Visual Inspection of Injectable Products:

Myth Busting …

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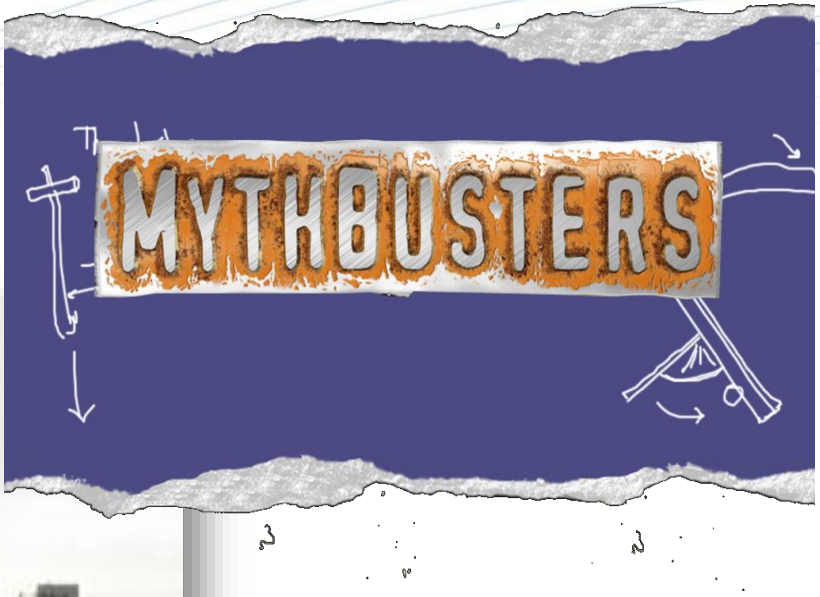
Agenda

- Inspection Myths
- Conclusions
- References and Acknowledgements

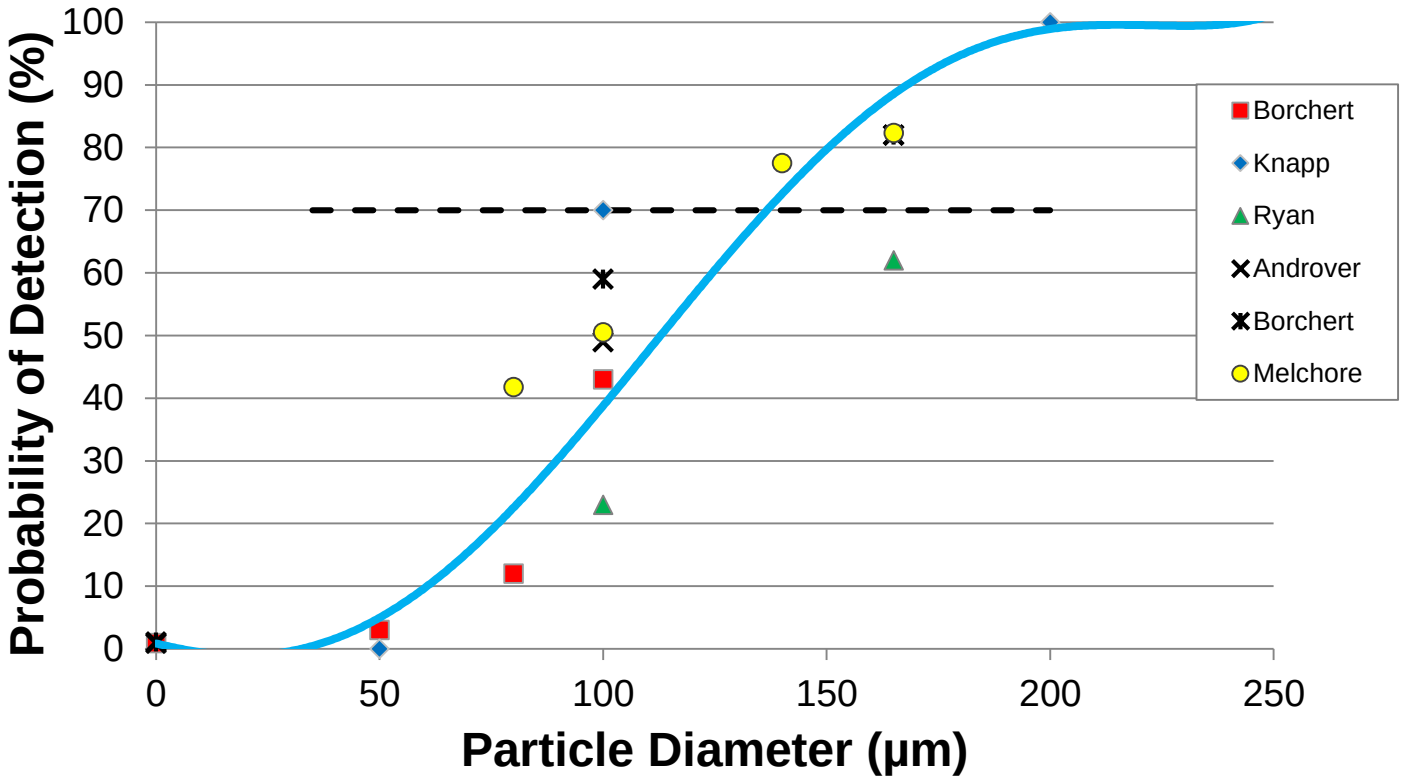
Inspection Myths



Inspection Myth #1

- 100% inspection means detection and elimination of all visible defects (e.g. particulate matter, cracks, etc.)
  - Inspection is a probabilistic process.
  - Detection probability is dependant on inspection conditions and defect characteristics.
  - Particles <200 um generally have a detection probability <100%.

Human Inspection Performance



From Shabushnig, Melchore, Geiger, Chrai and Gerger, PDA Annual Meeting 1995

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Inspection Myth #2

- Human manual inspection is a “validatable” process.
  - Human inspectors are not validatable
  - Qualified human inspectors can provide reliable performance
    - Define selection and training criteria
    - Control inspection conditions
      - Light, Background, Duration
      - SOP’s

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Inspection Myth #3

- Magnification always improves human manual inspection performance.
  - Inspectors will move head position to minimize eye-strain during extended inspection, reducing apparent magnification.
  - Controlled studies have not found increased detection of particulates or container defects with 3x magnification.

Detection Rate with Magnification

	5 mL		30 mL	
	No Mag	Mag	No Mag	Mag
Product	50.0%	37.5%	18.6%	18.6%
Container	37.5%	37.2%	45.4%	44.6%
Closure	62.3%	54.2%	72.5%	68.2%
All Defects	50.6%	46.0%	53.6%	51.4%
Good	0.5%	0.9%	2.0%	0.6%

Semi-automated inspection at 55 VPM, lyo test set, n=1000, 3x mag

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Inspection Myth #4

- If you use a sampling plan with an AQL of 0.1% and do not exceed the accept number in your sample, the defect rate in your batch will not exceed 0.1%.
  - AQL is the Acceptable Quality Level and is the defect rate where the rejection probability is 5%. 95% of batches with this defect rate will be accepted. This is a measure of the risk of rejecting good batches.
  - The UQL is the Unacceptable Quality Level and is the defect rate where the rejection probability is 90% for the batch.

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Conclusions

Conclusions

- Current industry performance is generally at or beyond the limits of medical risk.
- Compendial guidance is ambiguous, but getting better.
- “Zero defects” is a valuable goal, not a practical limit for particulate matter.
- Need to develop practical limits based on risk assessment and process capability measures.

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- PDA Technical Report No. 76: Identification and Classification of Visible Nonconformities in Elastomeric Components and Aluminum Seals for Parenteral Packaging (2016)
- PDA Technical Report No. 79: Particulate Matter Control in Difficult to Inspect Parenterals (2018)

Regulatory & Compendial

- US Pharmacopoeia (USP)
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  - <787> *Subvisible Particulate Matter in Therapeutic Protein Injections*
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  - <789> *Particulate Matter in Ophthalmic Solutions*
  - <790> *Visible Particulates in Injections*
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  Subpart B – Organization and Personnel
  - 211.25 Personnel qualifications

  Subpart C – Buildings and Facilities
  - 211.42 Design and construction features
  - 211.56 Sanitation

  Subpart D -Equipment
  - 211.63 Equipment design, size and location
  - 211.65 Equipment construction
  - 211.67 Equipment cleaning and maintenance
  - 211.68 Automatic, mechanical, and electronic equipment

Regulatory & Compendial

- US Code of Federal Regulations (CFR) 211 Food and Drugs

  Subpart E - Control of Component and Drug Product Containers and Closures

  – 211.80– General requirements
  – 211.84 Testing and approval or rejection of components, drug product containers, and closures
  – 211.94 Drug product containers and closures

  Subpart F – Production and Process Controls

  – 211.100 Written procedures: deviations
  – 211.110 Sampling and testing of in-process materials and drug products

  Subpart I – Laboratory Controls

  – 211.160 Laboratory controls – general requirements
  – 211.165 Testing and release for distribution

Regulatory & Compendial

- US Code of Federal Regulations (CFR) 211 Food and Drugs

  Subpart J – Records and Reports

  - 211.188 Batch production and control records
  - 211.192 Production record review
  - 211.194 Laboratory records
  - 211.198 Complaint files

  Subchapter F - Biologics

  - 600.10 Personnel
  - 600.11 Physical establishment, equipment, animals, and care

Regulatory & Compendial

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Conferences and Meetings

- PDA Visual Inspection of Parenterals Interest Group
- PDA Visual Inspection Forums

Equipment Vendors

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  - Sovizzo, Italy www.brevetti-cea.com
- Bonfiglioli Engineering, S.r.l.
  - Vigarano Pieve, Italy www.bonfigliolienginеering.com
- Dabrico, Inc.
  - Kankakee, IL www.dabrico.com
- Eisai Machinery Co., Ltd. (Bosch)
  - Tokyo, Japan www.eisai-mc.co.jp/english
- InnoScan K/S (Stevenato Group)
  - Braband, Denmark www.innoscan.dk

Equipment Vendors

- Optrel (Stevenato Group)
  - Padova, Italy www.optrelinspection.com
- Phoenix Imaging
  - Livonia, MI www.phoeniximaging.com
- Seidenader Maschinenbau, GmbH (Korber)
  - Munich, Germany www.seidenader.de
- Unchained Labs (Rap.ID Particle Systems)
  - Pleasanton, CA www.unchainedlabs.com
- Victor International Marketing, Inc.
  - Morristown, NJ, www.victorinternational.com
- Wilco AG
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Standards Vendors

Standard Particles:

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  - Palo Alto, CA www.dukescientific.com
- Mo-Sci Corp.
  - Rolla, MO www.mo-sci.com
- National Institute of Standards (NIST)
  - Gaithersburg, MD www.nist.gov
- Poly Sciences, Inc.
  - Warrington, PA www.polysciences.com

Standards Vendors

Finished Standard Containers:

- Material Analytischer Service (M.A.S.)
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- Micro Measurement Laboratories, Inc.
  - Wheeling, IL www.mmlabs.com
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  - Monroeville, PA www.rjlg.com
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Questions

Remember, everyone is an inspector …