

Yokogawa in Pharmaceutical Manufacturing

Yokogawa's VigilantPlant delivers visibility, predictability and the ability to quickly and easily respond to today's Pharmaceutical business needs.



Bulletin 53H01A01-01E

vigilantplant.[™]
The clear path to operational excellence

YOKOGAWA 

vigilantplant.™

The clear path to operational excellence

Envision a plant where people are watchful and attentive while your business responds to change quickly and efficiently. Now picture an operation that delivers consistent production, real-time information and accurately controlled and safe processes that comply to the regulatory and demanding requirements of the pharmaceutical industry.

Imagine no further. This is the vision and promise behind VigilantPlant, the clear path to right the first time operational excellence.

Making critical plant information fully visible is just the beginning of the vigilant cycle.

Seeing clearly gives you the knowledge necessary to anticipate changes required to understand the variability in your process. Knowing in advance brings you the speed and flexibility to optimize your plant in real-time. And by acting with agility, you are able to adapt to the variability of the process to enable your business to benefit from improved consistency and product quality.

VigilantPlant excels at bringing out the best in your plant and your people – keeping them fully aware, well informed, and ready to face the next challenge.

20,000L Bioreactor at Lonza Biologics Inc., Portsmouth, NH (USA)



ACT WITH AGILITY

Free of bottlenecks

Reduce delays, lost opportunities, knowledge silos



SEE CLEARLY

Less blind spots

Avoid guesswork, instability, sub-optimization

Minimize reactive measures, unexpected downtime, quality variations

Fewer surprises

KNOW IN ADVANCE



Be secure in the knowledge that your control system meets all regulatory requirements

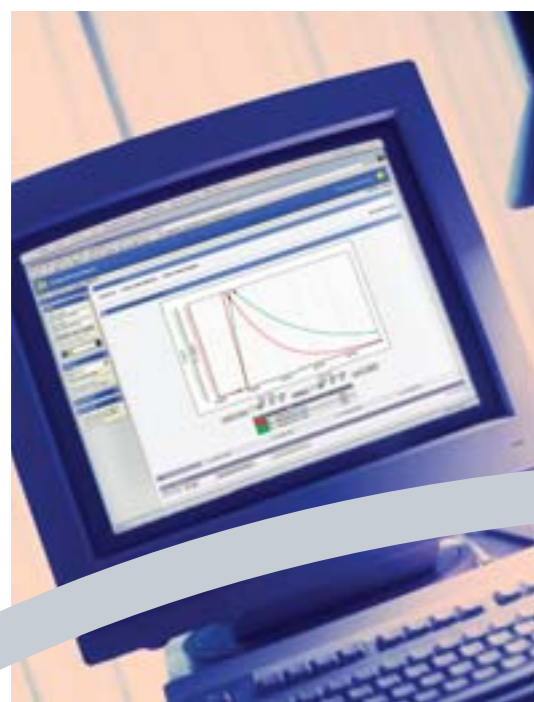
The plant's alert approach to operation, maintenance and information is obvious. Operators are calm and in control. Managers are well informed, but never overwhelmed with data. All facilities are validated and under control, ready for internal audits and inspections by regulatory authorities. At the same time potential problems are anticipated before they happen. All this in a day in the life of operating a VigilantPlant.

Batch operations run to order, are clearly visible and are totally reliable

At 07:00 the plant operators are ready to start the first batch of the shift. The previous shift's completed batches are ready for release and the currently executing batches are handed over without a hitch.

The control and safety systems automate the whole process so as to maximize throughput in the most efficient and safest manner possible.

The plant's information system is used to enable on-line data analysis and to compare current and previous batches. This information is paramount in enabling operators and other plant personnel to subsequently increase plant utilization, improve product quality and manufacturing efficiency.



Batches are run to optimize the use of resources on all levels

A fault on one of the reactor vessels has meant that batches need to run in a different order.

A previously validated and approved recipe is loaded from the control system's recipe manager and the system is ready to continue processing the next batch.

The complex plant is controlled via Yokogawa's highly developed batch software that is based upon the ISA-88 (IEC 61512) Batch standard.

An on-line FT-NIR is used to measure the composition of the product to ensure consistent product quality in line with the FDA's PAT initiative.

A dynamic alarm monitoring system sets alarm values depending upon the recipe being run and present plant status.

All plant information is gathered for audit purposes to help users comply with the FDA's 21 CFR Part 11 regulations on Electronic Records and Electronic Signatures.

Maximize your assets and be sure your plant is safe

In today's world, predictive maintenance and the ability to foresee problems in advance saves on plant down-time and protects your investment.

Quietly in the background the system is monitoring your assets. The smart instrumentation is connected via a digital network, providing data that is used to create predictive diagnostic information as well as the connected process with all plant systems. Through the unified architecture, asset information for the whole plant is gathered and made available for operations and maintenance personnel.

Maintenance staff are thereby informed of upcoming failures and can take the necessary preventative action. Changes to instrumentation can be made remotely, with changes recorded for audit trail purposes.

In the control room operators receive rich diagnostic information from the intelligent digital devices.



Continuous improvement is a reality not a dream

While dispensary personnel are accessing the recipe inventory lists, the plant manager accesses data from his PC, all of which are provided through the plant's thoroughly integrated and secure management information system.

From here, plant engineers can easily compare previous and current batches can be easily compared against each other via Gantt charts and other graphical means to showing incredibly detailed batch information.

From this vital information the plant manager is able to identify bottlenecks in the system and thus understand how to improve recipes and sequences of operation for plant optimization leading to continuous operational improvement and the ultimate 'Golden Batch'.

This is the way all plants should run - allowing you to See Clearly, Know in Advance, and Act with Agility. It should run like a VigilantPlant.

Real Stories in the Pharmaceutical Industry



Project Reference

Germany

High upon any pharmaceutical manufacturer's priority is continuous support and the knowledge that the system will provide long-term trouble free operation.

Sanofi-aventis recently required that their Fermtec insulin production facility be upgraded to suit the company's PIMS strategy.

Key to this initiative was to provide modern linking mechanisms (e.g. OPC Communications) and compliance with the FDA's 21 CFR Part 11 ruling on the use of Electronic Records and Electronic Signatures.

The existing Yokogawa CENTUM CS was subsequently upgraded to the latest version of CS 3000 R3. The upgrade was carried out according to an upgrade system specification provided by Yokogawa which listed each facet of the existing system and how it would be converted to the new

sanofi-aventis Control System

- CENTUM CS 3000 R3
- 11 Operator Stations
- 2 Field Control Stations
- 2,500 I/O
- Profibus Communications

system, the vast majority of functions being automatically converted. Following customer factory and site acceptance tests the system was switched over to the new system in approximately 60 minutes.

The resulting system now enables sanofi-aventis to plan for further expansion of the system and to fully utilize the electronic data created to further evaluate and optimize the system.



Project Reference

Singapore

Reflecting Yokogawa's leadership in industry, Schering-Plough once again chose Yokogawa's latest DCS – CENTUM CS 3000 for their recent project at Tuas, a multi-product plant in Singapore.

The plant utilizes state of the art equipment for API manufacture and offered Yokogawa the prestige of being associated with the latest major drug, ZETIA® (ezetimibe) used for cholesterol management.

Two projects were undertaken. In addition to the DCS, Yokogawa also supplied 80% of the instrumentation used for both projects. During these projects Yokogawa embraced the Good Automated Manufacturing Practice (GAMP) guidelines methodology for the execution of the project and also provided IQ/OQ, calibration and validation services with all Yokogawa personnel involved with the project receiving the appropriate cGMP, GDP and GAMP training.

Schering-Plough Control System

- CENTUM CS 3000 R3
- 50 Operator Stations
- 18 Field Control Stations
- 12,000 I/O

The project was a beneficial experience for both Yokogawa and Schering-Plough as it was executed according to a Joint Management Agreement, the major drive being to improve efficiency of project execution and enhance the quality of the system delivered.

"We are very happy to work with Yokogawa, and have continued to rely on Yokogawa to help us design and develop control systems for our new and very important expansion projects." Dr. Patrick Yeung Executive Director of Project, Schering-Plough, Singapore.



Project Reference

Ireland

Yokogawa is currently executing a new project for Takeda Pharma Ireland Ltd (a subsidiary of Takeda Pharmaceutical Company Ltd) at their new Active Pharmaceutical Ingredient (API) plant located in Dublin, Ireland. This is Takeda's first API facility to be constructed outside Japan. The plant utilizes Yokogawa's CENTUM CS 3000 R3 control system for process control.

The plant will be used to develop and produce APIs used in clinical trials through to launch and full commercialization. In addition Takeda also plans to produce APIs in order to continue to supply existing world markets with products such as their diabetes blockbuster drug Pioglitazone (brand name Actos). To meet the above challenges the system has been specifically designed to be multipurpose allowing a large number of products to be manufactured utilizing Yokogawa's CENTUM

Takeda Pharma Control System

- CENTUM CS 3000 R3
- 8 Operator Stations
- 1 Audit Trail Server
- 5 Field Control Stations
- 4,500 I/O
- Profibus Communications to Packaged Equipment
- On-line Batch and Process Reports

CS 3000 batch control system which is based on the ISA-88.01 batch standard.

The system helps Takeda comply with the current FDA requirements for the use of Electronic Records and Electronic Signatures (i.e. FDA's 21 CFR Part 11) an issue of vital importance when supplying control and information systems to the pharmaceuticals industry.

Delivering to your needs



Committed to the Pharmaceutical Industry

As one of the world's leading Industrial Automation suppliers Yokogawa is committed to delivering the best possible measurement and control systems for your plant. All analytical equipment is calibrated to pharmacopoeia standards and validation standards and can be readily supplied with the relevant supporting documentation. Yokogawa's DAQSTATION paperless recorders, CENTUM CS 3000 R3 DCS and Exaquantum/Batch Plant Information Management Systems can be vali-

dated to comply with 21 CFR Part 11 and offer extensive documentation supporting facilities.

Software development within Yokogawa is subject to stringent QA protocols that describe and monitor each step of a system's development, from user requirements specifications to product release and life cycle management.

Process Analytical Technology

Yokogawa is committed to support the FDA's Process Analytical Technology (PAT) initiative. In fact we see the FDA's reasoning behind the PAT initiative as being very much in keeping with our own VigilantPlant initiative – **See Clearly** - Measure the process as accurately as possible, **Know in Advance** – Understand the process in order to be able to control the process most effectively, **Act with Agility** – Optimize the operation of the plant based on the information received and on the knowledge of the process and how it is best controlled. Furthermore Yokogawa has formed its own PAT interest group in order to engage and promote the benefits of PAT for our customers.



FDA Compliant Systems

Yokogawa is committed to supplying all of our systems according to the relevant regulatory requirements and appropriate industry standards. For example our DAQSTATION paperless recorders include two versions with support for 21 CFR Part 11 while both our CENTUM CS 3000 R3 control system and our

Exaquantum/Batch Plant Information Management Systems comply with the FDA's regulations. We supply safety systems compliant with IEC 61508 and IEC 61511 and batch control systems based on the ISA-88 (IEC 61512) standards and information systems according to ISA-95.01 standards.

Life Cycle Approach to Computer System Validation

Yokogawa is committed to the life cycle approach to computer system validation as per the GAMP 4 guidelines. The life cycle approach sets out a clear path for how the system is to be developed, manufactured and installed. GAMP 4 guidelines are also tried and tested and are widely accepted by most of the major pharmaceutical companies as an acceptable method of establishing the necessary documentary evidence required for the validation of their systems. Although the concept is very simple it provides many advantages such as a rigorous project execution where each stage of the project cycle must be assured before progressing to the next stage. Such a way of working instills heightened confidence and

visibility in ensuring that a project is delivered according to requirements the first time.



Long Term Customer Relationships and Support

Yokogawa is committed to establishing long term customer relationships. Such long term relationships benefit you the customer in a number of ways, not least in enabling Yokogawa to understand your business demands and therefore being able to best provide for your needs.

In addition to the above we are also committed to providing you with the best possible after sales services such as maintenance and support contracts and other services including calibration and system validation.

With Yokogawa our interest and support does not end on completion of the commissioning phase of the project. We understand that customers require long term support and continued assistance to ensure the smooth running and longevity of their investment.

For these reasons Yokogawa provides a comprehensive upgrade path for any existing system. With this in mind existing software can commonly be re-used as part of a system upgrade.





> Visualizing the right information ensures product quality

**SEE
CLEARLY**

Analytical Technology

Yokogawa provides a wide range of analytical instruments including pH, conductivity, dissolved oxygen and gas analyzers. Our pH and conductivity instruments are world renowned and are used by more than 4,000 companies world wide. All loops can be supplied with validation protocols documenting the wetted parts of the sensors, pharmacopoeia compliance and configuration of the transmitter. SOPs are provided for Good Calibration Management.



EXAxt

Process Fourier Transform NIR

NIR is one of the most informative analytical techniques where chemical and physical process characteristics are concerned.

Yokogawa's NR800 Fourier Transform NIR takes process analytical information to a new level with unrivalled stability, wavelength and precision.

Direct transfer of a calibration model from laboratory to the process, or among processes, is also possible, this together with the ease of operation and user friendly software are key design concepts for the NR800.



NR800

Flow, Pressure and Temperature

Accurate and reliable measurement of your process is essential if you are to capitalize on your investment. Yokogawa provides a wide range of flow, pressure and temperature transmitters to suit a number of applications.

All instruments are calibrated to NIST traceable standards. Our Ultrasonic flow meter which stays outside the process is used widely for external verification of installed flow meters.

Yokogawa's range of flow meters comprise four different types of technologies i.e. Vortex, Differential Pressure, Magnetic and Coriolis Mass flow.



ADMAG AXF

DPharp EJX

ROTAMASS

Data Acquisition

Yokogawa's recorder portfolio includes both the more conventional chart recorders and paperless recorders. The DAQSTATION DX100P/DX200P paperless recorders (pharmaceutical models) provide electronic record keeping functions that comply with the requirements of FDA regulation 21 CFR Part 11. The DX100P/DX200P display measured data in real-time on a high resolution color TFT liquid crystal display. Electronic signatures can be added to the saved data records at the DAQSTATION itself or using the included PC software package. In addition to the above DX recorders can also be networked to a PC server and accessed via Microsoft Internet Explorer. Yokogawa can even provide as a package all the necessary validation protocols required to complete Installation and Operational Qualification of these recorders.



DX100P/DX200P

> Predicting plant behavior enables effective planning & management

KNOW
IN ADVANCE

Distributed Information at Your Fingertips

CENTUM CS 3000 R3 is a full featured Distributed Control System (DCS) that enables users to see clearly and know in advance of any situations that may contribute to the quality or safety related aspects of the process.

The system includes a variety of methods by which information can be quickly and clearly displayed as standard such as an explorer style navigation utility. Historical trends and events can all be displayed using powerful search and view facilities.

True to the VigilantPlant philosophy, alarm information is only highlighted when an abnormal event occurs. CS 3000 can also be provided with the Yokogawa Alarm Administration suit that enables dynamic alarm values to be set by the system depending upon the plant conditions.



Real-Time Device Maintenance

Yokogawa's Plant Resource Manager (PRM) is a real-time device maintenance and management tool that provides access to instrument data which can be viewed in a control room or office environment.

Managing device records through the PRM database together with Plug and Play device registration enables an efficient and cost effective method by which to maintain plant instrumentation.



Plant Information Management Systems

Exaquantum/Batch provides Management Information that enables you to capitalize on your investment. The system utilizes Client/Server technology and supports fault tolerant systems for added reliability.

Exaquantum/Batch requires minimal configuration (and therefore minimal validation effort) and provides users with a simple and intuitive graphical interface based on Microsoft Internet Explorer.

Exaquantum/Batch enables information to be displayed in a variety of ways including web, Gantt chart, histogram and trend display formats, all of which are standard and require no configuration. Exaquantum/Batch also provides a facility whereby Key Performance Indicators (KPIs) can be associated with batches.

This process can therefore be used to indicate 'Golden Batch' quality attributes and to provide Six Sigma quality type monitoring and process optimization information.



When connected to Yokogawa's CS 3000, Exaquantum/Batch utilizes automatic equalization whereby the CS 3000 database and recipe information is automatically read by the system. Such functionality enables the system to be easily validated due to the fact that only standard software is being used.



> Robust control and integrated safety assures speed and flexibility of business

**ACT
WITH AGILITY**

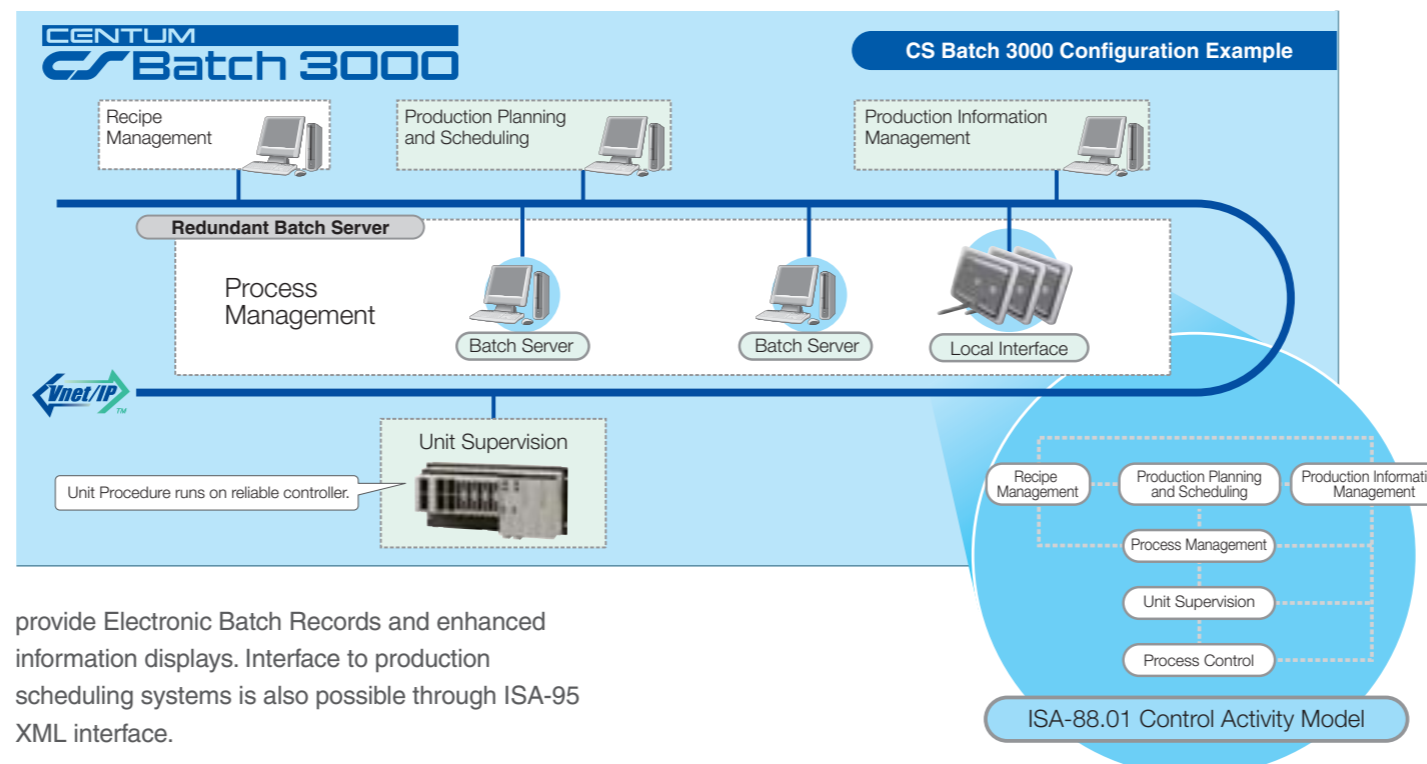
DCS Control for Batch

CENTUM CS 3000 is a truly scalable, modern, Distributed Control System (DCS) that runs on Windows Professional XP or Windows Server platforms.

The system is built to provide the ultimate in reliability as all components can be supplied in a dual redundant format for all components (e.g. processor cards, communications and powers supplies). Continuous control is provided via the standard CS 3000 operating environment whereas batch control is provided via the CS Batch 3000 Recipe and Batch management system thus enabling batch systems to be implemented according to the ISA-88.01 batch standard.

The system is completely scalable – ranging from one operator station, one Field Control Station and a few I/O to systems with multiple operator stations, multiple controllers and tens of thousands of I/O. Engineering is modular and efficient due to the use of the large number of standard function blocks supplied with the system. Reusability of common functions is maximized by the use of generic parameter variable naming. Compliance with the FDA's 21 CFR Part 11 ruling on the use of Electronic Records and Electronic Signatures can also be achieved including license options for audit trails for operations and engineering.

The system interfaces to other sub-systems via a large number of industry standard protocols such as Modbus RTU and TCP, Profibus, FOUNDATION Fieldbus, DeviceNet, OPC and XML. CS 3000 automatically links to Exaquantum/Batch to



provide Electronic Batch Records and enhanced information displays. Interface to production scheduling systems is also possible through ISA-95 XML interface.

Network Based Control Systems

STARDOM is an IEC 61131-3 Network Based Control compliant system. As such it can be programmed in Ladder, Sequential Function Chart, Structured Text, Instruction List and Function Blocks.

Stardom includes a Web Server allowing your process data to be displayed and analyzed using a simple web browser such as Microsoft's Internet Explorer.

The system is completely scalable and can be supplied in dual redundant format. Connection to the outside world can be via Ethernet, Fieldbus or Serial

communications. OPC communications makes it easy to connect to a host of other systems including commonly available SCADA systems including Yokogawa's FAST/TOOLS.



STARDOM

Safety Systems

For systems requiring Safety Integrity levels up to SIL3, ProSafe-RS offers PLC type technology but with the reliability and dual redundant operation expected of a Safety system. Both the ProSafe-RS and the Yokogawa organization have been certified by TÜV to be in compliance with IEC 61508 and IEC 61511. ProSafe-RS is certified as SIL3 in a single module configuration with redundancy for high availability. No gateway or interface hardware is required for data exchange between DCS and SIS functions. For systems requiring SIL levels up to SIL4 then ProSafe SLS offers a solid state dual redundant solution.



ProSafe-RS

Project Execution and Life Cycle Services

Project Execution and Consultancy



Project Execution

The ability to deliver projects on time and per customer requirements is as essential as the products and systems themselves. For this reason Yokogawa implements projects according to well defined procedures and operates a culture of best practice at all times. Good Automated Manufacturing Practice (GAMP) projects have been undertaken by Yokogawa with extremely successful results. Utilizing the GAMP4 “V-Model” of Function Specification, Design, Implementation, Factory Test, and Site Acceptance along with verification and testing including IQ/OQ provides objective evidence of meeting the requirements of the project. Other methods employed by Yokogawa is the use of system prototyping in the design phase to assist our customers in choosing and defining the solution that best suits their requirements.

Validation and Consultancy

Computer system validation and consultancy are common requirements in the pharmaceutical industry. Yokogawa is able to provide our services with regards to all project validation qualification stages (i.e. DQ, IQ, OQ and PQ) and are also able to provide SOPs regarding the use of our systems. Our consultancy services include process analytical technology consultancy, control and safety systems consultancy and products and systems validation consultancy.

Life Cycle Services Support



Maintenance

Yokogawa provides maintenance and support for all our products and systems. Yokogawa is able to provide local support from over 80 offices around the world. Maintenance contracts are provided to suit your exact requirements. Typical contracts include guaranteed call out and response times, bonded spares and periodic site maintenance visits to keep your system running smoothly and reliably.

Training


Yokogawa provides both standard and custom training courses. Training courses are available for all of our products and systems and are commonly run either at our customer’s own premises or at our local Yokogawa office. Custom courses are especially useful where specific training is required (e.g. operator training for a particular application). In this regard Yokogawa is able to tailor courses to suit your exact needs.

Calibration


Calibration of Yokogawa instrumentation can be conducted either on site or at many of our local offices. Periodic calibration of your instrumentation is commonly a manufacturing requirement to ensure that the process is operating correctly. As part of our calibration service Yokogawa provides calibration test certification according to nationally recognized and industry based standards.



VigilantPlant = *The clear path to operational excellence*



Revamp and Expansion
Online Expansion,
Hot Cutover



Maintenance and Upgrade
Asset Optimization,
Online Upgrade,
Lifecycle Solution Support


Plant-wide integration

Optimize ERP	Production Management Plant Information Management, Advanced Process Control	
	Asset Management and Operational Efficiency Plant Resource Management, Operational Efficiency Improvement	
Control	Production Control and Safety Management Continuous and Batch Production Control, Safety Management, SCADA and Network-based Control	
	Data Acquisition and Logic Control Recorders, Data Acquisition, IT Machine Control, Single Loop Control	
Measure	Analysis and Quality Control Process Gas, Process Liquid, Stack Gas, City Water, Waste Water Analysis	
	Sensing and Actuation Pressure, Temperature, Flow, Level Measurement, Final Control Elements, Primary Elements and Auxiliaries	


Computer System Validation
Process Analytical Technology
Consultancy and Validation
Consultancy Services



Design and Engineering
Front-End Engineering & Design (FEED), Main Instrumentation Vendor (MIV) Services



Installation and Commissioning
Site Engineering, Integration Tests, Turn-Key Services



Operation and Optimization
Optimization Consulting,
24/7 Operation Support,
Online Diagnosis Support



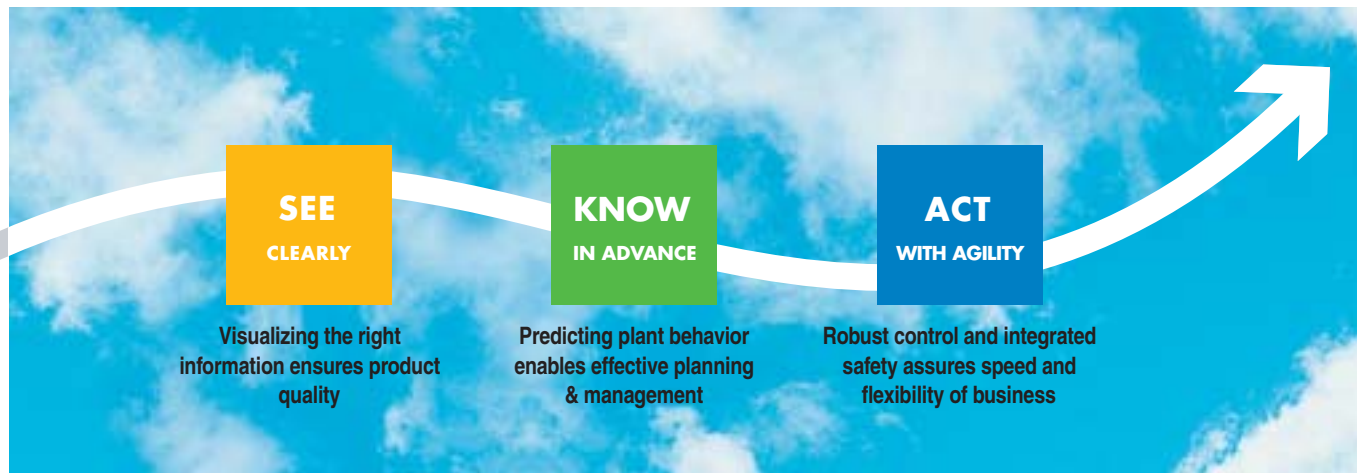
Life cycle optimization

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VigilantPlant excels at bringing out the best in your plant and your people - keeping them fully aware, well informed, and ready to face the next challenge.

A Yokogawa Commitment to Industry

vigilance.[®]

quality

innovation

foresight

What does Yokogawa **vigilance** mean to the future of your business? **Quality**. Through products that are built from the ground up and tested to the last hour, you're ensured continuous operation and more uptime. **Innovation**. Your business will benefit from new insights and capabilities, bringing true predictability to your process. **Foresight**. As the market changes, you'll have solutions that give you the continuity and flexibility to plan ahead and grow. Our partners know the difference. With Yokogawa, you can count on a lifetime of plant efficiency, from instrumentation to operation support. Let us be vigilant about your business.

YOKOGAWA ELECTRIC CORPORATION

World Headquarters
9-32, Nakacho 2-chome, Musashino-shi, Tokyo 180-8750, Japan
<http://www.yokogawa.com/>

YOKOGAWA CORPORATION OF AMERICA

2 Dart Road, Newnan, Georgia 30265, USA
<http://www.yokogawa.com/us/>

YOKOGAWA EUROPE B.V.

Databankweg 20, 3821 AL Amersfoort, The Netherlands
<http://www.yokogawa.com/eu/>

YOKOGAWA ENGINEERING ASIA PTE. LTD.

5 Bedok South Road, Singapore 469270, Singapore
<http://www.yokogawa.com/sg/>

YOKOGAWA CHINA CO., LTD.

K.Wah Centre 28, 29F, 1010 Huai Hai Zhong Rd.
Shanghai 200031, China
<http://www.yokogawa.com/cn/>

YOKOGAWA MIDDLE EAST B.S.C.(c)

P.O. Box 10070, Manama
Building 577, Road 2516, Busaiteen 225, Muharraq
Bahrain
<http://www.yokogawa.com/bh/>

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