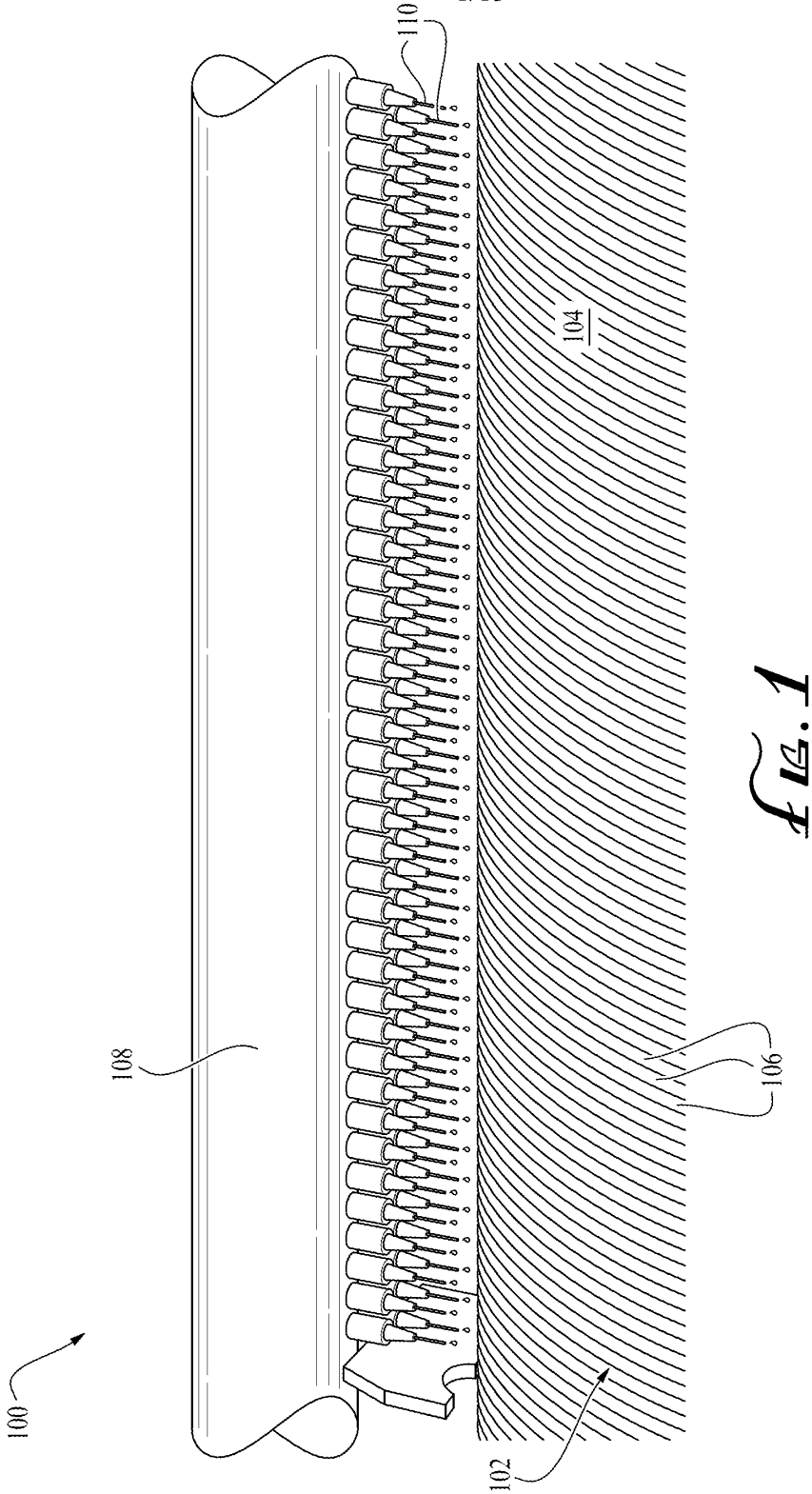


FIG. 1

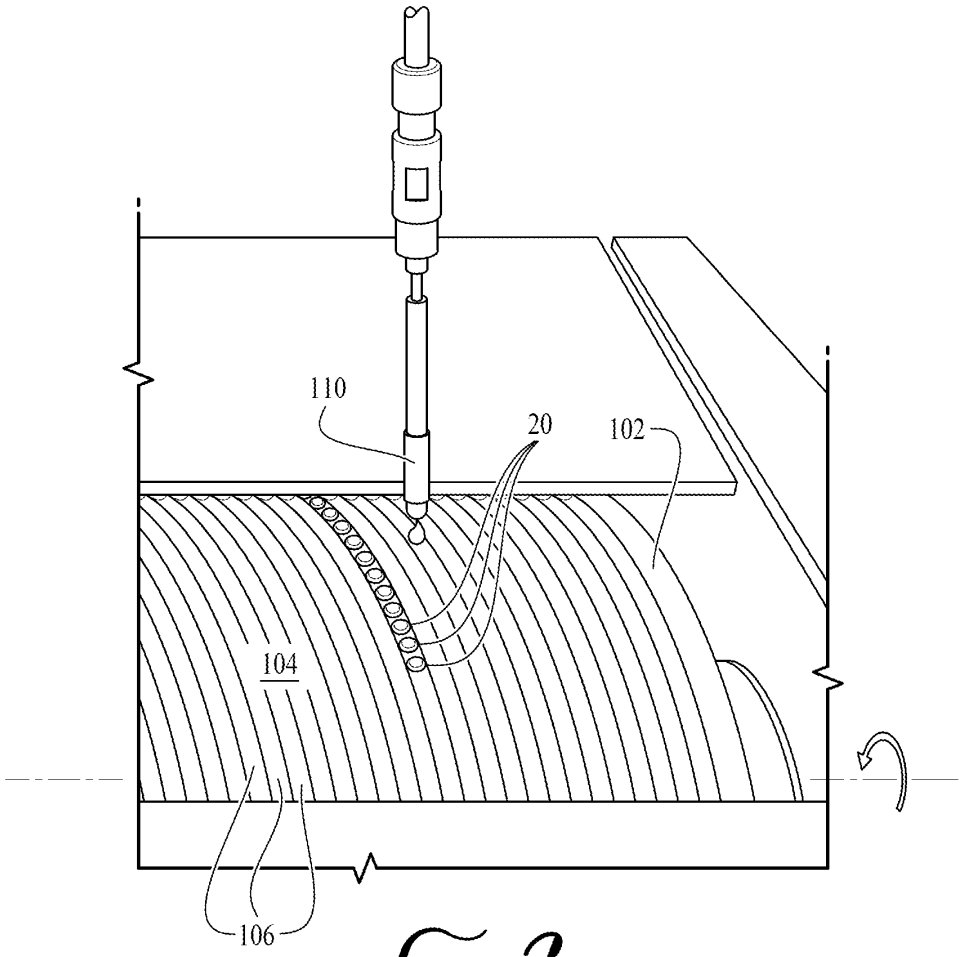


FIG. 2

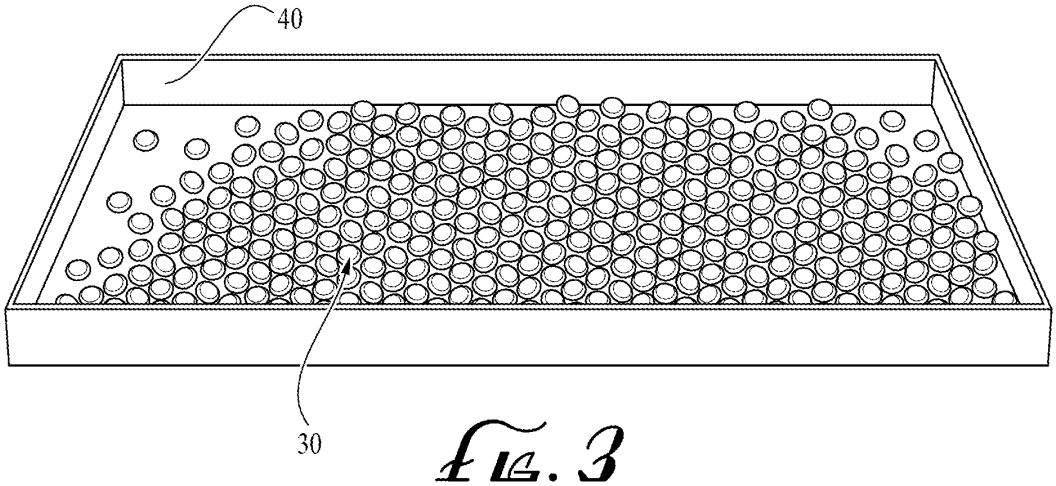


FIG. 3

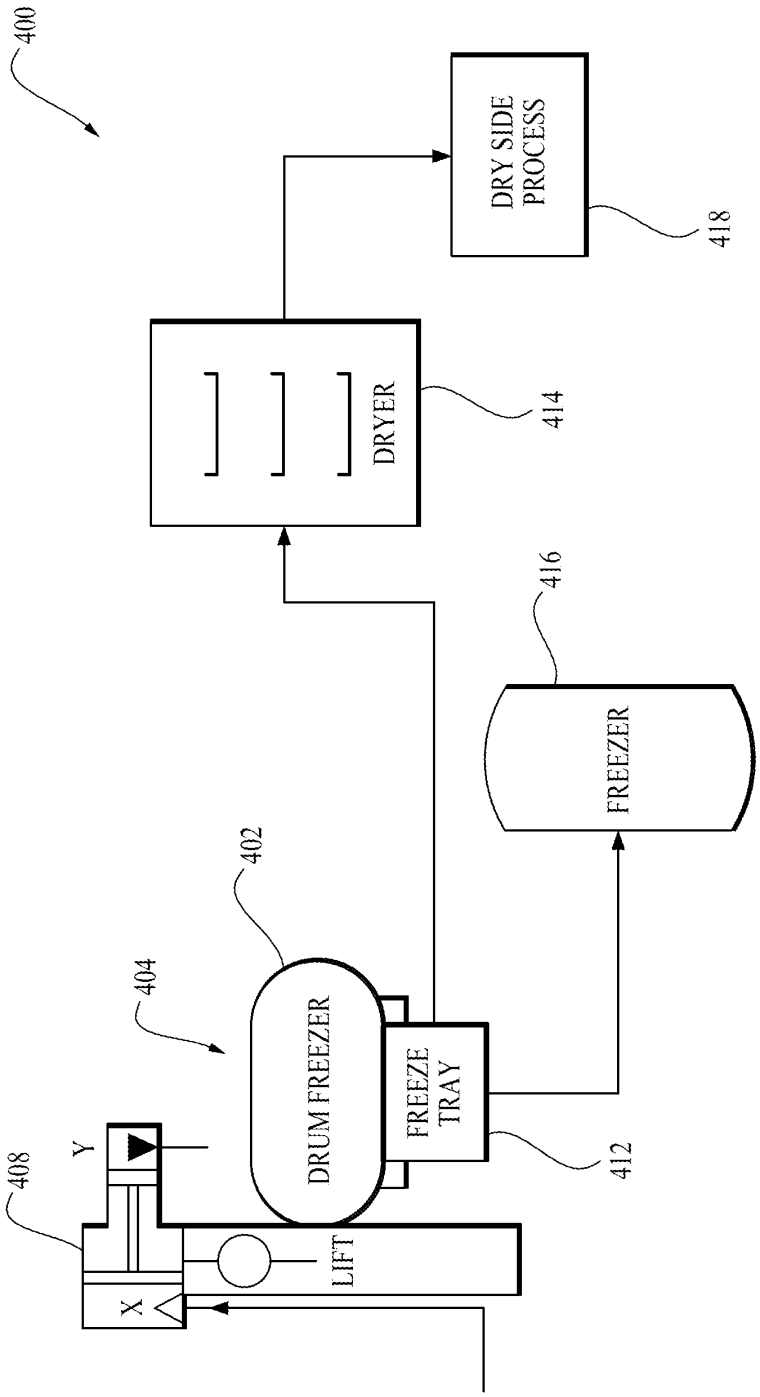

400
DRY SIDE PROCESS
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FREEZER
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FREEZE TRAY
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LIFT
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FIG. 4A

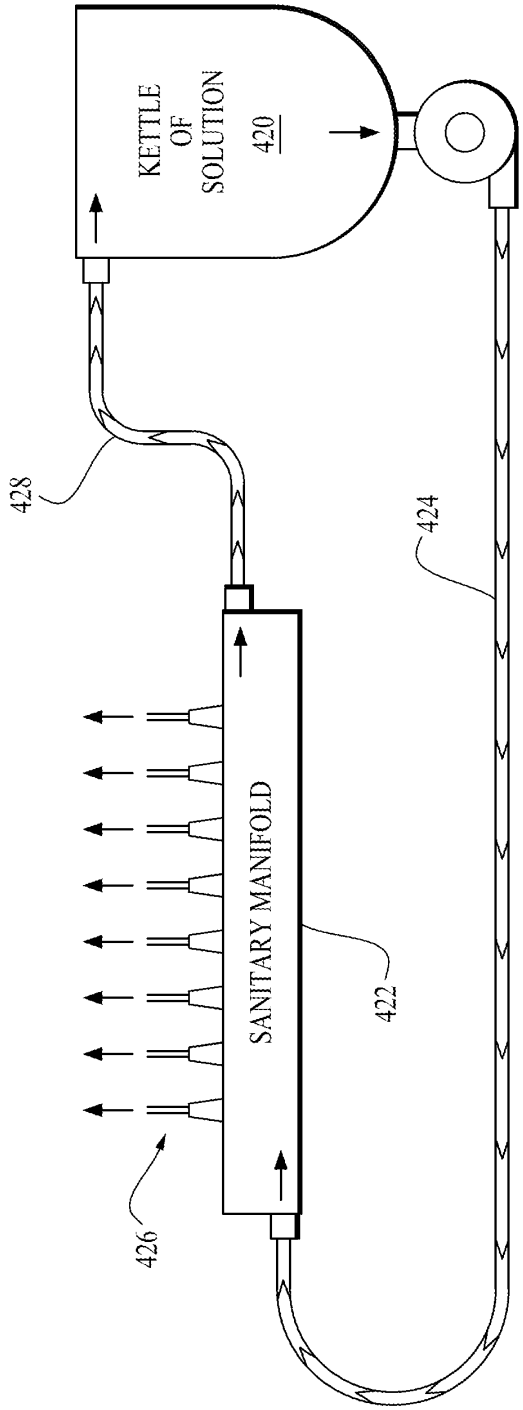


FIG. 4B

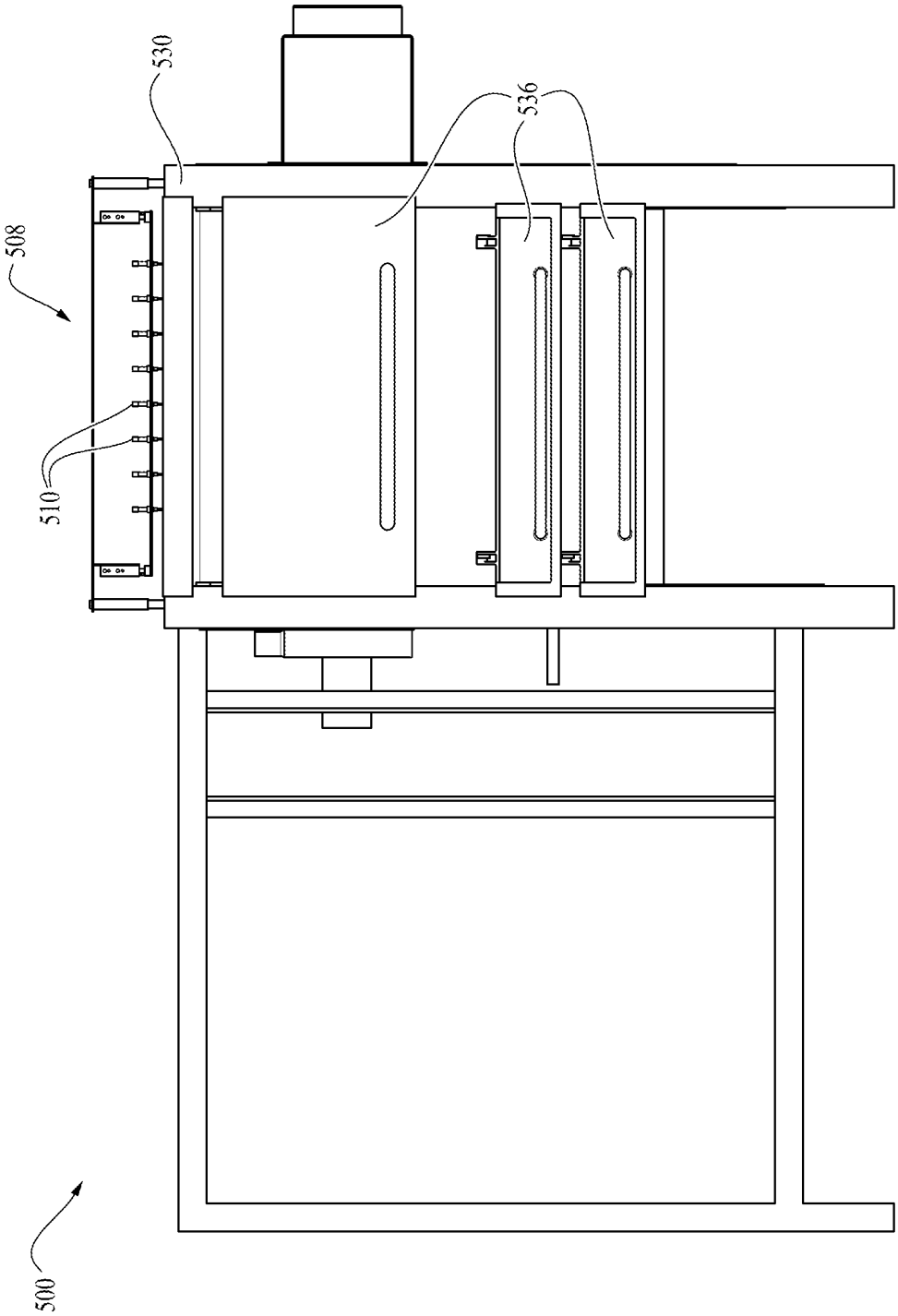


Fig. 5

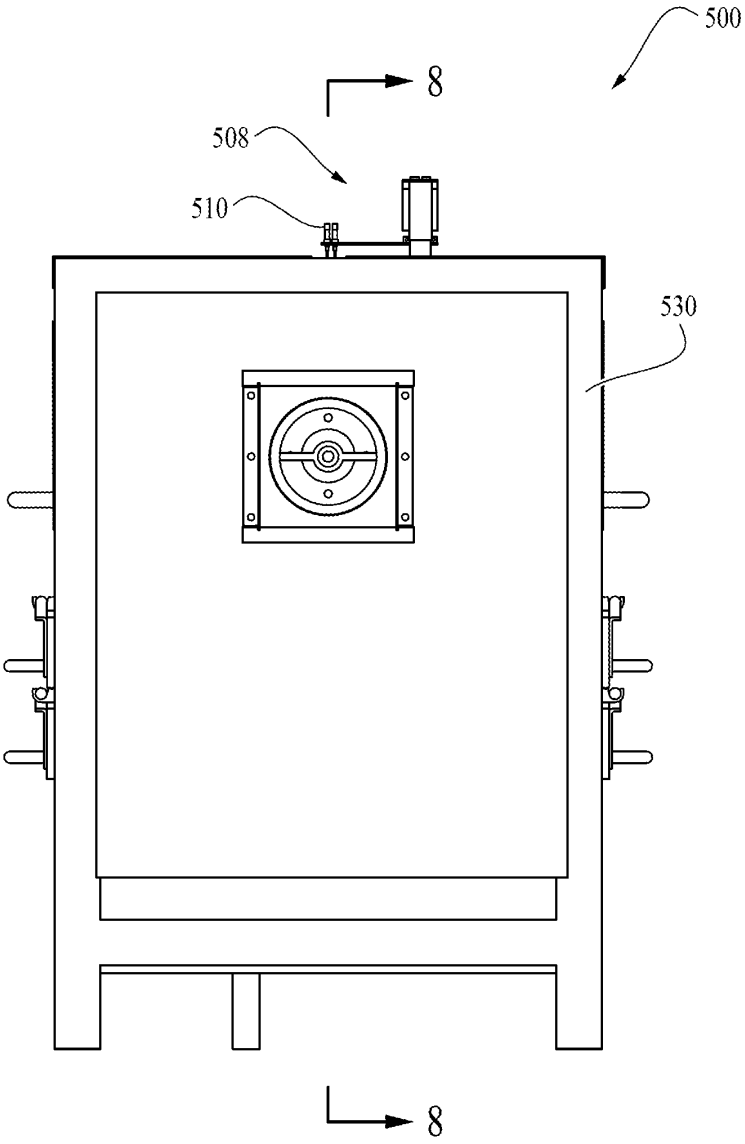


FIG. 6

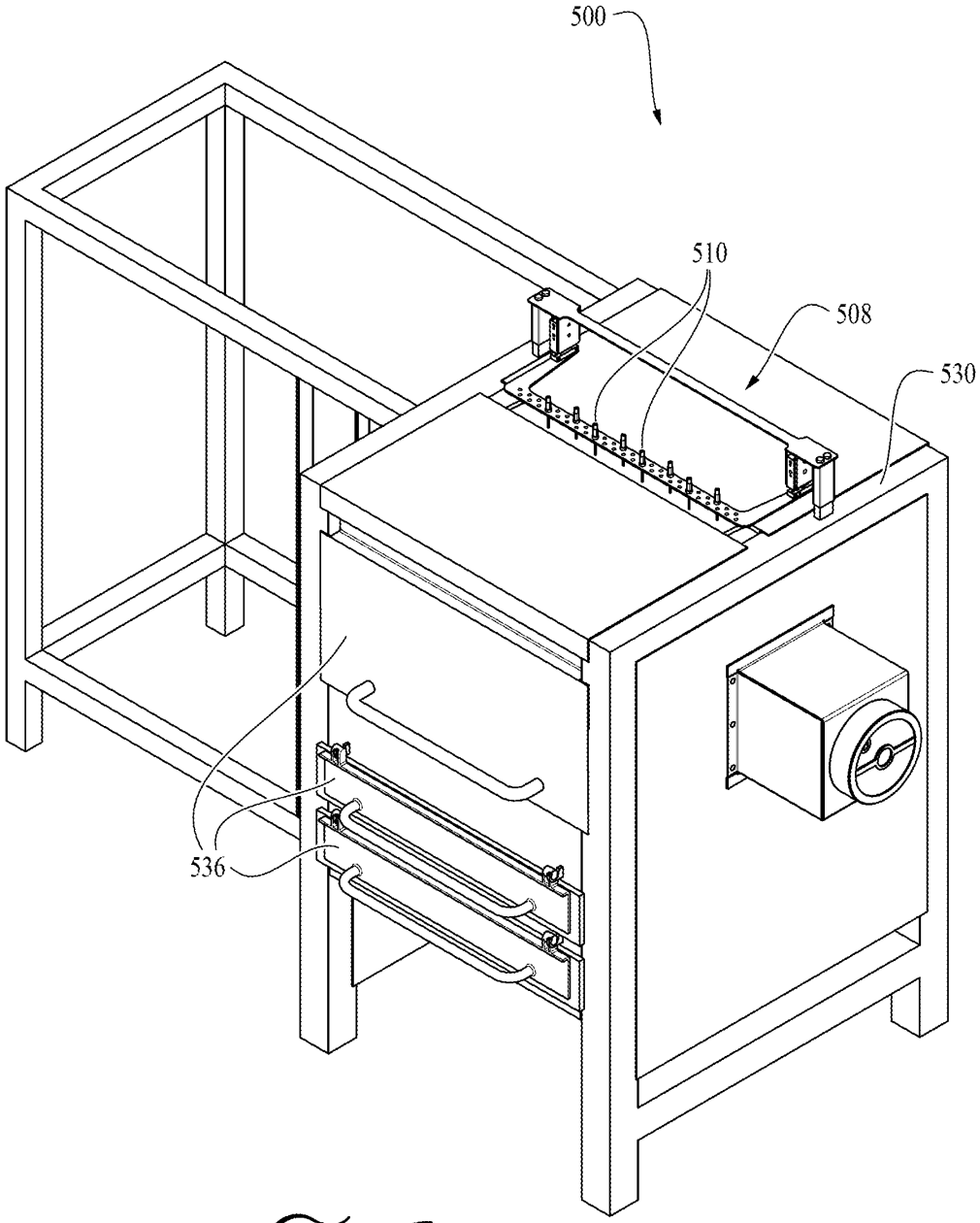


FIG. 7

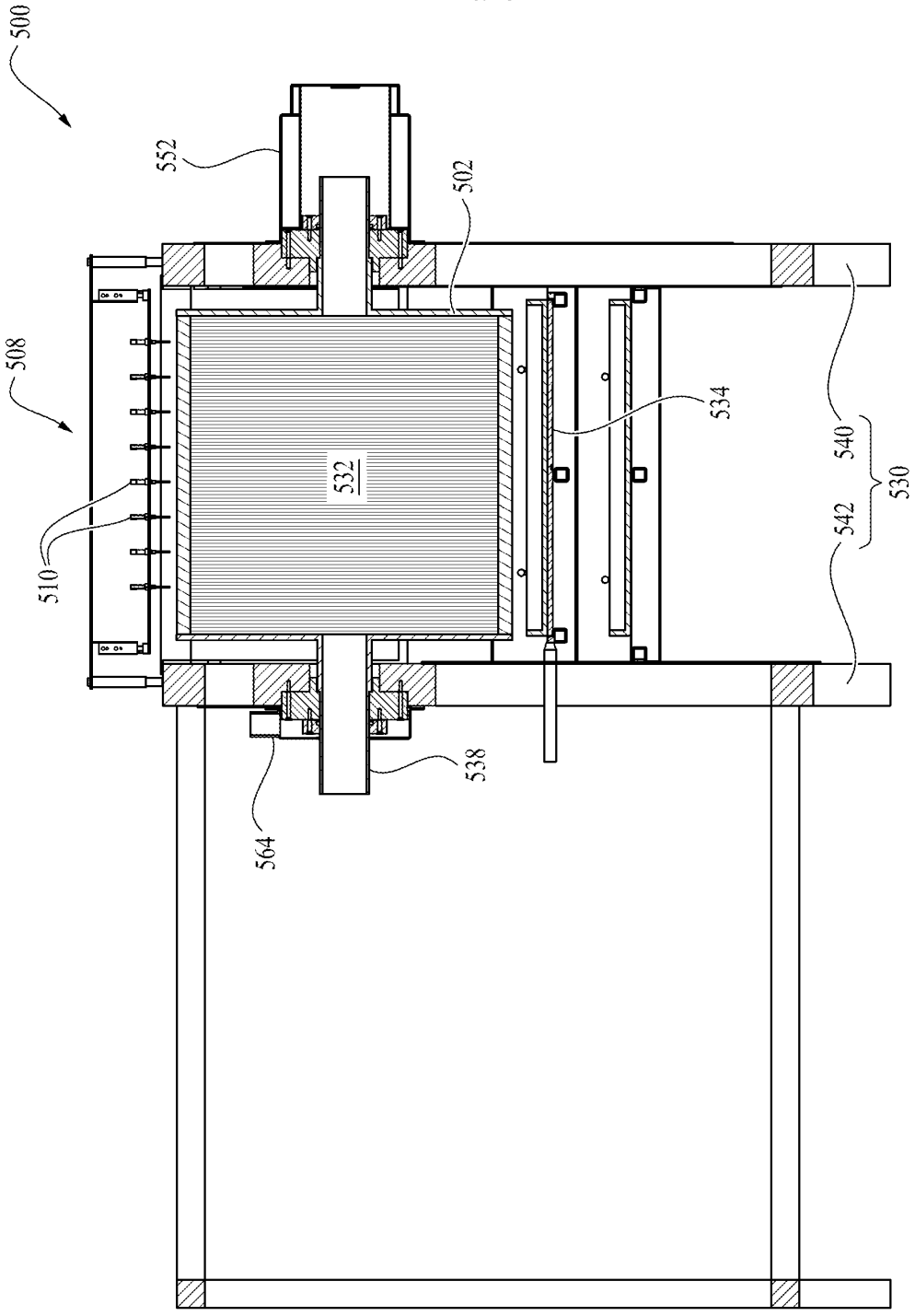


Fig. 8

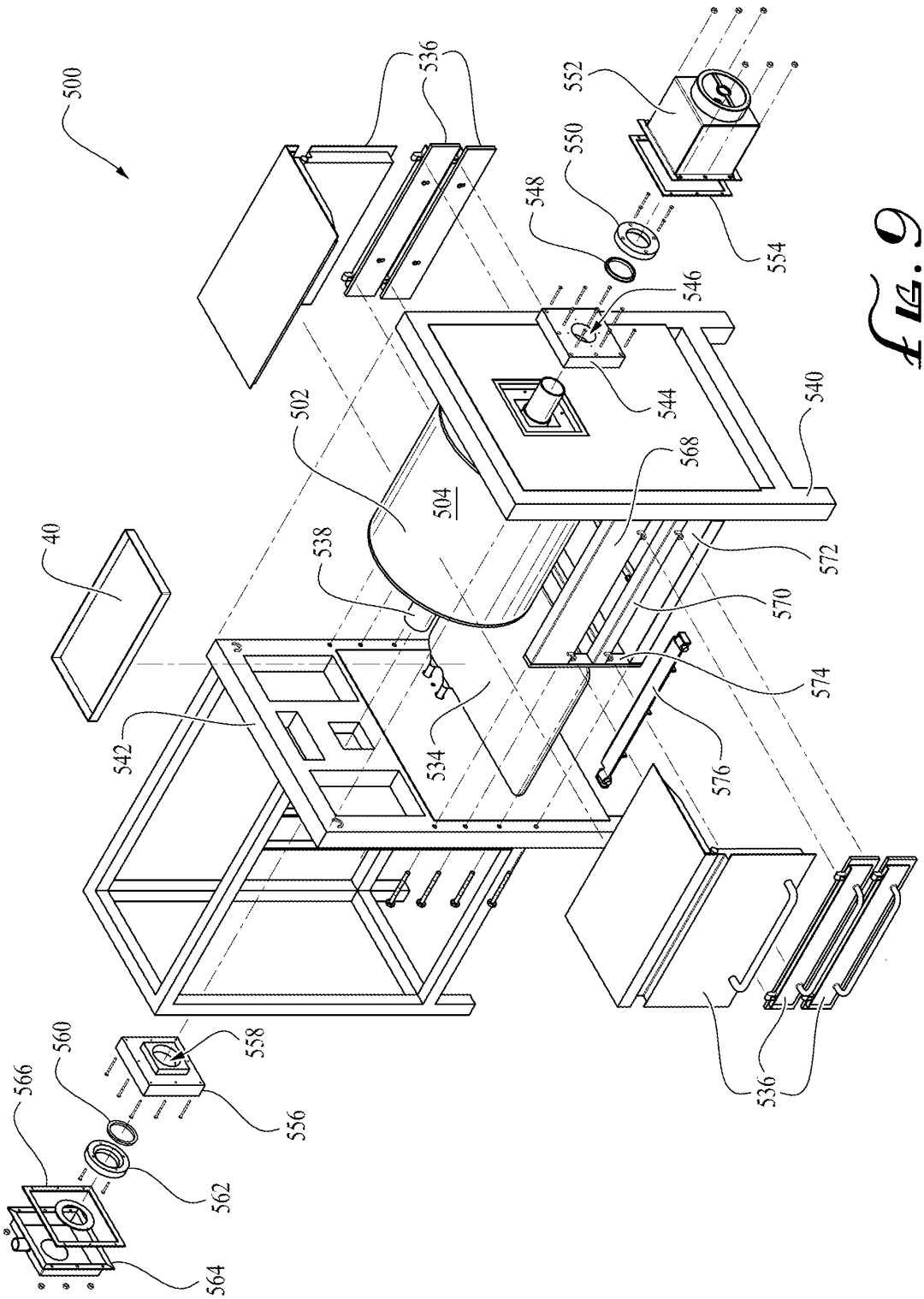

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Fig. 9

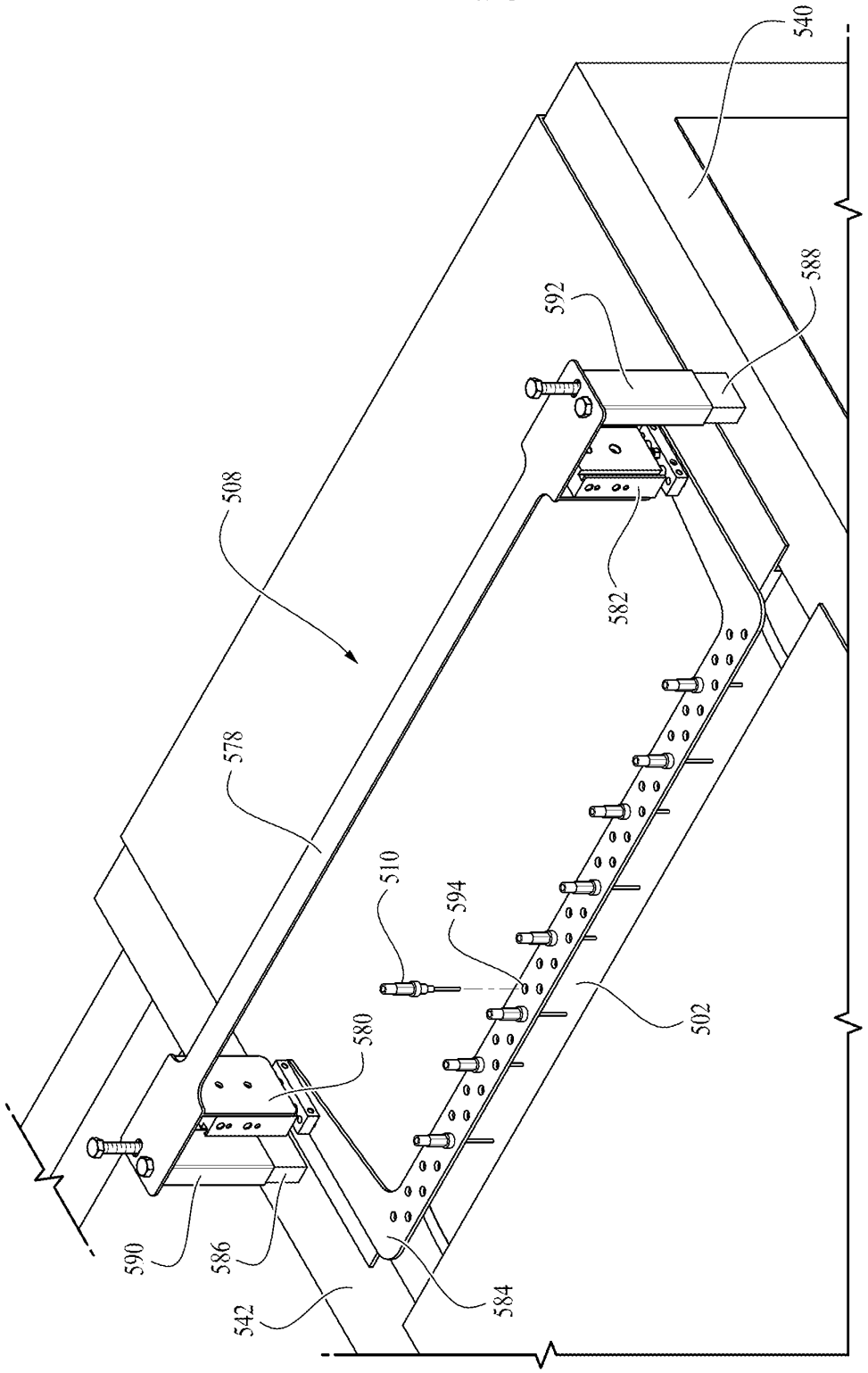


FIG. 10

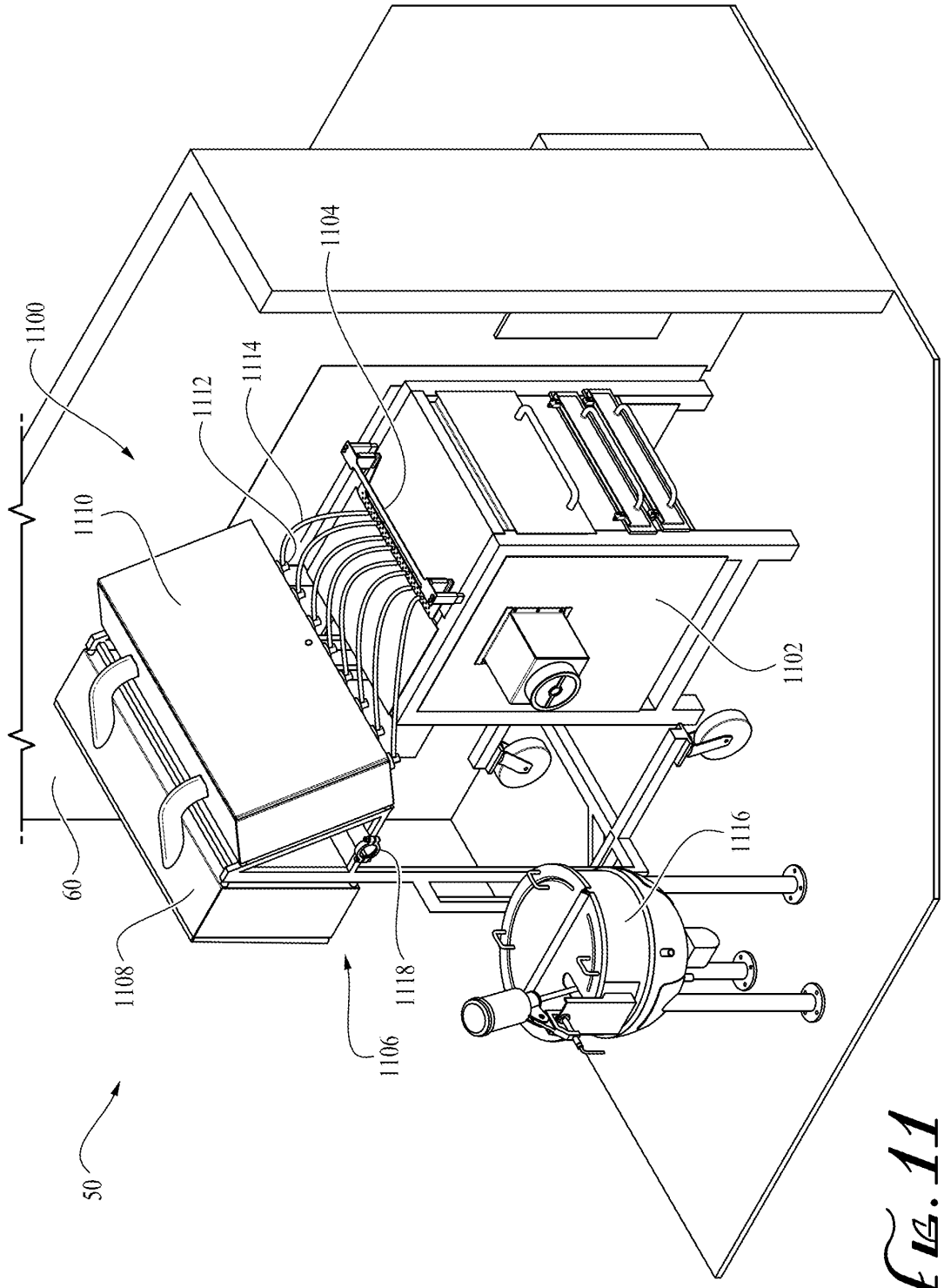


Fig. 11

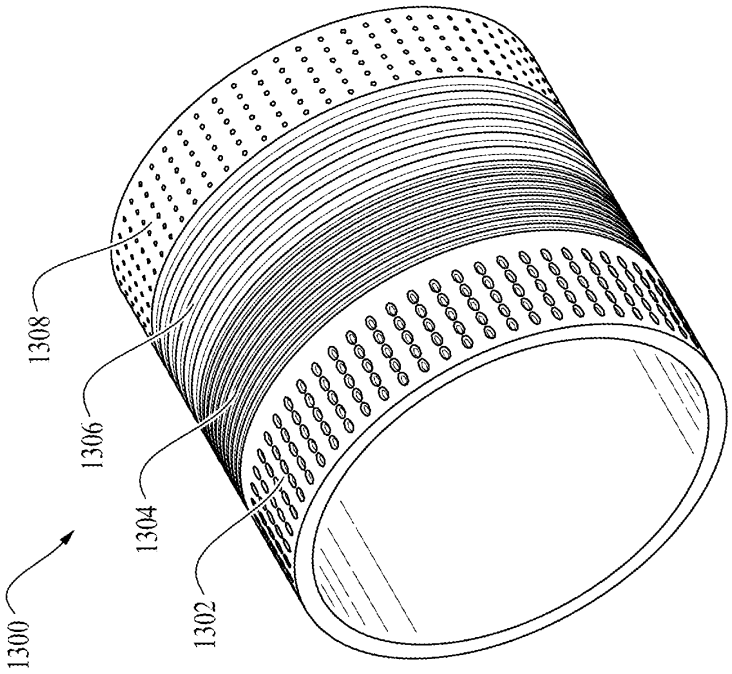


FIG. 13

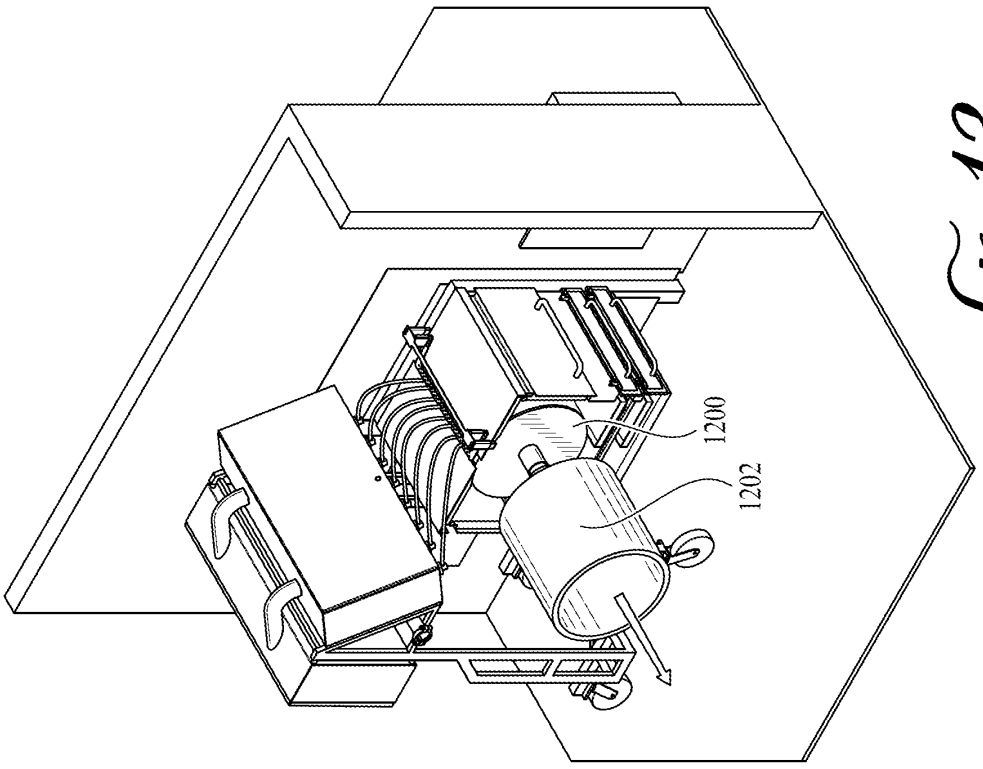


FIG. 12

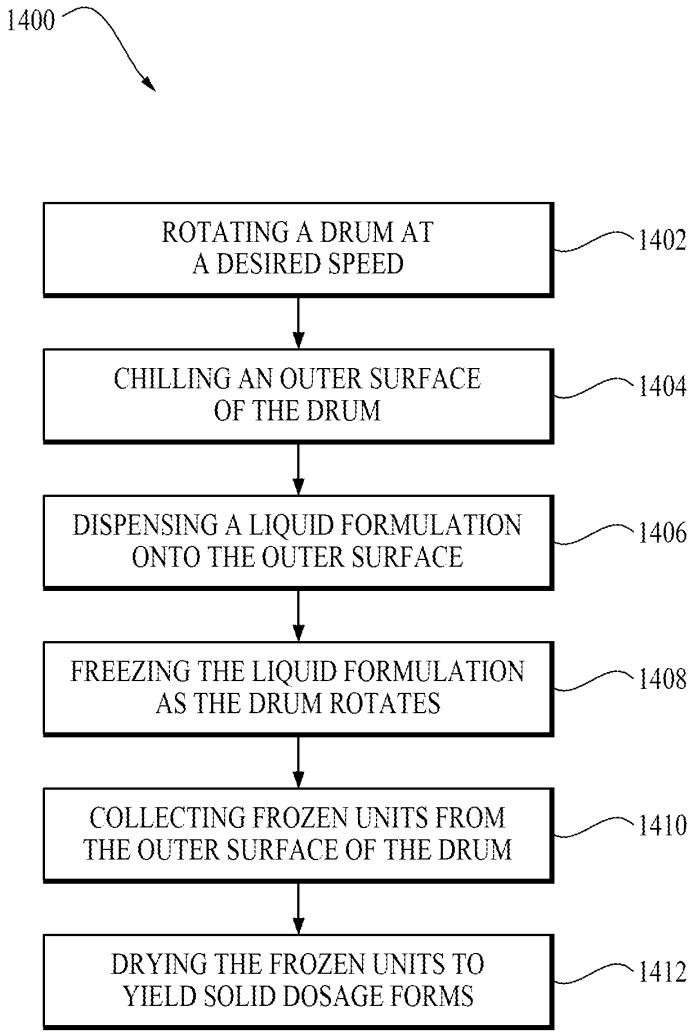

1400
ROTATING A DRUM AT A DESIRED SPEED
1402
CHILLING AN OUTER SURFACE OF THE DRUM
1404
DISPENSING A LIQUID FORMULATION ONTO THE OUTER SURFACE
1406
FREEZING THE LIQUID FORMULATION AS THE DRUM ROTATES
1408
COLLECTING FROZEN UNITS FROM THE OUTER SURFACE OF THE DRUM
1410
DRYING THE FROZEN UNITS TO YIELD SOLID DOSAGE FORMS
1412

FIG. 14