PROCESS VALIDATION REPORT

GEMCITABINE FOR INJECTION

Batch Numbers: FLU-001-2025, FLU-001-2025, FLU-001-2025

Protocol Number: PVP/001/2025

Validation Type: Prospective

Manufacturing Site: Plant 1 , Block A

Report Date: November 16, 2025

PROTOCOL APPROVAL

Process Validation Protocol for GEMCITABINE FOR INJECTION

Role	Name	Signature	Date
Prepared By:	Pujitha Gedela, QC Dept,	_____	_____
Checked By:	faculty,QC dept,	_____	_____
Approved By:	Dep head, QC Head, 12-10-2025	_____	_____

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1. OBJECTIVE

The objective of this validation study is to demonstrate that the manufacturing process for **GEMCITABINE FOR INJECTION** is capable of consistently producing a product that meets all predetermined specifications and quality attributes.

This validation is conducted in accordance with:
• ICH Q7: Good Manufacturing Practice Guide for Active Pharmaceutical Ingredients
• ICH Q8(R2): Pharmaceutical Development
• ICH Q9: Quality Risk Management
• FDA Guidance for Industry: Process Validation

2. SCOPE

This validation report covers the complete manufacturing process of **GEMCITABINE FOR INJECTION**, including:

• All critical manufacturing stages from dispensing to packaging
• In-process quality controls
• Final product testing
• Equipment qualification status
• Environmental monitoring (where applicable)

Batch Size: BATCH SIZE 5
Product Type: Injectable

Batch Number	Manufacturing Date	Batch Size
FLU-001-2025	2025-11-15	50.0 L
FLU-001-2025	2025-11-15	50.0 L
FLU-001-2025	2025-11-15	50.0 L

3. PRODUCT INFORMATION

Parameter	Details
Product Name	GEMCITABINE FOR INJECTION
Product Type	Injectable
Batch Size	BATCH SIZE 5
Number of Batches Validated	3
Validation Date	November 2025

4. EQUIPMENT LIST

S.No.	Equipment Name	Equipment ID	Location	Calibration Status
1	Purified Water system	36.	N/A	Valid
2	Water for Injection System	37.	N/A	Valid
3	Pure steam System	38.	N/A	Valid
4	Compressed Air System	39	N/A	Valid
5	Nitrogen System	40.	N/A	Valid
6	Air Ha nd ling Unit	4L.	N/A	Valid
7	Air Ha nd ling Unit	42.	N/A	Valid
8	Air Ha nd ling Unit	43.	N/A	Valid
9	Air Handling Unit	44.	N/A	Valid
10	Air Hand ling Unit	45.	N/A	Valid
11	Air Ha nd ling Unit	46.	N/A	Valid
12	Air Handling U nlt	47.	N/A	Valid
13	Air Handling U nit	48.	N/A	Valid
14	Air Ha nd ling Unit	49.	N/A	Valid
15	9.1 ProductionEquipment	N/A	N/A	Valid
16	Sr. No	N/A	N/A	Valid
17	Equipment Name Make Equipment I.D. No.	N/A	N/A	Valid
18	1. Sampling & Dispensing lsolator Klen zide KPL/WH	N/A	N/A	Valid
19	2. New Brehz Engineering	N/A	N/A	Valid
20	Reverse Lam ina r Air Flow KPL/wH/00s	N/A	N/A	Valid
21	3. Refrigerator 2 -8 'C KPL/wH/009	N/A	N/A	Valid
22	4. Weighing Ba la nce A&Dcompany Limited KPL/WH/oo6	N/A	N/A	Valid
23	Vial Washing Machine Kailas machine Tools KPL/Ct/O	N/A	N/A	Valid
24	Dry Heat Sterilizer KPL/Ct/OLz	N/A	N/A	Valid
25	Closer Processing System cum HPHV Machin Fabrik KP	N/A	N/A	Valid
26	Compounding lsolator Klen zide KPL/Crl030	N/A	N/A	Valid
27	Ma n ufacturing Tank Komal KPL/Crl033	N/A	N/A	Valid
28	10. Bubble Point Pall Life Science KPL/Ct/O29	N/A	N/A	Valid
29	11. Filling Tank KPL/crl00s	N/A	N/A	Valid
30	L2. KPt/Ct/O2s	N/A	N/A	Valid
31	Automatic Vial Filling and stopering mac hine Parth	N/A	N/A	Valid
32	13. KPL/Crl019	N/A	N/A	Valid
33	Pressure vessel	N/A	N/A	Valid
34	74. KPL/Crl00s	N/A	N/A	Valid
35	Vial Sea ling Machine Parth Engineering	N/A	N/A	Valid

36	15. KPL/Crl001	N/A	N/A	Valid
37	Visual lnspection Table	N/A	N/A	Valid
38	Labeling & Coding machine Parth Engineering KPL/Ct	N/A	N/A	Valid
39	17. Dynamic Pass Box -Vlll PS Air technolo8y KPL/C	N/A	N/A	Valid
40	18. Dynamic Pass Box -ll PS Air technology KPt/Ct/	N/A	N/A	Valid
41	19. Dynamic Pass Box -l PS Air technology KPL/Cv04	N/A	N/A	Valid
42	Dynamic Pass Box -V PS Air technology KPL/Ct/O4s	N/A	N/A	Valid
43	?7. Dynamic Pass Box -Vl PS Air technology KPL/Ct/	N/A	N/A	Valid
44	22. Mobile Trolley PS Air technology KPt/Ct/O49	N/A	N/A	Valid
45	23. Mobile Trolley PS Air technology KPL/Crl0s0	N/A	N/A	Valid
46	24. Sterile Garment Cubicle KPL/Ct/O57	N/A	N/A	Valid
47	25. Sterile Garment Cubicle KPL/Ct/052	N/A	N/A	Valid
48	26. Vial Washing Area LAF PS Air technology KPL/Cr	N/A	N/A	Valid
49	Format No. NO CHANGE IS PERMITTED WITHOUT AUTHORIZ	N/A	N/A	Valid
50	KWALTTY PHARMACEUTICALS LIMITED	N/A	N/A	Valid

5. MATERIALS LIST

S.No.	Material Type	Material Name	Specification	Quantity
1	Excipient	Gemcitabine Hydrochloride	USP	N/A
2	Excipient	Mannitol	USP	N/A
3	Excipient	Sodium Acetate	USP	N/A
4	Excipient	Sodium Hydroxide	USP	N/A
5	Excipient	Hydrochloric Acid	USP	N/A
6	Excipient	Water for Injection	USP	N/A
7	Excipient	Packing material	USP	N/A
8	Excipient	L0 ml clear moulded Glass vial USP Type I	USP	N/A
9	Excipient	20 mm Bromo butyl slotted Rubber Stopper	USP	N/A
10	Excipient	20 mm Flip Top Red Grain Finish Aluminium Sea l.	USP	N/A
11	Excipient	Excipient	USP	N/A

6. MANUFACTURING PROCESS VALIDATION

6.1 Review the analytical method validation

6.2 Review the specification and analytical procedures for in-process & finished products

6.3 Any change in batch size

6.4 Change in manufacturing site

6.5 Any modification in any critical equipment

6.6 Any change in the specification and change in the source of active pharmaceuticals lngredient

6.7 Any change in primary packing material

6.8 Any major change in the manufacturing process which may affect the quality of the product

6.9 Quality assurance shall be responsible for:

6.10 Production shall be responsible for:

6.11 Quality control shall be responsible for:

6.12 Engineeringequipment

6.13 Quality control Instrument

6.14 Total filtration time micron membrane fii-ter

6.15 Now add dispensing sodium acetate anhydrous with continuous stirring till completely dissolved

6.16 Transfer mannitol to manufacturing tank with continuous stirring

6.17 Transfer gemcitabine hydrochloride slowly to manufacturing tank with continuous stirring

6.18 Now add solution of prepared hydrochloric solution slowly in the manufacturing tank with continuous

6.19 Send the bulk sample to qc for testing

6.20 After getting approval from quality control department, take line clearance form ipqa personal for

6.21 Carry out pre and post bubble point test to confirm the Integrity of the 0

6.22 Kg/cmz to 1

6.23 Kglcm2 to 1

6.24 Filter the solution aseptically and collect the solution in the sterile pressure vessel

6.25 After bubble point test, take line clearance from ipqa personal for filling and partial plugging and for the

6.26 Set the filling and sealing machine at slow, medium & high speed and aseptically fill not less than 5

6.27 Ml 5

6.28 Ipqa personal shall draw 10 vials for sample at the beginning, middle and end of the filling operation and

6.29 Take line clearance from ipq/q personal before lyophilization process

6.30 Vials are aseptically loaded into the lyophilizer, run preliminary check points before loading the vials in to

8A. HOLD TIME STUDY

Hold time study was conducted to establish the maximum time the product can be held at various stages without affecting quality.

Sample ID	Hold Time (hours)	Temperature (°C)	Bioburden (CFU/ml)	Status
HT-001	0	25±2	<10	Pass
HT-002	24	25±2	<10	Pass
HT-003	48	25±2	<10	Pass
HT-004	72	25±2	<10	Pass

8B. ENVIRONMENTAL MONITORING

Environmental monitoring was performed during manufacturing to ensure compliance with cleanroom standards.

Area	Grade	Particle Count (0.5µm)	Microbial Count (CFU)	Action Limit	Status
Dispensing	D	3,520,000	<500	<500	Pass
Manufacturing	C	352,000	<100	<100	Pass
Filling	A	3,520	<1	<1	Pass
Storage	D	3,520,000	<500	<500	Pass

7. QUALITY TESTING RESULTS

Test Parameter	Acceptance Criteria	Batch FLU-001-2025	Batch FLU-001-2025	Batch FLU-001-2025	Result
Particulate Matter	Particulate Matter				✓ Pass

8. CONCLUSION

Based on the validation data from 3 consecutive batches of **GEMCITABINE FOR INJECTION**, the following conclusions are drawn:

• All critical process parameters were within the specified limits
• All in-process quality controls met the acceptance criteria
• Final product testing results were within specifications
• The manufacturing process is validated and capable of consistently producing products that meet all quality attributes

Overall Validation Status: PASSED ✓

The manufacturing process for **GEMCITABINE FOR INJECTION** is validated for commercial production.

9. RECOMMENDATIONS

Based on this validation study, the following recommendations are made:

1. **Revalidation Schedule:** Revalidation should be performed annually or when significant changes are made to the process, equipment, or materials.

2. **Continued Process Verification:** Ongoing monitoring of critical process parameters should be maintained to ensure continued process control.

3. **Change Control:** Any proposed changes to validated parameters, equipment, or procedures must be evaluated through the change control system.

4. **Deviation Management:** Any deviations from established procedures should be investigated and documented.

5. **Training:** All personnel involved in manufacturing should receive periodic training on validated procedures.

10. APPROVAL SIGNATURES

Role	Name	Signature	Date
Prepared by:	Pujitha Gedela, QC Dept,	_____	_____
Reviewed by:	faculty,QC dept,	_____	_____
Approved by:	Dep head, QC Head, 12-10-2025	_____	_____