



CODEN [USA]: IAJPBB

ISSN : 2349-7750

**INDO AMERICAN JOURNAL OF
PHARMACEUTICAL SCIENCES**

SJIF Impact Factor: 7.187

Available online at: <http://www.iajps.com>

Review Article

**REVIEW ON EQUIPMENT USED OF QUALITY CONTROL IN
PHARMACEUTICAL INDUSTRIES****Dr. Sunil S. Jaybhaye, Nandakishor Uddhav Gore.**¹Department of Pharmaceutical Analysis, Faculty of Pharmaceutical Analysis, Dr. Babasaheb Ambedkar Technological University, Lonere, Raigad.²Student of Bachelor in pharmacy, Faculty of Pharmacy, Dr. Babasaheb Ambedkar Technological University, Lonere, Raigad³Student of Bachelor in pharmacy, Faculty of Pharmacy, Dr. Babasaheb Ambedkar Technological University, Lonere, Raigad**Abstract:**

Objectives : *the main aim of this study is to a Highlight the most important guidelines and practice of Quality control in the pharmaceutical industry . The development of a drug product is a lengthy process involving drug discovery, laboratory testing, animal studies, clinical trials and regulatory registration. To further enhance the effectiveness and safety of the drug product after approval, many regulatory agencies such as the United States Food and Drug Administration (FDA) also require that the drug product be tested for its identity, strength, quality, purity and stability before it can be released for use. For this reason, pharmaceutical validation and process controls are important in spite of the problems that may be countered. Process controls include raw materials inspection, in-process controls and target so for final product. The function of of in-process controls is monitoring and if necessary adaption of the manufacturing process in order to comply with the specifications .this may include control of equipment and environment too. Inprocess materials should be tested for identity, strength, quality and purity as appropriate and approved or rejected by the quality control unit during the production process. Rejected in-process materials should be identified and controlled under a quarantine system designed to prevent their use in manufacturing Pharmaceutical Sciences.*

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QR code



Please cite this article in press Nandakishor Uddhav Gore et al., *Review On Equipment Used Of Quality Control In Pharmaceutical Industries., Indo Am. J. P. Sci, 2024; 11 (6).*

INTRODUCTION:

The development of a drug product is a lengthy process involving drug discovery, laboratory testing, animal studies, clinical trials and regulatory registration. To further enhance the effectiveness and safety of the drug product after approval, many regulatory agencies such as the United States Food and Drug Administration (FDA) also require that the drug product be tested for its identity, strength, quality, purity and stability before it can be released for use. For this reason, pharmaceutical validation and process controls are important in spite of the problems that may be countered. Process controls include raw materials inspection, in-process controls and target so for final product. The purpose is to monitor the on-line and off-line performance of them manufacturing process and then validate it. Even after the manufacturing process is validated, current good manufacturing practice also requires that a well-written procedure for process controls is established to monitor its performance. The QA/QC good practice guidance outlined here reflects practicality, acceptability, cost-effectiveness, existing experience, and the potential for application on a world wide basis. A QA/QC programme contributes to the objectives of good practice guidance, namely to improve transparency, consistency, comparability, completeness, and confidence in national inventories of emissions estimates. The outcomes of the QA/QC process may result in a reassessment of inventory or source category uncertainty estimates. For example, if data quality is found to be lower than previously thought and this situation cannot be rectified in the timeframe of the current inventory, the uncertainty estimates ought to be re-evaluated.

PRACTICAL CONSIDERATION IN DEVELOPING QA/QC SYSTEMS

Implementing QA/QC procedures requires resources, expertise and time. In developing any QA/QC system, it is expected that judgements will need to be made on the following: Resources allocated to QC for different source categories and the compilation process; Time allocated to conduct the checks and reviews of emissions estimates; Availability and access to information on activity data and emission factors, including data quality; Procedures to ensure confidentiality of inventory and source category information, when required; Requirements for archiving information; Frequency of QA/QC checks on different parts of the inventory; The level of QC appropriate for each source category; Whether increased effort on QC will result in improved emissions estimates and reduced uncertainties; Whether sufficient expertise is available to conduct the checks and reviews. In practice, the QA/QC

system is only part of the inventory development process and inventory agencies do not have unlimited resources.

Quality control requirements, improved accuracy and reduced uncertainty need to be balanced against requirements for timeliness and cost effectiveness. A good practice system seeks to achieve that balance and to enable continuous improvement of inventory estimates. Within the QA/QC system, good practice provides for greater effort for key source categories and for those source categories where data and methodological changes have recently occurred, than for other source categories³ It is unlikely that inventory agencies will have sufficient resources to conduct all the QA/QC procedures outlined in this review on all source categories. In addition, it is not necessary to conduct all of these procedures every year. For example, data collection processes conducted by national statistical agencies are not likely to change significantly from one year to the next.⁴ Once the inventory agency has identified what quality controls are in place, assessed the uncertainty of that data, and documented the details for future inventory reference, it is unnecessary to revisit this aspect of the QC procedure every year. However, it is good practice to check the validity of this information periodically as changes in sample size, methods of collection, or frequency of data collection may occur. The optimal frequency of such checks will depend on national circumstances. While focusing QA/QC activities on key source categories will lead to the most significant improvements in the overall inventory estimates, it is good practice to plan to conduct at least the general procedures. General QC Procedures on all parts of the inventory over a period of time. Some source categories may require more frequent QA/QC than others because of their significance to the total inventory estimates, contribution to trends in emissions over time or changes in data or characteristics of the source category, including the level of uncertainty.^{5,6} For example, if technological advancements occur in an industrial source category, it is good practice to conduct a thorough QC check of the data sources and the compilation process to ensure that the inventory methods remain appropriate⁵⁻⁷. It is recognised that resource requirements will be higher in the initial stages of implementing any QA/QC system than in later years. As capacity to conduct QA/QC procedures develops in the inventory agency and in other associated organisations, improvements in efficiency should be expected. A review of the final inventory report by a person not involved in the compilation is also good practice, even if the inventory were compiled using only Tier 1 methods. More extensive

QC and more rigorous review processes are encouraged if higher tier methods have been used. Availability of appropriate expertise may limit the degree of independence of expert reviews in some cases. The QC process is intended to ensure transparency and quality.

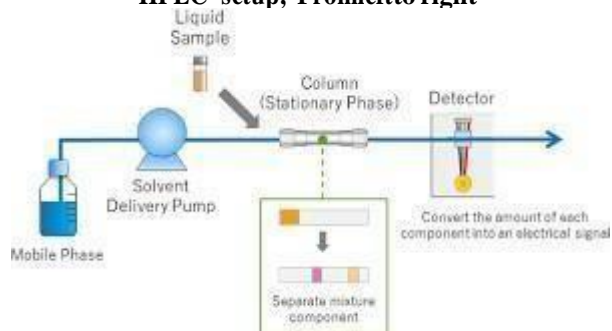
EQUIPMENT USED IN THE QUALITY CONTROL (QC) IN PHARMACEUTICAL INDUSTRIES:

QUALITY CONTROL EQUIPMENTS:

(A) High-performance liquid chromatography

Introduction: High-performance liquid chromatography (HPLC), formerly referred to as high-pressure liquid chromatography, is a technique in analytical chemistry used to separate, identify, and quantify each component in a mixture. It relies on pumps to pass a pressurized liquid solvent containing the sample mixture through a column filled with a solid adsorbent material. Each component in the sample interacts slightly differently with the adsorbent material, causing different flow rates for the different components and leading to the separation of the components as they flow of the column.

- **Diagram of High-performance liquid chromatography An HPLC setup; From left to right**



- **Acronym:** HPLC
- **Classification:** Chromatography

- **Analytes:** organic molecules, biomolecules, ions, polymers .
- **Other techniques:** Related Chromatography, Aqueous normal-phase chromatography, Hydrophilic Interaction Chromatography, Ion exchange chromatography, Size exclusion chromatography, Micellar liquid chromatography .

Hyphenated: Liquid chromatography-mass spectrometry .

HPLC has been used for manufacturing (e.g., during the production process of pharmaceutical and biological products), legal (e.g., detecting performance enhancement drugs in urine), research (e.g., separating the components of a complex biological sample, or of similar synthetic chemicals from each other), and medical (e.g., detecting vitamin D levels in blood serum) purposes.

Chromatography can be described as a mass transfer process involving adsorption. HPLC relies on pumps to pass a pressurized liquid and a sample mixture through a column filled A modern self-contained HPLC. Schematic representation of an HPLC unit.(1) Solvent reservoirs,

(2) Solvent degasser, (3) Gradient valve, (4) Mixing vessel for delivery of the mobile phase, (5) High-pressure pump, (6) Switching valve in "inject position", (6) Switching valve in "load position", (7) Sample injection loop, (8) Pre-column (guard column), (9) Analytical column, (10) Detector (i.e., IR, UV), (11) Data acquisition, (12) Waste or fraction collector. with adsorbent, leading to the separation of the sample components. **THE ACTIVE COMPONENT OF THE COLUMN, THE ADSORBENT, IS TYPICALLY A GRANULAR MATERIAL MADE OF SOLID PARTICLES (E.G., SILICA, POLYMERS, ETC.), 2–50 MM IN SIZE. THE COMPONENTS OF THE SAMPLE MIXTURE ARE SEPARATED FROM EACH OTHER DUE TO THEIR DIFFERENT DEGREES OF INTERACTION WITH THE ADSORBENT PARTICLES. THE PRESSURIZED LIQUID IS TYPICALLY A MIXTURE OF SOLVENTS (E.G., WATER, ACETONITRILE AND/OR METHANOL) AND IS REFERRED TO AS A "MOBILE PHASE". ITS COMPOSITION AND TEMPERATURE PLAY A MAJOR ROLE IN THE SEPARATION PROCESS BY INFLUENCING THE INTERACTIONS TAKING PLACE BETWEEN SAMPLE COMPONENTS AND ADSORBENT. These interactions are physical in nature, such as hydrophobic (dispersive), dipole–dipole and ionic, most often a combination. HPLC is distinguished from traditional ("low pressure") liquid**

chromatography because operational pressures are significantly higher (50–350 bar), while ordinary liquid chromatography typically relies on the force of gravity to pass the mobile phase through the column. Due to the small sample amount separated in analytical HPLC, typical column dimensions are 2.1–4.6 mm diameter, and 30–250 mm length. Also HPLC columns are made with smaller adsorbent particles (2–50 µm in average particle size). This gives HPLC superior resolving power (the ability to distinguish between compounds) when separating mixtures, which makes it a popular chromatographic technique. The schematic of an HPLC instrument typically includes a degasser, sampler, pumps, and a detector. The sampler brings the sample mixture into the mobile phase stream which carries it into the column. The pumps deliver the desired flow and composition of the mobile phase through the column. The detector generates a signal proportional to the amount of sample component emerging from the column, hence allowing for quantitative analysis of the sample components. A digital microprocessor and user software control the HPLC instrument and provide data analysis. Some models of mechanical pumps in an HPLC instrument can mix multiple solvents together in ratios changing in time, generating a composition gradient in the mobile phase. Various detectors are in common use, such as UV/Vis, photodiode array (PDA) or based on mass spectrometry. Most HPLC instruments also have a column oven that allows for adjusting the temperature at which the separation is performed.

Working

The sample mixture to be separated and analyzed is introduced, in a discrete small volume (typically microliters), into the stream of mobile phase percolating through the column. The components of the sample move through the column at different velocities, which are a function of specific physical interactions with the adsorbent (also called stationary phase). *The velocity of each component depends on its chemical nature, on the nature of the stationary phase (column) and on the composition of the mobile phase. The time at which a specific analyte elutes (emerges from the column) is called its retention time. The retention time measured under particular conditions is an identifying characteristic of a given analyte. Many different types of columns are available, filled with adsorbents varying in particle size, porosity, and surface chemistry. The use of smaller particle size packing materials requires the use of higher operational pressure ("backpressure") and typically improves chromatographic resolution (the degree of peak separation between consecutive analytes emerging*

from the column). Sorbent particles may be hydrophobic or polar in nature. Common mobile phases used include any miscible combination of water with various organic solvents (the most common are acetonitrile and methanol). Some HPLC techniques use water-free mobile phases (see normal-phase chromatography below). The aqueous component of the mobile phase may contain acids (such as formic, phosphoric or trifluoroacetic acid) or salts to assist in the separation of the sample components. The composition of the mobile phase may be kept constant ("isocratic elution mode") or varied ("gradient elution mode") during the chromatographic analysis. Isocratic elution is typically effective in the separation of sample components that are very different in their affinity for the stationary phase. In gradient elution the composition of the mobile phase is varied typically from low to high eluting strength. The eluting strength of the mobile phase is reflected by analyte retention times with high eluting strength producing fast elution (=short retention times). A typical gradient profile in reversed phase chromatography might start at 5% acetonitrile (in water or aqueous buffer) and progress linearly to 95% acetonitrile over 5–25 minutes. Periods of constant mobile phase composition may be part of any gradient profile. For example, the mobile phase composition may be kept constant at 5% acetonitrile for 1–3 min, followed by a linear change up to 95% acetonitrile. The chosen composition of the mobile phase depends on the intensity of interactions between various sample components ("analytes") and stationary phase (e.g., hydrophobic interactions in reversed-phase HPLC).

Depending on their affinity for the stationary and mobile phases, analytes partition between the two during the separation process taking place in the column. This partitioning process is similar to that which occurs during a liquid–liquid extraction but is continuous, not step-wise. In this example, using a water/acetonitrile gradient, more hydrophobic components will elute (come off the column) late, once the mobile phase gets more concentrated in acetonitrile (i.e., in a mobile phase of higher eluting strength). The choice of mobile phase components, additives (such as salts or acids) and gradient conditions depends on the nature of the column and sample components. Often a series of trial runs is performed with the sample in order to find the HPLC method which gives adequate separation.

Histroy and Development

Prior to HPLC scientists used standard liquid chromatographic techniques. Liquid chromatographic systems were largely inefficient due to the flow rate of solvents being dependent on gravity. Separations

took many hours, and sometimes days to complete. Gas chromatography (GC) at the time was more powerful than liquid chromatography (LC), however, it was believed that gas phase separation and analysis of very polar high molecular weight biopolymers was impossible. [3] GC was ineffective for many biochemists because of the thermal instability of the solutes. [4] As a result, alternative methods were hypothesized which would soon result in the development of HPLC. Following on the seminal work of Martin and Synge in 1941, it was predicted by Cal Giddings, Josef Huber, and others in the 1960s that LC could be operated in the high efficiency mode by reducing the packing-particle diameter substantially below the typical LC (and GC) level of 150 μm and using pressure to increase the mobile phase velocity. [3] These predictions underwent extensive experimentation and refinement throughout the 60s. A rotary fraction collector collecting HPLC output. The system is being used to isolate a fraction containing Complex I from *E. coli* plasma membranes. About 50 litres of bacteria were needed to isolate this amount. [2] History and development into the 70s. Early developmental research began to improve LC particles, and the invention of Zipax, a superficially porous particle, was promising for HPLC technology. [5] The 1970s brought about many developments in hardware and instrumentation. Researchers began using pumps and injectors to make a rudimentary design of an HPLC system. [6] Gas amplifier pumps were ideal because they operated at constant pressure and did not require leak-free seals or check valves for steady flow and good quantitation. [4] Hardware milestones were made at Dupont IPD (Industrial Polymers Division) such as a low-dwell-volume gradient device being utilized as well as replacing the septum injector with a loop injection valve. [4] While instrumental developments were important, the history of HPLC is primarily about the history and evolution of particle technology. [4] After the introduction of porous layer particles, there has been a steady trend to reduced particle size to improve efficiency. [4] However, by decreasing particle size, new problems arose. The practical disadvantages stem from the excessive pressure drop needed to force mobile fluid through the column and the difficulty of preparing a uniform packing of extremely fine materials. [7] Every time particle size is reduced significantly, another round of instrument development usually must occur to handle the pressure.

TYPES OF CHROMATOGRAPHY

(Partition chromatography : Partition chromatography was one of the first kinds of chromatography that chemists developed. [8] The

partition coefficient principle has been applied in paper chromatography, thin layer chromatography, gas phase and liquid-liquid separation applications. The 1952 Nobel Prize in chemistry was earned by Archer John Porter Martin and Richard Laurence Millington Synge for their development of the technique, which was used for their separation of amino acids. [9] Partition chromatography uses a retained solvent, on the surface or within the grains or fibers of an "inert" solid supporting matrix as with paper chromatography; or takes advantage of some coulombic and/or hydrogen donor interaction with the stationary phase. Analyte molecules partition between a liquid stationary phase and the eluent. Just as in Hydrophilic Interaction Chromatography (HILIC; a subtechnique within HPLC), this method separates analytes based on differences in their polarity. HILIC most often uses a bonded polar stationary phase and a mobile phase made primarily of acetonitrile with water as the strong component. Partition HPLC has been used historically on unbonded silica or alumina supports. Each works effectively for separating analytes by relative polar differences. HILIC bonded phases have the advantage of separating acidic, basic and neutral solutes in a single chromatographic run. [10] The polar analytes diffuse into a stationary water layer associated with the polar stationary phase and are thus retained. The stronger the interactions between the polar analyte and the polar stationary phase (relative to the mobile phase) the longer the elution time. The interaction strength depends on the functional groups part of the analyte molecular structure, with more polarized groups (e.g., hydroxyl-) and groups capable of hydrogen bonding inducing more retention. Coulombic (electrostatic) interactions can also increase retention. Use of more polar solvents in the mobile phase will decrease the retention time of the analytes, whereas more hydrophobic solvents tend to increase retention times.

(A) Normal-phase chromatography: Normal-phase chromatography was one of the first kinds of HPLC that chemists developed. Also known as normal-phase HPLC (NP-HPLC) this method separates analytes based on their affinity for a polar stationary surface such as silica, hence it is based on analyte ability to engage in polar interactions (such as hydrogen-bonding or dipole-dipole type of interactions) with the sorbent surface. NP-HPLC uses a non-polar, non-aqueous mobile phase (e.g., Chloroform), and works effectively for separating analytes readily soluble in non-polar solvents. The analyte associates with and is retained by the polar ... stationary phase. Adsorption strengths increase with increased analyte polarity. The interaction strength depends not only on the functional groups present in

the structure of the analyte molecule, but also on steric factors. The effect of steric hindrance on interaction strength allows this method to resolve (separate) structural isomers. The use of more polar solvents in the mobile phase will decrease the retention time of analytes, whereas more hydrophobic solvents tend to induce slower elution (increased retention times). Very polar solvents such as traces of water in the mobile phase tend to adsorb to the solid surface of the stationary phase forming a stationary bound (water) layer which is considered to play an active role in retention. This behavior is somewhat peculiar to normal phase chromatography because it is governed almost exclusively by an adsorptive mechanism (i.e., analytes interact with a solid surface rather than with the solvated layer of a ligand attached to the sorbent surface; see also reversed-phase HPLC below). Adsorption chromatography is still widely used for structural isomer separations in both column and thin-layer chromatography formats on activated (dried) silica or alumina supports. Partition- and NP-HPLC fell out of favor in the 1970s with the development of reversed-phase HPLC because of poor reproducibility of retention times due to the presence of a water or protic organic solvent layer on the surface of the silica or alumina chromatographic media. This layer changes with any changes in the composition of the mobile phase (e.g., moisture level) causing drifting retention times. Recently, partition chromatography has become popular again with the development of HILIC bonded phases which demonstrate improved reproducibility, and due to a better understanding of the range of usefulness of the technique.

(B) Displacement chromatography: The basic principle of displacement chromatography is: A molecule with a high affinity for the chromatography matrix (the displacer) will compete effectively for binding sites, and thus displace all molecules with lesser affinities. [11] There are distinct differences between displacement and elution chromatography. In elution mode, substances typically emerge from a column in narrow, Gaussian peaks. Wide separation of peaks, preferably to baseline, is desired in order to achieve maximum purification. The speed at which any component of a mixture travels down the column in elution mode depends on many factors. But for two substances to travel at different speeds, and thereby be resolved, there must be substantial differences in some interaction between the biomolecules and the ... chromatography matrix. Operating parameters are adjusted to maximize the effect of this difference. In many cases, baseline separation of the peaks can be achieved only with gradient elution and low column loadings. Thus, two drawbacks to elution mode chromatography, especially at the preparative scale,

are operational complexity, due to gradient solvent pumping, and low throughput, due to low column loadings. Displacement chromatography has advantages over elution chromatography in that components are resolved into consecutive zones of pure substances rather than "peaks". Because the process takes advantage of the nonlinearity of the isotherms, a larger column feed can be separated on a given column with the purified components recovered at significantly higher concentration.

(C) Reversed-phase chromatography (RPC): Reversed phase HPLC (RP-HPLC) has a non-polar stationary phase and an aqueous, moderately polar mobile phase. One common stationary phase is a silica which has been surface-modified with RMe_2SiCl , where R is a straight chain alkyl group such as $\text{C}_{18}\text{H}_{37}$ or C_8H_{17} . With such stationary phases, retention time is longer for molecules which are less polar, while polar molecules elute more readily (early in the analysis). An investigator can increase retention times by adding more water to the mobile phase; thereby making the affinity of the hydrophobic analyte for the hydrophobic stationary phase stronger relative to the now more hydrophilic mobile phase. Similarly, an investigator can decrease retention time by adding more organic solvent to the eluent. RP-HPLC is so commonly used that it is ... A chromatogram of complex mixture (perfume water) obtained by reversed phase HPLC often incorrectly referred to as "HPLC" without further specification. The pharmaceutical industry regularly employs RP-HPLC to qualify drugs before their release. RP-HPLC operates on the principle of hydrophobic interactions, which originates from the high symmetry in the dipolar water structure and plays the most important role in all processes in life science. RP-HPLC allows the measurement of these interactive forces. The binding of the analyte to the stationary phase is proportional to the contact surface area around the non-polar segment of the analyte molecule upon association with the ligand on the stationary phase. This solvophobic effect is dominated by the force of water for "cavity-reduction" around the analyte and the C18-chain versus the complex of both. **The energy released in this process is proportional to the surface tension of the eluent (water: $7.3 \times 10^{-6} \text{ J/cm}^2$, methanol: $2.2 \times 10^{-6} \text{ J/cm}^2$) and to the hydrophobic surface of the analyte and the ligand respectively. The retention can be decreased by adding a less polar solvent (methanol, acetonitrile) into the mobile phase to reduce the surface tension of water. Gradient elution uses this effect by automatically reducing the polarity and the surface tension of the aqueous mobile phase during the course of the**

analysis. Structural properties of the analyte molecule play an important role in its retention characteristics. In general, an analyte with a larger hydrophobic surface area (C-H, C-C, and generally non-polar atomic bonds, such as S-S and others) is retained longer because it is non-interacting with the water structure. On the other hand, analytes with higher polar surface area (conferred by the presence of polar groups, such as -OH, -NH₂, COO⁻ or -NH₃⁺ in their structure) are less retained as they are better integrated into water. Such interactions are subject to steric effects in that very large molecules may have only restricted access to the pores of the stationary phase, where the interactions with surface ligands (alkyl chains) take place. Such surface hindrance typically results in less retention. Retention time increases with hydrophobic (non-polar) surface area. Branched chain compounds elute more rapidly than their corresponding linear isomers because the overall surface area is decreased. Similarly organic compounds with single C-C bonds elute later than those with a C=C or C≡C triple bond, as the double or triple bond is shorter than a single C-C bond. Aside from mobile phase surface tension (organizational strength in eluent structure), other mobile phase modifiers can affect analyte retention. For example, the addition of inorganic salts causes a moderate linear increase in the surface tension of aqueous solutions (ca. 1.5×10^{-7} J/cm² per Mol for NaCl, 2.5×10^{-7} J/cm² per Mol for (NH₄)₂SO₄), and because the entropy of the analyte-solvent interface is controlled by surface tension, the addition of salts tend to increase the retention time. This technique is used for mild separation and recovery of proteins and protection of their biological activity in protein analysis (hydrophobic interaction chromatography, HIC). Another important factor is the mobile phase pH since it can change the hydrophobic character of the analyte. For this reason most methods use a buffering agent, such as sodium phosphate, to control the pH. Buffers serve multiple purposes: control of pH, neutralize the charge on the silica surface of the stationary phase and act as ion pairing agents to neutralize analyte charge. Ammonium formate is commonly added in mass spectrometry to improve detection of certain analytes by the formation of analyteammonium adducts. A volatile organic acid such as acetic acid, or most commonly formic acid, is often added to the mobile phase if mass spectrometry is used to analyze the column eluant. Trifluoroacetic acid is used infrequently in mass spectrometry applications due to its persistence in the detector and solvent delivery system, but can be effective in improving retention of

analytes such as carboxylic acids in applications utilizing other detectors, as it is a fairly strong organic acid. The effects of acids and buffers vary by application but generally improve chromatographic resolution. Reversed phase columns are quite difficult to damage compared with normal silica columns; however, many reversed phase columns consist of alkyl derivatized silica particles and should never be used with aqueous bases as these will destroy the underlying silica particle. They can be used with aqueous acid, but the column should not be exposed to the acid for too long, as it can corrode the metal parts of the HPLC equipment. RP-HPLC columns should be flushed with clean solvent after use to remove residual acids or buffers, and stored in an appropriate composition of solvent. The metal content of HPLC columns must be kept low if the best possible ability to separate substances is to be retained. A good test for the metal content of a column is to inject a sample which is a mixture of 2,2'- and 4,4'-bipyridine. Because the 2,2'-bipy can chelate the metal, the shape of the peak for the 2,2'-bipy will be distorted (tailed) when metal ions are present on the surface of the silica...

(D) Size-exclusion chromatography: Size-exclusion chromatography (SEC), also known as gel permeation chromatography or gel filtration chromatography, separates particles on the basis of molecular size (actually by a particle's Stokes radius). It is generally a low resolution chromatography and thus it is often reserved for the final, "polishing" step of the purification. It is also useful for determining the tertiary structure and quaternary structure of purified proteins. SEC is used ... primarily for the analysis of large molecules such as proteins or polymers. SEC works by trapping these smaller molecules in the pores of a particle. The larger molecules simply pass by the pores as they are too large to enter the pores. Larger molecules therefore flow through the column quicker than smaller molecules, that is, the smaller the molecule, the longer the retention time. This technique is widely used for the molecular weight determination of polysaccharides. SEC is the official technique (suggested by European pharmacopeia) for the molecular weight comparison of different commercially available low- molecular weight heparins.

ION-EXCHANGE CHROMATOGRAPHY:

In ion-exchange chromatography (IC), retention is based on the attraction between solute ions and charged sites bound to the stationary phase. Solute ions of the same charge as the charged sites on the column are excluded from binding, while solute ions of the opposite charge of the charged sites of the column are

retained on the column. Solute ions that are retained on the column can be eluted from the column by changing the solvent conditions (e.g., increasing the ion effect of the solvent system by increasing the salt concentration of the solution, increasing the column temperature, changing the pH of the solvent, etc.). Types of ion exchangers include polystyrene resins, cellulose and dextran ion exchangers (gels), and controlled-pore glass or porous silica. Polystyrene resins allow cross linkage which increases the stability of the chain. Higher cross linkage reduces swerving, which increases the equilibration time and ultimately improves selectivity. Cellulose and dextran ion exchangers possess larger pore sizes and low charge densities making them suitable for protein separation. In general, ion exchangers favor the binding of ions of higher charge and smaller radius. An increase in counter ion (with respect to the functional groups in resins) concentration reduces the retention time. A decrease in P^H reduces the retention time in cation exchange while an increase in pH reduces the retention time in anion exchange. By lowering the pH of the solvent in a cation exchange column, for instance, more hydrogen ions are available to compete for positions on the anionic stationary phase, thereby eluting weakly bound cations. This form of chromatography is widely used in the following applications: water purification, preconcentration of trace components, ligand-exchange chromatography, ... ion-exchange chromatography of proteins, high-pH anion-exchange chromatography of carbohydrates and oligosaccharides, and others.

BIOAFFINITY CHROMATOGRAPHY

This chromatographic process relies on the property of biologically active substances to form stable, specific, and reversible complexes. The formation of these complexes involves the participation of common molecular forces such as the Van der Waals interaction, electrostatic interaction, dipole-dipole interaction, hydrophobic interaction, and the hydrogen bond. An efficient, biospecific bond is formed by a simultaneous and concerted action of several of these forces in the complementary binding sites.

Aqueous

normal-phase chro

matography

Aqueous normal-phase chromatography (ANP) is a chromatographic technique which encompasses the mobile phase region between reversed-phase chromatography (RP) and organic normal phase chromatography (ONP). This technique is used to achieve unique selectivity for hydrophilic compounds, showing normal phase elution using reversed-phase

solvents.

Isocratic and gradient elution:

At the ARS Natural Products Utilization Research Unit in Oxford, MS., a support scientist (r) extracts plant pigments that will be analyzed by a plant physiologist (l) using an HPLC system. A separation in which the mobile phase composition remains constant throughout the procedure is termed isocratic (meaning constant composition). (The example of these the percentage of methanol throughout the procedure will remain constant i.e 10%) The word was coined by Csaba Horvath who was one of the pioneers of HPLC., The mobile phase composition does not have to remain constant. A separation in which the mobile phase composition is changed during the separation process is described as a gradient elution. One example is a gradient starting at 10% methanol and ending at 90% methanol after 20 minutes. The two components of the mobile phase are typically termed "A" and "B"; A is the "weak" solvent which allows the solute to elute only slowly, while B is the "strong" solvent which rapidly elutes the solutes from the column. In reversed-phase chromatography, solvent A is often water or an aqueous buffer, while B is an organic solvent miscible with water, such as acetonitrile, methanol, THF, or isopropanol. In isocratic elution, peak width increases with retention time linearly according to the equation for N, the number of theoretical plates. This leads to the disadvantage that late-eluting peaks get very flat and broad. Their shape and width may keep them from being recognized as peaks. Gradient elution decreases the retention of the later-eluting components so that they elute faster, giving narrower (and taller) peaks for most components. This also improves the peak shape for tailed peaks, as the increasing concentration of the organic eluent pushes the tailing part of a peak forward. This also increases the peak height (the peak looks A schematic of gradient elution. Increasing mobile phase strength sequentially elutes analytes having varying interaction strength with the stationary phase. "sharper"), which is important in trace analysis. The gradient program may include sudden "step" increases in the percentage of the organic component, or different slopes at different times – all according to the desire for optimum separation in minimum time. In isocratic elution, the selectivity does not change if the column dimensions (length and inner diameter) change – that is, the peaks elute in the same order. In gradient elution, the elution order may change as the dimensions or flow rate change. The driving force in reversed phase chromatography originates in the high order of the water structure. The role of the organic component of the mobile phase is to reduce this high order and thus reduce the retarding strength of the

aqueous component.

PARAMETERS

Theoretical

HPLC separations have theoretical parameters and equations to describe the separation of components into signal peaks when detected by instrumentation such as by a UV detector or a mass spectrometer. The parameters are largely derived from two sets of chromatographic theory: plate theory (as part of Partition chromatography), and the rate theory of chromatography / Van Deemter equation. Of course, they can be put in practice through analysis of HPLC chromatograms, although rate theory is considered the more accurate theory. They are analogous to the calculation of retention factor for a paper chromatography separation, but describes how well HPLC separates a mixture into two or more components that are detected as peaks (bands) on a chromatogram. The HPLC parameters are the: efficiency factor(N), the retention factor (κ'), and the separation factor (α).

Together the factors are variables in a resolution equation, which describes how well two components' peaks separated or overlapped each other. These parameters are mostly only used for describing HPLC reversed phase and HPLC normal phase separations, since those separations tend to be more subtle than other HPLC modes (e.g., ion exchange and size exclusion). Void volume is the amount of space in a column that is occupied by solvent. It is the space within the column that is outside of the column's internal packing material. Void volume is measured on a chromatogram as the first component peak detected, which is usually the solvent that was present in the sample mixture; ideally the sample solvent flows through the column without interacting with the column, but is still detectable as distinct from the HPLC solvent. The void volume is used as a correction factor. Efficiency factor (N) practically measures how sharp component peaks on the chromatogram are, as ratio of the component peak's area ("retention time") relative to the width of the peaks at their widest point (at the baseline). Peaks that are tall, sharp, and relatively narrow indicate that separation method efficiently removed a component from a mixture; high efficiency. Efficiency is very dependent upon the HPLC column and the HPLC method used. Efficiency factor is synonymous with plate number, and the 'number of theoretical plates'. Retention factor (κ') measures how long a component of the mixture stuck to the column, measured by the area under the curve of its peak in a chromatogram (since HPLC chromatograms are a function of time). Each chromatogram peak will have its own retention factor

(e.g., κ_1 for the retention factor of the first peak). This factor may be corrected for by the void volume of the column. Separation factor (α) is a relative comparison on how well two neighboring components of the mixture were separated (i.e., two neighboring bands on a chromatogram). This factor is defined in terms of a ratio of the retention factors of a pair of neighboring chromatogram peaks, and may also be corrected for by the void volume of the column. The greater the separation factor value is over 1.0, the better the separation, until about 2.0 beyond which an HPLC method is probably not needed for separation. Resolution equations relate the three factors such that high efficiency and separation factors improve the resolution of component peaks in an HPLC separation.

Internal diameter: The internal diameter (ID) of an HPLC column is an important parameter that influences the detection sensitivity and separation selectivity in gradient elution. It also determines the quantity of analyte that can be loaded onto the column. Larger columns are usually seen in industrial applications, such as the purification of a drug product for later use. Low-ID columns have improved sensitivity and lower solvent consumption at the expense of loading capacity. Larger ID columns (over 10 mm) are used to purify usable amounts of material because of their large loading capacity. Analytical scale columns (4.6 mm) have been the most common type of columns, though smaller columns are rapidly gaining in popularity. They are used in traditional quantitative analysis of samples and often use a UV-Vis absorbance detector. Narrow-bore columns (1–2 mm) are used for applications when more sensitivity is desired either with special UV-vis detectors, fluorescence detection or with other detection methods like liquid chromatography-mass spectrometry. Capillary columns (under 0.3 mm) are used almost exclusively with alternative detection means such as mass spectrometry. They are usually made from fused silica capillaries, rather than the stainless steel tubing that larger columns employ.

Particle size

Most traditional HPLC is performed with the stationary phase attached to the outside of small spherical silica particles (very small beads). These particles come in a variety of sizes with 5 μm beads being the most common. Smaller particles generally provide more surface area and better separations, but the pressure required for optimum linear velocity increases by the inverse of the particle diameter squared. According to the equations of the column velocity, efficiency and backpressure, reducing the particle diameter by half and keeping the size of the column the same, will double the column velocity and efficiency; but four times increase the

backpressure. And the small particles HPLC also can decrease the width broadening. Larger particles are Tubing on a nano-liquid chromatography (nano-LC) system, used for very low flow capacities. ... used in preparative HPLC (column diameters 5 cm up to >30 cm) and for non-HPLC applications such as solid-phase extraction.

Pore size

Many stationary phases are porous to provide greater surface area. Small pores provide greater surface area while larger pore size has better kinetics, especially for larger analytes. For example, a protein which is only slightly smaller than a pore might enter the pore but does not easily leave once inside.

Pump pressure

Pumps vary in pressure capacity, but their performance is measured on their ability to yield a consistent and reproducible volumetric flow rate. Pressure may reach as high as 60 MPa (6000 lbf/in²), or about 600 atmospheres. Modern HPLC systems have been improved to work at much higher pressures, and therefore are able to use much smaller particle sizes in the columns (2 μm). These "ultra high performance liquid chromatography" systems or UHPLCs, which could also be known as ultra high pressure chromatography systems, can work at up to 120 MPa (17,405 lbf/in²), or about 1200 atmospheres. The term "UPLC" is a trademark of the Waters Corporation, but is sometimes used to refer to the more general technique of UHPLC.

Detectors

HPLC detectors fall into two main categories: universal or selective. Universal detectors typically measure a bulk property (e.g., refractive index) by measuring a difference of a physical property between the mobile phase and mobile phase with solute while selective detectors measure a solute property (e.g., UV-Vis absorbance) by simply responding to the physical or chemical property of the solute. HPLC most commonly uses a UV-Vis absorbance detector, however, a wide range of other chromatography detectors can be used. A universal detector that complements UV-Vis absorbance detection is the Charged aerosol detector (CAD). A kind of commonly utilized detector includes refractive index detectors, which provide readings by measuring the changes in the refractive index of the eluant as it moves through the flow cell. In certain cases, it is possible to use multiple detectors, for example LCMS normally combines UV-Vis with a mass spectrometer. When used with an electrochemical detector (ECD) the HPLC-ECD selectively detects neurotransmitters such as: norepinephrine, dopamine, serotonin, glutamate, GABA, acetylcholine and others in neurochemical analysis research applications. The

HPLCECD detects neurotransmitters to the femtomolar range. Other methods to detect neurotransmitters include liquid chromatography-mass spectrometry, ELISA, or radioimmunoassays.

Autosamplers

Large numbers of samples can be automatically injected onto an HPLC system, by the use of HPLC autosamplers. In addition, HPLC autosamplers have an injection volume and technique which is exactly the same for each injection, consequently they provide a high degree of injection volume precision. It is possible to enable sample stirring within the sampling-chamber, thus promoting homogeneity.

APPLICATION

Manufacturing

HPLC has many applications in both laboratory and clinical science. It is a common technique used in pharmaceutical development, as it is a dependable way to obtain and ensure product purity. While HPLC can produce extremely high quality (pure) products, it is not always the primary method used in the production of bulk drug materials. According to the European pharmacopoeia, HPLC is used in only 15.5% of syntheses. However, it plays a role in 44% of syntheses in the United States pharmacopoeia. This could possibly be due to differences in monetary and time constraints, as HPLC on a large scale can be an expensive technique. An increase in specificity, precision, and accuracy that occurs with HPLC unfortunately corresponds to an increase in cost.

Legal

This technique is also used for detection of illicit drugs in urine. The most common method of drug detection is an immunoassay. This method is much more convenient. However, convenience comes at the cost of specificity and coverage of a wide range of drugs. As HPLC is a method of determining (and possibly increasing) purity, using HPLC alone in evaluating concentrations of drugs is somewhat insufficient. With this, HPLC in this context is often performed in conjunction with mass spectrometry. Using liquid chromatography instead of gas chromatography in conjunction with MS circumvents the necessity for derivatizing with acetylating or alkylation agents, which can be a burdensome extra step. This technique has been used to detect a variety of agents like doping agents, drug metabolites, glucuronide conjugates, amphetamines, opioids, cocaine, BZDs, ketamine, LSD, cannabis, and pesticides. Performing HPLC in conjunction with Mass spectrometry reduces the absolute need for standardizing HPLC experimental runs.

Medical

Medical use of HPLC can include drug analysis, but falls more closely under the category of nutrient

analysis. While urine is the most common medium for analyzing drug concentrations, blood serum is the sample collected for most medical analyses with HPLC. Other methods of detection of molecules that are useful for clinical studies have been tested against HPLC, namely immunoassays. In one example of this, competitive protein binding assays (CPBA) and HPLC were compared for sensitivity in detection of vitamin D. Useful for diagnosing vitamin D deficiencies in children, it was found that sensitivity and specificity of this CPBA reached only 40% and 60%, respectively, of the capacity of HPLC. While an expensive tool, the accuracy of HPLC is nearly unparalleled.

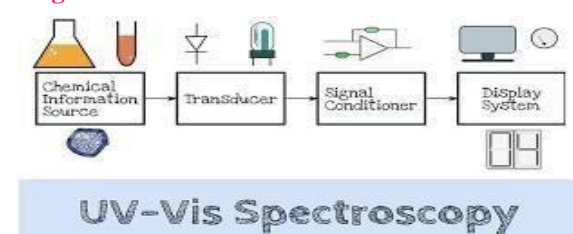
Research

Similar assays can be performed for research purposes, detecting concentrations of potential clinical candidates like anti-fungal and asthma drugs. This technique is obviously useful in observing multiple species in collected samples, as well, but requires the use of standard solutions when information about species identity is sought out. It is used as a method to confirm results of synthesis reactions, as purity is essential in this type of research. However, mass spectrometry is still the more reliable way to identify species.

(B) ULTRAVIOLET-VISIBLE SPECTROSCOPY

Introduction: Ultraviolet-visible spectroscopy or ultraviolet-visible spectrophotometry (UV-Vis or UV/Vis) refers to absorption spectroscopy or reflectance spectroscopy in part of the ultraviolet and the full, adjacent visible regions of the electromagnetic spectrum. This means it uses light in the visible and adjacent ranges. The absorption or reflectance in the visible range directly affects the perceived color of the chemicals involved. In this region of the spectrum, atoms and molecules undergo electronic transitions. Absorption spectroscopy is complementary to fluorescence spectroscopy, in that fluorescence deals with transitions of electrons from the excited state to the ground state, while absorption measures transitions from the ground state to the excited state.

Diagram:



Principle of Ultraviolet visible absorption

Molecules containing bonding and non-bonding electrons (n-electrons) can absorb energy in the form of ultraviolet or visible light to excite these electrons to higher anti-bonding molecular orbitals. The more easily excited the electrons (i.e. lower energy gap between the HOMO and the LUMO).

Application

UV/Vis spectroscopy is routinely used in analytical chemistry for the quantitative determination of different analytes, such as transition metal ions, highly conjugated organic compounds, and biological macromolecules. Spectroscopic analysis is commonly carried out in solutions but solids and gases may also be studied.

- Solutions of transition metal ions can be colored (i.e., absorb visible light) because d-electrons within the metal atoms can be excited from one electronic state to another. The colour of metal ion solutions is strongly affected by the presence of other species, such as certain anions or ligands. For instance, the colour of a dilute solution of copper sulfate Principle of ultraviolet-visible absorption An example of a UV/Vis readout is a very light blue; adding ammonia intensifies the colour and changes the wavelength of maximum absorption (λ_{max}).
- Organic compounds, especially those with a high degree of conjugation, also absorb light in the UV or visible regions of the electromagnetic spectrum. The solvents for these determinations are often water for water-soluble compounds, or ethanol for organicsoluble compounds. (Organic solvents may have significant UV absorption; not all solvents are suitable for use in UV spectroscopy. Ethanol absorbs very weakly at most

wavelengths.) Solvent polarity and pH can affect the absorption spectrum of an organic compound. Tyrosine, for example, increases in absorption maxima and molar extinction coefficient when pH increases from 6 to 13 or when solvent polarity decreases.

- While charge transfer complexes also give rise to colours, the colours are often too intense to be used for quantitative measurement.

THE BEER–LAMBERT LAW STATES THAT THE ABSORBANCE OF A SOLUTION IS DIRECTLY PROPORTIONAL TO THE CONCENTRATION OF THE ABSORBING SPECIES IN THE SOLUTION AND THE PATH

LENGTH. Thus, for a fixed path length, UV/Vis spectroscopy can be used to determine the concentration of the absorber in a solution. It is necessary to know how quickly the absorbance changes with concentration. This can be taken from references (tables of molar extinction coefficients), or more accurately, determined from a calibration curve. A UV/Vis spectrophotometer may be used as a detector for HPLC. The presence of an analyte gives a response assumed to be proportional to the concentration. For accurate results, the instrument's response to the analyte in the unknown should be compared with the response to a standard; this is very similar to the use of calibration curves. The response (e.g., peak height) for a particular concentration is known as the response factor. The wavelengths of absorption peaks can be correlated with the types of bonds in a given molecule and are valuable in determining the functional groups within a molecule. The Woodward–Fieser rules, for instance, are a set of empirical observations used to predict λ_{\max} the wavelength of the most intense UV/Vis absorption, for conjugated organic compounds such as dienes and ketones. The spectrum alone is not, however, a specific test for any given sample. The nature of the solvent, the pH of the solution, temperature, high electrolyte concentrations, and the presence of interfering substances can influence the absorption spectrum. Experimental variations such as the slit width (effective bandwidth) of the spectrophotometer will also alter the spectrum. To apply UV/Vis spectroscopy to analysis, these variables must be controlled or accounted for in order to identify the substances present. The method is most often used in a quantitative way to determine concentrations of an absorbing species in solution, using the Beer–Lambert law: $A = \epsilon c L$, where A is the measured absorbance (in Absorbance Units (AU)), I_0 is the intensity of the incident light at a given wavelength, I is the transmitted

intensity, L the path length through the sample, and c the concentration of the absorbing species. For each species and wavelength, ϵ is a constant known as the molar absorptivity or extinction coefficient. This constant is a fundamental molecular property in a given solvent, at a particular temperature and pressure, and has units of $\text{L mol}^{-1} \text{cm}^{-1}$. The absorbance and extinction ϵ are sometimes defined in terms of the natural logarithm instead of the base-10 logarithm. The Beer–Lambert Law is useful for characterizing many compounds but does not hold as a universal relationship for the concentration and absorption of all substances. A 2nd order polynomial relationship between absorption and concentration is sometimes encountered for very large, complex molecules such as organic dyes (Xylenol Orange or Neutral Red, for example).

PRACTICAL CONSIDERATIONS:

The Beer–Lambert law has implicit assumptions that must be met experimentally for it to apply; otherwise there is a possibility of deviations from the law. For instance, the chemical makeup and physical environment of the sample can alter its extinction coefficient. The chemical and physical conditions of a test sample therefore must match reference measurements for conclusions to be valid. Worldwide, pharmacopoeias such as the American (USP) and European (Ph. Eur.) pharmacopoeias demand that spectrophotometers perform according to strict regulatory requirements encompassing factors such as stray light and wavelength accuracy.

Spectral bandwidth

It is important to have a monochromatic source of radiation for the light incident on the sample cell. Monochromaticity is measured as the width of the "triangle" formed by the intensity spike, at one half of the peak intensity. A given spectrometer has a spectral bandwidth that characterizes how monochromatic the incident light is. If this bandwidth is comparable to (or more than) the width of the absorption line, then the measured extinction coefficient will be mistaken. In reference measurements, the instrument bandwidth (bandwidth of the incident light) is kept below the width of the spectral lines. When a test material is being measured, the bandwidth of the incident light should also be sufficiently narrow. Reducing the spectral bandwidth reduces the energy passed to the detector and will, therefore, require a longer measurement time to achieve the same signal to noise ratio.

Wavelength error

In liquids, the extinction coefficient usually changes slowly with wavelength. A peak of the absorbance curve (a wavelength where the absorbance reaches a maximum) is where the rate of change in absorbance with wavelength is smallest. Measurements are

usually made at a peak to minimize errors produced by errors in wavelength in the instrument, that is errors due to having a different extinction coefficient than assumed.

Deviations from the Beer–Lambert law

AT SUFFICIENTLY HIGH CONCENTRATIONS, THE ABSORPTION BANDS WILL SATURATE AND SHOW ABSORPTION FLATTENING. THE ABSORPTION PEAK APPEARS TO FLATTEN BECAUSE CLOSE TO 100% OF THE LIGHT IS ALREADY BEING ABSORBED. THE CONCENTRATION AT WHICH THIS OCCURS DEPENDS ON THE PARTICULAR COMPOUND BEING MEASURED. ONE TEST THAT CAN BE USED TO TEST FOR THIS EFFECT IS TO VARY THE PATH LENGTH OF THE MEASUREMENT. IN THE BEER–LAMBERT LAW, VARYING CONCENTRATION AND PATH LENGTH HAS AN EQUIVALENT EFFECT—DILUTING A SOLUTION BY A FACTOR OF 10 HAS THE SAME EFFECT AS SHORTENING THE PATH LENGTH BY A FACTOR OF 10. IF CELLS OF DIFFERENT PATH LENGTHS ARE AVAILABLE, TESTING IF THIS RELATIONSHIP HOLDS TRUE IS ONE WAY TO JUDGE IF ABSORPTION FLATTENING IS OCCURRING. SOLUTIONS THAT ARE NOT HOMOGENEOUS CAN SHOW DEVIATIONS FROM THE BEER–LAMBERT LAW BECAUSE OF THE PHENOMENON OF ABSORPTION FLATTENING. THIS CAN HAPPEN, FOR INSTANCE, WHERE THE ABSORBING SUBSTANCE IS LOCATED WITHIN SUSPENDED PARTICLES.

Additional Application

UV/Vis can be applied to determine the kinetics or rate constant of a chemical reaction. The reaction, occurring in solution, must present color or brightness shifts from reactants to products in order to use UV/Vis for this application. For example, the molecule mercury dithizonate is a yellow-orange color in diluted solution (1×10^{-5} M), and turns blue when subjected with particular wavelengths of visible light (and UV) via a conformational change, but this reaction is reversible back into the yellow "ground state".

USING OPTICAL FIBERS AS A TRANSMISSION ELEMENT OF SPECTRUM OF BURNING GASES IT IS POSSIBLE TO DETERMINE A CHEMICAL COMPOSITION OF A FUEL, TEMPERATURE OF GASES, AND AIR-FUEL RATIO.

The rate constant of a particular reaction can be determined by measuring the UV/Vis absorbance

spectrum at specific time intervals. Using mercury dithizonate again as an example, one can shine light on the sample to turn the solution blue, then run a UV/Vis test every 10 seconds (variable) to see the levels of absorbed and reflected wavelengths change over time in accordance with the solution turning back to yellow from the excited blue energy state. From these measurements, the concentration of the two species can be calculated.

Some Types Spectroscopy:

- Ultraviolet–visible spectroscopy of stereoisomers
 - Infrared spectroscopy and Raman spectroscopy are other common spectroscopic techniques, usually used to obtain information about the structure of compounds or to identify compounds. Both are forms of vibrational spectroscopy.
 - Fourier-transform spectroscopy
 - Near-infrared spectroscopy
 - Vibrational spectroscopy
 - Rotational spectroscopy
 - Applied spectroscopy
 - Slope spectroscopy
- Benesi–Hildebrand method Spectrophotometry

(C) FRIABILATOR

Introduction

Friabilator is the instrument which is used to detect the friability of the tablets. Friability is the combined effects of shock and abrasions. So to resist shock and abrasions friability test is done for the tablets. In this a no. of tablets are put in the friabilator and revolves at 25rpm, dropping the tablets a distance of six inches with each revolutions. Conventional compressed tablets that lose less than 0.5 to 1.0% of their weight are generally considered as acceptable. When capping is considered on friability testing, the tablet should not be considered as for commercial use, regardless of the %age of loss seen.

Diagram:



Fig: Roche Friabilator For Uncoated Tablets

It can also be thought of as measuring “dusting”. Tablets are rotated in a plastic drum for a specified

period of time. A gravimetric determination is then made to quantitate the amount of surface material that has worn off.

Uses: Friabilator is the instrument which is used to detect the friability of the tablets .

DISSOLUTION TEST APPARATUS

Introduction

The dissolution test is conducted to assure that drug is properly breaks into their parts in a respective medium. Dissolution testing can be continued through three stages . STAGE(1-3)-Six tablets are tested and are acceptable if all the tablets are not less than monograph tolerance limit plus 5%.if the tablet fails

,an additional six tablets are tested. The tablets are acceptable if average of the twelve tablets are greater than or equal to tolerance limit and no unit less than tolerance limit minus 15% ,if tablet still fails the test, an additional 12 tablets are tested. The tablets are acceptable if the average of all 24 tablets is greater than or equal to tolerance limit and if not more than 2 tablets are less than tolerance limit minus 15%.Industrial pharmacists routinely test their formulations for dissolution.

Diagram:



Principle : A dissolution test uses an **apparatus with specific test conditions in combination with acceptance criteria to evaluate the performance of the product.** General chapter <711> Dissolution includes 4 standardized apparatus: basket, paddle, reciprocating cylinder, and flow-through cell.

Uses:

A Dissolution Test is used for **in vitro testing of the tablets and capsules. Dissolution apparatus are used through the product development life cycle, from Product release to stability testing in the Quality Control department.**

(E) DIGITAL PH METER

Introduction:

Digital pH meter is used in pharmaceutical industries to assure the pH of the solutions which is needed for the preparation of the drug, pH is very important to make assure the stability of the product.

Solutions stability investigation usually commence with probing experiments to confirm decay at the extremes of pH for an e.g 0.1N HCL,Water, and0.1N NaOH).These intentionally degraded samples may be used to confirm assay specificity as well as to provide estimates for maximum rates of degradation. This initial experiment should be followed by the generation of a complete pH rate profile to identify the pH of maximum stability. Aqueous buffers are used to produce solutions over a wide range of ph values with constant levels of drug ,cosolvent and ionic strength. Since most solution pharmaceuticals are intended for parenterals routes of administration ,this initial ph Rte study should be conducted at a constant ionic strength that is compatible with physiologic media. Ionic strength of an isotonic 0.9% NaCl solution is 0.15.85.

Diagram



Principle of PH Meter:

A pH meter is a scientific instrument that measures the hydrogen-ion activity in solutions, indicating its acidity or basicity (alkalinity) expressed as pH value. The principle of pH meter is **the concentration of hydrogen ions in the solution** e.g. it is the negative logarithm of an hydrogen ion.

Uses:

A digital potential of hydrogen (pH) meter is an electronic gadget **used to accurately measure and record the pH values of liquids.** Measuring pH allows one to determine the acidity or alkalinity of a substance in a liquid state.

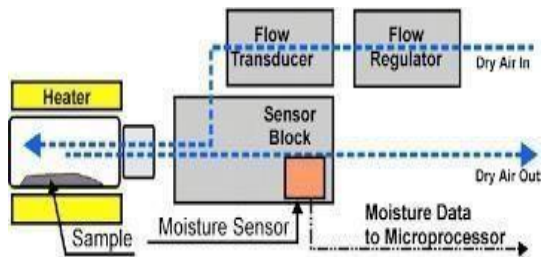
(F).MOISTURE ANALYZER

Introduction

A moisture analyzer indicating by its name as to analyze moisture in a drug content. The formula which is used to detect moisture is as follows: $v\%$ moisture content (M.C) = $(\text{wt. of water in sample} / \text{wt. of dry sample}) \times 100$

Drying of solids The moisture content in a solid can be expressed on a wet-weight or dry weight basis. On wet weight basis, the water content of a material is calculated as a %age of the weight of the wet solid, whereas on the dry weight basis, the water is expressed as a %age of the weight of the dry solid. In pharmacy loss on drying is commonly referred as L.O.D, is an expression of moisture content on a wet weight basis which is calculated as follows: 8

Diagram



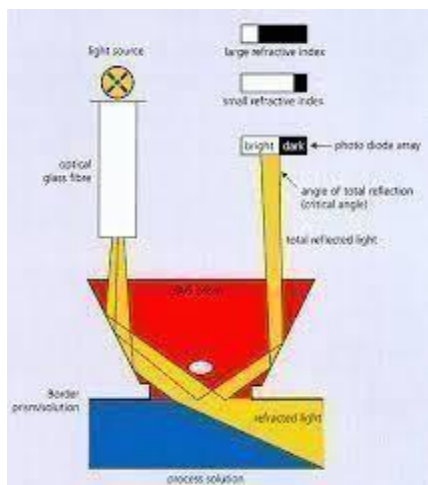
(F) Process viscometer

This instrument is capable for performing the rheologic studies of most pharmaceutical preparations such as semi-solid preparations or formulations: pastes, ointments and creams.

(G) Digital refractometer Introduction

Digital refractometer is used for those product which are sensitive to light refraction so it is simply used to check the refraction spectrum of drug product.

Diagram



Principle of the Digital refractometer:

How does a Digital Refractometer work? In digital

refractometers **the light (1) travels from a prism (2) with a high refractive index (normally glass or artificial sapphire) into the sample (3)** When measuring turbid samples, however, part of the light is reflected by the particles in the sample.

(H) Leak test apparatus Introduction

A leak test apparatus is used for checking the crimping of the valve which must be available to prevent defective containers due to leakage. For metal containers, this is accomplished by measuring the "crimp" dimensions and ensuring that they meet specifications. Final testing of the efficiency of the valve closure is accomplished by passing the filled containers through the water bath. Periodic checks are made of the temperature of the water bath, these results are recorded.

CONCLUSION:

Monitoring chemical processes for the formation of an API is the first step to ensuring quality in pharmaceutical manufacturing. Having reliable and reproducible methods will enable the production plant to guarantee the consistency of drugs batch after batch. Furthermore, it may simplify the characterization of such processes and their chemical profile. Through the years, vast publications and general information have been presented to pharmaceutical industry specialists about the validation of analytical methods. Federal and international regulatory groups have published various guidelines to shed light on analytical method validation. No such emphasis has been given, or guidelines described, however, the validation of in-process control methods. This article intends to establish a starting point for discussions about the validation of in-process methods. So in this, in-process methods quality control and validation are dealt with several of criteria that are discussed in this review.

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