

HLL BIOTECH LIMITED, CHENNAI

INTEGRATED VACCINES COMPLEX, CHENGALPATTU

nne pharmaplan®

User Requirement Specifications

Equipment/System	Lyophilizer		
Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02
Effective Date:	13-12-2013	Revision No:	03




User Requirement Specifications Lyophilizer

Process Code	Area	Equipment ID	Quantity	Capacity
F1	Viral vaccine formulation area (Measles)	F1-LYO 02	1	20 m ²

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	Effective Date:	13-12-2013	Revision No:		03


URS Annexure List

URS Annex No.	Detail
1.	Layout showing location of the Lyophiliser technical area
2.	List of components and make
3.	Process Flow Diagram for transfer of lyophiliser loading and unloading cart
4.	Specifications of Vials

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INTEGRATED VACCINES COMPLEX, CHENGALPATTU

nne pharmaplan®	User Requirement Specifications			
	Equipment/System	Lyophilizer		
	Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02
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Table of Contents

1.0	APPROVAL SIGNATURE	4
2.0	EQUIPMENT DESCRIPTION	5
3.0	PROCESS DESCRIPTION	7
3.1	INPUT & CHARGING METHOD.....	7
3.2	BRIEF PROCESS STEPS.....	7
3.3	OUTPUT & DISCHARGING METHOD	7
4.0	PRODUCTIVITY REQUIREMENT	7
4.1	DESIRED/ SUGGESTED CAPACITY	7
4.2	STANDARD BATCH SIZE.....	7
4.3	CHANGE OVER TIME (IF APPLICABLE)	8
4.4	OTHER PRODUCTIVITY REQUIREMENT.....	8
5.0	CONTAINMENT	8
6.0	GMP REQUIREMENTS	8
6.1	PROCESS CONTROL.....	8
6.2	FAILURE MODE DETECTION	9
6.3	IN –PROCESS CONTROL	9
6.4	LEVEL OF INSTRUMENTATION	10
6.5	BATCH DATA DISPLAY AND RECORD.....	11
6.6	GMP REQUIREMENTS (OTHERS).....	11
6.7	SPECIFIC REQUIREMENTS	11
7.0	CONSTRAINTS	25
7.1	EQUIPMENT LOCATION AND AVAILABLE SPACE.....	25
7.2	AVAILABLE UTILITY	26
8.0	ABBREVIATION	27

HLL BIOTECH LIMITED, CHENNAI

INTEGRATED VACCINES COMPLEX, CHENGALPATTU

nne pharmaplan®	User Requirement Specifications				 <div>HLL BIOTECH LIMITED (Subsidiary of HLL Lifecare Limited) (A Government of India Enterprise)</div>
	Equipment/System	Lyophilizer			
	Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02	
	Effective Date:	13-12-2013	Revision No:	03	

1.0 Approval Signature

This document is prepared by the Process, Validation and GMP Compliance team of “NNE Pharmaplan India” for the project “Integrated Vaccine Complex, Chengalpattu, Chennai” (**project number:** 120310) of HLL BIOTECH LIMITED (Chennai) under the authority of their Project Manager. Hence, this document before being effective shall be approved by the QA team of HLL BIOTECH LIMITED, and authorized by the appropriate Project Authority

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HLL BIOTECH LIMITED, CHENNAI

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nne pharmaplan®	User Requirement Specifications				 <div>HLLBIOTECH LIMITED (Subsidiary of HLL Lifecare Limited) (A Government of India Enterprise)</div>
	Equipment/System	Lyophilizer			
	Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02	
	Effective Date:	13-12-2013	Revision No:	03	

2.0 Equipment description

The Lyophilizer shall be used to freeze-dry the Viral vaccine filled in half-stoppered glass vials (Refer URS **annexure-4** for specifications of vials). The fill volumes shall be 0.6ml or 1.2ml (10% overage will be considered over the fill volume). Lyophilizer shall full stopper the vial before unloading.

S. No.	Identification no.	Chamber Size
1.	F1-LYO 02	20 m ²

The Lyophilizer shall be of single door type for loading and unloading from the same Class A/B room. The Pizza Type door shall opening in the aseptic area for loading / unloading of vials. The vial loading and unloading shall be done with manual loading-unloading machine using transfer carts/frames. Stoppering conditions should be done in the presence of vacuum/nitrogen gas.

Whereas at the back side of the chamber opening in the technical area shall be the full body swing door for maintenance access. Accordingly, the condenser shall be placed on one side of the chamber.

As per the equipment location layout the Lyophilizer shall be horizontally configured i.e. condenser and refrigeration unit shall be installed at the back of the Lyophilizer with all accessories.

This equipment is a part of an integrated line.


The machine should consist of following parts in order to run operation smoothly

S. No.	Description	Purpose
1	Chamber with the shelves	For keeping the vials for lyophilization
2	Condenser with the cooling coil	For trapping the vapour on the coil from the chamber
3	Refrigeration system	For cooling the product as per the product specification
4	Heating system	For heating the product as per the product specification
5	Vacuum System	For creating the desired vacuum as per the product requirement
6	Hydraulic system	For movement of the shelf for auto stoppering of the lyophilized vials inside the chamber
7	Silicon oil circulating system	For transferring the heat by convection and conduction by circulation of silicon oil
8	CIP system with tank	For cleaning the lyophilizer after use
9	SIP system	For sterilizing the lyophilizer before use
10	Loading and Unloading System (Not in Lyophilizer vendor scope)	For loading the vials in to the chamber shelf and unloading the vials from the shelf for sealing.
11	Aeration system with provision for filter integrity test	To validate the filter integrity

All points of the IRS except below mentioned would be applicable for the equipment

HLL BIOTECH LIMITED, CHENNAI

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nne pharmaplan®	User Requirement Specifications			 <div>HLLBIOTECH LIMITED (Subsidiary of HLL Lifecare Limited) (A Government of India Enterprise)</div>	
	Equipment/System	Lyophilizer			
	Identification No:	F1-LYO 02	Document No:		URS/F1-LYO 02
	Effective Date:	13-12-2013	Revision No:		03

- 4.1.11, 4.1.13, 4.1.17
- ANSI/NSF 49-2008

Note:

I.	This Technical Specification is the basis for an inquiry to a vendor and therefore the basis for the vendor's proposal.
II.	The vendor is asked to state in "REMARKS" column with "yes" if the described requirement will be completely fulfilled and with "no" in case the requirement will not or cannot be fulfilled with the proposed equipment. In case of any deviation a comment must be inserted or enclosed as a separate annexure by referring to the respective URS specification number.
III.	The vendor must clearly comment each item of the Technical Specification. The comments must be in English language. If extra cost for necessary options becomes necessary the item must be clearly stated.
IV.	In case that the requirement includes a question or request or information from the vendor, the answer / information should be stated in the "REMARKS" column.
V.	The final version of this document including the vendor's comments will become basis of a potential purchase order or contract.
VI.	The Technical Specification serves to define a summary of all vendor's requirements concerning scope of delivery and services.
VII.	The vendor is responsible for technically unobjectionable function of the equipment. This TS is not intended to dictate a technical design to the vendor. If agreed upon with the vendor, the vendor can apply his practically proven design.
VIII.	Special Instruction <ol style="list-style-type: none"> If no comments against any specification shall be considered as "NO" and If there is no reply / comments against the complete URS by the vendor then it shall be treated as unresponsive / technically non-compliant and rejected.
IX.	All the instruments and controls mentioned in the URS(s) are expected to be standard supply and part of your standard equipment model. In case of any deviation or redundancy or additional scope of supply is noticed, vendor is required to obtain clarification from HBL before submitting the quotes.
X.	The makes requested are standard international makes. In case of any deviation, vendor to seek clarification from HBL before submitting the offers.
XI.	Refer document Installation Requirement Specification and Specific Instructions with URS; NPI-120310-IRS-F1-01
XII.	Refer Tender document with URS; NPI-120310-EQP-F1-TD-01


HLL BIOTECH LIMITED, CHENNAI				
INTEGRATED VACCINES COMPLEX, CHENGALPATTU				
nne pharmaplan®	User Requirement Specifications			
	Equipment/System	Lyophilizer		
	Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02
	Effective Date:	13-12-2013	Revision No:	03
Specifications				Remarks
3.0 Process Description				
3.1 Input & Charging method				
3.1.1. Filled and half stoppered vials: The half stoppered, filled vials will be transferred to cassetting station which will be collected on frames and transferred from the vial filling machine to the lyophilizer with the help of a mobile LAF trolley. The loading shall be manual type				
<ul style="list-style-type: none"> Input: Liquid solution of product filled and half stoppered glass vials. 				
3.1.2. Process air: Sterile Filtered compressed air shall be used to purge the chamber and condenser during vacuum break. Filtered compressed air is also used for drying the chamber and condenser after the SIP or CIP cycle.				
3.2 Brief Process Steps				
The Lyophilizer shall perform the following process step:				
3.2.1 Automatic leak test of the chamber along with shelves.				
3.2.2 CIP of the chamber and condenser.				
3.2.3 SIP of the chamber and condenser.				
3.2.4 Lyophilisation process.				
3.2.5 Partial aeration of the chamber with sterile nitrogen gas (optional).				
3.2.6 Stoppering of vials under vacuum.				
3.2.7 Vacuum break.				
3.2.8 Aeration of the chamber to atmospheric pressure using sterile filtered air.				
3.2.9 De-icing.				
3.3 Output & Discharging method				
3.3.1 Full-stoppered vials with lyophilized vaccine: The full-stoppered vials with the lyophilised product shall be unloaded from the shelf of the Lyophilizer. Further the vials shall be transferred to the vial sealing machine by means of a transfer cart (LAF trolley).				
4.0 Productivity Requirement				
4.1 Desired/ suggested capacity				
<ul style="list-style-type: none"> The lyophilizer shall be capable of lyophilising 80,000 vials of customised size: Refer URS Annexure-4 for specifications of vials. Each vial contains 0.6ml or 1.2ml of product. Minimum Ice capacity to be 150 kg or it is near standard with all other accessories complying with the above requirement. 				
4.2 Standard batch size				
4.2.1 Single load should contain: <ul style="list-style-type: none"> Product:-80000 vials /batch, Vial size: customized 4R vials 				
4.2.2 Process Time for Viral Vaccine:				
File Name	NPI_120310_EQP_URS_F1-LYO 02		Page No.	Page 7 of 29

HLL BIOTECH LIMITED, CHENNAI				
INTEGRATED VACCINES COMPLEX, CHENGALPATTU				
nne pharmaplan®	User Requirement Specifications			
	Equipment/System	Lyophilizer		
	Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02
	Effective Date:	13-12-2013	Revision No:	03
Specifications				Remarks
LYOPHILISATION PROCESS TIME (HRS)		VOLUME PER VIAL (ml)		
52		0.6 ml		
		1.2 ml		
<p>Note: 10% overage will be considered over the fill volume</p> <p>4.2.3 Vendor shall provide the following requirement on the basis of batch size Product: 80000 vials / batch</p> <p>a) Frame size and numbers of vials/frame b) Frame/ FD Load c) Frame per shelf</p> <p>4.2.4 Frames: The frame size need to be designed based on the quality of the glass, homogeneity, tolerance for robust loading and unloading of vials. The arrangement of the vials in the frame should be row shape.</p> <p>Note: Vendor shall supply frames capable to accommodate 80000 vials / batch and trays to accommodate 1/3rd of the mentioned capacity.</p> <p>Vendor to provide the GA drawing of the frames and trays along with the technical bid.</p> <p>The quantity of the frames should be equivalent to 1 batch.</p>				
4.3 Change Over Time (if applicable)				
Not applicable				
4.4 Other Productivity Requirement				
<p>4.4.1 The following sequence to be accomplished fully automatic within eight hours:</p> <ul style="list-style-type: none"> De-icing CIP SIP Drying in place Leak test Re-cooling Filter test 				
5.0 Containment				
Not applicable				
6.0 GMP requirements				
6.1 Process Control				
6.1.1 Shelf temperature from ambient should reach - 55°C in 90 minutes time under no load condition.				
6.1.2 Refrigerant circuit must work in overpressure also when condenser is at -70°C				
6.1.3 Shelf temperature from - 55°C up to + 40°C (standard deviation among all shelves +/- 2°C)				
File Name	NPI_120310_EQP_URS_F1-LYO 02		Page No.	Page 8 of 29



HLL BIOTECH LIMITED, CHENNAI

INTEGRATED VACCINES COMPLEX, CHENGALPATTU

nne pharmaplan®	User Requirement Specifications			 HLL BIOTECH LIMITED <small>(Subsidiary of HLL Lifescare Limited) (A Government of India Enterprise)</small>	
	Equipment/System	Lyophilizer			
	Identification No:	F1-LYO 02	Document No:		URS/F1-LYO 02
	Effective Date:	13-12-2013	Revision No:		03

Specifications	Remarks
6.1.4 During process cycle, the Lyophilizer should achieve the following range of temperatures; a) Chamber temp: -55 °C b) Condenser temp: -70 °C	

6.2 Failure mode detection

6.2.1 Equipment shall be capable to detect the following failure, notify the operator with alarm and shutdown the process.

6.2.1.1 Emergency stop activated	
6.2.1.2 The steam temperature during the SIP hold time below the set limit (only alarm required)	
6.2.1.3 The vacuum pump stop during the process (only alarm required)	
6.2.1.4 The compressor stop when during the process (only alarm required)	
6.2.1.5 The silicone oil circulating pump stop during the process (only alarm required)	
6.2.1.6 The Hydraulic pump stop during the process (only alarm required)	
6.2.1.7 Purging stop during the process (only alarm required)	
6.2.1.8 Electrical Heater (Silicone oil Heating system) failure during the process (only alarm required)	
6.2.1.9 Water ring vacuum pump stop during the process (only alarm required)	
6.2.1.10 Failure in data communication during the process (only alarm required)	
6.2.1.11 The hydraulic movement of the shelf shall be stopped when the generated pressure in the system goes beyond the set limit. (alarm & shutdown required)	

6.2.2 Equipment shall be capable to detect the following failure, notify the operator for procedural control

6.2.2.1 The compressed air / Nitrogen pressure below the set value.	
6.2.2.2 The purified water and WFI pressure below the set value during the CIP cycle.	
6.2.2.3 The condenser cooling failures during the lyophilisation cycle.	
6.2.2.4 The set vacuum level not achieved.	
6.2.2.5 GMP critical test failure i.e. chamber leak test failure, pressure rise test, water load test.	


6.3 In -Process control

Not Applicable	
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HLL BIOTECH LIMITED, CHENNAI

INTEGRATED VACCINES COMPLEX, CHENGALPATTU

nne pharmaplan®	User Requirement Specifications			
	Equipment/System	Lyophilizer		
	Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02
	Effective Date:	13-12-2013	Revision No:	03



HLL BIOTECH LIMITED
(Subsidiary of HLL Lifescare Limited)
(A Government of India Enterprise)

Specifications	Remarks
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6.4 Level of instrumentation


Sufficient and suitable instrumentation for the process, safety and productivity control as indicated in the following table:

Type of control	Purpose	Operation range	Desired Least Count	Extent of Instrumentation			
				Indication	Alarm	Control	Recording
Temperature	For controlling/ monitoring the shelf temperature	(- 60) °C to (+ 60 °C)	0.1 °C	Y	Y	Y	Y
Temperature	For controlling/ monitoring the condenser temperature	(- 90) °C	0.1 °C	Y	Y	Y	Y
Temperature	For controlling/ monitoring the Chamber drain temperature during SIP	0-150 °C	0.1 °C	Y	Y	Y	Y
Temperature	For controlling/ monitoring the condenser drain temperature during SIP	0-150 °C	0.1 °C	Y	Y	Y	Y
Temperature	For controlling/ monitoring the vent filter temperature during SIP	0-150 °C	0.1 °C	Y	Y	Y	Y

HLL BIOTECH LIMITED, CHENNAI

INTEGRATED VACCINES COMPLEX, CHENGALPATTU

nne pharmaplan®	User Requirement Specifications			
	Equipment/System	Lyophilizer		
	Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02
	Effective Date:	13-12-2013	Revision No:	03



HLL BIOTECH LIMITED
(Subsidiary of HLL Lifescare Limited)
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Specifications								Remarks
Pressure	For controlling/ monitoring the lyophilizer chamber pressure	1 bar (a) to 2.5 bar (a)	1 mbar	Y	Y	Y	Y	
Pressure	For monitoring/ controlling the pressure across the sterilizing grade vacuum break filter	1 bar (a) to 8.0 bar (a)	0.01 bar	Y	Y	Y	N	
Pressure	For monitoring the main compressed air line pressure for pneumatic control	1 bar (a) to 8.0 bar (a)	0.1 bar	Y	Y	Y	N	
Pressure	Hydraulic Pressure	1 bar (a) to 160 bar (a)	0.1 bar	Y	Y	Y	N	
Vacuum	Chamber Vacuum	1 μ bar (a)	--	Y	Y	Y	Y	
Y Required, N Not required								

6.5 Batch data display and record

Refer Installation Requirement Specification

6.6 GMP requirements (Others)

6.6.1	The stoppering system of the lyophilizer should not create any particle or affect the sterility of the system	
6.6.2	The installation of piping and components in the technical area must be as such that all the pipes and components are easily reachable for maintenance.	
6.6.3	Separate control cabinets that are not integrated into the equipment shall be located outside the clean room environment in the technical area, refer attached layout. The necessary length of connecting cables must be considered	


6.7 Specific requirements

6.7.1	Electric Motors	
File Name	NPI_120310_EQP_URS_F1-LYO 02	Page No.
		Page 11 of 29

HLL BIOTECH LIMITED, CHENNAI

INTEGRATED VACCINES COMPLEX, CHENGALPATTU

nne pharmaplan®	User Requirement Specifications			
	Equipment/System	Lyophilizer		
	Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02
	Effective Date:	13-12-2013	Revision No:	03




HLL BIOTECH LIMITED
(Subsidiary of HLL Lifesciences Limited)
(A Government of India Enterprise)

Specifications		Remarks	
6.7.1.1	Possible leakage currents from the frequency transmitters or upstream filters must not influence the automation networks or analogous measuring signals respectively.		
6.7.1.2	All electrical components like motors must be controlled by control cabinets.		
6.7.1.3	Motors must be protected by safety switches.		
6.7.1.4	In order to avoid high start-up currents of large actuators (as from 7.5 kW) without frequency transmitter, suitable measures (soft starter) must be projected.		
6.7.2	Chamber:		
6.7.2.1	The chamber must be pressure rated to withstand conditions up to 130°C and 2.7 bar (a) found during sterilization.		
6.7.2.2	All safety features relevant for pressure vessels must be provided as stipulated in the pressure vessel and safety standards.		
6.7.2.3	Special attention must be given to the safety valves being tight also in vacuum.		
6.7.2.4	Chamber bottom, all ports and flanges welded to the chamber and all interface lines and dead legs must be sloped with minimum 2% for proper drainage.		
6.7.2.5	All internal corners must be rounded for easy cleaning (r > 20 mm where possible).		
6.7.2.6	All area on top of the chamber that must be accessed for maintenance or calibration purpose must be reinforced.		
6.7.2.7	A bellow must be provided to cover the hydraulic cylinder shaft of the shelf movement in order to maintain sterility of the unit. A continuous leak control must be provided to assure no leakage of the bellow during SIP. The system design must facilitate CIP and SIP cycles. Sterility must be maintained during the full cycle.		
6.7.2.8	CIP tank to be provided along with the CIP system to supply the CIP solution.		
6.7.2.9	The sampling valve shall be provided at the drain line to chamber for sampling the wash water during CIP cycle.		
6.7.2.10	The chamber shall have at least following ports and connection: <ul style="list-style-type: none">• Vacuum measuring probes• Pressure transmitter for overpressure• Air/ inert gas inlet• Connection to condenser• 2 validation ports (integral to the entire machine).• Rods of stoppering system• CIP/ SIP inlets• Overpressure safety valves• Sight glass with illumination to the chamber and condenser. (1 no in technical area and 1 in the loading side(Cleanroom))• Drain• Refrigerant inlets/ outlets• Cooling jacket inlet /outlet• Cooling jacket safety valve		
6.7.2.11	The chamber must be equipped with a system (e.g. sieve) to prevent glass of broken vials entering the chamber drain or other piped outlets. The sieve must be		
File Name	NPI_120310_EQP_URS_F1-LYO 02	Page No.	Page 12 of 29

HLL BIOTECH LIMITED, CHENNAI

INTEGRATED VACCINES COMPLEX, CHENGALPATTU

nne pharmaplan®	User Requirement Specifications			
	Equipment/System	Lyophilizer		
	Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02
	Effective Date:	13-12-2013	Revision No:	03




HLL BIOTECH LIMITED
(Subsidiary of HLL Lifescare Limited)
(A Government of India Enterprise)

Specifications	Remarks
easily accessible for removal of trapped particles and cleaning.	
6.7.2.12 The chamber have to be designed for automated CIP/SIP cycles	
6.7.2.13 Suitable liquid-ring pump shall be in place to evacuate the CIP solution from the chambers after CIP	
6.7.2.14 All Valves shall be of sanitary type for CIP and WFI which is directly connected to chamber.	
6.7.3 Ice condenser:	
6.7.3.1 The distance between the ice condenser and the drying chamber should be kept to a minimum. Preferably the condenser is integrated into the main chamber of the freeze dryer.	
6.7.3.2 Depending on the configuration of chamber and condenser the vendor is asked to describe the design of the isolation valve between chamber and condenser.	
6.7.3.3 Direct visual contact between condenser and product should be avoided (radiation influences) for example by the use of a large poppet valve plate.	
6.7.3.4 The condenser must be pressure rated to withstand conditions up to 130 °C and 2.7 bar (a) found during sterilization.	
6.7.3.5 The condenser have to be designed for automated CIP/SIP cycles	
6.7.3.6 All safety features relevant for pressure vessels must be provided as stipulated in the pressure vessel and safety standards	
6.7.3.7 Special attention must be given to the safety valves being tight also in vacuum.	
6.7.3.8 Condenser bottom, all ports and flanges welded to the chamber and all interface lines and dead legs must be sloped with minimum 2% for proper drainage.	
6.7.3.9 All internal corners must be rounded for easy cleaning ($r > 20$ mm where possible).	
6.7.3.10 Design should be based on maximum ice thickness on condenser tubes.	
6.7.3.11 The condenser chamber, refrigerant cooling coil and jacket must be provided with safety devices stipulated in the pressure vessel and safety standards.	
6.7.3.12 The insulation should be complete to avoid icing in the technical area. Catchment tray to be provided to collect the condensed ice and further this catchment should lead to the main drain point in the room.	
6.7.3.13 The ice condenser shall have at least following ports and connection: <ul style="list-style-type: none"> • Pressure transmitter for overpressure • Air/ inert gas inlet • Vacuum systems • Main vacuum valve to the chamber • Spare flange • Validation flange • CIP/ SIP inlets • Overpressure safety valves • Drain • Refrigerant inlets/ outlets 	

HLL BIOTECH LIMITED, CHENNAI

INTEGRATED VACCINES COMPLEX, CHENGALPATTU

nne pharmaplan®	User Requirement Specifications			
	Equipment/System	Lyophilizer		
	Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02
	Effective Date:	13-12-2013	Revision No:	03




HLL BIOTECH LIMITED
(Subsidiary of HLL Lifesciences Limited)
(A Government of India Enterprise)

Specifications	Remarks
6.7.3.14 The ice condenser must be equipped with an automatic aeration independent from the chamber	
6.7.3.15 A bellow must be provided to cover the hydraulic cylinder shaft of the valve in order to maintain sterility of the unit. A continuous leak control must be provided to assure no leakage of the bellow during SIP. The system design must facilitate CIP and SIP cycles. Sterility must be maintained during the full cycle.	
6.7.3.16 Cycle life of bellow must be not less than 10 ⁵ cycles.	
6.7.3.17 The condenser must be equipped with a system (e.g. sieve) to prevent glass of broken vials entering the chamber drain or other piped outlets. The sieve must be easily accessible for removal of trapped particles.	
6.7.3.18 The vendor shall provide the detail nozzle schedule of the chamber and condenser in the documentation.	
6.7.3.19 It has to be assured that fallen vials cannot reach the condensers under all conditions. The used precaution should be described.	
6.7.4 Chamber Door:	
6.7.4.1 The door shall open only after the chamber temperature is well below the 60 °C	
6.7.4.2 Manual hinged full size door for maintenance access to chamber, shelves and condenser. Opening at least 100°. The closing bolts shall be operated automatically.	
6.7.4.3 The chamber door must be foreseen with a door contact to detect the position of door.	
6.7.4.4 Appropriate design should be provided for chamber door cooling.	
6.7.4.5 Door locking switch: Only individually coded safety switches must be used.	
6.7.4.6 Door contacts must have an interlock with the venting valve to make sure no air & N2 can enter the chamber with the door open.	
6.7.4.7 Door gaskets must be able to withstand CIP/ SIP. The sealing of the door must be designed in a way that no condensate or CIP water remains between the door and the chamber.	
6.7.4.8 The door operation (opening and closing) should be manual and sealing will be automatic with door locking indication in the PLC.	
6.7.4.9 The door sealing must operate without any additional lubricant.	
6.7.4.10 The replacement of any door sealing must be possible without disassembling of any other parts or components.	
6.7.4.11 The door must be auto locked if the pressure in the chamber goes above atmospheric pressure.	
6.7.4.12 The service area shall be provided with the full swing door.	
6.7.4.13 The panelling of the equipment should reach the suspended ceiling. The cladding panel should be constructed to allow easy removal for inspection and maintenance.	
6.7.4.14 MOC of gasket shall be USFDA approved.	

HLL BIOTECH LIMITED, CHENNAI

INTEGRATED VACCINES COMPLEX, CHENGALPATTU

nne pharmaplan®	User Requirement Specifications			
	Equipment/System	Lyophilizer		
	Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02
	Effective Date:	13-12-2013	Revision No:	03




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Specifications					Remarks
6.7.5 Loading/Unloading					
6.7.5.1 Mobile LAF cart will be used for loading and unloading of vials from the lyophilizer loading & unloading of vials will be manual.					
6.7.5.2 Loading and unloading height will be between ~900 ±30 mm.					
6.7.5.3 Vials have to be pulled or pushed manually frame by frame from/to the shelf for unloading/loading					
6.7.5.4 Mechanical changes or adjustments for format change must be avoided.					
6.7.5.5 For transportation of vials from filling line cassetting station to lyophilizer loading and from lyophilizer unloading side to loading side of sealing machine will be done by LAF trolley.					
6.7.6 Shelves					
6.7.6.1 Shelf distance has to be optimized for given vials (half stoppered). clearance between the two shelf shall be not less than 70mm.					
6.7.6.2 Roughness of top side of all shelves should have an Ra value < 0.8 µm					
6.7.6.3 Bottom side of all shelves should be designed suitably to prevent sticking of stoppers.					
6.7.6.4 The planarity of the shelves must not to exceed 1.0 mm over the whole shelf.					
6.7.6.5 A radiation shelf must be foreseen between load frame first shelf to ensure that drying conditions on all shelves are the same.					
6.7.6.6 One product probe per shelf for product temperature and eutectic point monitoring to be provided.					
6.7.6.7 Special arrangements to be provided to secure the temperature probe during stoppering/moving the shelves.					
6.7.6.8 Shelf guiding and positioning in all directions must be reproducibly accurate to ensure docking of the loading and un-loading process So as to avoid flipping vials or damaged vials					
6.7.6.9 Fixed guide stoppers shall be provided within the shelves to prevent high friction force during loading and unloading (manual mode) of the vials.					
6.7.6.10 The flexible tubes must be free of tension during upwards and downwards movement.					
6.7.6.11 The connections of the cooling / heating media flexible pipes to the shelves must be welded (preferred solution) or with leak-proof coupling.					
6.7.6.12 All quality tests to ensure robust design should be carried out post fabrication and documented.					
6.7.6.13 It has to be sure, that no vials will fall from the sides of the shelves. Therefore the shelves shall be executed with a border system on the sides to ensure coherent lyophilization conditions even on the shelf edges					
6.7.6.14 The collapsing (and levelling after CIP/SIP) of shelves should be performed automatically. The construction should be described in the documentation.					
6.7.6.15 The connection of heating/cooling media to the shelves should be leak proof.					
6.7.6.16 In addition the position of each shelf must be mechanically adjustable (to ensure					
File Name	NPI_120310_EQP_URS_F1-LYO 02			Page No.	Page 15 of 29

HLL BIOTECH LIMITED, CHENNAI

INTEGRATED VACCINES COMPLEX, CHENGALPATTU

nne pharmaplan®	User Requirement Specifications			
	Equipment/System	Lyophilizer		
	Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02
	Effective Date:	13-12-2013	Revision No:	03




HLL BIOTECH LIMITED
(Subsidiary of HLL Lifesciences Limited)
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Specifications	Remarks
minimum tolerances concerning constant loading level for each shelf).	
6.7.6.17 The shelf must be level and the constructed to tolerance of $\pm 0.5\text{mm/metre}$.	
6.7.6.18 Each shelf shall have raised SS edge on the rear and on the left & right to ensure the location of the vials.	
6.7.6.19 Control of shelf movement should be provided from both sides (Clean room and technical area).	
6.7.6.20 Emergency stop button for shelf movement should be provided on both sides (Clean room and technical area).	
6.7.7 Hydraulic System for Shelves	
6.7.7.1 The positioning must be accurate enough to harmonize with the transfer cart / frames.	
6.7.7.2 Hydraulic drive for the shelves to allow loading at constant level and closing of vials.	
6.7.7.3 The shelf lifting mechanism should not pull any contaminants into the chamber.	
6.7.7.4 The bellow shall be removable from the chamber without removing the complete piston.	
6.7.7.5 The effective stoppering function required.	
6.7.7.6 Shelves and the hydraulic cylinder must be designed in a way to prevent the need for spacers even if only one shelf is loaded.	
6.7.7.7 Shelves must be kept compressed after stoppering of the product until the pressure in the chamber has reached a value (adjustable).	
6.7.7.8 All the shelves shall be pressure tested at 20% higher than the design pressure.	
6.7.7.9 A leak tight bellow must be provided to cover the hydraulic cylinder shaft in order to maintain the sterility of the unit.	
6.7.7.10 The hydraulic pump should be provided with high pressure interlocking	
6.7.7.11 Hydraulic system shall be operated by both the side (sterile, Non sterile).	
6.7.7.12 Stoppering pressure shall be adjustable from $0-70\text{KN/m}^2$	
6.7.7.13 Stoppering speed shall be around 4mm/sec	
6.7.8 Heating and Cooling for Shelves	
6.7.8.1 The heating and cooling system must operate automatically.	
6.7.8.2 The preferred heat transfer medium in the secondary loop is silicon oil.	
6.7.8.3 A backup pump system must be provided, which is automatically activated when the primary system fails.	
6.7.8.4 An expansion vessel (with filter cartridge) with pressure indication should be provided.	
6.7.8.5 Each shelf must be separately fed with cooling / heating medium.	
6.7.8.6 Pt 100 (min. 3 wired) temperature probes placed in stainless steel tubes both at the inlet and the outlet of the shelf manifold should be provided. (1 Pt 100 used for cycle control, 1 for measurement)	

HLL BIOTECH LIMITED, CHENNAI

INTEGRATED VACCINES COMPLEX, CHENGALPATTU

nne pharmaplan®	User Requirement Specifications		
	Equipment/System	Lyophilizer	
	Identification No:	F1-LYO 02	Document No: URS/F1-LYO 02
	Effective Date:	13-12-2013	Revision No: 03




HLL BIOTECH LIMITED
(Subsidiary of HLL Lifesciences Limited)
(A Government of India Enterprise)

Specifications	Remarks
6.7.8.7 Distribution of heating and cooling media should be uniform throughout the shelves (without any dead spaces) so that proper and uniform freeze drying of the product can be achieved and temp difference of the shelves must be $\pm 1^{\circ}\text{C}$.	
6.7.9 Primary Cooling System	
6.7.9.1 The cooling system shall consist of two independent refrigeration circuits. - The first circuit works with a heat exchanger in the silicon oil circulation system for shelf cooling. The second circuit works by direct expansion on the tubes of the ice condenser.	
6.7.9.2 The cooling circuit must be built in that way that all compressors can be used for the cooling of the shelves (initial freezing) and that during drying one compressor can be used for the shelves and the others for the cooling of the condenser.	
6.7.9.3 Compressors shall be two stages.	
6.7.9.4 Redundancy for compressor, vacuum pump, to be in place so that if one of the above equipment fails, cycle must complete safely and automatic switching off should be considered.	
6.7.9.5 The following safety devices have to be provided: <ul style="list-style-type: none"> • A pressure valve to avoid overload during starting: start pressure regulation • Hand valves in the upstream and downstream of the compressors. • Thermal circuit breaker • Thermistors in the motor coils with control unit. • High pressure lubrication system with a gear pump. • Auxiliary cooling system by expansion of refrigerant through the motor including: temperature switch with bulb on the discharge line, solenoid valve, expansion system, bypass line and electrical control. • Differential oil pressure switch • High pressure switch. • Pump down must be done during standby of the compressor When the pressure is low enough the compressor must stop running • Crankcase heater to avoid any refrigerant condensation when the compressor is switched off. • Check-valve on the discharge line. • Double safety valves for each compressor unit. 	
6.7.9.6 Only HFCs according to Montreal protocol are permitted as refrigerants. Vendor to specify the type of refrigerants used.	
6.7.9.7 Temperature measurements at the inlet and outlet of the cooling water. Measurements must be visible on SCADA.	
6.7.9.8 Pressure switch at low, intermediate and high pressure side of the compressors.	
6.7.9.9 Intermediate pressure side must always be $> 1 \text{ bar (a)}$.	
6.7.9.10 Pressure transmitters in refrigerant circuit at outlet of the ice condenser and silicon oil heat exchanger of the cooling system. Measurements must be visible on SCADA.	
6.7.9.11 Oil separator (after compressor) and liquid separator (before compressor) must be provided.	

HLL BIOTECH LIMITED, CHENNAI

INTEGRATED VACCINES COMPLEX, CHENGALPATTU

nne pharmaplan®	User Requirement Specifications			
	Equipment/System	Lyophilizer		
	Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02
	Effective Date:	13-12-2013	Revision No:	03




HLL BIOTECH LIMITED
(Subsidiary of HLL Lifescare Limited)
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Specifications	Remarks
6.7.9.12 Possibility to open oil separator for cleaning.	
6.7.9.13 A separate connection for filling the compressors with cooling liquid must be provided.	
6.7.9.14 Drainable trays to collect the condensate below the compressors have to be provided.	
6.7.9.15 All components reachable to perform maintenance	
6.7.9.16 During a WIT, the condenser needs to be cooled to gain time during the leak test if this follows the WIT.	
6.7.9.17 If leak test fails, option to be provided in the lyophiliser to abort the cycle or restart.	
6.7.10 Vacuum System	
6.7.10.1 Vibration dampers need to be foreseen to minimize effect of vibration of pumps to the surrounding operations.	
6.7.10.2 The rotary vane vacuum pumps should operate with gas ballast in order to avoid water vapour condensation and to force oil diffusion to the exhaust.	
6.7.10.3 Oil sealed primary pumps are used. A system should be provided to avoid oil diffusion into the condenser.	
6.7.10.4 As an alternative the vendor shall propose a suitable oil free system (dry pumps)	
6.7.10.5 A safety valve between the condenser and the vacuum system must be provided. In case of power failure this valve has to close immediately and automatically.	
6.7.10.6 A vacuum system capable of generating a vacuum of up to: <ul style="list-style-type: none"> 0.01 mbar(a) in the chamber 0.003 mbar(a) at pump head 	
6.7.10.7 The evacuation time of the system from atmospheric pressure to: <ul style="list-style-type: none"> 0.1 mbar(a) should take less than 40 min 	
6.7.10.8 The control system incorporates the following <ul style="list-style-type: none"> 1 pressure transmitters (MKS) installed on the drying chamber. 	
6.7.10.9 High pressure alarms Pmax-x (stop of heating) and Pmax (refreezing of shelves) have to be split up in primary and secondary drying.	
6.7.11 Provision for integrity testing shall be provided.	
6.7.11.1 Chamber vacuum should be maintained after the completion of cycle (with Alarm). Vacuum should be released only on human intervention.	
6.7.11.2 Choice of aeration with either N2 or process air: selectable by software and recipe driven	
6.7.12 Ergonomic requirements	
6.7.12.1 Equipment which must be calibrated will be installed that it is easy accessible from the ground floor and without difficult dismantling.	
6.7.12.2 To improve the accessibility pedestals and stairs (steep ladders are not acceptable) have to be designed and provided.	
6.7.12.3 Good accessibility of all buttons, switches and components for operator handling is required.	

HLL BIOTECH LIMITED, CHENNAI

INTEGRATED VACCINES COMPLEX, CHENGALPATTU

nne pharmaplan®	User Requirement Specifications			
	Equipment/System	Lyophilizer		
	Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02
	Effective Date:	13-12-2013	Revision No:	03



HLL BIOTECH LIMITED
(Subsidiary of HLL Lifescare Limited)
(A Government of India Enterprise)


Specifications					Remarks
6.7.12.4	All buttons, switches, and components which must be used by the operator are clearly indicated to make human errors impossible.				
6.7.12.5	The specified equipment must be designed and executed without sharp hooks and borders to avoid injuries.				
6.7.13	Performance requirement				
6.7.13.1	Chamber: Maximum leak rate of < 0,01 mbar * l *s-1 in the range of 0.01mbar till 0.1 mbar at condenser temperature of -40 Deg C				
6.7.13.2	Condenser: Maximum leak rate of < 0. 01 mbar l/s starting with initial vacuum at < 0, 01 mbar.				
6.7.13.3	A leakage rate between drying chamber and the ice condenser of less than 1*10 ⁻⁷ mbar*l*s-1 should be guaranteed. The valve between the product chamber and the condenser chamber must have stable positioning and be absolutely tight in both directions against atmospheric pressure. A pressure rise test with an open and with a closed valve (atmospheric pressure in the condenser chamber) must be performed.				
6.7.13.4	Water Load Test: - A purified water load test will be performed. This test will evaluate the systems sublimation rate capacity and ice loading pattern on the condenser. - Purified water will be put upon the full loaded surface area of each shelf utilizing thin aluminum trays. Each tray will be equally filled such that the total load will equal to the specified ice capacity.				
6.7.13.5	Minimum ramping velocity with full chamber at least 1 °C /min				
6.7.13.6	Temperature difference between manifold inlet and outlet should be ±1 °C in a steady state with load.				
6.7.14	General Design Requirements				
6.7.14.1	During the loading, process and unloading any damage of vials and friction between vials is not allowed.				
6.7.14.2	The max. Length of the flanges and ports must be designed so that these flanges and ports are cleanable and sterilizable. Dead ends <1.5d where possible.				
6.7.14.3	All blind flanges must be able to withstand the full vacuum as well as the sterilization pressure.				
6.7.14.4	Moving parts which are going outside of the sterile area should be foreseen with a leak-tight bellow (with possibility to verify.) Air from bellow is blown in technical area.				
6.7.14.5	Critical process valves (min. requirement: process water valves, media lines, bottom valves, pressure release valves, etc.) must be equipped with end position switches.				
6.7.14.6	Activation of the emergency stop button or opening of the protective door (if available) leads to immediate stop of all outputs via the safety circuit.				
6.7.14.7	Activation of the emergency stop button or opening of the protective door (if available) leads to immediate stop of the valve clusters.				
6.7.14.8	Installation of equipment with refrigerants has to be done by a certified cooling technician. Before starting the works, a copy of the certificate has to be delivered.				
6.7.14.9	The specified equipment must be completely free of asbestos.				

File Name	NPI_120310_EQP_URS_F1-LYO 02	Page No.	Page 19 of 29
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HLL BIOTECH LIMITED, CHENNAI

INTEGRATED VACCINES COMPLEX, CHENGALPATTU

nne pharmaplan®	User Requirement Specifications			
	Equipment/System	Lyophilizer		
	Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02
	Effective Date:	13-12-2013	Revision No:	03




HLL BIOTECH LIMITED
(Subsidiary of HLL Lifescare Limited)
(A Government of India Enterprise)

Specifications		Remarks
6.7.14.10	An over-temperature switch has to be installed in the control circuit of the heating relay	
6.7.14.11	All lines and equipment surfaces which represent a danger to operators and maintenance personnel with regard to freezing or burns shall be adequately insulated.	
6.7.14.12	A central vacuum valve between the condenser and the vacuum system must be provided. In case of power failure this valve has to close immediately and automatically.	
6.7.14.13	In case of power failure the valve between the drying chamber and ice condenser should remain in previous position before power failure.	
6.7.14.14	During the SIP cycle after power failure recovery, another new SIP cycle shall restart from the beginning (if temperature drops below the set value).	
6.7.14.15	During the CIP Cycle, De-Icing Cycle, and lyophilization cycle after power failure recovery the remaining sequence of the cycle shall restart from the stop point.	
6.7.14.16	Provision to provide to connect the control system to Centralised UPS system. The UPS power will be used for sensors, PLC controls, LAF and differential pressure cascade. After power failure the system should start automatically with last recipe loaded. Primary cooling, vacuum pumps, condensers, silicone oil circulation pump etc should run on generators. All the major components and processes must start automatically within 3 minutes. When on emergency power, all components should restart automatically except the heating elements. In this case it must be possible to switch on heating manually.	
6.7.14.17	All hygienic lines, WFI, CIP water and pure steam must be orbital welded. All welded lines in contact with WFI, CIP water or clean steam must be inspected by endoscope (10% of welds). Inspection certificate with photographs with P&ID tags to be provided.	
6.7.14.18	Vendor shall provide the effective design for CIP to minimize the water consumption.	
6.7.15 Cleaning and Sterilisation requirement		
6.7.15.1	Automatic CIP and SIP	
6.7.15.2	The Clean in Place system shall include manifolds, nozzles/ spray ball and sanitary valves to allow the CIP media to be sprayed onto product chamber, condenser and shelf surfaces	
6.7.15.3	No. of spray ball, position, location and height of the spray ball shall be provided by the vendor	
6.7.15.4	CIP consists typically following repeatable steps: <ul style="list-style-type: none">• first rinse with Purified water (re-circulated-3 cycles)• last rinse with WFI (once through passage) The respective media, quantities and durations shall be defined as parameters in the recipe.	
6.7.15.5	Recirculation pump shall be included for CIP. Pump shall be self-drainable during and after the sterilization.	
6.7.15.6	SIP consists typically following steps:	
File Name	NPI_120310_EQP_URS_F1-LYO 02	Page No.
		Page 20 of 29

HLL BIOTECH LIMITED, CHENNAI

INTEGRATED VACCINES COMPLEX, CHENGALPATTU

nne pharmaplan®	User Requirement Specifications			
	Equipment/System	Lyophilizer		
	Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02
	Effective Date:	13-12-2013	Revision No:	03




HLL BIOTECH LIMITED
(Subsidiary of HLL Lifescare Limited)
(A Government of India Enterprise)

Specifications	Remarks
<ul style="list-style-type: none"> Vacuum to evacuate all the air Heat up Sterilization Cooling and drying <p>The respective pressures, temperature and durations shall be defined as parameters in the recipe. 6 log reductions shall be achieved during SIP on all surfaces within the chamber, condenser, and CIP system.</p>	
6.7.15.7 The integrated CIP system shall be designed to minimize water consumption.	
6.7.15.8 Only 1 connection point is foreseen for each media. A signal needs to be given from the lyophiliser PLC to specify which media is requested.	
6.7.15.9 The CIP cycles will be recipe driven and fully automated with temperature, flow rate and volume control.	
6.7.15.10 The CIP system must ensure that 100% of the critical surfaces, such as shelves, are cleaned. Suitable and sufficient spray nozzles and balls for complete impact cleaning must be provided.	
6.7.15.11 The drying chamber, the shelves, the ice condenser and all connecting lines and all the ports on the chamber have to be cleaned in place.	
6.7.15.12 All valves in CIP lines and lines to be CIP'ed must be aseptic valves.	
6.7.15.13 Vendor to specify spray pressure, spray time, selection sequence of the spraying nozzle along with their spray time	
6.7.15.14 The temperature difference across and between shelves during the sterilization hold period must be less than 1 deg C.	
6.7.15.15 The sterilization cycle must be controlled by the temperature at the coldest spot and the pressure in the chamber.	
6.7.15.16 The pure steam piping for the SIP cycle must be equipped with automatic actuated control valves and steam traps.	
6.7.15.17 The supplier of the lyophilizer shall ensure to cool down the condensate < 60°C.	
6.7.15.18 Adequate space will be provided for manual cleaning and inspection of shelves and chamber area from the access door on the mechanical side of operations. Total opening of the door shall be 150deg angle.	
6.7.15.19 The configuration of any flanges and ports must ensure that all internal surfaces are covered by the CIP system and will reach and maintain sterilization conditions during the sterilization cycle.	
6.7.15.20 The SIP cycle sterilization hold time shall reset as the drain probe temperature comes below 121 °C and recounting of the time shall start after achieving the set sterilization temperature. If the door is closed incorrectly, CIP/SIP shall not start.	
6.7.15.21 The exhaust valve shall be closed during the SIP cycle.	
6.7.15.22 The pressure gauge needs to be installed immediately after the CIP pump and another pressure gauge at the inlet of the WFI for the chamber.	
6.7.15.23 Vendor to provide details of different cleaning media that is compatible for cleaning of the equipment	
6.7.15.24 For CIP / SIP of the lyophilizer the shelf shall have a collapsible angle of 5 deg approximate to avoid water or condensate on the shelf.	

HLL BIOTECH LIMITED, CHENNAI

INTEGRATED VACCINES COMPLEX, CHENGALPATTU

nne pharmaplan®	User Requirement Specifications			
	Equipment/System	Lyophilizer		
	Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02
	Effective Date:	13-12-2013	Revision No:	03



HLL BIOTECH LIMITED
(Subsidiary of HLL Lifescare Limited)
(A Government of India Enterprise)

Specifications	Remarks
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6.7.16 Maintenance requirement

6.7.16.1 Lubricating points:

All lubricating points must be registered, shown and clearly labeled in an overall plan. Inaccessible lubricating points must be made accessible by installing corresponding lines without opening the protective door. It must be guaranteed by suitable measures that oils or lubricants do not reach the product. The lubricant type applied must be registered. Oils and lubricants applied must be approved by USFDA. A corresponding certificate must be supplied.

6.7.16.2 Testing means lists

The suppliers must provide the testing means lists electronically as tables. Testing means include all process and quality relevant measuring points, e. g. temperature, pressure, LF, flow etc. Testing means must be classified in terms of Biotechnology or technical relevance. In advance, the measuring points must be agreed upon with the principal. For measuring points the following must be indicated: measuring range, calibration range, working range, set-point, accuracy class, recommended calibration frequency.

6.7.16.3 Access to testing means:

The testing means must be easily accessible and assembled under due consideration of an easy and quick recalibration. Necessary auxiliary energies (220 V, compressed air) must be available in the proximity of the measuring points.

6.7.17 Interface to other systems

6.7.17.1 Interface: The required interconnection to other systems takes place by means of potential free contacts. Besides those mentioned in this URS, 5 additional potential free contacts must be provided for further occupation (e. g. control of a vapor extractor).

6.7.17.2 Collective Alarm: In order to centrally visualize the general system condition, a collective alarm signal shall be provided on a potential free contact.

6.7.17.3 Interfaces to on site utility supply systems: The onsite utilities are specified in attached utility spec.

6.7.17.4 If the specified equipment is connected or integrated into on site partition walls or ceiling panels dimensions and locations for necessary cutouts must be stated in the equipment layout drawings.

6.7.17.5 Parts of the specified equipment must not be attached to cleanroom ceiling panels

6.7.17.6 Interface with building and building services such as process utilities

6.7.18 Level of Automation

6.7.18.1 The freeze drying process operates without operator's assistance. Operator selects or downloads recipes and starts the freeze dry cycle. All operations shall be controlled by PLC-controller and the SCADA-system with a variety of different recipes for different products. Industrial Computer system and Printer shall be provided.


6.7.18.2 Data loss is not admissible.

6.7.18.3 Fail safe position: In case of auxiliary energy failure (electric or pneumatic) the armatures and actors must run into defined fail safe position so that no hazard is

HLL BIOTECH LIMITED, CHENNAI

INTEGRATED VACCINES COMPLEX, CHENGALPATTU

nne pharmaplan®	User Requirement Specifications			
	Equipment/System	Lyophilizer		
	Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02
	Effective Date:	13-12-2013	Revision No:	03




HLL BIOTECH LIMITED
(Subsidiary of HLL Lifesciences Limited)
(A Government of India Enterprise)

Specifications		Remarks
	caused to persons and products.	
6.7.18.4	Energy efficiency class: All electric motors must at least comply with the current requirements of the EC energy efficiency class (EFF2).	
6.7.18.5	Actors: In case of error or failure of the field bus communication the actors must be switched to fail safe position.	
6.7.18.6	Actors: Identification labels must be fixed undetectably (e. g. on the base plate of a valve but not on interchangeable valve) and must be resistant against materials used in the system and its environment.	
6.7.18.7	Actors must be protected in useful groups to enable easy and quick localization of possible error/failure (short circuit).	
6.7.18.8	Wiring and installation	
a)	Final wiring between the single components, machines and devices must be installed. It must be stable and equipped with step protection. Signal and data lines must be separated from power lines.	
b)	In the technical area wires shall be run in grating channels.	
c)	Metric packed screwing with segments shall be used as cable ducts.	
d)	Corresponding to the ambient conditions as well as mechanical and chemical load caused by the system and its materials, suitable cable types must be installed. The cable types installed must be described in the machine documentation.	
6.7.18.9	Switching and control systems	
a)	The switching and control cabinets shall not prejudice access to the PU so that maintenance and repair works can be carried out without problems.	
b)	Multiple terminals are not admissible, except double terminals.	
c)	Modem (with activation switch) to be installed for online problem redressals. Supplier to install an Ethernet socket in the control cabinet to connect remote maintenance system. Remote maintenance is established by means of laptops which are connected to the Ethernet socket by the maintenance technician.	
6.7.18.10	Supply	
a)	Adjustments must be corresponding to the requirements for selective switch- off	
b)	Feed-in to be supervised on low voltage and phase failure. Supervision to be registered in the pertaining automation system.	
c)	Feed-in must be assigned on input terminals in the control cabinet and conducted over a switch.	
d)	Control voltage supply must be provided: <ul style="list-style-type: none">• SCADA/ Computer• PLC• Decentralized I/O system• As well as all other control and instrumenting components (actors/sensors)• All network components concur	
e)	Additional auxiliary voltage required (e. g. 24 V) must be generated in the system itself and distributed selectively.	
f)	Signals and control commands from the control system must be switched to decentralized I/O modules or I/O modules of the automation system respectively	
g)	Power control units, power outputs, electronic devices and circuits of the control system must be arranged and designated according to EMC (EMC guideline 204(108/EU for electromagnetic compatibility).	
6.7.18.11	Field Bus	
File Name	NPI_120310_EQP_URS_F1-LYO 02	Page No. Page 23 of 29

HLL BIOTECH LIMITED, CHENNAI

INTEGRATED VACCINES COMPLEX, CHENGALPATTU

nne pharmaplan®	User Requirement Specifications			
	Equipment/System	Lyophilizer		
	Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02
	Effective Date:	13-12-2013	Revision No:	03



HLL BIOTECH LIMITED
(Subsidiary of HLL Lifescare Limited)
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Specifications	Remarks
a) Profibus DP to be installed as field bus system for connection of periphery.	
b) Connection of Profibus DP components generally to be equipped with screened connecting plugs, termination resistors which can be switched off and additional programming socket.	
c) Supplier to issue measuring protocols for all data lines (Profibus, network, LWL etc.) showing function and capacity.	
6.7.18.12 Automation system (AS) control	
a) For safety relevant functions, the correspondingly fail safe hardware (e. g. Safety Integrated, F controls) must be applied. Field bus system users installed at site shall be connected to the AS.	
b) I/O cards can be used for the AS. This must be specified.	
c) Continuation must not be possible without acknowledgement and new start by the operator.	
d) Connection to all systems involved to be established automatically, i. e. in case of failure of one component, connection must be established automatically after repair.	
6.7.18.13 PC as Operating System	
a) Industrial PC to be provided for freeze dryer data management with monitors of at least 19 inch size.	
b) An Ethernet network card and cable for connection to network must be provided.	
c) For data recovery (e. g. after hard disc failure), corresponding programs, back-ups and descriptions must be supplied. By means of these systems it must be possible to restore 5 GB data per hour. Data manipulation must be excluded.	
d) Easy machine operation by clear structures of the operating panel to enable the operator to view all relevant information.	
e) The main operating panel must be installed on the loading/unloading side.	
f) Layout of Templates: Industry standard templates to be provided to represent the utilities, process parameters etc	
g) Provision for manual operation of all the sequences connected to the PLC to be made for controlling lyo cycle manually.	
h) Operating system should be of the latest user adaptable version.	
6.7.18.14 Software Development	
a) Development of the software applied according to current version of the GAMP standard. Critical parameters, modification of user level and limit values are protected by password or equivalent authorizations	
b) Supplier of the automation system to deliver all application software to realize required functions, displays, protocols etc. as source code.	
c) Storage Capacity: A storage capacity must be specified at which data are deleted in order to avoid an overflow.	
d) Cycle Time: The cycle times can be freely selected and can be allocated to the single measuring points according to the process and system requirements.	
e) CPU capacity utilization: Capacity utilization of the PLC storage must not exceed 50% of the available capacity.	
f) All information including data display and software language should be in English.	
6.7.18.15 Display and operating components	
a) OS's to be connected to the automation system via available interfaces.	

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INTEGRATED VACCINES COMPLEX, CHENGALPATTU				
HBL HLL BIOTECH LIMITED (Subsidiary of HLL Lifecare Limited) (A Government of India Enterprise)	User Requirement Specifications			
	Equipment/System	Lyophilizer		
	Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02
	Effective Date:	13-12-2013	Revision No:	03
Specifications				Remarks
b) OS to be installed in the system to the PC through SCADA.				
c) An audit trail must be integrated in the OS. The audit trail must include at least: <ul style="list-style-type: none">• user ID• date (day, time)• parameters• old value• new value• It must be possible to read out the audit trail from the OS and store				
6.7.18.16 Measurement and Sensors				
a) Measurement and sensorics of the system to be connected to the pertaining decentralized I/O and control systems resp. with clear identification label.				
b) For internal device errors the measuring device must be adjusted to generate a defined malfunction being detected by the control system. eg. at a temperature range of 80 - 120 °C, 40 °C may be a malfunction.				
c) GMP relevant measurement must be suitably calibrated, mainly by means of 3 point calibration over the complete measuring chain. The corresponding calibration points shall be within the required measuring range.				
d) Measuring devices must be easily detachable from the process, if required, shut-off units or relief facilities (e. g. for pressure) resp. must be provided.				
e) For all devices installed in the measuring chains, adjustment facilities must be specified or adjustment must be described, and complete operating instructions must be supplied.				
f) Measurement and sensors must be particularly easily accessible and interchangeable.				
6.6.3.1 Vendor should ensure vendor shall include all necessary parts / components for the smooth operation of the machine as per technical specs:				
7.0 Constraints				
7.1 Equipment location and available space				
This equipment will be installed in the Viral Vaccine Formulation Block of Integrated Vaccines Complex , Chengalpattu, Chennai. Equipment Location:F1-LYO 02 Block: <u>Viral Vaccine Formulation Block</u> Floor: <u>Ground floor</u> Room No.: F1G044 Room Dimension : 230 sq.m (Technical area) Available room dimensions for equipment: 5300mm x 8900mm Slab Height: 6.0 m The equipment location is indicated in the relevant block of the layout enclosed as URS Annex-1 . Physical condition of the rooms: <u>Liquid Filling Rooms (Lyophilizer loading and unloading areas)</u> 1. Room No.: F1G086				
File Name	NPI_120310_EQP_URS_F1-LYO 02		Page No.	Page 25 of 29

HLL BIOTECH LIMITED, CHENNAI

INTEGRATED VACCINES COMPLEX, CHENGALPATTU

nne pharmaplan®	User Requirement Specifications			
	Equipment/System	Lyophilizer		
	Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02
	Effective Date:	13-12-2013	Revision No:	03



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Specifications	Remarks
2. Room will be non-hazardous 3. Class: EU Class "B" 4. Differential Pressure: 65 Pa Absolute 5. Temperature maintained: 22°C ± 2°C 6. Relative Humidity: Not more than 55%	

7.2 Available utility

a) Electricity: Single (220 V) & 3 phase (420 - 440 V) (Report Requirement) b) Compressed air 6-8 bar, 10 CFM (Report Requirement) c) WFI at 80 deg C, 2.5 m ³ /hr (Report Requirement) d) Purified water, 2.5 m ³ /hr (Report Requirement) e) Cooling water @ 30 to 35 °C, 37 m ³ /hr (Report Requirement) f) Pure steam @ 3 bar, 300 kg/hr (Report Requirement) g) Soft water for ring water pump- 10 LPM (Report Requirement) h) Nitrogen (Report Requirement) Note: <ul style="list-style-type: none"> Vendor to confirm on the above utilities provided for the equipment. Vendor to provide Pressure reducing valves and Pressure gauges along with the equipment as per equipment utility requirements. Vendor to provide the all utility consumptions in detail for the equipment during pre-bid. 	
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	Equipment/System	Lyophilizer			
	Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02	
	Effective Date:	13-12-2013	Revision No:	03	

8.0 Abbreviation

Abbreviation	Definition
ANSI	American National Standards Institute
CIP	Clean In-Place
EU	European Union
FAT	Factory Acceptance Test
HBL	HLL Biotech Limited
I/O	Input / Output
IRS	Installation Requirement Specifications
GA	General Assembly
GAMP	Good Automated Manufacturing Practice
GMP	Good Manufacturing Practice
ISO	International Standards Organization
MOC	Material of Construction
NPI	NNE Pharmaplan India
PLC	Programmable Logic Controller
PRV	Pressure reducing valve
P&ID	Piping and Instrumentation Diagram
SCADA	Supervisory Control And Data Acquisition
SIP	Sterilization In-Place
QA	Quality Assurance
OS	Operating System
USFDA	United States Food and Drug Administration
WFI	Water For Injection

Revision index

Revision	Date	Reason for revision
00	27-05-2013	First Draft for Client's Review
01	31-10-2013	As per comments given by HBL on 10-10-2013 by email
02	29-11-2013	Updated as per MOM dated 26-11-2013
03	13-12-2013	Updated as per comments given by HBL dated 12-12-2013 by email

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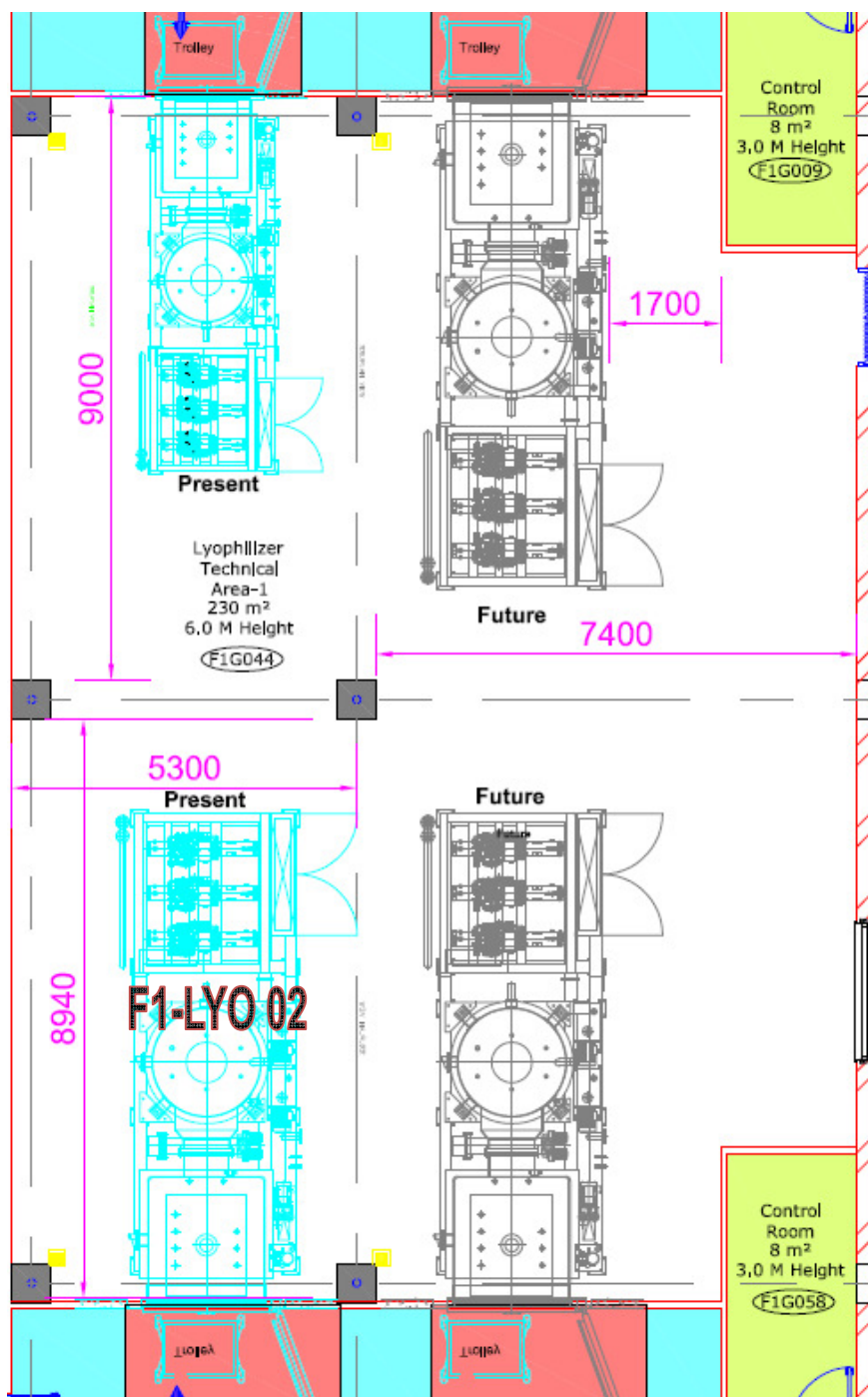
User Requirement Specifications

Equipment/System	Lyophilizer		
Identification No:	F1-LYO 02	Document No:	URS/F1-LYO 02
Effective Date:	13-12-2013	Revision No:	03




URS ANNEXURE 1: Layout showing location of the Lyophiliser technical area

Room No: F1G044 - Lyophilizer Technical area



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	Identification No:	F1-LYO 02	Document No:		URS/F1-LYO 02
	Effective Date:	13-12-2013	Revision No:		03

URS Annexure - 2

List of components and make for Lyophilizer

S.No	Description	Preferred List
1.	Refrigeration Compressor Two Stage	Carlyle/ Bitzer/ Copeland
2.	Oil Separator	Henry/ Temprite/ Danfoss
3.	Suction Accumulator	AC and R / Henry GVN
4.	Refrigeration Valves	Danfoss / Sporlan / Henry
5.	Expansion Valves	Danfoss / Sporlan / Henry
6.	Plate Heat Exchanger	Alfalaval / Danfoss /WTT
7.	Refrigeration Ball valves	Danfoss / Sporlan / Henry
8.	Vacuum Pump	Pfeiffer Vacuum / Edwards /Leybol
9.	Vacuum Valves	Elomatic / Danfoss / Tyco
10.	Vacuum Sensors	MKS
11.	Isolation Valves	Elomatic / Danfoss /Tyco
12.	Fluid Pump	Grundfos / Elmo /3M Pumps
13.	Steam PRV Sanitary	Spirax / Steriflow
14.	Steam Valves only Diaphragm	Burkert / Gemu / ITT
15.	Safety Valves Sanitary	Spirax / Steriflow
16.	Steam Traps Sanitary	Spirax / Steriflow
17.	Check valves Sanitary	Spirax / Steriflow
18.	Pneumatic Controls	Burkert / Festo / Janatics
19.	Water Ring Pump	Atalntic Fluidics / Nash Elmo
20.	Spray Nozzles	Spraying Systems USA / BETE USA
21.	Fluid Fittings	Swagelok / Parker / Gemu
22.	Hydraulic Pump	Bosch / Parker / Rexroth
23.	Computer System	DELL / SONY /LENOVO
24.	PLC and Controls	Allen Bradley / Siemens
25.	Pressure Sensors	Wika / Endress Hauser / Honeywell
26.	Temperature Sensors	Omega / Wika / Endress Hauser
27.	Servo Motors	SEW Germany / Allen Bradley /Siemens
28.	Electrical Controls	Schneider Electric / Allen Bradley / Siemens