mixing element is large in relation to the vessel and rotates at low speeds (10–100 rpm).

سرعة أقل من

propeller

هناك كانت (1-20 rpm)

Paddle mixers



Types of mixers used for liquids and suspensions

Turbine mixers → اقوى من propeller و paddle

- Turbine mixers may be used for more viscous liquids than those mixed by propeller.

4 blades

- The impeller has four flat blades surrounded by perforated inner and outer diffuser ring.

يسحب السائل

- The rotating impeller draws the liquid into the mixer head and forces the liquids through the perforations →

تسحب السائل للداخل وتدفعه للخارج
عبر ring

- They can produce stable emulsions.

75

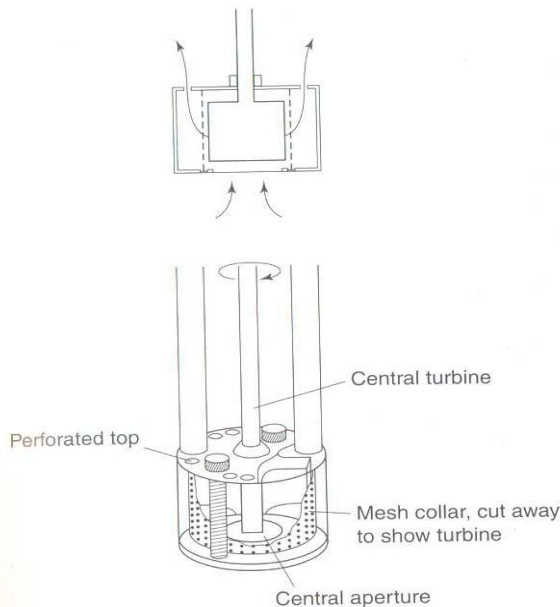
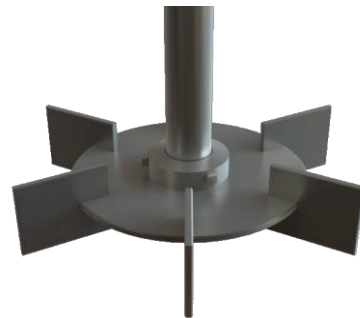


Fig. 13.14 Turbine mixer.



76

هي نوع من الخلاطات التي لا تستخدم مراوح أو شفرات دوارة ميكانيكية، بل تعتمد على قوة دفع تيار من الهواء أو الغاز لخلط السوائل. تعمل على مبدأ نقل الطاقة والحركة من الغاز إلى السائل.

Types of mixers used for liquids and suspensions

Air jet mixers

- These mixers utilize jets of air or some other gases.
- The liquid must be of low viscosity, **non-foaming**, **unreactive** with the gas employed and reasonably nonvolatile.

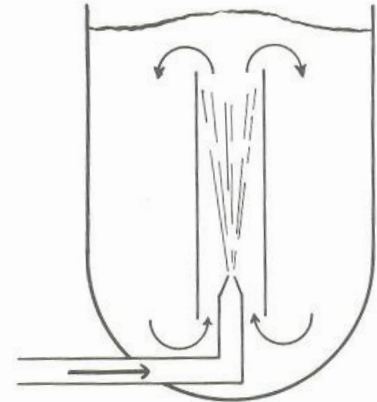


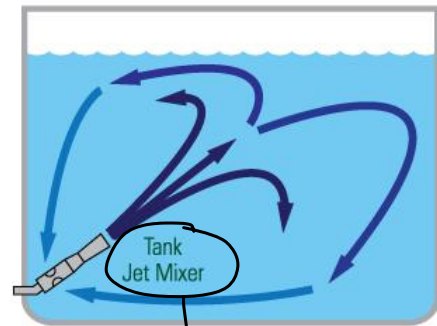
FIG. 1-4. Vertical tank with centrally located air jet and draft tube. Bubbles confined within the draft tube rise, inducing an upward fluid flow in the tube. This flow tends to circulate fluid in the tank, bringing it into the turbulent region in the vicinity of the jet.

77

Types of mixers used for liquids and suspensions

تتعتمد هذه الخلاطات على طاقة تيار سائل عالي السرعة.

- When liquids are to be pumped into a tank for mixing, the power required for pumping is often used to accomplish the mixing.
- The fluids are pumped through a nozzle arranged to permit good circulation of the material through the tank. فوهة: يتم ضخ السائل من خلالها
- It is also possible to pump the liquid from the tank through the jet into the tank. (فزان) من tank فسخ السائل من tank و يرجع إلى tank



الخزان

78

Types of mixers used for liquids and suspensions

Inline mixers (Continuous mixing)

- In this case, mobile, miscible components are fed through an inline mixer designed to create turbulence in a flowing fluid stream.
- It can be accomplished essentially in two ways: ^① in a tube (pipe) through which the fluids flow, or ^② in a chamber in which a considerable amount of hold up and recirculation occur.
- Controlling the feeding rate of raw materials is necessary to ensure uniform mixtures.

79

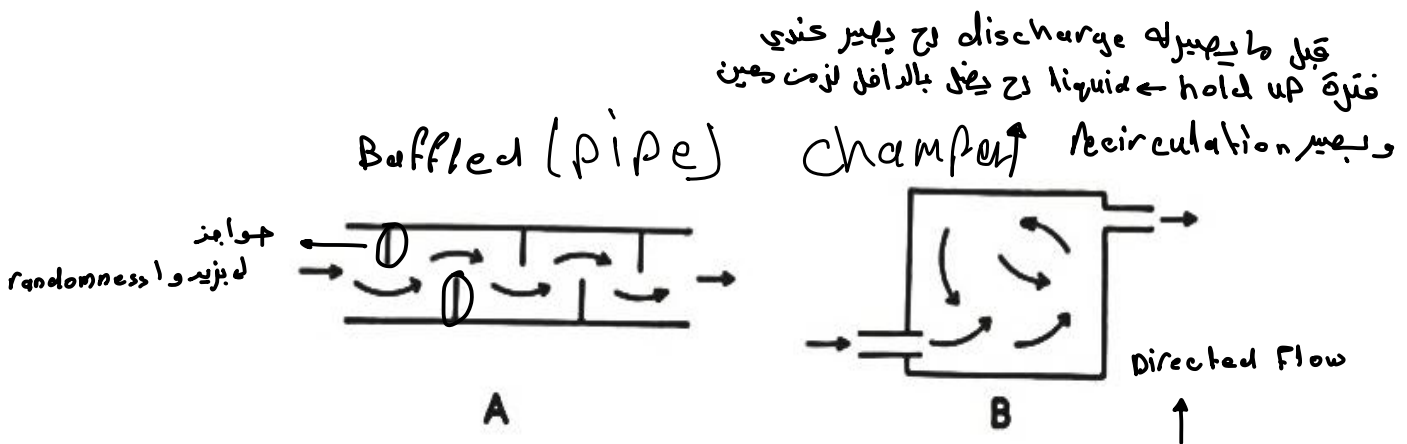


FIG. 1-5. Continuous fluids mixing devices. A, Baffled pipe mixer; B, mixing chamber with flow induced recirculation.

continuous mixing : continuous feeding & continuous discharging

Types of mixers used for liquids and suspensions

mixing vessels

• On an industrial scale, solutions are prepared in large mixing vessels with ports for mechanical stirrers.

• When heat is desired, thermostatically controlled mixing tanks may be used.



FIGURE 13.1 Large-scale pharmaceutical mixing vessels. (Courtesy of Schering Laboratories.)

heat-jacketing بنعل
عشان نناظ على الحرارة

81

(creams, ointment, gels)

neutral mixture

Mixing of semisolids

- Semisolids, unlike liquids and powders, do not flow easily. → بدنا mixing force عشان
بهر عا good mixing
- The suitable mixers must have rotating elements with narrow clearances between them selves and the mixing vessel to avoid dead spots

قلنا لما بدنا نخط كريم مش لازم نحس بوجوده علي ايدينا فبنحتاج نعمل
shearing (كنا نستعمل mortar and pestle) مبدأه يكون عندي 2
surfaces المسافة او clearance بيناتهم قليلة جدا.

82

Types of mixers for semisolids

1) Planetary mixers

2) Sigma blade mixer

3) Vessels (tanks) with counter-rotating mixing bars

الذي نالنا فوق

primary or pre mixing

• It is very difficult using primary mixers to completely disperse powder particles in a semisolid base so that they are invisible to the eye.

compression + shearing

• The mix is usually subjected to the further action of a roller mill or colloid mill, so as to 'rub out' these particles by the intense shear generated by rollers or cones set with a very small clearance between them.

لو استعملنا اي mixer في البداية عشان اعمل التحريك بغض النظر عن النوع ما رح يكون كافي عشان يعمل good dispersion، فبححتاج بعد هاي العملية another further mixing يا اما roller او colloid mill.

second mixing

Counter rotating

بتركونا بعكس
اتجاه بعض ويكون
الحافة بينهم ضيقة
(clearance is low)

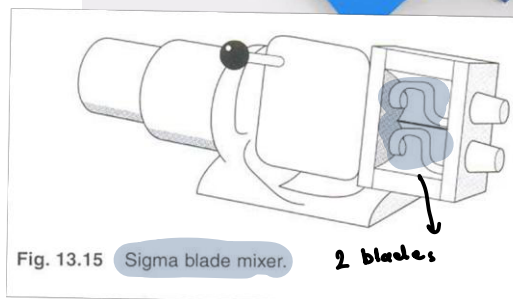
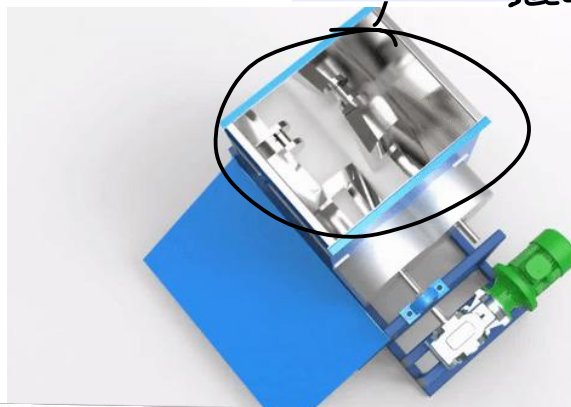
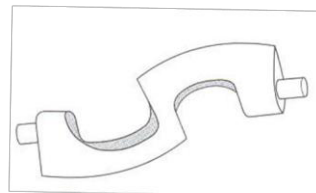


Fig. 13.15 Sigma blade mixer.

2 blades



counter rotating

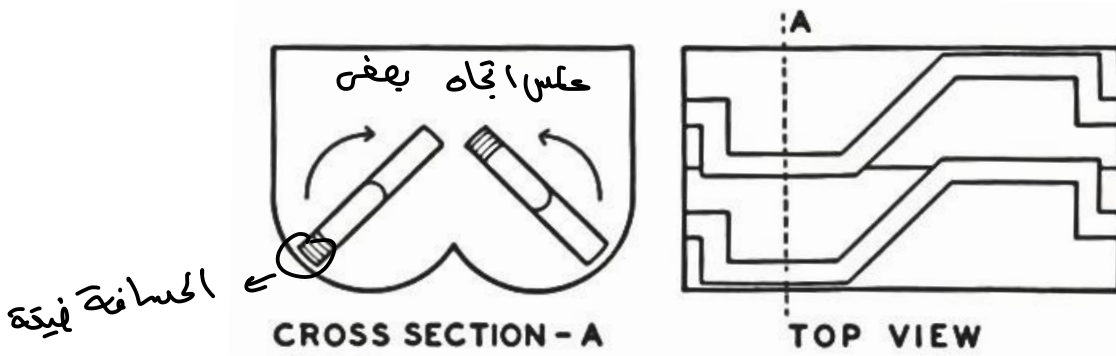


FIG. 1-8. Schematic drawing of a top-loading sigma-blade mixer with overlapping blades. The top view shows the relationship of the counter rotating blades to the overall geometry of the mixer.

85

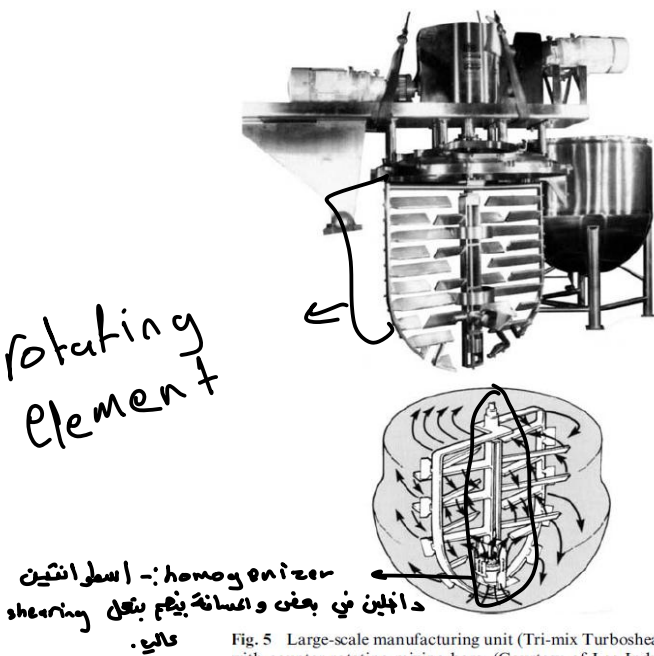


Fig. 5 Large-scale manufacturing unit (Tri-mix Turboshear) with counter-rotating mixing bars. (Courtesy of Lee Industries, Inc., Philipsburg, Pennsylvania.)



Stainless steel tank, which has counter sweep agitation and a built-in homogenizer.

86 حلة agitation احدى من strike