# Presentazione: Carry-over of impurities from materials for API Synthesis

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data: 02/10/2015



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# Carry-over of impurities from materials for API Synthesis

The evaluation of potential carry-over of impurities is important for:

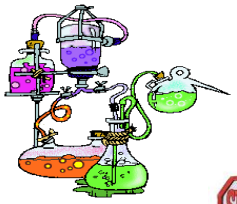
- Define the impurity profiling of API

- Define suitable specification for API
- Improve the knowledge of the manufacturing process
- Set up process parameters/in process control (IPC)

# Possible source of contamination

Residues of Raw Materials, SM, intermediates etc..

Residues of by-products

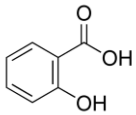


Residues of degradation products


Materials used during manufacturing

Residues of detergents/sanitizers

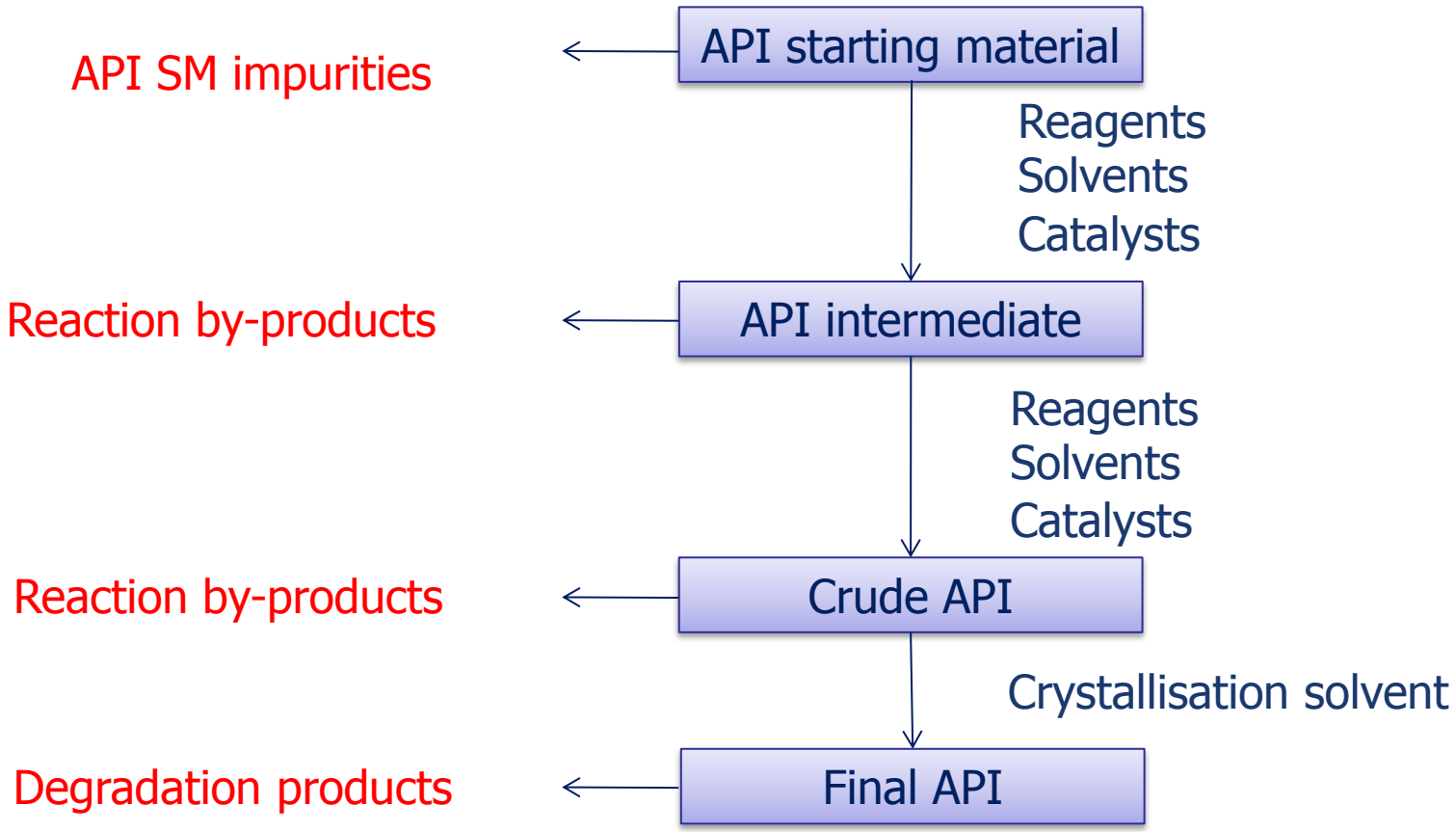
Residues of other API productions




Microbial contaminants, endotoxins

Quality Aspects ⇄ GMP Aspects

# Potential impurities in API Synhesis



# Potential impurities in API Synhesis

- Residue of the SM
- Residue of the intermediate
- Impurities in the SM
- Reagents
- Solvents
- Catalysts
- Reaction by-products
- Degradation products

# API Starting Material definition

ICH Q7:

*An "Active Substance Starting Material" is a raw material, intermediate, or an active substance that is used in the production of an active substance and that is incorporated as a significant structural fragment into the structure of the active substance.*

*From this point on, appropriate GMP as defined in these guidelines should be applied to these intermediate and/or active substance manufacturing steps.*

# API Starting Material

**Table 1: Application of this Guide to API Manufacturing**

| Type of Manufacturing | Application of this Guide to steps (shown in grey) used in this type of manufacturing | | | | |
|---|---|---|---|---|---|
| Chemical Manufacturing | Production of the API Starting Material | Introduction of the API Starting Material into process | Production of Intermediate(s) | Isolation and purification | Physical processing, and packaging |
| API derived from animal sources | Collection of organ, fluid, or tissue | Cutting, mixing, and/or initial processing | Introduction of the API Starting Material into process | Isolation and purification | Physical processing, and packaging |
| API extracted from plant sources | Collection of plant | Cutting and initial extraction(s) | Introduction of the API Starting Material into process | Isolation and purification | Physical processing, and packaging |
| Herbal extracts used as API | Collection of plants | Cutting and initial extraction | | Further extraction | Physical processing, and packaging |
| API consisting of comminuted or powdered herbs | Collection of plants and/or cultivation and harvesting | Cutting/ comminuting | | | Physical processing, and packaging |
| Biotechnology : fermentation/ cell culture | Establishment of master cell bank and working cell bank | Maintenance of working cell bank | Cell culture and/or fermentation | Isolation and purification | Physical processing, and packaging |
| "Classical" Fermentation to produce an API | Establishment of cell bank | Maintenance of the cell bank | Introduction of the cells into fermentation | Isolation and purification | Physical processing, and packaging |

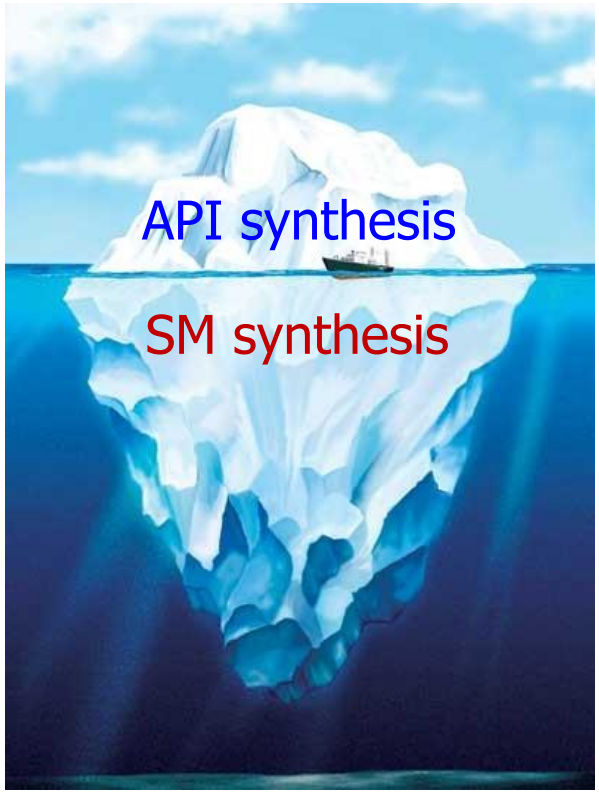
# Selection of API Starting Material

Choice of API-SM in the route of synthesis


-ICH Q11:

*Manufacturing steps that impact the impurity profile of the drug substance should normally be included in the manufacturing process described in section 3.2.S.2.2 of the application;*

# Carry over of impurities/solvents from the Starting Materials




Reflection Paper EMA/448443/2014 - 16/09/2014

- The specification for a starting material should address impurities and is expected to consider suitable limits for known, unknown impurities and total impurities and where appropriate, limits for solvents, reagents and catalysts used during synthesis of a starting material.
- Moreover, the potential carry-over of impurities/solvents in the API should be discussed.

*Information on the manufacturers and suppliers of starting materials should be provided, including name and address, and a scheme of the synthetic route used to manufacture them, showing all reagents, catalysts and solvents used. Without this information, the suitability of specifications cannot be adequately assessed.*

# Residues of raw materials

- Solvents: demonstrate the absence of particular solvents in the API used in particular production steps (e.g. in the last step) or set a limit in API specifications (or in suitable intermediate). This evaluation should be consider Class 1 solvents (eg. Benzene) as contaminants of other solvents. *ICH Q3C and related Annexes*

- Residues of catalysts: Demonstrate absence of residues of catalysts or set a limit in API specifications (or suitable intermediate).

  *EMEA draft guideline on catalysts (CPMP/SWP/4446/00)*

- Residues of Reagents: demonstrate the absence of particular reagents in the final substance or set a limit in API specifications (or in suitable intermediate). *ICH Q3A*

# Carry over of inorganic/organic impurities

ICH Q3A:

- Inorganic Impurities

*Inorganic impurities are normally detected and quantified using pharmacopoeial or other appropriate procedures. Carry-over of catalysts to the new drug substance should be evaluated during development. The need for inclusion or exclusion of inorganic impurities in the new drug substance specification should be discussed. Acceptance criteria should be based on pharmacopoeial standards or known safety data.*

- Organic Impurities

*The applicant should summarise the actual and potential impurities most likely to arise during the synthesis, purification, and storage of the new drug substance.*

# Acceptance criteria for organic impurities

ICH Q3A:

| Maximum Daily Dose[1] | Reporting Threshold[2,3] | Identification Threshold[3] | Qualification Threshold[3] |
|---|---|---|---|
| ≤ 2g/day | 0.05% | 0.10% or 1.0 mg per day intake (whichever is lower) | 0.15% or 1.0 mg per day intake (whichever is lower) |
| > 2g/day | 0.03% | 0.05% | 0.05% |

*Organic Impurities*

- Each specified identified impurity
- Each specified unidentified impurity
- Any unspecified impurity with an acceptance criterion of not more than (≤) the identification threshold
- Total impurities

# Detection of impurities by suitable validated analytical method

Impurities methods described in EP monographs?

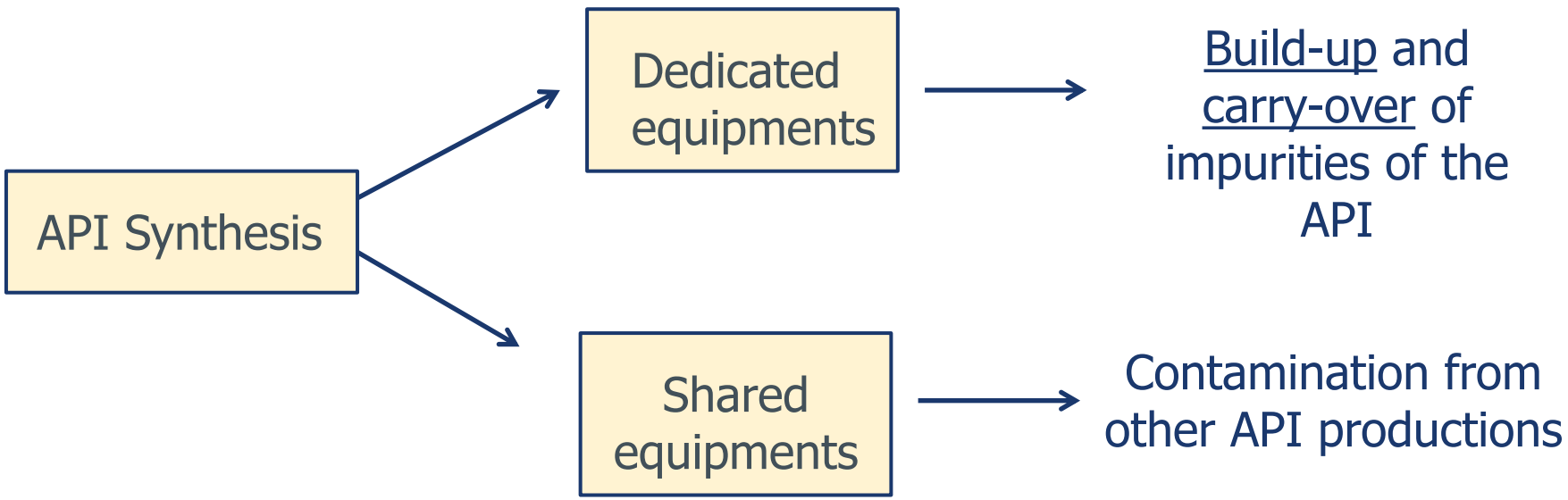
yes → No complete validation is required

↓ No

Complete validation is required according to the ICH Q2 (R1)

→ Verification of specificity, linearity, accuracy, precision, robustness, etc…

# Potential carry-over in dedicated and shared equipments



# Carry-over of impurities in dedicated Equipment

Cleaning Validation of equimpments to defines:

1. Maximum campaign lenght;
2. Cleaning procedure;
3. Clean Holding time (CHT): the time between the completion of cleaning and the beginning of the next manufacturing operation.
4. Dirty Hold time (DHT): the time between the end of manufacturing and the beginning of cleaning procedure.

EU GMP Part II:

*Equipments maintenance and cleaning: 5.23 Where equipment is assigned to continuous production or campaign production of successive batches of the same intermediate or API, equipment should be cleaned at appropriate intervals to prevent build-up and carry-over of contaminants (e.g. degradants or objectionable levels of micro-organisms).*

Cleaning Validation of dedicated equipment

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# Potential contamination in shared equipments/facilites

EU GMP Annex 15:

*Cleaning validation: 10.6 Limits for the carryover of product residues should be based on a toxicological evaluation. The justification for the selected limits should be documented in a risk assessment which includes all the supporting references. Limits should be established for the removal of any cleaning agents used. Acceptance criteria should consider the potential cumulative effect of multiple items of equipment in the process equipment train.*

EMA/CHMP/CVMP/SWP/169430/2012 "*Guideline on setting health based exposure limits for use in risk identification in the manufacture of different medicinal products in shared facilities*"

# Potential contamination from materials

Many materials used during production could represent a source of contamination if not removed or if mainteinence and/or assembling of the equipment are not performed correctly

•charcoal,

•paper particles from filters,

•monomers released by polymeric resins

•lubricants from motors and bearings,

•fiber from personnel garments ,

•small slivers of stainless steel,

•etc…..

# Potential contamination from materials

EU GMP Part II:

*Sanitation and Maintenanance: 4.70 Buildings used in the manufacture of intermediates and APIs should be properly maintained and repaired and kept in a clean condition.*

*Process equipment: 5.14 Any substances associated with the operation of equipment, such as lubricants, heating fluids or coolants, should not contact intermediates or APIs so as to alter their quality beyond the official or other established specifications. Any deviations from this should be evaluated to ensure that there are no detrimental effects upon the fitness for purpose of the material. Wherever possible, food grade lubricants and oils should be used.*

*Contamination control: 8.51 Production operations should be conducted in a manner that will prevent contamination of intermediates or APIs by other materials.*

# Potential contamination from utilities

EU GMP Part II:

*Utilities: 4.20 All utilities that could impact on product quality (e.g. steam, gases, compressed air, and heating, ventilation and air conditioning) should be qualified and appropriately monitored and action should be taken when limits are exceeded. Drawings for these utility systems should be available.*

*HVAC system*

*Water production/distribution*

*Nitrogen storage/distribution*

*Qualified and monitored*

# Stressfull production steps

*The potential impact of some manufacturing steps on the impurity profiling of API should be evaluated*

*- Milling/Micronization steps*

*- Gamma Radiation Sterilization*

# Conclusions

*The evaluation of impurities' carry-over and its monitoring is a complex exercise which involves many quality and GMP aspects….*

*R&D*

*QA*

*Production*

*Maintenance*

*QC*

*Regulatory*


*Engineering*


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