

# Contents

<b>1</b>	<b>Introduction</b>	<b>13</b>
1.1	Background	13
1.2	Purpose and Objectives	13
1.3	Scope and Usage	13
1.4	Structure of the Manual	14
<b>2</b>	<b>Fundamental Considerations</b>	<b>17</b>
2.1	The Term “Containment”	17
2.2	Primary and Secondary Containment	17
2.3	Thresholds and Hazard Categories of Highly Potent Substances	18
2.4	Thresholds for Planning an Equipment	20
2.5	Regulatory and Legal Requirements	21
2.6	Basic Concepts	22
2.6.1	Building Concept	22
2.6.2	Organizational Measures	23
2.6.3	Flow of Personnel	23
2.6.4	Flow of Material	23
<b>3</b>	<b>Risk Assessment</b>	<b>27</b>
3.1	Risks	27
3.2	Risk Management Process	27
3.3	Methods	28
3.4	Risk Assessments in the Manufacture of Highly Potent Substances	29
<b>4</b>	<b>Life-Cycle of Containment Solutions</b>	<b>33</b>
4.1	Conception, Planning	33
4.2	Procurement	33
4.3	Design	33
4.4	Commissioning, FAT, SAT	34
4.5	Production, Use of Equipment	35
4.6	Repair and Maintenance	35
4.7	Cleaning	36
4.8	Decommissioning	37
<b>5</b>	<b>Process Requirements</b>	<b>41</b>
5.1	Pharmaceutical Production	41
5.1.1	Dispensing Area (Assembling, Weighing, Mixing, Dissolving)	41
5.1.1.1	Weighing the Active Pharmaceutical Ingredients	42
5.1.1.2	Inwards and Outwards Transferring	43
5.1.1.3	Transferring the APIs to the Mixing Tank	44
5.1.1.4	Connecting Product Tubes/Pipes	45
5.1.2	Granulation and Drying	46
5.1.2.1	Mixer for Wet Granulation	46
5.1.2.2	Mixer for Spray Granulation	48
5.1.2.3	Fluid-Bed Granulator	49
5.1.2.4	Single Pot Mixer Granulator	51
5.1.3	Comminution	51
5.1.3.1	Milling	51
5.1.3.2	Sieving–Sifting	54
5.1.3.3	Examples for the Usage of Milling and Screening Equipment in Containment	57
5.1.4	Tableting, Coating, Blistering	58
5.1.4.1	Tableting	58
5.1.4.2	Coating	63
5.1.4.3	Blister Packaging	65

5.1.5	Liquid Filling: Aseptic/Non-Aseptic	66
5.1.5.1	Ampoules	66
5.1.5.2	Vials	67
5.1.5.3	Disposable Syringes	67
5.1.6	Capsule Filling	67
5.1.7	Transfer from Equipment to Equipment	69
5.1.8	Lyophilisation	70
5.1.9	Goods Receiving	74
5.2	Production of Active Pharmaceutical Ingredients (APIs)	74
5.2.1	Charging	74
5.2.2	Processing	77
5.2.3	Solid/Liquid Separation	78
5.2.4	Drying	79
5.2.5	Packaging	81
5.2.6	Transfer	83
<b>6</b>	<b>Technical Systems</b>	<b>87</b>
6.1	Primary Containment	87
6.1.1	Isolators	87
6.1.1.1	Ergonomic Study (Mock-Up)	89
6.1.2	Systems with Low-Turbulence Displacement Flow (Laminar Flow Systems)	90
6.1.3	Restricted Access Barrier System (RABS)	91
6.1.4	Rapid Transfer Ports (RTP)	93
6.1.5	Split Butterfly Valve Systems	96
6.1.6	Split Cone Systems	98
6.1.7	Film Connection Systems	99
6.1.8	Sampling, Samplers	101
6.1.9	Pneumatic Conveyor Systems	102
6.1.10	Other Connections	104
6.1.11	Single-Use Technologies	106
6.1.11.1	Disposable Isolators	106
6.1.11.2	Continuous Liner Systems	108
6.1.11.3	Film Closure Systems	108
6.1.12	Local Extraction Ventilation	110
6.1.13	Safety Cabinets	113
6.2	Secondary Containment	116
6.2.1	Workspaces/Ventilation/Airlock Systems	116
6.2.2	Workspace Concept	116
6.2.2.1	Workspace without Airlocks	117
6.2.2.2	Workspace with Common Personnel and Material Airlock	118
6.2.2.3	Workspace with Separate Material and Personnel Airlocks	118
6.2.2.4	Workspace with Separate Material and Personnel Airlocks for Entrances and Exits	119
6.2.2.5	Additional Technology Zones Separate from the Workspace	119
6.2.3	Pressure Cascade Concept	120
6.2.3.1	Workspace with Positive Air Pressure	120
6.2.3.2	Workspace with Negative Air Pressure	121
6.2.3.3	Negative Pressure Corridor	121
6.2.4	Cleanroom Classifications	122
6.2.5	Cleanrooms	122
6.2.6	Personnel Airlocks	123
6.2.7	Material Airlocks (incl. Pass-throughs, Mouseholes, Gates)	124
6.2.8	Decontamination Systems (Cleaning Systems)	125
6.2.9	Ventilation	125
6.2.10	Media	126
6.3	De-Dusting/Filtration Technology	126
6.3.1	Air Filters	126
6.3.1.1	Coarse Dust Filters	129
6.3.1.2	Fine Particulate Air Filters and High-Efficiency Particulate Air Filters	129

6.3.2	Handling of Air Filters	130
6.3.3	Exposure Measurements at Filter Units	131
6.3.4	Local Aspiration and Central Aspiration	132
6.3.5	Safe Change Filter Systems	133
6.3.5.1	Push-Push Filter Systems	133
6.3.5.2	Bag-In/Bag-Out Change Method (BIBO)	133
<b>7</b>	<b>Occupational Hygiene/ Industrial Hygiene Validation</b>	<b>141</b>
7.1	Basic Principles	141
7.2	Strategy	141
7.3	Validated Sampling Method	141
7.4	Validated Sample Analysis	143
7.4.1	Selectivity and Specificity	144
7.4.2	Linearity	144
7.4.3	Limit of Detection and Limit of Quantification	144
7.4.4	Precision and Accuracy	144
7.4.5	Recovery Rate	145
7.5	Procedure	145
7.6	Evaluation of the Occupational Hygiene Measurement Results	147
<b>8</b>	<b>Cleaning/Waste Treatment</b>	<b>151</b>
8.1	Process Systems	151
8.1.1	Treatment of Production Wastes	151
8.1.2	Treatment of Packaging Wastes	152
8.1.3	Treatment of Filter Wastes	152
8.1.4	Treatment of Cleaning Wastes	152
8.2	Rooms	153
8.3	Airlocks	153
8.3.1	Material Airlocks in Containment Systems	153
8.3.2	Waste Airlocks in Containment Systems	153
8.3.3	Personnel, Material, and Waste Airlocks in Production Rooms and Sections	154
8.4	Cleaning Media	154
8.4.1	Water as a Cleaning Medium	154
8.4.1.1	Background	154
8.4.1.2	Types of Water Used	154
8.4.1.3	Detergents and Cleaning Agents	154
8.4.1.4	Washing Procedures	154
8.4.1.5	Various Cleaning Cycles	155
8.4.2	Disposal of Wastewater	155
8.5	Contaminated Waste	156
8.6	Post-Treatment of Wastes	156
<b>9</b>	<b>Personnel</b>	<b>159</b>
9.1	Training	159
9.2	Exposure Monitoring	160
<b>10</b>	<b>Appendix</b>	<b>163</b>
10.1	List of Abbreviations	163
10.2	Literature	167
10.3	List of Figures and Tables	168