We claim:

1. A solid oral dosage form comprising a plurality of particles, each particle comprising a core comprising an active agent susceptible to abuse and an internal adhesion promoter, wherein the cores are (i) dispersed in a matrix comprising a controlled release material or (ii) coated with a controlled release material.
2. The solid oral dosage form of claim 1, wherein the core further comprises a dissolution enhancer.
3. The solid oral dosage form of any of claims 1 or 2, wherein the coating or matrix further comprises a pore former, preferably sodium chloride.
4. The solid oral dosage form of any of claims 1-3, further comprising an alcohol resistant material.
5. The solid oral dosage form of any of claims 1-4, further comprising an external adhesion promoter to promote the adhesion of the alcohol resistant material and the controlled release material.
6. The solid oral dosage form of any of claims 1-5, wherein the controlled release material is a polymer, preferably an acrylic polymer, preferably a neutral acrylic polymer.
7. The solid oral dosage form of any of claims 1-6, wherein the internal adhesion promoter is selected from the group consisting of a carbomer, a cellulosic material, preferably hydroxypropylmethylcellulose, a surfactant, preferably a non-ionic surfactant, preferably selected from the group consisting of nonoxynol, a sorbitan ester and a mixture thereof.

# The solid oral dosage form of claim 2, wherein the dissolution enhancer is a cellulosic material, a sugar, a starch or a polymer, preferably an alkylcellulose, preferably methylcellulose.

1. The solid oral dosage form of claim 3, wherein the pore former is a polysaccharide, a polymer, an organic solvent or an inorganic material, preferably selected from the group consisting of sodium chloride, lactose, dextrose, mannitol, microcrystalline cellulose, methylcellulose and a mixture thereof.
2. The solid oral dosage form of claim 4, wherein the alcohol resistant material is a cellulosic material, preferably an alkylcellulose, preferably methylcellulose.
3. The solid oral dosage form of claim 5, wherein the external adhesion promoter is selected from the group consisting of a carbomer, a cellulosic material, preferably hydroxypropylmethylcellulose, a surfactant, preferably a non-ionic surfactant, preferably selected from the group consisting of a nonoxynol, a sorbitan ester and a mixture thereof.
4. The solid oral dosage form of any of claims 1-11, wherein the particles are contained in a pharmaceutically acceptable capsule or compressed into a tablet.
5. The solid oral dosage form of any of claims 4 or 10, wherein the active agent and internal the adhesion promoter are granulated to form core granules, preferably wherein the cores are mixed, granulated or coated with the controlled release material to obtain controlled release particles, preferably wherein the controlled release particles are mixed, granulated or coated with the alcohol resistant material to obtain alcohol resistant controlled release particles, preferably wherein the alcohol resistant controlled release particles are compressed into a tablet.
6. The solid oral dosage form of any of claims 12 or 13, wherein the tablet has a breaking strength of less than 400N.
7. The solid oral dosage form of any of claims 1-14, wherein the weight ratio of the active agent to the controlled release material is from about 2:1 to about 1:100.
8. The solid oral dosage form of any of claims 1-15, wherein the particles have a mean diameter from about 0.01 mm to about 3 mm.
9. The solid oral dosage form of any of claims 1-16, comprising from about 0.1 % to about 80% (w/w) active agent.
10. The solid oral dosage form of any of claims 1-17, comprising from about 10 % to about 90% (w/w) controlled release material.
11. The solid oral dosage form of any of claims 1-18, comprising from about 0.05 % to about 10% (w/w) internal adhesion promoter.
12. The solid oral dosage form of any of claims 2 or 8, comprising from about 1 % to about 40% (w/w) dissolution enhancer.
13. The solid oral dosage form of any of claims 3 or 9, comprising from about 0.5 % to about 25% (w/w) pore former.
14. The solid oral dosage form of any of claims 4 or 10 or 13, comprising from about 1 % to about 50% (w/w) alcohol resistant material.
15. The solid oral dosage form of any of claims 5 or 11, comprising from about 0.5 % to about 15% (w/w) external adhesion promoter.
16. The oral dosage form of any of claims 1-23, which provides a dissolution release rate in-vitro of the active agent, when measured by the USP Type 2, Paddle Method at 50 rpm in 900 ml Simulated Gastric Fluid (SGF) without enzymes at 37° C of at least about 15% by weight of the active agent released at 1 hour, from about 25% to about 65% by weight of the active agent released at 2 hours, from about 45% to about 85% by weight of the active agent released at 4 hours, and at least about 60% by weight of the active agent released at 8 hours.
17. The oral dosage form of any of claims 1-24, wherein the amount of active agent released at 0.5 hour, 1 hour, 2 hours or 4 hours when measured in a USP Type 2, Paddle Method at 50 rpm in 900 ml simulated gastric fluid (SGF) without enzymes with 40% ethanol at 37° C, is less than the amount of active agent released at the same time period when measured in a USP Type 2, Paddle Method at 50 rpm in 900 ml simulated gastric fluid without enzymes (SGF) with 0% ethanol at 37°.
18. The oral dosage form of any of claims 1-25, wherein the amount of active agent released from a crushed dosage form at 0.5 hour, 1 hour, 2 hours or 4 hours when measured in a USP Type 2, Paddle Method at 50 rpm in 900 ml simulated gastric fluid (SGF) without enzymes at 37° C, is within 50%, 40%, 30% or 20% of the amount of active agent released from an intact dosage form at the same time period when measured in a USP Type 2, Paddle Method at 50 rpm in 900 ml simulated gastric fluid without enzymes (SGF) with 0% ethanol at 37°.
19. The solid oral dosage form of any of claims 1-26, wherein the recovery of the active agent is less than about 50%, less than about 30%, or less than about 10% based on a syringability test whereby the dosage form is crushed and mixed with 5 or 10 mL solvent and the resultant solution is aspirated with a 18, 22, 25, or 27 gauge needle.
20. The solid oral dosage form of any of claims 1-27, wherein the active agent is selected from the group consisting of opioid agonists, tranquilizers, CNS depressants, CNS stimulants, sedative hypnotics, and mixtures thereof, preferably an opioid agonist, preferably selected from the group consisting of codeine, morphine, oxycodone, oxymorphone, hydrocodone, hydromorphone, pharmaceutically acceptable salts thereof, and mixtures thereof, preferably oxycodone, morphine and pharmaceutically acceptable salts thereof, preferably comprising from about 5 mg to about 320 mg oxycodone or a pharmaceutically acceptable salt thereof or from about 5 mg to about 250 mg morphine or a pharmaceutically acceptable salt thereof.
21. The solid oral dosage form of any of claims 1-28, further comprising an aversive agent, preferably selected from the group consisting of emetics, antagonists, bittering agents, irritants, gelling agents and mixtures thereof.
22. The solid oral dosage form of any of claims 1-29, wherein the ratio of extraction from an unheated extraction test at 10 minutes and/or 60 minutes to a corresponding heated extraction test is from about 1:50 to about 50:1; from about 1:40 to about 40:1; from about 1:30 to about 30:1; from about 1:20 to about 20:1; from about 1:10 to about 10:1; from about 1:5 to about 5:1; from about 1:4 to about 4:1; from about 1:3 to about 3:1; from about 1:2 to about 2:1; from about 1:1.5 to about 1.5:1; from about 1:1.3 to about 1.3:1 or from about 1:1.1 to about 1.1:11.