

Contents

Preface XIII

Part One Introduction 1

1 Biopharmaceutical Production: Value Creation, Product Types and Biological Basics 3

- 1.1 Role of Production in Pharmaceutical Biotechnology 3
- 1.1.1 Relationship between Production and Development 6
- 1.1.2 Relationship between Production and Marketing 8
- 1.2 Product Groups 10
- 1.2.1 Vaccines 11
- 1.2.2 Pharmaceuticals from Blood and Organs 13
- 1.2.3 Recombinant Therapeutic Proteins 13
- 1.2.4 Cell and Gene Therapeutics 13
- 1.2.5 Antibiotics 16
- 1.3 Basics of Biology 17
- 1.3.1 Cells and Microorganisms 17
- 1.3.1.1 Structure and Types of Cells 18
- 1.3.1.2 Metabolism 21
- 1.3.1.3 Reproduction and Aging 22
- 1.3.1.4 Viruses and Bacteriophages 23
- 1.3.1.5 Protein Biosynthesis 24
- 1.3.2 The Four Molecular Building Blocks of Biochemistry 26
- 1.3.2.1 Proteins 26
- 1.3.2.2 Nucleic Acids 31
- 1.3.2.3 Polysaccharides 31
- 1.3.2.4 Lipids 32

Part Two Technology 33

2 Manufacturing Process 35

- 2.1 Role of the Manufacturing Process in Biotechnology 35
- 2.2 Process Schematic and Evaluation 37

2.2.1	Drug Substance Manufacturing	38
2.2.2	Drug Product Manufacturing	40
2.2.3	Key Factors for Process Evaluation	41
2.3	Cell Bank	43
2.3.1	Expression Systems	43
2.3.1.1	Microbial Systems	43
2.3.1.2	Metazoan Systems	45
2.3.1.3	Transgenic Systems	46
2.3.2	Manufacturing and Storage of the Cell Bank	46
2.4	Fermentation	48
2.4.1	Basic Principles	48
2.4.1.1	Cell Growth and Product Expression	48
2.4.1.2	Comparison of Batch and Continuous Processes	50
2.4.1.3	Sterility and Sterile Technology	52
2.4.1.4	Comparison of Fermentation with Mammalian Cells and Microorganisms	54
2.4.2	Technologies and Equipment	55
2.4.2.1	Fermentation in Suspension Culture	55
2.4.2.2	Adherent Cell Cultures	56
2.4.2.3	Transgenic Systems	59
2.4.3	Raw Materials and Processing Aids	60
2.4.3.1	Nutrient Media	60
2.4.3.2	Water, Gases and Other Processing Aids	61
2.4.4	Overview of Fermentation	62
2.5	Purification	63
2.5.1	Basic Principles	64
2.5.1.1	Basic Pattern of Purification	64
2.5.1.2	Types of Impurities	68
2.5.1.3	Principles of Separation Technologies	70
2.5.2	Technologies for Cell Separation and Product Isolation	72
2.5.2.1	Cell Separation	72
2.5.2.2	Cell Disruption, Solubilization and Refolding	73
2.5.2.3	Concentration and Stabilization	75
2.5.3	Technologies for Final Purification	79
2.5.3.1	Chromatographic Processes	80
2.5.3.2	Precipitation and Extraction	88
2.5.3.3	Sterile Filtration and Virus Removal	89
2.5.4	Raw Materials and Processing Aids	90
2.5.4.1	Gels for Chromatography	90
2.5.4.2	Membranes for TFF	92
2.5.5	Overview of Purification	93
2.6	Formulation and Filling	95
2.6.1	Basic Principles	95
2.6.2	Freeze-Drying	97
2.7	Labeling and Packaging	98

3	Analytics	101
3.1	Role of Analytics in Biotechnology	101
3.2	Product Analytics	103
3.2.1	Identity	104
3.2.2	Content	106
3.2.3	Purity	106
3.2.4	Activity	107
3.2.5	Appearance	109
3.2.6	Stability	110
3.2.7	Quality Criteria of Analytical Methods	111
3.2.8	Analytical Methods	112
3.2.8.1	Amino Acid Analysis	113
3.2.8.2	Protein Sequencing	113
3.2.8.3	Peptide Mapping	114
3.2.8.4	Protein Content	114
3.2.8.5	Electrophoresis	115
3.2.8.6	Western Blot	117
3.2.8.7	HCP enzyme-linked immunosorbent assay (ELISA)	119
3.2.8.8	Analytical Chromatography	120
3.2.8.9	Infrared (IR) Spectroscopy	122
3.2.8.10	UV/Vis Spectroscopy	122
3.2.8.11	Mass Spectrometry	123
3.2.8.12	Glycoanalytics	124
3.2.8.13	PCR	124
3.2.8.14	DNA/RNA Sequencing	125
3.2.8.15	Endotoxins and Pyrogen Testing	126
3.2.8.16	Bioburden Test	126
3.2.8.17	Virus Testing	127
3.2.8.18	TEM	127
3.2.8.19	Circular Dichroism	127
3.2.8.20	Differential Scanning Calorimetry	128
3.3	Process Analytics	128
3.3.1	Fermentation	129
3.3.2	Purification	129
3.3.3	Formulation and Packaging	131
3.4	Environmental Monitoring	132
3.5	Raw Material Testing	133
3.6	Product Comparability	134

Part Three Pharmacy 137

4	Pharmacology and Drug Safety	139
4.1	Action of Drugs in Humans	140
4.1.1	Pharmacokinetics	141
4.1.2	Pharmacodynamics	144

4.1.2.1	Principles of Phenomenological Effects	145
4.1.2.2	Parameters of Drug Effects	146
4.2	Routes and Forms of Administration	148
4.3	Drug Study	149
4.3.1	Pre-Clinical Study	151
4.3.2	Clinical Study	152
4.3.2.1	Phases of Clinical Studies	153
4.3.2.2	Design and Conduct of Clinical Trials	155
4.4	Path of the Drug from the Manufacturer to Patients	158
4.5	Drug Safety	159
4.5.1	Causes and Classification of Side-Effects	160
4.5.2	Methods of Supervising Drug Safety (Pharmacovigilance)	162
4.5.3	Measures at Incidence of Adverse Reactions	162
Part Four Quality Assurance 165		
5 Fundamentals of Quality Assurance 167		
5.1	Basic Principles	167
5.2	Benefit of Quality Assurance Activities	167
5.3	Quality Management According to ISO 9000	169
5.3.1	Fields of Activity	169
5.4	Structure of Quality Management Systems	171
5.5	Quality Management System Components in the Pharmaceutical Area	173
5.5.1	Documentation	173
5.5.2	Failure Prevention and Correction	174
5.5.3	Responsibility of Management and Training of Personnel	178
5.5.4	Audits	179
5.5.5	External Suppliers	180
5.5.6	Contract Review	181
5.6	Quality Assurance in Development	181
6 Quality Assurance in Manufacturing 183		
6.1	GMP	183
6.1.1	Personnel	188
6.1.2	Premises and Equipment	189
6.1.2.1	Measures to Avoid External Contamination	189
6.1.2.2	Measures to Avoid Cross-Contamination and Product Confusion	192
6.1.3	Equipment Qualification	195
6.1.4	Process Validation	197
6.1.5	Computer Validation	199
6.1.6	Documentation	200

6.2	Operative Workflows under GMP Conditions	201
6.2.1	Product Release and Deviation Management	201
6.2.2	Changes in the Manufacturing Process	203
6.3	Production of Investigational Drugs	207

Part Five Pharmaceutical Law 209

7	Pharmaceutical Law and Regulatory Authorities	211
7.1	Fields of Pharmaceutical Law	211
7.2	Bindingness of Regulations	212
7.3	Authorities, Institutions and their Regulations	213
7.3.1	FDA	214
7.3.2	EMA	216
7.3.3	German Authorities	218
7.3.4	Japanese Authorities	220
7.3.5	Other Important Institutions	221
7.4	Official Enforcement of Regulations	224
7.5	Drug Approval	225

Part Six Production Facilities 227

8	Facility Design	229
8.1	Basic Principles	229
8.2	GMP-Compliant Plant Design	233
8.2.1	Production Flow Diagram	234
8.2.2	Conceptual Plant Layout	236
8.2.3	GMP Flow Analysis	239
8.2.4	Zoning Concept	243
8.3	Basic Concepts for Production Plants	246
8.3.1	Single- and Multi-Product Plants	248
8.3.2	Fractal and Integrated Configuration	250
8.3.3	Flexible and Fixed Piping	251
8.3.4	Steel Tanks and Disposable Equipment	253
8.4	Clean and Plant Utilities	254
8.4.1	Clean Utilities	254
8.4.1.1	Water	254
8.4.1.2	Clean Steam	260
8.4.1.3	Gases and Process Air	261
8.4.2	Plant Utilities	261
8.4.3	Waste Management	263
8.5	Equipment Cleaning	265
8.6	Clean-Rooms	266
8.6.1	Separation of Zones by Clean-Room Design	267
8.6.2	Finishing of Floors, Walls and Ceilings	269
8.6.3	HVAC Installations	269
8.6.4	Qualification	270
8.7	Automation	271

8.8	Quality Control Laboratories	273
8.9	Location Factors	273
9	Planning, Construction and Commissioning of a Manufacturing Plant	277
9.1	Steps of the Engineering Project	277
9.1.1	Planning	278
9.1.2	Construction	279
9.1.3	Commissioning, Qualification, Validation	279
9.2	Project Schedules	283
9.3	Cost Estimates	285
9.4	Organization of an Engineering Project	286
9.4.1	Expert Groups Involved	286
9.4.2	Role and Selection of Contractors	287
9.4.3	Contracts and Scope Changes	288
9.5	Successful Execution of an Engineering Project	292
9.6	Legal Aspects of Facility Engineering	292
9.6.1	Health, Safety and Environmental Law	293
9.6.2	Building Law	294
	Part Seven Economy	297
10	Product Sales and Manufacturing Costs	299
10.1	Lifecycle of a Drug	299
10.2	Position of the Manufacturing Costs in the Overall Cost Framework	303
10.2.1	Basic Principles of Cost Calculation	305
10.2.1.1	Nominal Accounting – Actual Accounting	305
10.2.1.2	Cost Accounting – Profit and Loss Accounting	306
10.2.1.3	Direct Costs – Overhead Costs	306
10.2.1.4	Fixed Costs – Variable Costs	306
10.2.1.5	Relevant and Irrelevant Costs	308
10.2.1.6	Cost Type, Cost Center and Cost Unit	308
10.3	Manufacturing Costs	309
10.3.1	Cost Types	310
10.3.1.1	Depreciation	311
10.3.1.2	Interest	311
10.3.2	Typical Costs of Biotechnological Manufacturing Processes	312
10.3.3	Methods of Calculation	313
10.3.3.1	Cost Calculations	319
10.3.3.2	Profit and Loss Calculation	323
11	Investments	325
11.1	Basic Principles	326
11.1.1	Investment Targets	326

11.1.2	Types of Investments	326
11.1.2.1	Classification According to the Object of Investment	327
11.1.2.2	Classification According to the Effect of Investment	328
11.1.2.3	Classification According to Other Criteria	328
11.1.3	Decision Processes	329
11.2	Value–Benefit Analysis	332
11.3	Investment Appraisal	334
11.3.1	Static Methods	337
11.3.1.1	Cost Comparison	338
11.3.1.2	Profit Comparison	338
11.3.1.3	Profitability Comparison	338
11.3.1.4	Static Payback Time	339
11.3.2	Dynamic Methods	339
11.3.2.1	Capital Value	339
11.3.2.2	Internal Rate of Return	340
11.3.2.3	Annuity	340
11.3.2.4	Dynamic Payback Time	341
12	Production Concept	343
12.1	Capacity Planning	343
12.2	Dilemma of In-House Manufacturing	346
12.3	Aspects of Manufacturing Out-Sourcing	349
12.3.1	Types of Cooperation	350
12.3.2	Contractual Agreements	351
12.3.3	Technology Transfer	352
12.3.4	Time Schedules	354
12.4	Make-or-Buy Analysis	355
12.5	Process Optimization after Market Launch	357
12.6	Supply-Chain Management	359
	References	363
	Index of Abbreviations	369
	Index	375

