

การศึกษาคุณสมบัติการตอบอั้ด เป็นเม็ดของแบงช้าเจ้าดัดแปลง
โดยใช้เทคนิคสเปรย์คราฟและปฏิกรณ์กรดออกซิเจน

ร.อ. ศรีษะ ทิมอรุณ



วิทยานิพนธ์นี้เป็นส่วนหนึ่งของการศึกษาตามหลักสูตรปริญญา เภสัชศาสตรมหาบัณฑิต
ภาควิชาเภสัชศาสตร์สาขาวรรณ
พ.ศ. ๒๕๗๗

ISBN 974-584-129-3

ลิขสิทธิ์ของบัณฑิตวิทยาลัย จุฬาลงกรณ์มหาวิทยาลัย

STUDY OF TABLETTING PROPERTIES OF MODIFIED
RICE STARCH PREPARED BY SPRAY DRYING
TECHNIQUE AND CROSSLINKING REACTION

Siriyos Timaroon

A Thesis Submitted in Partial Fulfillment of the Requirements
for the degree of Master of Science in Pharmacy

Department of Manufacturing Pharmacy

Graduate School

Chulalongkorn University

1994

ISBN 974-584-129-3

Thesis Title Study of Tabletting Properties of
 Modified Rice Starch Prepared
 by Spray-drying Technique and
 Crosslinking Reaction

By Siriyos Timaroon

Department Manufacturing Pharmacy

Thesis Advisor Assistant Professor Poj Kulvanich,
 Ph.D.

Accepted by the Graduate School, Chulalongkorn
University in Partial Fulfilment of the Requirements
for the Master's Degree

.....*Thavorn Vajrabhaya*.....Dean of Graduate School
(Professor Thavorn Vajrabhaya, Ph.D.)

Thesis Committee

.....*Parunee Thanomkiat*.....Chairman
(Associate Professor Parunee Thanomkiat, M.Sc.)

.....*P. Kulvanich*.....Thesis Advisor
(Assistant Professor Poj Kulvanich, Ph.D.)

.....*Chaiyo Chaichantipyuth*.....Member
(Associate Professor Chaiyo Chaichantipyuth, M.Sc.)

.....*Garnpimol C. Ritthidej*.....Member
(Associate Professor Garnpimol C. Ritthidej, Ph.D.)

พิมพ์ต้นฉบับทักษิณอวิทยานิพนธ์ภาษาในกรอบสีเขียวนี้เพียงแผ่นเดียว

คิริยศ กิมอรุณ, ร.อ. : การศึกษาคุณล้มเหลวต่�建การตอกอวด เป็นเม็ดของแบงข้าวเจ้าตัดแปลง โดยใช้เทคนิคล Ernest ประยัตราชและปฏิกริยาครองลัศก์ อ.กปริกษา : ผศ.ดร. พจน์ ฤลวนิช, 178 หน้า, ISBN 974-584-129-3

ผลการศึกษาพบว่า แบงข้าวเจ้า เมื่อเปรียบเทียบกับแบงขันดื่นที่ผลิตได้ในประเทศไทย มีคุณลักษณะ ให้ความลับที่จะหลุดร่วง เป็นสารช่วยขันดื่นตอกโดยตรง โดยการตัดแปลงให้อยู่ในรูปของกลุ่มเม็ดแบง ทรงกลมด้วยเทคนิคล Ernest ประยัตราช และปฏิกริยาครองลัศก์ เมื่อนำมาแบงข้าวเจ้ามาลักษ์โปรดตื้นออกก่อน ที่จะนำมากำปฏิกริยาครองลัศก์นาน 6 ชั่วโมง แล้วมาผ่านการลับประยัตราชภายใต้ลักษณะที่เหมาะสม จะได้กลุ่มเม็ดแบงข้าวเจ้าที่มีคุณลักษณะตอกอวด เป็นเม็ดที่ดีที่สุด

เมื่อเปรียบเทียบคุณลักษณะในการตอกอวด เป็นเม็ดของแบงข้าวเจ้าตัดแปลงที่ได้พัฒนาขึ้นนี้ กับ ผลิตภัณฑ์แบงตัดแปลงอื่นที่มีจำหน่ายในห้องตลาด พบร้าว่า มีคุณลักษณะในด้านการตอกอวดสูงกว่า และเวลาการ กระ化จายตัวลั้นกว่า

ภาควิชา ภาส्यอุตสาหกรรม
สาขาวิชา ภาส्यอุตสาหกรรม
ปีการศึกษา 2536

ลายมือชื่อนักศึกษา
ลายมือชื่ออาจารย์ที่ปรึกษา
ลายมือชื่ออาจารย์ที่ปรึกษาร่วม

C275201 : MAJOR INDUSTRIAL PHARMACY

KEY WORD: MODIFIED RICE STARCH/SPRAY-DRYING/CROSSLINKING REACTION/DIRECTLY COMPRESSIBLE DILUENT

SIRIYOS TIMAROON : STUDY OF TABLETTING PROPERTIES OF MODIFIED RICE STARCH PREPARED BY SPRAY DRYING TECHNIQUE AND CROSSLINKING REACTION.

THESIS ADVISOR : ASSIST. PROF. POJ KULVANICH, Ph.D. 178 pp. ISBN 974-584-129-3

Among various locally available native starches, rice flour was found to be the most suitable to be developed into a directly compressible diluent. The starch was modified into the form of spherical starch aggregates by spray-drying technique and crosslinking reaction. Rice starch aggregates which were deproteinized and crosslinked for 6 hrs. before being spray-dried exhibited the best tabletting properties.

When compared with other commercial modified starch products, modified rice starch derived by the process in this study gave higher tablet hardness with shorter disintegration time.

ภาควิชา.....เคมีอุตสาหกรรม

ลายมือชื่อนิสิต.....*ดร. พลิกา คงยู*

สาขาวิชา.....เคมีอุตสาหกรรม

ลายมือชื่ออาจารย์ที่ปรึกษา.....*พญ. นรีกาญจน์*

ปีการศึกษา..... 2536

ลายมือชื่ออาจารย์ที่ปรึกษาร่วม.....



Acknowledgements

I would like to express my deepest gratitude to my thesis advisor and head of Industrial Pharmacy Department, Assistant Professor Poj Kulvanich, Ph.D. for his excellent supervision, encouragement, guidance, and patience throughout the very long course of this study.

I am also most grateful to Assistant Professor Surapong Nawangkasattusasana, Ph.D., Department of Food Technology for his invaluable advises and guidance.

A special thank is extended to Dr. Krisana Kraisintu, director of the Institute of Research and Development, Government Pharmaceutical Organization for the use spray-dryer and other facilities.

Finally, the sincere acknowledgements are given to all my friends, classmates, and departmental personnel for their suggestions and assistance.

CONTENTS

	Page
Abstract (Thai).....	IV
Abstract (English).....	V
Acknowledgements.....	VI
List of Tables.....	VII
List of Figures.....	XI
List of Abbreviations.....	XX
Chapter	
I Introduction.....	1
Objectives.....	3
Overview.....	3
II Experimental.....	34
III Results.....	48
IV Discussion and Conclusion.....	130
References.....	154
Appendices.....	157
Vitae.....	178

LIST OF TABLES

Table	Page
1 Starch Granule Properties (Rutenberg, 1980)....	7
2 Average Chemical Composition of Starch Granules (Swinkles, n.p.).....	7
3 Chemical Composition of Various Starches (Mukhprasert, 1992).....	8
4 Enthalpy of Gelatinization (- ΔH_g) for Native Granular Starches (Zobel, 1984).....	8
5 Modification of Starch (Rutenberg, 1980).....	22
6 Chemical Composition of Broken Rice (Hogan, 1967).....	22
7 Tableting Properties of Various Native and Modified Starches (by crosslinking for 6 hrs.)...	48
8 Effects of Concentration of Starch Slurry on Physical Properties of Starch Aggregates (F.R. 12.96 g/min, Temp. 130 °C, P. 1.5 bar)....	50
9 Effects of Concentration of Starch Slurry on Tableting Properties of Starch Aggregates (F.R. 12.96 g/min, Temp. 130 °C, P. 1.5 bar)....	53
10 Effects of Inlet Air Temperature on Physical Properties of Starch Aggregates (Conc. 50 % W/W, F.R. 12.96 g/min, P. 1.5 bar).....	56

Table(Cont.)	Page
11 Effects of Inlet Air Temperature on Tabletting Properties of Starch Aggregates(Conc. 50 % W/W, F.R. 12.96 g/min, P. 1.5 bar).....	58
12 Effects of Feed Rates on Physical Properties of Starch Aggregates(Conc. 50 % W/W,Temp.130 °C, P. 1.5 bar).....	61
13 Effects of Feed Rates on Tabletting Properties of Starch Aggregates(Conc. 50 % W/W,Temp.130 °C, P. 1.5 bar).....	63
14 Effects of Atomizing Pressure on Physical Properties of Starch Aggregates(Conc. 50 % W/W, Temp. 130 °C, F.R. 12.96 g/min).....	66
15 Effects of Crosslinking Time on Physical Properties of Starch Aggregates.....	69
16 Effects of Crosslinking on Tabletting Properties of Starch Aggregates.....	71
17 Effects of Crosslinking and Deproteinization on Physical Properties of Starch Aggregates....	74
18 Effects of Crosslinking and Deproteinization on Tabletting Properties of Starch Aggregates.	77
19 Physical Properties of Commercial Modified Starch Products.....	80

Table(Cont.)	Page
20 Tabletting Properties of Commercial Modified Starch Products.....	82
21 Viscosities of Crosslinked Rice Flours at 40 °C..	93
22 Viscosities of Deproteinized and Crosslinked Rice Flours at 40 °C.....	93
23 Swelling Powers of Crosslinked Rice Flours.....	96
24 Swelling Powers of Deproteinized and Crosslinked Rice Flours.....	96
25 Particle Size Distribution of Starch Aggregates prepared at inlet air temperature of 130 °C(Conc. 50 %, FR.12.96 g/min., P.1.5 bar)	169
26 Particle Size Distribution of Starch Aggregates prepared at inlet air temperature of 135 °C(Conc. 50 %, FR.12.96 g/min., P.1.5 bar)	169
27 Particle Size Distribution of Starch Aggregates prepared at feed rate 4.32 g./min (Conc. 50 %, Temp. 130 °C, P. 1.5 bar).....	170
28 Particle Size Distribution of Starch Aggregates prepared at feed rate 21.60 g./min (Conc. 50 %, Temp. 130 °C, P. 1.5 bar).....	170
29 Particle Size Distribution of 2-hrs. crosslinked Starch Aggregates (Conc. 50 %, Temp. 135 °C, FR. 12.96 g/min., P.1.5 bar).....	171

Table(Cont.)	Page
30 Particle Size Distribution of 6-hrs. crosslinked Starch Aggregates (Conc. 50 %, Temp. 135 °C, FR. 12.96 g/min., P.1.5 bar).....	171
31 Particle Size Distribution of 10-hrs. crosslinked Starch Aggregates (Conc. 50 %, Temp. 135 °C, FR. 12.96 g/min., P.1.5 bar).....	172
32 Particle Size Distribution of Deproteinized Starch Aggregates (Conc. 50 %, FR.30.24 g/min., Temp. 135 °C, P. 1.5 bar).....	172
33 Particle Size Distribution of Deproteinized and 2-hrs. crosslinked Starch Aggregates (the same conditions as Table 32).....	173
34 Particle Size Distribution of Deproteinized and 6-hrs. crosslinked Starch Aggregates (the same conditions as Table 32).....	173
35 Particle Size Distribution of Deproteinized and 10-hrs. crosslinked Starch Aggregates (the same conditions as Table 32).....	174
36 Particle Size Distribution of Starch ^R 1500.....	174
37 Particle Size Distribution of Eratab ^R	175
38 Tabletting Properties of Various Directly Compressible Diluents.....	132
39 Physical Properties of Various Directly Compressible Diluents.....	150

LIST OF FIGURES

Figure		Page
1	Synthesis of starch from glucose in plant which is previously formed in the photosynthesis process.....	5
2	Condensation of glucoses to starch which, upon hydrolysis, converts back into glucoses.	5
3	The beta-glucosidic linkage of Cellulose (a) and the alpha glucosidic linkage of Amylose (b).....	9
4	Mechanism of starch retrogradation (Amylose).	9
5	Branched structure of Amylopectin and chemical configuration at the branch point...	11
6	Amylopectin structure according to the cluster hypothesis of D. French.....	11
7	Potato Starch, Polarized Light.....	13
8	Schematic model of the structure of a starch granule.....	13
9	Structure of molecules in a layer of a starch granule. Thickened areas represent micelles produced by association of chains.....	14
10	Computer drawing of starch double helix.....	14
11	Swelling, disruption and dispersion of a starch granule during gelatinization.....	16

Figure(Cont.)

Page

12	Micellar organization within swollen starch granules.....	16
13	Brabender viscoamylograph.....	18
14	Gelatinization endotherms of granular starches.....	21
15	Crosslinking reaction of starch.....	21
16	The effect of crosslinking on the gelatinization and viscosity of corn starch..	27
17	Structure of the rice grain (Schoch, 1967)...	28
18	Diagram of Spray-dryer.....	31
19	Effects of Concentrations of Starch Slurry on Mean Diameters of Starch Aggregates.....	51
20	Effects of Concentrations of Starch Slurry on Angles of Repose of Starch Aggregates....	51
21	Pressure-Hardness Profile of tablets prepared from Starch Aggregates spray-dried at 50 % w/w conc.....	54
22	Pressure-Disintegration Time Profile of Tablets prepared from Starch Aggregates spray-dried at 50 % w/w conc.....	54
23	Effects of Temperatures on Mean Wt. Diameters of Starch Aggregates.....	57

Figure(Cont.)

Page

24	Effects of Temperatures on Angles of Repose of Starch Aggregates.....	57
25	Effects of Temperatures on Hardness of Starch Aggregates Tablets spray-dried at 130 & 135 °C (at 1,000, 1,500 and 2,000 lbs.).....	59
26	Effects of Temperatures on Disintegration Time of Starch Aggregates Tablets spray-dried at 130&135 °C(at 1,000, 1,500 and 2,000 lbs.).	59
27	Effects of Feed Rates on Mean Wt. Diameters of Starch Aggregates prepared at Different Feed Rates.....	62
28	Effects of Feed Rates on Angles of Repose of Starch Aggregates prepared at Different Feed Rates.....	62
29	Effects of Feed Rates on Hardness of Starch Aggregates Tablets(at 1,000, 1,500 and 2,000 lbs.).....	64
30	Effects of Feed Rates on Disintegration Time of Starch Aggregates Tablets(at 1,000, 1,500 and 2,000 lbs.).....	64
31	Effects of Crosslinking Time on Mean Wt. Diameters of Starch Aggregates.....	70

Figure(Cont.)	Page
32 Effects of Crosslinking Time on Angles of Repose of Starch Aggregates.....	70
33 Effects of Crosslinking Time on Hardness of Tablets compressed at 1,000, 1,500 and 2,000 lbs.....	72
34 Effects of Crosslinking Time on Disintegration Time of Tablets compressed at 1,000, 1,500, and 2,000 lbs.	72
35 Effects of Deproteinization and Crosslinking on Mean Wt. Diameters of Starch Aggregates...	75
36 Effects of Deproteinization and Crosslinking on Angles of Repose of Starch Aggregates....	75
37 Effects of Deproteinization and Crosslinking on Hardness of Starch Aggregates Tablets compressed at 1,000, 1,500, and 2,000 lbs..	78
38 Effects of Deproteinization and Crosslinking on Disintegration Time of Starch Aggregates Tablets compressed at 1,000, 1,500, and 2,000 lbs.....	78
39 Brabender Viscosity Curve of Rice Flour (native).....	83
40 Brabender Viscosity Curve of Rice Flour, Crosslinked 2 hrs.	85

Figure(Cont.)	Page
41 Brabender Viscosity Curve of Rice Flour, Crosslinked 6 hrs.	86
42 Brabender Viscosity Curve of Rice Flour, Crosslinked 10 hrs.	87
43 Brabender Viscosity Curve of Deproteinized Rice Flour.....	88
44 Brabender Viscosity Curve of Deproteinized Rice Flour, Crosslinked 2 hrs.....	90
45 Brabender Viscosity Curve of Deproteinized Rice Flour, Crosslinked 6 hrs.....	91
46 Brabender Viscosity Curve of Deproteinized Rice Flour, Crosslinked 10 hrs.....	92
47 Viscosities of Rice Flour at 40 C (Native & Deproteinized) at various crosslinking times.	94
48 Swelling Powers of Rice Flour (Native & Deproteinized) at various crosslinking times.	94
49 Differential Thermal Analysis of Various Starches.....	97
50 Photomicrograph of Rice Flour (Native) A x 100 B x 500.....	99
51 Photomicrograph of Starch Aggregates (30 % Conc., FR.12.96 g/min, Temp.130 °C, P.1.5 bar) A x 150 B x 1000.....	100

Figure(Cont.)	Page
52 Photomicrograph of Starch Aggregates (40 % Conc., FR.12.96 g/min, Temp.130 °C, P.1.5 bar) A x 150 B x 1000.....	101
53 Photomicrograph of Starch Aggregates (50 % Conc., FR.12.96 g/min, Temp.130 °C, P.1.5 bar) A x 150 B x 1000.....	103
54 Photomicrograph of Starch Aggregates (50 % Conc., FR.12.96 g/min, Temp.135 °C, P.1.5 bar) A x 150 B x 1000.....	104
55 Photomicrograph of Starch Aggregates, Crosslinked 2 hrs. (the same conditions as Fig.56) A x 100 B x 350.....	105
56 Photomicrograph of Starch Aggregates, Crosslinked 6 hrs. (the same conditions as Fig.56) A x 100 B x 500.....	106
57 Photomicrograph of Starch Aggregates, Crosslinked 10 hrs. (the same conditions as Fig.56) A x 100 B x 500 C x 3500.....	107
58 Photomicrograph of Starch ^R 1500 A x 100 B x 500.....	109

Figure(Cont..)	Page
59 Photomicrograph of Eratab ^R A x 100 B x 500 C x 3500.....	110
60 Photomicrograph of Deproteinized Starch Aggregates A x 100 B x 500.....	112
61 Photomicrograph of Starch Aggregates (Deproteinized & crosslinked 2 hrs.) A x 100 B x 500.....	113
62 Photomicrograph of Starch Aggregates (Deproteinized & crosslinked 6 hrs.) A x 100 B x 500.....	114
63 Photomicrograph of Starch Aggregates (Deproteinized & Crosslinked 10 hrs.) A x 100 B x 500 C x 3500 D x 7500.....	115
64 Particle Size Distribution of Starch Aggregates prepared by spraying at inlet air temperature 130 °C (Conc. 50 %, F.R. 12.96 g./min., P. 1.5 bar).....	117
65 Particle Size Distribution of Starch Aggregates prepared by spraying at inlet air temperature 135 °C (Conc. 50 %, F.R. 12.96 g./min., P. 1.5 bar).....	117

Figure(Cont.)

Page

66	Particle Size Distribution of Starch Aggregates prepared by spraying at feed rate 4.32 g./min. (Conc. 50 %, Temp. 130 °C, P. 1.5 bar).....	120
67	Particle Size Distribution of Starch Aggregates prepared by spraying at feed rate 21.60 g./min. (Conc. 50 %, Temp. 130 °C, P. 1.5 bar).....	120
68	Particle Size Distribution of 2-hrs. crosslinked Starch Aggregates (the same conditions as Figure 67).....	121
69	Particle Size Distribution of 6-hrs. crosslinked Starch Aggregates (the same conditions as Figure 67).....	121
70	Particle Size Distribution of 10-hrs. crosslinked Starch Aggregates (the same conditions as Figure 67).....	123
71	Particle Size Distribution of Deproteinized Starch Aggregates (Conc. 50 %, Temp. 135 °C, F.R. 21.6 g./min., P. 1.5 bar).....	123
72	Particle Size Distribution of Deproteinized and 2-hrs. Crosslinked Starch Aggregates (the same conditions as Fig.73).....	124

Figure(Cont.)

	Page
73 Particle Size Distribution of Deproteinized and 6-hrs. Crosslinked Starch Aggregates (the same conditions as Fig.73).....	124
74 Particle Size Distribution of Deproteinized and 10-hrs. Crosslinked Starch Aggregates (the same conditions as Fig.73).....	126
75 Particle Size Distribution of Starch 1500 ^R ...	126
76 Particle Size Distribution of Eratab ^R	127
77 Diagram of Flash Dryer (Perry & Chilton, 1973).....	135
78 Comparison of Hardness of Starch Aggregates Tablets prepared by various types of Modification.....	151

LIST OF ABBREVIATIONS

A.G.U.	Anhydroglucose unit(s)
A.O.R.	Angle of Repose
B.D.	Bulk Density
B.U.	Brabender Unit(s)
Cl.	Crosslinked
Cont.	Continued
Conc.	Concentration
D.P.	Deproteinized
DSC	Differential Scanning Calorimetry
D.T.	Disintegration Time
DTA	Differential Thermal Analysis
F.R.	Feed Rate
Fl.R.	Flow Rate
hrs.	hour(s)
g.	gram(s)
kp.	kilopond(s)
lb.	pound(s)
M.C.	Moisture Content
mg.	milligram(s)
min.	minute(s)
ml.	millilitre(s)
mm.	millimetre(s)

P.	Atomizing Pressure
S.A.	Starch Aggregates
S.D.	Standard Deviation
sec.	second(s)
S.E.M.	Scanning Electron Microscopy
T.	Time
T.D.	Tapped Density
Temp.	Temperature
um	micrometre(s)
Wt.	Weight
W/W	Weight by Weight
%	Percent
°C	degree Celsius