

Index

- 3D printing *see* three-dimensional (3D) printing
- abnormal events, PAT detects 469, 470
see also disturbances; impurities
- Abo Akadmi University 541
- Accendo Conjure 131
- accuracy of dosing of oral drugs 511, 512
- acetaminophen, printing of 533–4
- acetylsalicylic acid 202, 204
- activation energy in nucleation 177–8
- active pharmaceutical ingredients *see* APIs
- actuators 436, 437
 in control frameworks 438, 439, 440
 pairing with control variables 87–8
 selecting 434
- additive manufacturing (AM) 541–6
- adipic acid 192
- adsorptive and desorptive techniques
 (catch-release) 142, 143
- Advancement of Emerging Technology*
Applications to Modernize the
Pharmaceutical Manufacturing Base
Guidance for Industry 518
- Advion NanoTek 131
- Aesica 382
- agglomeration 179
- agility, CM increases 9
- agitators *see* impellers and impeller blades
- alarm management 469, 470
- Alexanderwerk Inc (roller manufacturer) 314,
 326
- alglucosidase alpha 242
- aliskiren hemifumarate 151, 152, 169, 197–8
 continuous manufacture 448–52
- Allergan 365
- alternating tangential flow *see* ATF
- AM Technology 3
- American Chemical Society (ACS) 127
- American Society for Testing Materials
 standards 109, 357, 383
- p*-aminobenzoic acid 196–7
- analytical techniques/tools 375–6, 411
 and flow technology 144–50
 and innovative manufacturing 516, 518
 off line, summary of 213–15
 see also PAT (process analytical technology)

- anti-biofilm properties 546
- anti-inflammatory drugs 155, 158–9
- anti-solvent 171, 174, 175, 176
- antibodies 248–9, 255–7, 263
 - analysis of 274, 275
 - filtration used 259
 - formulation 266
 - printing of 538
- antihemophilic factor VIII 242
- APIs (active pharmaceutical ingredients) 2, 4, 5, 6, 38
 - crystallization 471–2
 - flow technology 127–62
 - multi-step synthesis 150–6
 - high-potency 570–3
 - in hot melt extrusion 337
 - liquid dispensing technology (LDT)
 - for 562–3
 - adding to carrier tablet 556, 560–3
 - pad printing 565–7
 - for liquid dosage 169
 - low aqueous solubility 472–4
 - and low potency 552
 - printing of 508, 533, 537
 - compared to LDT 554
 - onto porous substrates 533–4
- app-based personal monitoring 521
- aqueous solubility, poor 472–4, 535
- Arburg GmbH 545
- artemisinin 151, 152–3
- arthritis drugs 161
- ascorbic acid 192–3
- ASPEN Plus 78
- Aspen Technology Inc 425
- aspirin *see* acetylsalicylic acid
- ASTM standards 109, 357, 383
- AstraZeneca 3, 155, 161, 365
- at-line monitoring 233, 270
 - see also* in-line measurement/monitoring
- ATF (alternating tangential flow) 252–3, 256, 268, 274–5, 374
- atomic force microscopy 214
- ATR (attenuated total reflectance)
 - spectroscopy 207
- automated control loops 455–6
 - and disturbances 460, 461–3, 465
 - soft sensors for 469–70
 - see also* control loops
- automation and flow technology 142–50
- auxostat operation 231
- averaging level control 466–8
- axial mixing 291–3, 418, 419
- baby hamster kidney cells (BHK) 251
- back mixing 416, 419, 431
- balance equations 15–19
- Balda Medical 513
- ballroom design 380–1
- Banzel 155
- basiliximab 242
- batch, definition of 110, 111, 123–4, 249–50, 372
 - for individualized products 520
- batch manufacturing/processes 1, 2, 28, 485–6
 - of biopharmaceuticals 247, 248, 249
 - comparison with continuous 250–1
 - downstream 257, 258
 - and categorizing unit operations 14
 - fermentation 229–30, 232, 242, 243
 - modeling process chains 489–90
 - problems with 33–4
 - for solid drug manufacture 38, 452
 - space comparisons 390
- batch release 115–16, 568, 571
- Bayer 3, 161
- Beecham 155
- bend-mode inkjet technology 531
- benzoic acid 187, 195–6, 200
- Bepex (roller manufacturer) 313
- BET analysis 214
- beta-glucocerebrosidase 242
- BHK (baby hamster kidney cells) 251
- binders and fillers 328, 330
- bioactive substances, printing for 526
 - see also* drugs
- biobased polymers 239
- bioequivalence considerations 123
- bioethanol 238
 - see also* ethanol
- biological applications of flexographic printing 538
- biomanufacturing, continuous 250–1
- biomedical area, 3D printing in 545–6
- Biopharm services 270, 274
- biopharmaceutical industry 371
- biopharmaceuticals 5–6, 228
 - continuous fermentation 227–43
 - continuous manufacture 6, 247–76
 - current status of manufacturing 247–9
 - innovative 519

- Biopharmaceutics Risk Assessment Roadmap (BioRAM) 508
 biopolymer hydrogel matrices 538
 bioprocessing, continuous manufacturing
 in 371–81
 bioreactors 372–3
 disposable 268, 269
 ethanol production 238–9
 fermentation in 228, 229–32
 lactic acid production 239
 in single cell protein production 240–1
 see also perfusion reactors
 Biosolve software package 274
 blend uniformity metrics 57–8
 blenders (mixers) 415–21
 modeling 56–63, 78, 79, 80, 81
 scaling-up problems with 26
 blood coagulation factors 247
 blood plasma 263
 blood plasma proteins 248
 body-feed filtration 259
 Bohle 3
 Bosch 3
 Bristol-Myers-Squibb 156, 159
 brivamib alaninate, synthesis of 156
 buffering 45–8
 see also holding vessels
 bullwhip effect, supply chain 393–4
 business case for CM 387–91
 business environment 382, 387, 388
 business excellence 370, 387–95

 C-SOPS 3, 85, 86
 caffeine, printing of 533–4
 calcium lactate 187
 calibration 208–9, 320, 411
 Camo, Unscrambler X by 438
 campaign basis manufacturing 2
 cancer 509
 see also tumors
 capacity flexibility 399
 capsules 38–9, 43, 313
 see also solid drug products
 carrier tablets in LDT 555–6, 564, 567
 printing or coating of 565–6
 cascade (series) of ideally mixed systems 22–3
 cascading control loops 434
 cash flow 388, 391–2
 Catalent 382
 cell culture 254–7, 372–3, 377, 378–9
 cell harvest 373–4, 376
 cell line stability 250, 251–2
 cell retention devices 252–4
 cell separation 373–4
 Celligen packed bed reactor 254
 Center for Drug Evaluation and Research (CDER) 371, 396
 Centre for Continuous Manufacturing 381
 centrifugation 265, 272
 centrifuges, continuous 257
 Cerezyme 242
 CFD model 19, 75
 CFR *see Code of Federal Regulations*
 cGMP (current Good Manufacturing Practice) 53
 and batch release 115–16
 FDA publication 372, 553–4
 see also GMP
 ChemCAD 78
 chemical imaging for HME 361
 chemical intensification 131, 132
 chemical potential 174
 chemostat operation 231, 254
 Chemtrix 3, 131, 161
 Chinese hamster ovarian cells (CHO) 251–2
 chromatography 374–5, 377
 continuous 260, 262, 268, 272–3, 275
 inverse gas phase 214
 liquid (LC), higher throughput 468–9
 semi-continuous, economics of 275
 classical nucleation theory (CNT) 177–8
 cleaning 121–2, 173
 and liquid dispensing technology 572–3
 in vertical CM lines 386–7
 cleanrooms 379–81
 PODs as 397, 398
 clinical trials 33, 464
 LDT in 553, 556, 557, 560, 563
 rapid scale-up after 520
 closed-loop systems 270, 405, 442
 characterization and verification 440–2
 definition 432
 evaluation 90–1
 integrated model of 436–8
 and open-loop compared 432, 433
 closures in balance equations 15–16
 CM *see* continuous manufacturing
 CMAC Future Manufacturing Research Hub 2

- CMAs (critical material attributes) 409, 429
 in closed loop systems 432, 442
 in open loop performance 428, 429
- co-current mode 14
- co-extrusion 354–6
- co-rotating twin-screw extruders 347, 348
- Code of Federal Regulations* 123–4, 249, 372, 568
- coil/tubular reactor 131
- comil 40, 78, 79, 80, 81
see also milling/co-milling
- commercial comparisons 377–9
- commercial scale LDT machine 557, 558
 cleaning 573
 commercial line operation 559–60
 inspection systems 563–5
 compared to pilot scale 567
- compaction, models of 64
- compartmental structures 514, 515, 516, 518
- competitive advantages 369–71
- computational fluid dynamics (CFD) model 19, 75
- conceptual flow modeling 298–300
- conductive heating 134
- conservation equations 180
- ConsiGma 3, 284–7, 396, 398–9
- contact transfer printing 535
see also flexographic printing
- contacting method, categorizing unit operations by 12–14
- contamination risk 232
- continuous biomanufacturing, rationale for 250–1
- continuous bioprocessing (CBP) 371–2
- continuous blenders 415–21
- continuous centrifuges 257
- continuous chromatography 260, 262, 268, 272–3, 275
 semi-continuous, economics of 275
- continuous crystallization 169–217
 crystallization principles 173–80
 crystallizers and applications 185–207
 key stages 170
 particle characteristics 213–15
 process development 180–5
 process monitoring, analysis and control 207–13
- continuous downstream processing 257–66
see also continuous manufacturing (CM)
- continuous fermentation for
 biopharmaceuticals 227–43
 examples 238–41
 operation of fermentation systems 229–37
 prospects and challenges 241–3
 reactor operation 231–2, 238
- continuous filtration 258–60
- continuous formulation 266
- continuous inkjet systems 527–9, 531
- continuous line roller compaction 313–34
- continuous manufacturing (CM)
 advantages of 8–11, 28
 authors' views 3–7
 of biopharmaceuticals 247–76
 challenges to developing 249–50
 current status 247–9
 in bioprocessing 371–81
 examples of 376–7
 compared to batch 390, 485–6
 crystallization *see* continuous crystallization
 definitions 1–2
 design of systems 405–43
 development considerations, and regulations 111–12
 downstream processing 257–66
 early stage decision-making 485–503
 economics of 274–5
 engineering principles of 11–28
 fermentation *see* continuous fermentation for biopharmaceuticals
 flow technology 127–62
 hot melt extrusion (HME) in 356–60
 importance of closed-loop control in 442
 improved technology 477
 industry investment in 161
 for innovative flexible products 518, 520
 integration of unit operations 447–80
 liquid dispensing technology (LDT) as 552
 for oral solid dosage forms 381–95
 printing technologies 525–46
 process simulation and control, solid drug products 33–94
 processes for aliskiren hemifumarate 448–52
 of proteins, problems with 247–8
 quality considerations 115–23
 regulatory environment 108–15
 roller compaction 313, 330–2
 process control of 332–3
 of solid drug products 33–94, 381–95
 equipment for 39–44

- process control 81–93
 - as ultimate application of QbD 447
 - unit operation 14–15
 - roller compaction as 313, 330–2
 - see also* continuous processing
- Continuous Manufacturing and
 - Crystallization 161
- continuous membrane filtration 260, 261
- continuous oscillatory flow reactors 199
- Continuous Pharmaceuticals 3
- continuous phase contact 12–13
- continuous phases 12
- continuous precipitation 263–6
- continuous process verification (CPV) 110, 117–18
- continuous processing 108
 - industry drivers for 369–71
 - lack of flexibility in 406
 - status and perspective 369–401
 - see also* continuous manufacturing (CM)
- continuous quality verification (CQV) 109
- continuous tubular blenders 418–20
- continuous upstream processing 251–7
- continuous wet granulation 284–7
- continuously stirred-tank reactors *see* CSTRs
- continuum models 44, 49
- control
 - averaging level control 466–8
 - of continuous fermentation processes 234–7
 - and disturbances and nonlinearities 460–4
 - manufacturing of biopharmaceuticals 270–3
 - model-based 447, 452
 - plant-wide 455–6
 - state of control *see* state of control
 - see also* process control; process monitoring
- control algorithms 24
- control architecture
 - design of 431, 432–6
 - implementation 436–8
- control framework, implementation and
 - verification of 438–40
- control loops 434–5
 - implementation and verification 438–40
 - integration of 436–7
 - running entire process 440–2
 - see also* automated control loops
- control objectives, classification between 455–6
- control strategies
 - in continuous manufacture 469
 - fermentation 242–3
 - hot melt extrusion (HME) 338, 356–7
 - in crystallization 210–13
 - and design of systems 409
 - for liquid drug dispensing
 - technology 569–70, 574
 - and regulations 112–14
- control structures 471
 - in continuous fermentation processes 236–7
- control systems 451, 469
 - running entire process 440–2
 - supervisory 364–5, 432
 - see also* process control
- control variables
 - critical 86–7
 - and modeling fermentation 235–6
 - pairing with actuators 87–8
- controllers 436
 - in continuous tablet manufacture 88–9, 92–3
 - level controllers 466–8
 - MPC *see* MPC controllers
 - parameters and constraints 437
 - PID *see* PID controllers
 - selecting at design stage 435–6
- convective heating 132–4
- convective mixers 40
- conveying system in feeders 48, 53
- cooling 174–6, 177
- cooling calender 354
- Corning glass microreactor 161
- corrective action and preventative action (CAPA)
 - system 119
- cost estimating relationship 497
- cost per tablet savings 388–9
- cost-benefit analysis 503
- cost-benefit assessment 381–2
- costs
 - and continuous fermentation 231, 232
 - immobilization of yeast cells 239
 - and continuous manufacturing 274–5
 - of drug development 502
 - of drugs, reduced 11
 - in early decision-making 494, 502
 - analysis of categories 492–3
 - deriving heuristics for 495–7
 - equipment costs 497–8
 - of fermentation methods compared 241
 - of investment, reduced 10
 - reduction through CM 370, 389
 - savings, with PCMM platforms 397, 400

- costs (*cont'd*)
see also economic issues; investment costs;
 manufacturing costs
- counter-current loading 262
- counter-current mode 14
- counter-rotating twin-screw extruders 346–7
- CPPs (critical process parameters) 272, 409, 423
 in closed loop systems 432, 442
 in LDT machines 560
 and open loop performance 427, 428
- CPV (continued process verification) 110,
 117–18
- CQAs (critical quality attributes) 9, 109, 237,
 272
 in the absence of true steady-state
 operation 453–4
 in closed loop systems 432, 440, 441
 running entire process 442
 in control architecture 434
 and design of systems 409, 423
 for LDT 563–5, 569–70
 and startup and shutdown procedures 465
- critical material attributes *see* CMAs
- critical process parameters *see* CPPs
- critical quality attributes *see* CQAs
- cryogenic conditions 132
- crystallization 173–80, 471–7
 control strategies 210–13
 importance of 169–70
 process development 180–5
see also continuous crystallization
- crystallizers 171–3, 185–207
see also reactors
- CSTRs (continuously stirred-tank reactors) 22,
 173
 for cell cultivation 254, 255–6
- cultivation systems, comparison of 229–32
- current Good Manufacturing Practices *see*
 cGMP
- customization 526
 3D printing in 542
see also personalized medicine
- Cutter Laboratories, Berkeley 248
- cybersecurity hazards 521
- cyclosporine 193, 198
- cystic fibrosis, drug for 3, 486
- Darunavir (HIV drug) 3
- data acquisition and process control
 systems 364–5
- data availability in decision-making 486–7, 491,
 503
- data characterisation approaches 307
- data management tools 43, 439
- data mining of biological databases 508
- data processing for HME 362, 363
- decentralization 10
- decision-making chain 487
- decision-making, early stage 485–503
- deferasirox 187, 189
- Delta V control platform 439, 440
- DEM (discrete element method) 19, 44, 45, 49
 blenders 58, 59
 drying 75
 feeders 53
 particle-scale simulation using 305–7
 powder compaction 64
 roller compaction 317, 333
 roller compactors 67, 68
 tablet presses 63
 twin-screw granulation 298
 wet granulation 72–3
- Demonstration of Uniformity of Dosage Units
 using Large Sample Sizes* 520
- depth filtration 258–9, 260, 268
- design
 computerized drug design 514–15, 518
 and continuous bioprocessing 377–81
 of control architecture 431, 432–6
 of integrated continuous manufacturing
 systems 405–43
 model-based 447, 452
 rough conceptual design 406–10
- design of experiments *see* DoE
- desktop flexography 540–1
- diafiltration 266, 267
- dielectric heating 134–5
- dielectric spectroscopy 234
- differential balances 15
- differential scanning calorimetry 215
- dimensioning 27–8
- 2,2-dimethylchromenes, synthesis of 156, 158
- direct compaction 407, 410, 412
- direct costs 494
- direct delivery to patients 4, 5
see also patient-centred medicine
- direct shaping of final product 350–2
- discontinuous mode of phase contact 13
- discrete element method *see* DEM
- dispersed phases 12

- dispersive mixing 345
- disposable equipment 274
 - see also* single-use technology
- distillation 140–2
- distributive mixing 345
- disturbances 460
 - control implications 460–4, 465
 - and buffer tanks 466–8
 - see also* abnormal events; impurities
- documentation, regulations on 124
- DoE (design of experiments) 181, 271–2, 388, 389, 391–2
 - integrated continuous manufacturing systems 428, 429, 440, 441
 - twin-screw granulation 307
- dosage forms 511
- dosage units, new terminology for 520
- dosing in LDT manufacture 560–3
 - imaging to check 564–5
- downstream manufacturing 38
 - see also* secondary manufacturing
- downstream processing
 - in biopharmaceutical manufacture 248–9, 257–66
 - and continuous melt extrusion 349–56
 - disposable unit operations in 268–70
 - and flow technology 139–42
 - hot melt extrusion products 338
 - monitoring and control 272–3
 - streamlining, in tablet manufacture 452
- downtime
 - at design stage 408
 - in fermentation 230, 231, 232
- Drexel University 545
- driving force 174, 176, 179
- drop on demand inkjet systems 527, 528, 529
 - piezoelectric *see* piezoelectric inkjet printers
 - thermal *see* thermal inkjet (TIJ) printers
- drop formation, ink 531–2
- drug delivery systems (DDS)
 - flexographic printing in 537, 538
 - printing technologies for 525, 533–5
 - prototype fabrication 540–1
- drug development, costs of 502
- drug therapies, personalized 507–21
- drug-eluting stents 533
- drugs
 - anti-inflammatory 155, 158–9
 - development, and flow technology 160–1
 - dosage forms 511
 - and early stage decision-making 485–503
 - erectile dysfunction, orodispersible films for 538
 - future medicines, personalized 507–21
 - and genetic factors 509
 - low dose 551–74
 - orodispersible films for 514, 538
 - poor water-solubility 534–5, 539
 - printing technologies for 525–46
 - solid *see* tablets
 - see also* product
- dry granulation 313, 407
- dryers 38, 39, 42
- drying, models for 75–6
- DSM Pharma Chemicals 161
- dual microdispenser system 535
- dynamic models 48
- dynamic process simulations 465
- dynamic sensitivity analysis method 87
- dynamic vapour sorption 214
- early stage decision-making 485–503
- economic issues 5, 387–95
 - biopharmaceutical manufacturing 274–5
 - continuous bioprocessing 377–81
 - continuous versus batch manufacturing 426
 - technical-economic evaluation
 - methodology 486–503
 - see also* costs
- Egalet technology 514
- Ehrfeld 3, 161
- Eisai 155
- elderly/geriatric populations 507, 509
- electric heating 135–6
- electrospinning drugs 477, 478
- Eli Lilly and Company 158
- Emerson Process Management 439
- empirical models 35, 47–8, 51–2
 - for blenders 62–3
 - in crystallization 211–12
 - and feeders 55–6
 - for fermentation 235
- emulsion embedded hydrophobic drugs 472–4
- energy balance models for drying 76
- energy balances 18–19
- engineering models 46–7
 - for drying 76
 - for milling 77
 - for roller compactors 68–71
 - tablet presses 65–7

- engineering models (*cont'd*)
 wet granulation 74–5
 for wet granulation 74–5
 engineering principles 11–28
 environmental issues 11, 555, 572–3
 enzymes, industrial production of 227, 242, 251
 equilibrium and crystallization 174
 equilibrium saturation solubility curve 174, 175
 equipment
 in continuous manufacture of solid
 drugs 39–44
 in early decision-making 492, 497–8
 overall equipment effectiveness (OEE) 489,
 490, 491
 and regulatory environments 112–13, 122
 erectile dysfunction drugs 538
 ethanol 227, 228, 238–9, 242
 ethnical populations 507, 508
 7-ethyltryptopol 158–9
 etodolac 158–9
 Eucreas (Novartis) 366
 European Consortium for Continuous
 Manufacturing 3
 European Medicines Agency (EMA) 110
 European Pharmacopeia monograph 2.9.47 520
 European Union 8, 110
 evaluation of models 90–1, 423
 evaporative crystallization 176
 excipients 4, 5, 6
 in downstream manufacturing 38
 in hot melt extrusion 337
 for inkjet and flexography 539
 in innovative manufacturing 516
 and roller compaction 328, 330
 experimental data
 and modified Johanson model 320
 and PBM framework 301
 pressure distribution in roller
 compactors 322–4
 for twin-screw granulation 298, 300, 302, 308
 extractables and leachables 268–9
 extruders 41, 338–41
 feeding 341–5
 operation points 347–9, 350
 twin-screw 345–7, 348
 extrusion
 3D printers use 543–5
 co-extrusion 354–6
 hot melt *see* hot melt extrusion
 in innovative manufacturing 516
 and innovative product design 513–14
 twin-screw 345–7
 fabbster (3D printer) 545
 facility design 379–81
 see also layout of installations
 failure modes 113
 FBRM (focused beam reflectance
 measurement) 210
 FDA (Food and Drug Administration) 371, 396,
 518
 categorisation of sensors 270
 cGMP 53, 115–16, 372, 553–4
 definitions by 207, 372
 guidance 109, 568
 meetings with manufacturers 410
 and PAT 36, 142, 207, 233
 promotes continuous manufacturing 248, 410,
 486, 568
 QbD requirements 237
 regulations *see Code of Federal Regulations*
 site visits by 111
 FDM (fused deposition modeling) 534, 542,
 543–4
 feedstock material for 544–5, 546
 fed-batch production
 biopharmaceuticals 274–5
 comparison with perfusion systems 377,
 378–9
 fermentation 230–1, 232, 242, 243
 for ethanol 238
 feed frames 63–4, 80, 81
 feedback 436, 460–3, 468–9
 feeders 38, 39, 40
 and design of systems 413–14
 in flowsheet modeling 78, 79–81
 loss in weight 341–5, 412–15
 models for 48, 53–6
 for roller compactors 314–15
 see also feeding
 feedforward control 434–5, 460, 461
 feeding 341–5, 420–1
 multiple ingredients 408–9
 see also feeders
 feedstock 400
 for FDM printing 544–5, 546
 felodipine, dispersion of 534
 FEM (finite element method) 44, 49
 powder compaction 64
 roller compaction 67, 317, 321, 326, 327, 333

- fenofibrate 472–4, 475, 533
- fermentation, continuous 227–43
 systems operation 229–37
- FFF (fused filament fabrication) printing 527,
 542, 543–4
- film extrusion 354
- films 474–7, 513, 538
 orodispersible 514, 538
- filtration, continuous 258–60, 268
- finite element method *see* FEM
- first principle models 35, 44, 49
 for blenders 58
 for drying 75
- Fitzpatrick (roller manufacturer) 313
- flash chemistry 132
- FLEX (fused layer extrusion) 545
- flexibility 399–400
 and design of systems 408
 increased by CM 8
 lack of, in continuous processes 406
- flexible dosing 510–13
- flexographic printing 526, 527, 535–8
 pharmaceutical applications 525, 537–9
- flocculation 259, 260
- flow aid mechanical unit 48, 53
- flow intensification 128
- flow modes 13–14
- flow rate 55–6, 111, 119
- flow reactors 130, 131
 continuous oscillatory flow reactors 199
 oscillatory flow reactors 171, 172
 plug flow reactors 171, 198–206
- flow technology 127–62
 industrial applications 160–1
 larger-scale synthesis 156–60
 micro flow technology 128–50
- flow visualisation 293, 295
- flowsheet modeling 36, 37
 design of integrated systems 425, 432, 436,
 437
 and early decision-making 494, 495
 in solid drug product manufacture 77–81
 and tablet presses 67
- FlowStart Evo 131
- FlowSyn (Uniqsis) 131, 155
- Flublok manufacture 251
- flufenamic acid 202
- fluidized beds for drying 75
- fluorescence spectroscopy 234
- focused beam reflectance measurement
 (FBRM) 210
- folic acid, nanosuspensions of 534–5
- Food and Drug Administration *see* FDA
- footprint, reduced 108, 128
see also space
- formulation 266
 at plant design stage 406–7
 of hot melt extrusion product 337–8
 for inkjet and flexography 538–9
 and liquid dispensing technology 555–6
 properties, and process maps 307–8
 and roller compaction 328, 330
- Freund-Vector 313
- friction
 in powder densification 316
 and pressure gradient on rolls 317, 320, 321
- FTIR spectroscopy 144, 146, 147
 mid FT-IR 214
- fused deposition modeling *see* FDM
- fused filament fabrication *see* FFF
- fused layer extrusion (FLEX) 545
- fused-bicyclic isoxazolidines 158
- Future Chemistry 3
- future health care scenario 513–21
- future medicines, personalized 507–21
- future performance 470–1
- FutureChemistry 131, 161
- G-CON Manufacturing Inc 396, 398
- GAMP 5 guidelines 362, 364
- gastrointestinal stromal tumors 154
- GC/LC-MS 215
- GCG-70 (Glatt) 417, 420
- gCRYSTAL 184
- GE-Healthcare 270
- GEA Group 3, 284–7, 396, 398
- generic twin-screw granulation 300, 302–7
- genetic factors 509
- Genzyme 248
- Gericke GCM-250 blender 417
- Gerteis (roller manufacturer) 314
- Ghent University 3
- Glatt 3, 417, 420
- GlaxoSmithKline (GSK) 3, 161, 381, 396
 and continuous manufacturing 486
 liquid dispensing technology 552–3, 554,
 555, 574
 air monitoring by 570–1
 patent rights 557

- Gleevee (imatinib mesylate) 154–5
 L-glutamic acid 191–2, 202, 203
 glycine 206
 GMP 3, 362, 390, 568
 pilot LDT machine 557, 558, 567
 see also cGMP
 gOMATLAB 438
Good Automated Manufacturing Practices
 (GAMP 5) 362, 364
 good manufacturing practices *see* cGMP; GMP
 GPCC drying batch system 3
 gPROMS 33, 78, 79, 332, 438
 optimization routine of 437
 simulation software 436
 granulation 38, 39, 41–2
 roller compactors for 38, 39, 41, 67
 twin-screw 283–308
 wet *see* wet granulation
 granulation time 288–91
 granule characteristics on regime maps 303, 304
 granule production rate 333
 granule size
 and energy input 304
 evolution 294–7
 and roller compaction 328, 330
 and shape dynamics 295, 296
 granule size distribution (GSD)
 and energy input 304
 in twin-screw granulators 287, 288
 link with RTD and liquid distribution 295,
 297
 and shape dynamics 295, 296
 and solid-liquid mixing 293–4
 tracking 300–2
 gravimetric controllers 413
 gravimetric feeding 341–2
 gravure printing 526, 535
 Graz University of Technology 3
 green chemistry 127, 162
 Green Chemistry Institute (GCI) 127
 growth 174, 175, 176–9
 GSD *see* granule size distribution
 GSK *see* GlaxoSmithKline
*Guidance for Industry PAT-A Framework for
 Innovative Pharmaceutical Development,
 Manufacturing, and Quality
 Assurance* 109
*Guidance for Industry Process Validation:
 General Principles and Practice* 109,
 568
Guideline on NIR 110
Guideline on Real Time Release Testing 110
Guidelines for Process Validation 110
 H-Cube reactor (ThalesNano) 131, 155
 health care, future scenario for 513–21
 heat, speeding up reactions with 132–7
 heat transfer intensification 129
 Heckel equation 65
 Heinrich-Heine University 3
 HER-2 positive tumors 509
 Herceptin 509
 heterogeneous nucleation 176, 177
 hierarchical viewing 455–6, 457, 465
 high volume/low value 392–3
 high-potency products 552–3, 570–3
 HIV, drug for 3
 HME *see* hot melt extrusion
 holding vessels 451
 see also buffering
 homogenous primary nucleation 176–7
 hoppers 48, 53, 314
 in hot melt extrusion 342–4
 modeling of 44, 45
 hot die-face cutting 353–4
 hot melt extrusion (HME) 337–66
 continuous manufacturing with 356–60
 extruders 338–41
 feeding 341–5
 twin-screw extrusion 345–7
 hot-stage microscopy 215
 5HT^{1B} antagonist, synthesis of 155
 human genome 508, 510
 hybrid control strategies in
 crystallization 212–13
 hydrodynamics of flow 129
 hydrophobic drugs, emulsion embedded 472–4
 6-hydroxybuspirone 159–60
 hydroxypyrrrolotriazine, synthesis of 156, 157–8
 hyperspectral imaging NIR (near-infrared) 540
 hypertension, drugs for 151
 ibuprofen, micro flow technology for 153–4
 iCellis 254
 ICH (International Conference on
 Harmonisation) 108, 110
 publications 108–9, 115, 117, 124, 372, 567
 ICI 2
 ideal plug-flow systems 21–2, 23
 ideally-mixed systems 22

- cascade of 22–3
- imaging 88
 - and innovative manufacturing 516, 518
 - on LDT machines 560–1, 563–5, 574
 - near infrared hyperspectral imaging 540
 - see also* spectroscopy
- imatinib mesylate (Gleevec) 154–5
- immobilization of yeast cells 238–9
- immunoglobulin 263
- impellers and impeller blades 416–18, 419, 420
- impinging jet crystallizers 206–7
- impinging jet mixers 171
- implementation strategies 393–5
- impurities 263, 458–60, 472
 - see also* abnormal events; disturbances
- in situ measurement 142
 - see also* in-line measurement/monitoring
- in-line measurement/monitoring 270, 375
 - applied to crystallization 207, 208
 - in continuous manufacture of aliskiren hemifumarate 468–9
 - in hot melt extrusion 357
 - of roller compaction process 326–8, 329, 333
 - soft sensors for 469–70
 - and state of control 357
 - see also* at-line monitoring; in situ measurement; in-process controls; on-line monitoring
- in-process controls (IPCs) 111, 113, 120
 - and regulations 110
 - and systems design 430
 - see also* in-line measurement/monitoring
- in-process material, regulations for 119
- indirect costs (overheads) 494
 - see also* overheads
- individualized manufacturing 6, 7, 10
- individualized medicine 5
- individualized needs 508–9
- indomethacin, nanosuspensions of 538
- induction time in nucleation 177
- inductive heating 136–7
- industrial applications of flow technology 160–1
- industry *see* pharmaceutical industry
- infliximab 242
- information technology
 - computerized drug design 514–15, 518, 519
 - computerized systems, process integration into 362–5
 - and innovative flexible pharmaceutical products 521
 - see also* modeling
- information transfer 426–7
- infrared *see* IR
- inhibition 230, 231, 232
- injection molding (IM) 351–2
- inkjet printing 514, 515, 516, 517, 526, 527–35
 - combined with flexography 537
 - and LDT compared 554
 - pharmaceutical applications of 525, 533–5
- inks 531–2, 535
 - formulation of 538–9
- innovative flexible pharmaceutical products 513–18, 520
- innovative products 513–18, 520
 - flexible dosing with 510–13
 - supply chain 520–1
- inoculation 228
- Inovelon 155
- insect cells 251
- inspection 422–3, 563–5, 569
 - see also* in-line measurement/monitoring
- instability of low dose drugs 551–2, 556
- installation layouts 383–7
 - see also* facility design
- insulin 227, 229, 242
- integral balances 15
- integrated continuous manufacturing
 - of biopharmaceuticals 247–76
 - full process train 270
 - process monitoring and control 270–3
 - design of systems 405–43
- integrated model 424–7
- integration of unit operations 447–80
- intensification 128, 129, 131–8
- intermediates 411, 452
 - buffer tanks for 465
 - in continuous melt extrusion 352–6
 - and regulations 112, 119
- International Conference on Harmonisation *see* ICH
- International Society for Pharmaceutical Engineering (ISPE) 362, 364
- International Symposium on Continuous Manufacturing of Pharmaceuticals 2
- intra-uterine devices 546
- inverse gas phase chromatography 214
- investment 382, 389
 - rational basis for decisions 488
 - strategies 388
- investment costs 10, 408

- investment costs (*cont'd*)
see also costs
- IPCs *see* in-process control
- IR
 FTIR spectroscopy 144, 146, 147, 214
 MIR (mid-infrared spectroscopy) 234
 NIR *see* NIR (near-infrared); NIR
 (near-infrared) spectroscopy
- isoxazolidines, fused-bicyclic 158
- ISPE (International Society for Pharmaceutical Engineering) 362, 364
- IT *see* information technology
- itraconazole, nanosuspensions of 538
- Johanson model 68–71, 316, 317–19, 332
 modified 319–22
- Johnson and Johnson 486
- K-Tron KT-20 feeder 416, 420
- Kawakita model 65–6, 67
- Kenics mixers 202
- ketoconazole 202
- kinetics and crystallization 176, 177, 179, 213
 models 211
 nucleation and growth 183–5
 semi-empirical kinetic models 209–10
see also rate
- Kogenate 242, 376
- Kolbe-Schmitt reaction, speeding up 132–3
- Kuentz and Leuenberger model 66, 67
- laboratory LDT machine 557
- laboratory simulator 557, 559
- lactic acid 239, 242
- lactose 204–6
- Lang factor 498
- large scale flow reactors 130
- laser diffraction 214
- layout of installations 383–7
see also facility design
- LDT *see* liquid dispensing technology
- leachables 268–9
- Lennox-Gastaut syndrome 155
- leukaemia 154
- level controllers 466–8
- levothyroxine 552
- lipoic acid-nicotinamide 199–200
- liquid chromatography (LC), higher
 throughput 468–9
- liquid dispensing cell 560–3
- liquid dispensing technology (LDT) 551–74
 machines 555–9
 design details 559–66
 inspection systems 563–5
 overview of 553, 555–9
 program goals 554–5
 real-time release 567–70
 scale-independence of 566–7
- liquid medicines 511
- liquid systems, modelling of 34–5
- liquids, mixing *see* solid-liquid mixing
- LIW *see* loss in weight (LIW) feeders
- location flexibility 400
- Lonza 161
- loperamide hydrochloride, printing of 534
- loss in weight (LIW) feeders 341–5
 and design of systems 412–15
see also feeders
- lot, definitions of 124, 249–50
- low aqueous solubility APIs 472–4
- low dose drugs, manufacture of 551–74
- low potency drugs 551, 552
- low volume/high value 392–3
- mAb (monoclonal antibody) 255–6
- magnesium ammonium phosphate 191
- maintenance factor 496
- malaria, artemisinin for 151
- mammalian cells 228, 229, 242
 continuous production of 251–2
 proteins from 248
 and virus removal 259
- manipulated variables 357
- manufacturing
 batch *see* batch manufacturing
 continuous *see* continuous manufacturing
 (CM)
 for innovative flexible pharmaceutical
 products 513–18
 low dose drug products 551–74
 paradigm shift required 513
 route type, and design of systems 407
 solid drug products 33–94
 equipment for 39–44
 processes in 38–44
 manufacturing costs 388, 496, 503
see also costs
- manufacturing on demand production units 508
- market segment 382
- market size and fermentation products 228

- mass balances 16–18
 and fermentation 230, 231, 232
see also population balance equations
- mass flow rate, synchronization of 330–2
- mass spectroscopy 150
- mass transfer 129
- mass transfer intensification 129
- material carry-over 120
- material diversion 120
- material hold-up 417, 418, 419, 420
- material transport 287–94
- materials
 characterising unit operation with 412–21
 and design of continuous systems 410–11
 as input and output for models 423–4
 traceability *see* traceability
see also raw materials
- Mathematica 425
- mathematical models *see* modeling; models
- MathLab (The MathWorks Inc, UK) 332
- MatLab 425, 438, 440
- mechanistic description 284, 307, 308
- mechanistic models 35, 44
 for blenders 58, 59
 for drying 75
 for feeders 53
 for fermentation 235
 for milling 76
 of powder compaction 64
 for roller compactors 67–8
 for wet granulation 72–3
- medicines *see* drugs; product
- melting points 215
- melts, crystallization from 174
- membrane filtration 258, 259–60, 261, 268
- membrane-based separators 142
- Merck Millipore 270
- mesoscale flow reactors 130
- metabolism of microorganisms 227
- metastable zone width (MSZW) 174, 175, 176, 177, 184
- micro distillation 140–1
- micro flow reactors 131
- micro flow technology 128–50
 in API multi-step synthesis 150–6
 reaction activation tools 130–9
see also flow technology
- micro scale flow reactors 130
- micro-indentation 324–5
- microbiological testing 365
- microcapsules, formation of 535
- Microchip (flow reactor) 131
- microdosing dispenser head 534–5
- microfluidics 207, 515
- micromixing 129–30
- microorganisms 227, 238, 239
 in single cell protein production 240–1
- microparticles, drug-loaded 535
- microwave heating 134–5
- Mikrotechnik BTS 161
- milling/co-milling 315
 comil 40, 78, 79, 80, 81
 models for 76–7
 in solid drug product manufacture 40, 43
- mini extruder deposition (MED) 545
- mini-tablets 513, 514
- miniaturization 397, 399, 515
- MIR (mid-infrared spectroscopy) 234
- MIT (Massachusetts Institute of Technology) 2, 3, 248, 381, 382, 472
see also Novartis-MIT Centre
- mixed suspension mixed product removal *see* MSMMPR
- mixers *see* blenders (mixers)
- mixing
 back mixing 416, 419
 in blenders 416–20
 continuous blenders 415–21
 in continuous crystallization 170
 in extruders 341, 345
 micromixing 129–30
 solid-liquid *see* solid-liquid mixing
 in twin-screw granulators 291–4, 295
- mobile health apps 521
- MODCOS system 3
- mode of operation, categorizing by 14–15
- model integration basics 425
- model predictive control (MPC) 24, 470–1
- model predictive controllers *see* MPC controllers
- model-based analysis of twin-screw granulation 298–302, 307–8
- model-based control 24
 algorithms 24
 in crystallization 210–11, 212–13
- model-based design and control 447, 452
- model-free control in crystallization 211–13
- ModelBuilder 78, 79
- modeling 44–8
 and bioprocesses 234–7

- modeling (*cont'd*)
- for control applications 234–5
 - of fermentation 235–6
 - flowsheet *see* flowsheet modeling
 - of liquid systems 34–5
 - for out of specification material 358
 - process, fundamentals of 15–16
 - process chains 489–90
 - of solids 35
 - of twin-screw granulation 284, 298–300, 305–7
 - see also* models; simulation
- models 34
- calibration models for analytical sensors 411
 - of compaction 64
 - coupled with experimental data 298, 300
 - for crystallizers 209
 - for drying 75–6
 - engineering *see* engineering models
 - inferring process variables through 470–1
 - integration of 77–81
 - Johanson Model 316, 317–19, 332
 - modified 319–22
 - of open loop systems 424–7
 - phenomenological *see* phenomenological models
 - population balance *see* population balance models (PBMs)
 - for roller compaction 316–22, 332–3
 - semi-empirical kinetic 209–10
 - types of, solid drug manufacture 34–6
 - unit operation 48–81, 422–4
 - see also* modeling; regime maps; simulation
- modified Johanson Model 319–22
- modifiers in formulations for inkjet and flexography 538–9
- modular design 451
- momentum balances 16, 19
- monitoring
- of biopharmaceutical manufacture 270–3
 - of fermentation processes 232–4
 - of roller compaction process 326–8, 329
 - see also* process monitoring
- monitoring tools 88
- see also* PAT; sensors
- mouse myeloma (SP2/0) 251
- MPC algorithm 440
- MPC controllers 37, 83–4, 88–9, 92–3, 332, 435, 436
- MPC-PID hybrid model 438
- MS *see* mass spectroscopy
- MSMPR (mixed suspension mixed product removal) 171, 185–93
- cascade 172, 193–8
 - optimizing 472
- MSZW (metastable zone width) 174, 175, 176, 177, 184
- multi-compartment systems 525
- multi-dimensional population balance models 44–6, 50
- multi-layer membranes 525
- multi-orifice oscillatory baffled crystallizer 204–6
- multi-phase balances 16
- multi-stage MSMPR 172, 193–8
- multilayer printing 539
- multivariate data analysis software 438, 439
- murine melanoma cells (NS0) 251
- mutation probability in fermentation 232
- Myozyme 242
- nabumetone 155
- nanocrystals 472
- nanofibres containing drugs 477
- nanofiltration, virus removal with 259
- nanoparticles 515, 532
- nanosuspensions 534–5, 538, 539
- naproxinod 161
- National Centre for Innovative Manufacturing 161
- NatureWorks 239
- near infrared *see* NIR (near-infrared); NIR (near-infrared) spectroscopy
- net present value (NPV) 382, 388, 391
- and batch size 392, 393
- nicotinamide 199–200
- NicOx 161
- nip angle 315, 316, 317–19, 320, 321
- measurements of 322, 323
- nip region (compactors) 316
- NIR (near-infrared) 215, 565
- chemical imaging (NIR-CI) 326–8, 329, 333
 - hyperspectral imaging 540
 - probes using 357, 429–30
 - sensors using *see* NIR sensors
- NIR (near-infrared) spectroscopy 110
- for continuous fermentation processes 233–4
 - and flow technology 144, 146
 - for hot melt extrusion 360
- NIR probes 357, 429–30

- NIR sensors 361, 376
 in real time monitoring 82, 88, 89, 90, 92, 93
- NIST calibration 561, 563
- NJIT 2
- NMR spectroscopy
 for crystallization 215
 and flow technology 147, 149–50
- non-aqueous solvent, printing of 535
- non-conforming materials 119–20, 520
see also out of specification material
- Noracet 155
- Novartis 3, 151, 154, 161, 255, 366, 381, 486
- Novartis-MIT Centre 2, 85–6, 161, 471, 472, 480
see also MIT
- novel process windows (NPW) 130–2
- Novo Nordisk 229
- NPW *see* net present value
- nucleation 170
 and growth 176–9
 increased rates of 475–7
- occupational health
 and high potency drugs 552–3, 572, 574
 and liquid dispensing technology 570–2
see also safety issues
- off-line characterization 213–15
 of continuous fermentation processes 233
 of ribbon quality 324–6
- Ohnesorge number (Oh) 532
- OLUPX (online prediction engine) 440
- on-demand fabrication 526
- on-line monitoring of fermentation 233
- on-line prediction tool 438, 439
- on-line probes 233–4
- on-line sensing and model design 429–30
- on-line sensors 270
in situ near-infrared 376
- on-line testing of PAT tools 430–1
- oncology 508
- OPC (OLE process control) protocol 438, 439, 440
- open-loop systems 424–9, 430–1
 and closed-loop compared 432, 433
- operating temperature, increase in 132–7
- operation points for extruders 347–9, 350
- operational costs in early decision-making 494
see also costs
- optical coherence tomography (OCT) 361
- optical microscopy 214
- optimal experimental design (OED)
 approach 307
- Optimal Industrial Automation Ltd 439
- optimization control layer 236–7
- oral films 513, 538
- oral solid dosage 38, 381–95
 next generation 396–9
 printing technology for 533
see also tablets
- Orkambi (cystic fibrosis drug) 3, 486
- orodispersible drug formulations 514, 538
 mini-tablets 513
- oscillatory flow reactors (OFR) 171, 172
- out of specification material 357–60, 431
see also non-conforming materials
- overall equipment effectiveness (OEE) 489, 490, 491
- overheads 494
 in early decision-making 494, 495–7
- Ozurdex (Allergan) 365
- packed bed reactors 131, 253–4
- paclitaxel solutions, printing of 535
- pad printing cell 565–7
- Panzytrat OK 513
- paracetamol 190, 194–5
- Parkinsons disease, orodispersible films for 538
- particle characteristics 213–15
- particle size 211, 324, 361
- particle size distribution (PSD) 171
 and crystallizer type 186, 199
 impinging jet crystallizers 206–7
- particle-scale simulation 305–7
- PAT (process analytical technology) 8, 24, 25, 36–7, 120–1
 and biopharmaceuticals 272
 and bioprocessing 371, 375–6, 384
 PCMM platform 397, 399, 400
 and continuous fermentation processes 233
 continuous printing applications 539–40
 and control strategies 112
 and crystallization 184, 201, 207–10, 211
 data management tools 91–2, 439
 and flow technology 142–50, 159, 162
 and hot melt extrusion 338, 357–8, 359, 360–2, 365
 and real-time release testing 365
 and innovative manufacturing 516, 518, 520
 in integrated continuous
 manufacturing 468–9, 479

- PAT (process analytical technology) (*cont'd*)
 in integrated system design 409, 428, 429–31, 439
 and liquid dispensing technology 552, 554, 568
 regulatory considerations 108, 109, 110
 and roller compaction 326, 333
 and twin-screw granulation 286–7
- patent rights for LDT 557
- Patheon 382
- patient-centred medicine 507
- patient-centric drug development 508
- patient-centric supply chain 520
- patient-specific needs 6, 7
- patients
 direct delivery to 4, 5
 groups of 507, 508–9
- PBEs *see* population balance equations
- PBMs *see* population balance models
- PCMM 396–400
- PCS7 control platform 439, 440
- performance targets and early decision-making 488
- perfusion reactors 252, 254, 371, 372–4
 commercial 376
 disposable 268
see also bioreactors
- perfusion systems 270, 273, 274–6
 analytic tools 375–6
 comparisons with other systems 377–9
 counter-current loading 262
 products 242, 247, 254–7
 reactors *see* perfusion reactors
- personalized doses, printing for 534
- personalized drug therapies 507–21
- personalized medicine 370, 508–10
see also customization
- personnel procedures and training 120
- perturbations 431
- Pfizer 3, 381, 396, 486
- pharmaceutical applications
 of flexographic printing 537–8
 of inkjet printing 533–5
 three-dimensional printing in 525, 545–6
see also drugs
- Pharmaceutical CGMPs for the 21st century - A Risk-Based Approach* 372, 553–4
- pharmaceutical industry
 batch processing in 33–4
 continuous manufacturing 2, 161, 381–3
 current examples 376–7
 drivers for 369–71
 status and perspective 369–401
 lack of advancement in 554
 modernization compared to other industries 485
 needs process engineering skills 442–3
 supply chain of the future 395–400
- pharmaceutical ingredients *see* APIs
- pharmaceutical quality system (PQS) 109, 115
- pharmaceuticals *see* drugs
- pharmacogenomics 508
- pharmacokinetics 509, 510
- phase diagrams 174–6, 183, 184
- phases, categorizing unit operations by 11–12
- phenomenological models 35, 44, 46–7, 50
 drying 76
 milling 77
 roller compactors 68–71
 tablet presses 65–7
 wet granulation 74–5
- physico-chemical equivalence considerations 123
- physico-chemical principles 11, 12
- PI feedback control, pilot plant uses 460
- PID control, disadvantages of 332
- PID controllers 83, 88–9, 92–3, 333, 435, 436, 437, 438
- PID (proportional integral derivative) 37
- piezoelectric inkjet printers 528, 530–1, 537
 for drug delivery 533–4, 535
 ink for 531, 532
- pilot plants
 continuous tablet manufacture 82, 83, 94, 381
 design and control 452–9, 460–1, 465–7, 470–1
 operating and control user interface 440, 441
 and flow technology 156, 157, 160
- pilot scale LDT machine 557, 558, 567
- piroxicam 535
- plant cells 251
- plant-wide control 236–7, 455–6
- plastification units 339, 340
- plug flow reactors 171, 198–206
- plug-flow systems, ideal 21–2, 23
- plug-flow transport in twin-screw granulators 292, 294, 300
- POC (point of care) diagnostics 509–10, 521
- POD systems 396, 397, 398, 399

- point of care diagnostics 509–10, 521
- polymers
 - in 3D printing 544–5
 - biobased 239
 - and electrospinning drugs 477
 - in hot melt extrusion 337–8
 - in innovative manufacturing 516
 - in liquid dispensing technology 556
- poorly soluble drugs, printing for 534–5, 539
- population balance equations (PBEs) 17–18, 301
 - crystallization 180
- population balance models (PBMs) 44, 49–51
 - for blenders 58–60
 - for crystallization 180, 210
 - for drying 75–6
 - gCRYSTAL for 184
 - lower dimensionality 46
 - for milling 76–7
 - multi-dimensional 44–6, 50
 - particle-scale modeling 305–6
 - for roller compactors 68
 - tracking granule size distribution 300–2
 - for wet granulation 72–4
- portability 397, 399
- potency
 - high 552–3, 570–3
 - low 551, 552
- powder compaction, models of 64
- powder densification 313, 315–17
- PQS (pharmaceutical quality system) 109, 115
- pre-blends, feeding 408–9
- pre-coat filtration 259
- precipitation, continuous 263–6
- precision extruding deposition (PED) 545
- prednisolone 533
- pressure distribution in roller compactors 317–19
 - experimental 322–4
 - modified model 320
- pressure gradient on rolls 317–19
- primary manufacturing 4–6, 490
 - see also* upstream processing
- primary nucleation 174, 175, 176–8
- printability of inks 531–2
- printing technologies 535
 - in drug manufacturing 525–46
 - products 512, 514–15
- probability density function (PDF) 46
- probability distribution of induction time 177
- process analytical technology *see* PAT
- Process Analytical Technology Team 110
- process chains, modeling 489–90
- process control 24–6, 36–7
 - basics 83–4
 - continuous printing applications 539–40
 - continuous roller compaction 332–3
 - hot melt extrusion 364–5
 - solid-based drug manufacture 81–93
 - systemic methodology for design 84–93
 - closed-loop operation 92–3
 - control variables 86–8
 - controllers and control parameters 88–90
 - implementation 91–2
 - monitoring tools 88
 - performance evaluation 90–1
 - see also* control systems
- process design intensification 131–2
- process development
 - crystallization 180–5
 - and regulations 111
- process drift 568
- process engineering skills, need for 442–3
- process and facility design comparison 379–81
- process integration into computerized systems 362–5
- process maps 303–4, 308
- process monitoring
 - continuous crystallization 207–10
 - in hot melt extrusion 358
 - in integrated continuous manufacturing 468–71
 - of biopharmaceuticals 270–3
 - and regulatory environments 113
- process options in early stage decision-making 492–8
- process performance and material properties 410–11
- Process Pulse 439, 440
- process simulation 34–6, 452
 - in early decision-making 494, 495
 - effect of recycling on impurities 458–60
 - for startup and shutdown 465
 - see also* simulation
- process systems engineering (PSE) tools 34, 36
- process technologies 372–7
- process understanding hot melt extrusion 356
- process validation 109, 110, 117–18, 568
- process variables
 - inferring with soft sensors 470

- process variables (*cont'd*)
 and state of control 357
- process verification, continued 568
- product
 with continuous melt extrusion 349–56
 criteria for accepting 113
 flexibility 399–400, 408
 from continuous upstream processing 254–7
 of hot melt extrusion 365–6
 launch and time to market effects 391–2
 low dose, manufacture of 551–74
 monitoring, production floor 120–1
 out of specification *see* out of specification material
 quality
 and batch release 116
 and regulatory environments 113
 and steady-state operation 453–4
 type and design of systems 406–7
- product costing with activity model 495
- product inhibition 230, 231, 232
- product life cycle 503
- product performance drivers 370
- protein concentration 234
- proteins
 cell culture products 255–6
 continuous production problems 247–8
 recombinant, upstream processes for 252
 single cell proteins 240–1, 242
- prototyping
 3D printing in 542
 drug delivery systems 540–1
- PSD *see* particle size distribution
- PSE 425, 436
see also gPROMS
- Purdue University 2, 86
- purification processes 374–5, 377
- push-mode inkjet technology 531
- push/pull scheme (throughput control) 455
- Python 425
- QbD (Quality by Design) 8, 36, 37, 447, 486
 and biopharmaceuticals 271, 272
 and bioprocessing 371, 372
 and crystallization 170
 and design of integrated systems 409, 442
 and future medicines 508
 and liquid dispensing technology 553, 554
 regulatory environment 108, 110, 115, 237
 and roller compaction 326
- quality
 and batch release 116, 568
 in continuous manufacturing 115–23
 and conventional tablet manufacturing 567–8
 in hot melt extrusion 349, 350
 and regulations 109, 112
- quality assurance
 and batch release 568
 real-time 4, 9, 405
- Quality by Design *see* QbD
- quality control 370
 and absence of steady-state operation 453–4
 buffer tanks provide opportunity for 465
- quality product target profile (QPTP) 486–7
- quality risk management, FDA guidance on 109
- quality systems, FDA guidance on 109
- quasi-continuous manufacturing 1
- quasi-plug flow 128
- R2⁺/R4 reactor (Vapourtec) 155
- radial mixing 291, 418–19
- Raman spectroscopy 234
 and crystallization 215
 and flow technology 146, 148
 for hot melt extrusion 360–1
- ranking in early decision-making 498, 502
- rapamycin derivative 533
- rasagiline mesylate 534, 538
- Rasilez (UK brand name) 151
- rate
 of growth of crystals 179
 of nucleation 177, 475–7
 of reaction, increasing 132–9
- rational approach 488, 503
- raw materials 410–11
 and crystallization 181–2
 extrusion of 338–41
 modeling in feeders 53–5
 and regulations 112, 116, 119
 variability 110, 121
see also materials
- RDT (residence time distribution) MSMPRs 186
- React-IR DiComp probe 160
- reaction activation tools 130–9
- reactivity, increased 370
- reactors
 bio- *see* bioreactors
 for continuous upstream processing 255–6
 for crystallization 171–3
see also crystallizers

- CSTRs 22, 173, 254, 255–6
 flow 130, 131, 171, 172, 198–206
 types of 21–3
- real-time measurements applied to
 crystallization 207, 208
- real-time monitoring 233, 432, 435
- real-time product quality information 108
- real-time quality assurance 9, 109, 405
- real-time quality evaluation 109
- real-time release (RTR) 9, 567–70
- real-time release testing (RTRT) 110, 112, 365
- Rebif 376
- recombinant antibodies 248–9, 274, 275
 see also antibodies
- recombinant proteins 252
- recycling 456, 458–60, 472
- reduced-order models (ROM) 47–8
 for blenders 62–3
 and feeders 55–6
- refilling 342–3, 413, 414, 416
- refolding processes 251
- regime maps 302–5
- regulatory control 236, 237
- regulatory environment 8, 108–15, 271–2, 388
 Code of Federal Regulations 123–4, 249,
 372, 568
 definitions 123–4, 249–50
 and innovative products 518, 520
- regulatory strategy 409–10
- regulatory submissions 115
- Relafen 155
- relative gain array (RGA) method 87
- relative ribbon density 319, 320, 321, 324
 as key product quality attribute 333
 off-line measurements 324–6, 327
 see also ribbon quality
- relief printing 535
 see also flexographic printing
- Remicade 242, 376
- representative stability batches 114
- Research Centre for Pharmaceutical Engineering
 (RCPE) 3
- research and development
 savings and costs 388, 392
 to commercial production 383
- research-scale inkjet models 540–1
- residence time
 in continuous fermentation 231, 232
 in transitions between unit operations 428
 see also RTD
- residence time distribution *see* RTD
- residence time function 20
- resolution, printing 537
- Reynolds number (Re) 531–2
- rheumatoid arthritis 159
- ribbon quality 324–8, 329
 see also relative ribbon density
- risk assessment 422–3
 and early decision-making 490–2
 and regulatory environments 113
- risk factors and early decision-making 488, 491
- risk scores 490–1, 492
- risk-based approach 108–9
- roll surface 315
- roller compaction 313–34
 formulative aspects of 328, 330
 in-line monitoring 326–8, 329
 powder densification in 315–17
- roller compactors 38, 39, 41
 main components of 313–15
 models for 67–71
 pressure distribution in 317–19, 320
 experimental 322–4
- rough conceptual design 406–10
- Roughton mixer 200, 210
- RTD (residence time distribution) 20–1, 46
 and blenders 60–2, 420–1
 characterising using process
 materials 412–21
 in CSTRs 22, 23
 in extruders 346, 347
 and feeders 53–4, 415
 ideal plug-flow systems 21
 impact of recycling 456, 458–60
 and material traceability 119
 micro flow technology reduces 128
 modeling 46–7, 50–1
 for tablet presses 63
 in twin-screw granulators 288–90, 291–3
 and liquid distribution 295, 297
 modeling 298–300
- RTRT (real-time release testing) 110, 112, 365
- rufinamide 155–6
- Rutgers University 2, 85
- Ryshkewitch–Duckworth equation 66
- safety issues
 reduced, with flow technology 128
 and supercritical solvents 139
 see also occupational health

- salbutamol sulfate 534
- salicylic acid 200
- sampling 110
 - of continuous fermentation processes 233
 - and model design 429–30
 - and regulatory environments 113, 114, 117
- Sanofi 275
- scale-down 26, 108
- scale-independence 566–7
- scale-out 26, 113, 127–8
- scale-up 9, 26–7, 34
 - and bioprocessing 383, 397
 - and cell retention devices 254
 - for continuous fermentation 232
 - of microtechnology 161
 - and regulatory environments 108, 113
 - safety concerns 139
 - and stability considerations 114
- scanning electron microscopy 214
- science-based approach 108–9
- Scottish Blood Transfusion Centre 248
- screen printing 526
- screw extruders 41, 338–41
 - twin-screw 345–7, 348
 - see also* extruders
- screw feeding systems 314
- Sculptify 545
- seamless/straight-through processing 249
- secondary manufacturing 4, 5, 6–7, 490
 - see also* downstream manufacturing
- secondary metastable limit 176
- secondary nucleation 174, 175, 177, 178–9
- sectioning 324–5
- seed crystals 174–5, 176
- seeded segmented tubular flow reactor 172
- seeding in fermentation 228
- segmented (slug) flow reactors 171
- semi-batch manufacturing 1
- semi-continuous manufacturing 1, 2
- semi-empirical kinetic models 209–10
- sensitivity analysis 87–8, 502
- sensor technology 375–6
- sensors 24–6, 429–30, 436
 - in biopharmaceutical manufacture 250, 270–3
 - in closed-loop systems 435
 - in continuous tablet manufacture 88, 451
 - in control frameworks 438–9, 440
 - for crystallization 210, 211
 - FDA categorisation of 270
 - with hot melt extrusion 360
 - NIR *see* NIR sensors
 - soft sensors 469–70
 - software sensors 308
 - see also* PAT
- separation techniques 139–42
- shape dynamics in granulators 295, 296
- shaping calender 351
- shear stresses in roller compaction 323–4
- shear-mode inkjet technology 531
- shearing forces in powder densification 315, 316
- shutdown *see* startup and shutdown
- Siemens 439, 451
- Simatic PCS7 (Siemens) 451
- Simca P+ 438, 439
- simulation 427, 437
 - for blenders 58, 59
 - and computerized drug design 514–15, 518, 519
 - for continuous roller compaction 332
 - for feeders 53
 - particle-scale 305–7
 - for tablet presses 63
 - see also* process simulation
- simulation software 425, 426
 - gPROMS 436
- Simulect 242
- single cell proteins (SCP) 240–1, 242
- single pass tangential flow filtration 260, 261
- single-phase balances 16
- single-use technology 266, 268–70, 371, 373
 - and cell separation 374
 - and facility design 379, 380–1
 - sensors 376
 - UV-C viral inactivation devices 375
 - see also* disposable equipment
- Sintermask GmbH 545
- SiPAT (PAT data management platform) 439, 440
- site visits by regulators 111
- slip region (compactors) 315–16
- soft sensors 469–70
- soft-gel manufacturing 554
- software sensors 308
- solid dosage pen 512
- solid drug products
 - formulations 511–13
 - manufacture of 33–94
 - process control in 81–93
 - processes in 38–44
 - see also* tablets

- solid feeding of extruders 341–2
- solid freeform fabrication (SFF) 546
 - see also* three-dimensional (3D) printing
- solid-liquid mixing 287, 288, 291, 293–4, 297
 - and modeling 304, 306–7
- solids, modeling of 35
- solubility 176, 214
 - poor 472–4, 535
- solution NMR 215
- solvent-free conditions 138–9
- solvents
 - and crystallization 182–3
 - supercritical 139
- L-sorbose 192–3
- space gained 391
 - see also* footprint
- spectroscopy 207–9, 233–4
 - FTIR 144, 146, 147, 214
 - mass 150
 - mid-infrared (MIR) 234
 - near infrared *see* NIR (near-infrared) spectroscopy
 - NMR 147, 149–50, 215
 - Raman 146, 148, 215, 234, 360–1
 - terahertz 215
 - UV-vis 147, 149
 - see also* imaging; PAT
- spherical crystallization 195–6
- spherical crystallization of benzoic acid 195–6
- squeeze-mode inkjet technology 531
- stability 114–15, 441–2
- stacked systems 525
- Standard Guide for Application on Continuous Processing in the Pharmaceutical Industry* 371
- startup and shutdown 453–4, 464–5
 - in biopharmaceutical manufacture 257
 - in continuous fermentation processes 236
 - reducing delays due to 250–1
 - in regulations 112, 116–17
- state of control 112, 116, 117–22, 357
 - definition 124, 357
- static mixers 171, 172
- statistical modeling approaches 307
- steady-state 48, 254, 273
 - absence of 453–4
- STELARA 242
- stents, drug-eluting 533
- stick deposition moulding (SDM) 545
- stirred tank 186
 - see also* CSTRs
- strain development 228
- strand cutting 352–3
- Stratasys 543
- Strathclyde University 2
- strength of tablets 328, 330
- struvite 191
- substrate inhibition 230, 231, 232
- supercritical fluids 176
- supercritical solvents 139
- superheated conditions 132–4
- supersaturation 173–6, 177, 212–13
- supervisory control 236, 237, 432
- supply chain 8–9, 381, 393, 395
 - bullwhip effect 393–4
 - of the future 395–400
 - increased flexibility 370
 - for innovative products 520–1
- surface forces in microenvironments 142
- surface tension 531–2, 534, 535
 - for separation 142
- suspension formulation 534–5
- synTQ (PAT data management platform) 439, 440
- Syrris 3, 131, 161
- system boundaries and early
 - decision-making 488, 489
- system dynamics 452–68
- tablet press 38–9, 43
 - modeling 63–7, 78, 80
- tablets 38
 - from films 474–7
 - formulation 511–13
 - and roller compaction 328, 330
 - manufacture 33–94, 381–95
 - critical control variables 86–7
 - injection molding in 35
 - integration of units 448–52
 - liquid dispensing technology in 552, 555–70, 574
 - novel tableting 471
 - processes control 81–93
 - processes in 38–44
 - roller compaction in 313, 330–2
 - shaping calendars in 351
 - next generation 396–9
 - printing technologies for 533, 546
 - properties 66
 - and ribbon quality 324

- tadalafil, suspensions containing 538, 539
- tanks in series (TIS) approach 298–300
- technical feasibility 488, 490–2, 495
- technical-economic evaluation
methodology 486–503
- techno-economic profile (TEP) 488
- technology transfer 114
- Tekturna 151
- temperature *see* operating temperature
- TEP (techno-economic profile) 498
- terahertz spectroscopy 215
- ThalesNano 3, 131, 155
- theophylline, printing of 533–4, 540
- theoretical modeling
coupled with experimental data 298, 300, 308
of twin-screw wet granulation process 284
see also modeling
- therapy, individualized 508–9
- thermal gravimetric analysis 215
- thermal inkjet (TIJ) printers 528, 529–30
for deposition of APIs 533
for drug delivery systems 534
ink for 531
- thermal range with flow technology 128
- thioquinazolinones 156
- three-dimensional (3D) printing 514, 516, 518,
541–6
and LDT compared 554
in pharmaceutical applications 525, 545–6
- 3D Systems Inc 545–6
- L/D-threonine 197
- time to market 391–2
- total installed cost (TOT) 498
- traceability 113, 116, 412, 415
- tracers 20–1, 46, 415, 416
and blenders 420
in twin-screw granulator investigations 289
- transient models 48
- transient states 112, 116–17
- transitions between unit operations 428, 430
- transport model, one-dimensional 298
- Tricor tablets 474
- tubular blenders 415–21
- tubular crystallizers 172, 185
- tubular pipes as crystallizers 199
- Tufts Centre for the Study of Drug
Development 502
- tumors 154, 509
see also cancer
- turbidostat operation 231, 254
- turret 63
- twin-screw extruders 345–7, 348
- twin-screw granulation 283–308
granule size evolution in 294–7
model-based analysis 284, 298–302
- twin-screw granulators (TSG) 284, 300
- twin-screw loss in weight feeders 341, 342
- UCB 3
- ultrafiltration 260
- ultrasound
and crystallization 192, 193, 204
fouling reduction with 173
- Umetrics, Simca P+ by 438
- uncertainty analysis 502
- Uniqsis 3, 131, 155, 161
- unit operations 11–15, 39–44
in biopharmaceutical manufacturing 257
characterising, using actual process
materials 412–21
in continuous manufacture of aliskiren
hemifumarate 448–52
disposable 268–70
integration of 447–80
models 48–81, 422–7
reducing numbers of 471
roller compaction as 313, 330–2
- United States 8
Food and Drug Administration *see* FDA
- University of Basel 2
- University of Eastern Finland 3
- University of Puerto Rico 2, 85
- University of Southern California 542
- Unscrambler X 438, 439
- upstream processing 38
continuous 251–7, 376, 452
monitoring and control 272, 468
see also primary manufacturing
- US 8
FDA *see* FDA
- ustekinumab 242
- UV sensors 451, 461–4
- UV-C viral inactivation devices 375
- UV-vis spectroscopy and flow technology 147,
149
- Vapourtec 3, 155, 161
- variables in model development 422–3, 434
- VDI guidance 488
- velocity gradient through ribbon thickness 321

- verification 568
 - continuous process verification (CPV) 110, 117–18
 - continuous quality verification (CQV) 109
 - of control framework 438–40, 441
 - in model development 423
- Vertex 3, 381, 486
- virus inactivation/removal 248, 259, 375
- viscosity
 - of drug-containing liquids 534, 538–9
 - of inks 531, 532, 535
- vitamin C (ascorbic acid) 192–3
- volumetric efficiency 231
- volumetric feeding 341, 343–4, 412–13

- Weber number (We) 531–2
- weighing platforms 413

- weighting factors in decision-making 492, 498, 502
- wet granulation 38, 39, 42
 - and design of systems 407
 - models for 71–5
 - scaling-up problems 26–7
 - twin-screw 283, 284–7
 - typical horizontal line 384–5
- Wolfram Alpha Ltd 425

- X-ray micro-computed tomography (X-ray CT) 324–5
- X-ray powder diffraction 214

- yield 471, 472

- Zoladex (AstraZeneca) 365