

## Contents

### Preface *xi*

|          |   |           |
|----------|---|-----------|
| <b>1</b> | <b>Introduction to Freeze-drying and Ice Templating</b>   | <b>1</b>  |
| 1.1      | Introduction  | 1         |
| 1.2      | The Freeze-drying Process   | 3         |
| 1.2.1    | Additives in the Solution   | 4         |
| 1.2.1.1  | Additives to Maintain Integrity/Activity of Biological Samples  | 4         |
| 1.2.1.2  | Lyoprotectants to Prevent Denaturation of Biopharmaceutics or Enhance Reconstitution of Pharmaceuticals | 5         |
| 1.2.1.3  | Stabilizer/Binders for Particulate Suspensions  | 5         |
| 1.2.2    | Optimizing the Freezing Stage   | 5         |
| 1.2.3    | Primary Drying in Freeze-drying   | 7         |
| 1.2.4    | Secondary Drying in Freeze-drying   | 9         |
| 1.3      | Ice Templating for Porous Structures  | 10        |
| 1.3.1    | Solutes or Particles  | 10        |
| 1.3.2    | Solvents  | 11        |
| 1.3.3    | Controlled Freezing   | 12        |
| 1.3.3.1  | Control Orientation of Ice Crystal Growth   | 12        |
| 1.3.3.2  | Ways of Freezing Samples  | 13        |
| 1.3.4    | Removal of Ice Crystal Templates  | 14        |
| 1.3.5    | Ice-templated Materials   | 15        |
| 1.3.5.1  | Shape and Form  | 15        |
| 1.3.5.2  | Pore Structure and Morphology   | 16        |
| 1.3.5.3  | Type of Materials   | 18        |
| 1.4      | The Practice in Our Laboratory  | 18        |
| 1.4.1    | Controlled Freezing   | 18        |
| 1.4.2    | Observation of Freezing and Freeze-drying   | 20        |
| 1.4.3    | Freeze-drying Procedure   | 22        |
|          | References  | 24        |
| <b>2</b> | <b>Fundamentals of Controlled Freezing for Ice-templated Porous Materials</b>                           | <b>29</b> |
| 2.1      | Introduction  | 29        |
| 2.2      | The Basics of Ice Crystals  | 30        |

|          |  |           |
|----------|--|-----------|
| 2.3      | Instruments and Techniques for Investigation of Freezing Aqueous Particulate Systems   | 32        |
| 2.3.1    | Optical Microscope Equipped with a Freezing Stage                                      | 33        |
| 2.3.2    | Optical Interferometry   | 34        |
| 2.3.3    | Cryogenic Transmission Electron Microscopy (CryoTEM)                                   | 35        |
| 2.3.4    | X-ray Radiography and Tomography   | 36        |
| 2.3.5    | Small Angle X-ray Scattering   | 38        |
| 2.4      | The Interactions Between a Particle and the Freezing Front                             | 41        |
| 2.4.1    | Basic Models and Equations for the Critical Freezing Velocity                          | 41        |
| 2.4.2    | Effects of Thermal Gradient, Particle Radius, and Viscosity on Critical Velocity       | 42        |
| 2.4.3    | Geometry and Interfacial-curvature Effects   | 44        |
| 2.5      | Morphology Instability at the Freezing Front   | 45        |
| 2.5.1    | Mullins–Sekerka Equation   | 45        |
| 2.5.2    | Linear Stability Analysis  | 47        |
| 2.5.3    | Morphology Zones and Stability Diagram   | 48        |
| 2.6      | Effect of Parameters on the Structure and Morphology of Ice-templated Materials        | 53        |
| 2.6.1    | Formulation of Solution/Suspensions  | 53        |
| 2.6.1.1  | Solutes or Particles   | 53        |
| 2.6.1.2  | Particle Size and Shape  | 53        |
| 2.6.1.3  | Concentration of Polymers or Particles   | 54        |
| 2.6.1.4  | Additive or Binder   | 54        |
| 2.6.1.5  | Solvent  | 55        |
| 2.6.1.6  | Emulsion   | 55        |
| 2.6.2    | Control of the Freezing Conditions   | 55        |
| 2.7      | Summary  | 56        |
|          | References   | 57        |
| <b>3</b> | <b>Applications of Freeze-drying in Pharmaceuticals, Biopharmaceuticals, and Foods</b> | <b>63</b> |
| 3.1      | Introduction   | 63        |
| 3.2      | Excipients in Pharmaceutical Formulations  | 63        |
| 3.3      | Improving the Freeze-drying Process  | 66        |
| 3.3.1    | The Types of Freeze-drying Processes   | 67        |
| 3.3.1.1  | Spray Freeze-drying Process  | 67        |
| 3.3.1.2  | Spin Freezing  | 68        |
| 3.3.1.3  | Atmospheric Freeze-drying  | 68        |
| 3.3.2    | Process Development and Design   | 68        |
| 3.4      | Applications of Freeze-drying in Pharmaceutics   | 71        |
| 3.4.1    | Spray Freeze-drying  | 72        |
| 3.4.2    | Orally Disintegrating Tablets (ODTs)   | 73        |
| 3.4.3    | Floating Drug Delivery System  | 73        |
| 3.4.4    | Emulsion Freeze-drying   | 74        |
| 3.5      | Applications of Freeze-drying in Biopharmaceutics                                      | 75        |
| 3.5.1    | The Freeze-drying Process for Biopharmaceutics   | 76        |
| 3.5.1.1  | During Freezing  | 76        |

|          |   |            |
|----------|---|------------|
| 3.5.1.2  | During Freeze-drying  | 77         |
| 3.5.1.3  | During Solid State Storage                                    | 78         |
| 3.5.2    | Biopharmaceutical Formulations                                | 81         |
| 3.5.2.1  | Peptide Formulations  | 82         |
| 3.5.2.2  | Protein Formulations  | 83         |
| 3.5.2.3  | Vaccine Formulations  | 85         |
| 3.5.2.4  | Nucleic Acid-based Formulations                               | 87         |
| 3.6      | Freeze-drying in Food Applications                            | 89         |
| 3.6.1    | Simple Freeze-drying  | 89         |
| 3.6.2    | Encapsulation   | 90         |
| 3.6.3    | Probiotic Foods   | 90         |
| 3.7      | Summary   | 92         |
|          | References  | 92         |
| <b>4</b> | <b>Porous Polymers by Ice Templating</b>                      | <b>103</b> |
| 4.1      | Introduction  | 103        |
| 4.2      | Porous Polymers by Freeze-drying of Solutions and Suspensions | 104        |
| 4.2.1    | Polymer Sponges   | 104        |
| 4.2.2    | Aligned Porous Polymers by Directional Freezing               | 106        |
| 4.2.2.1  | Water-based Systems   | 107        |
| 4.2.2.2  | Organic Solvent-based Systems                                 | 108        |
| 4.2.2.3  | Compressed CO <sub>2</sub> Solution                           | 110        |
| 4.2.3    | Nanofibrous Polymers  | 111        |
| 4.2.4    | Combining Ice Templating and Other Templating Methods         | 112        |
| 4.3      | Hydrogels and Crosslinked Porous Polymers                     | 114        |
| 4.3.1    | Hydrogels By a Freeze–thaw Process                            | 114        |
| 4.3.2    | Macroporous Cryogels  | 116        |
| 4.3.3    | Aligned Porous Materials By Frozen Polymerization             | 118        |
| 4.3.4    | Post-freeze-drying Crosslinking                               | 120        |
| 4.4      | Applications  | 121        |
| 4.4.1    | Biocompatibility and Tissue Engineering                       | 121        |
| 4.4.2    | Controlled Drug Release                                       | 124        |
| 4.4.3    | Encapsulation   | 125        |
| 4.4.4    | Water Treatment   | 127        |
| 4.4.5    | Liquid Chromatography and Separation                          | 129        |
| 4.4.6    | Other Applications  | 130        |
| 4.5      | Summary   | 130        |
|          | References  | 131        |
| <b>5</b> | <b>Porous Ceramics and Metals by Ice Templating</b>           | <b>141</b> |
| 5.1      | Introduction  | 141        |
| 5.2      | Porous Ceramics by Ice Templating                             | 142        |
| 5.2.1    | Effect of Formulations  | 142        |
| 5.2.1.1  | Ceramic Particles   | 142        |
| 5.2.1.2  | Solvent   | 145        |
| 5.2.1.3  | Dispersant or Stabilizer                                      | 146        |
| 5.2.1.4  | Binder  | 147        |

|          |  |            |
|----------|--|------------|
| 5.2.1.5  | Additives  | 147        |
| 5.2.2    | Freezing Conditions  | 150        |
| 5.2.2.1  | Modes of Processing and Freezing   | 150        |
| 5.2.2.2  | Freezing Velocities  | 157        |
| 5.3      | Porous Ceramics by Gelation-Freeze-Casting                                       | 158        |
| 5.3.1    | Gelation with Gelatin  | 158        |
| 5.3.2    | Photopolymerization (or Photocuring) of Frozen Slurry                            | 158        |
| 5.3.3    | Polymerization (or Gelation) of Slurry   | 159        |
| 5.4      | Porous Ceramics via Cryo-Sol-Gelation  | 159        |
| 5.5      | Porous Metals via Ice templating   | 162        |
| 5.6      | Applications of Ice-templated Ceramics   | 163        |
| 5.6.1    | Filtration/Gas Permeation  | 163        |
| 5.6.2    | Thermal Insulator  | 163        |
| 5.6.3    | Bioceramics  | 165        |
| 5.6.4    | Electric/electrode Materials   | 166        |
| 5.6.5    | Catalysis  | 167        |
| 5.7      | Summary  | 168        |
|          | References   | 169        |
| <b>6</b> | <b>Strong and Tough Ceramic Composites via Ice Templating</b>                    | <b>177</b> |
| 6.1      | Introduction   | 177        |
| 6.1.1    | Enhanced Applications by Ceramic Composites                                      | 177        |
| 6.1.2    | Processing and Mechanical Behaviour of Ceramic Composites                        | 179        |
| 6.2      | Mechanical Characterizations of Ceramic Composites                               | 182        |
| 6.2.1    | Strength   | 182        |
| 6.2.2    | Hardness   | 185        |
| 6.2.3    | Fracture Mechanics and Fracture Toughness  | 186        |
| 6.2.4    | Toughening Mechanism in Ceramics and Ceramic Composites                          | 187        |
| 6.3      | Porous Ceramic/Polymer Composites  | 189        |
| 6.3.1    | Hydroxyapatite (HA)-based Composites   | 191        |
| 6.3.2    | Clay-based Composites  | 193        |
| 6.4      | Porous Ceramic–Ceramic Composites  | 196        |
| 6.5      | Nacre-like Layered Ceramic–Polymer Composites                                    | 198        |
| 6.5.1    | Nacre and Nacre-mimic Composites   | 198        |
| 6.5.2    | Layered Polymer–Ceramic Composites by Infiltrating Ice-templated Porous Ceramics | 200        |
| 6.5.3    | Magnetic Field-assisted Freeze-casting for Strong Composites                     | 207        |
| 6.6      | Nacre-like Ceramic/Metal Composites  | 209        |
| 6.7      | Enamel-mimic Ceramic–Polymer Composites  | 211        |
| 6.8      | Ceramic–Ceramic Composites with the Second Nanoscale Ceramic Phase               | 214        |
| 6.9      | Tough and Functional Composites  | 216        |
| 6.10     | Summary  | 218        |
|          | References   | 219        |

|          |   |            |
|----------|---|------------|
| <b>7</b> | <b>Porous Carbon and Carbon-based Materials via Ice Templating and Freeze-drying</b>                | <b>229</b> |
| 7.1      | Introduction  | 229        |
| 7.2      | Carbon Cryogels and Ice-templated Carbons   | 230        |
| 7.2.1    | Carbon Cryogels   | 230        |
| 7.2.2    | Ice-templated Carbons   | 237        |
| 7.3      | Carbon Nanofibres   | 241        |
| 7.4      | Carbon Nanotubes (CNTs) and CNT-based Materials   | 245        |
| 7.4.1    | Introduction to CNTs  | 245        |
| 7.4.2    | CNT Aerogels/Cryogels   | 246        |
| 7.4.3    | CNT-based Porous Materials  | 247        |
| 7.5      | Porous Graphene Networks and Graphene-based Materials   | 250        |
| 7.5.1    | Graphene and 3D Graphene Networks   | 250        |
| 7.5.2    | Porous Graphene by Ice Templating/Freeze-drying   | 251        |
| 7.5.3    | Graphene-based or Graphene-containing Materials by Ice Templating                                   | 258        |
| 7.6      | Porous Graphene/CNT Hybrid Structures   | 261        |
| 7.7      | Summary   | 264        |
|          | References  | 265        |
| <b>8</b> | <b>Nanomedicine via Freeze-drying and Ice Templating</b>  | <b>277</b> |
| 8.1      | Introduction  | 277        |
| 8.2      | Poorly Water-soluble Drugs and Drug Classifications   | 277        |
| 8.3      | Nanoformulation Approaches for Poorly Soluble Drugs   | 280        |
| 8.4      | Bioavailability and Delivery of Drug Nanoparticles  | 284        |
| 8.4.1    | The Absorption Process  | 284        |
| 8.4.1.1  | The Orally Administering Route  | 285        |
| 8.4.1.2  | Absorption in Lung by Pulmonary Delivery  | 288        |
| 8.4.2    | Nanoparticle Clearance and Distribution   | 289        |
| 8.4.3    | Metabolism and Excretion  | 291        |
| 8.4.4    | Nanoparticle Toxicology   | 293        |
| 8.5      | Freeze-drying of Solutions/Suspensions for Nanomedicine   | 294        |
| 8.6      | Emulsion-Freeze-drying for Drug Nanoparticles   | 295        |
| 8.7      | Solvent Evaporation Within Porous-Soluble Polymers  | 301        |
| 8.8      | Summary   | 303        |
|          | References  | 304        |
| <b>9</b> | <b>Nanostructured Materials Fabricated via Ice Templating of Colloidal/Nanoparticle Suspensions</b> | <b>313</b> |
| 9.1      | Introduction  | 313        |
| 9.2      | Cellulose Nanofibres (CNFs) and Cellulose Nanocrystals (CNCs)                                       | 314        |
| 9.3      | Nanoparticles and Colloids  | 318        |
| 9.4      | Nanowires and Nanofibres  | 323        |
| 9.5      | Platelets and Nanosheets  | 323        |
| 9.6      | Mixing Colloids and Core–Shell Nanoparticles  | 325        |
| 9.7      | Summary   | 327        |
|          | References  | 328        |

|           |  |            |
|-----------|--|------------|
| <b>10</b> | <b>Other Developments and Perspectives in the Fabrication of New Materials Facilitated by Freezing and Freeze-drying</b> | <b>333</b> |
| 10.1      | Combining Ice-templating and Other Techniques  | 333        |
| 10.1.1    | Ice Templating and Emulsion Templating   | 333        |
| 10.1.2    | Gelation/Crosslinking and Ice Templating   | 335        |
| 10.1.3    | Ice Templating with Green Solvents   | 336        |
| 10.2      | Freezing-induced Self-assembly   | 337        |
| 10.3      | Reaction and Polymerization in Frozen Solutions  | 337        |
| 10.4      | Ice-templated Hierarchically Porous Materials Containing Micropores  | 341        |
| 10.5      | General Summary and Perspectives   | 344        |
|           | References   | 345        |
|           | <b>Index</b>   | <b>349</b> |