



## ***AseptiBag Gold*** 2D Single Use Systems for Storage and Transfer

Biopharmaceutical process involves a very wide range of process fluids such as media, growth regulators, harvests, post centrifuge supernatants, buffers, process intermediates, drug substance and formulations.

A critical requirement is storage and transfer of these fluids during and between process step(s) as well as between different process areas. Process owners using conventional reusable storage and transfer systems involving glass bottles, large carboys or stainless steel vessels face multiple challenges in terms of extraneous contamination due to multiple open system handling, cleaning validation and documentation, limited availability of storage space (specially at low temperatures up to - 80 ° C) due to large footprint and issues of safe transportation.

### **Single Use Systems**

Single use disposable pre-sterilized storage and transfer systems help overcome all the above functional challenges and help achieve greater regulatory compliance. These systems however, need to address user concerns with respect to integrity and strength, sterility, endotoxins, biosafety, extractables, particle/fiber release that may impact the identity, strength, quality and purity of the process fluids.

MDI ***AseptiBag*** Gold systems provide validated and reliable single use disposable solutions for biopharmaceutical process requirements such as storage and transfer of sterile media, process intermediates, sterile buffers with wide ranging pH, sterile drug substances and formulations. These are well characterized for various physical, chemical and microbiological properties to alleviate all the above mentioned concerns.

# AseptiFlex-D

# Datasheet

## The Heart of AseptiBag Gold Systems

The MDI **AseptiFlex-D** Film type FBG-1 is a highly inert, multilayered polyethylene film specially designed for bioprocess applications.

The film is physically tough and inert to chemicals and solvents used in the biopharmaceutical industry and the various layers of the film provide an excellent barrier to Oxygen, CO<sub>2</sub> and moisture.

The contact layer is 130 µm ultra low density Polyethylene layer without any additives.

The AseptiFlex-D film is produced in classified areas through validated processes to ensure consistently high quality meeting various regulatory as well as functional requirements.

### Deeply characterized and validated

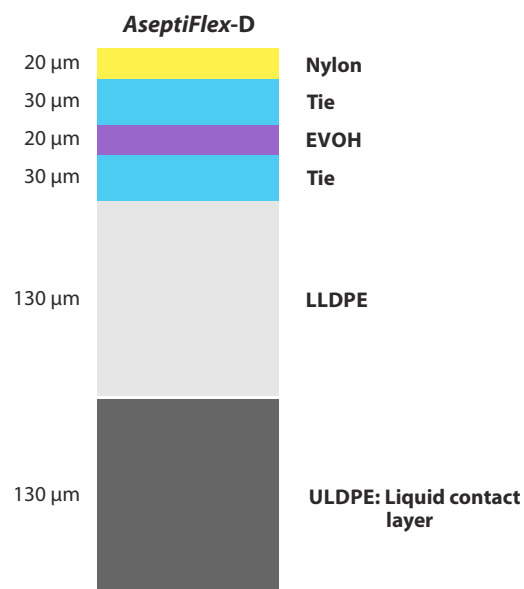
AseptiFlex-D has been extensively characterized after gamma irradiation at 50 kGy to deliver high performance:

**High strength and flexibility:** for safety and integrity during handling, storage and transport

Test		Reference Standard	Average Values
Tear strength	TD	ASTM D1938	25.556 N
	MD		17.873 N
Puncture Resistance		EN14477	10.9578 N
Tensile Strength (MD)		ASTM D-882	27.0298 N/mm <sup>2</sup>
Flex Durability Test (Gelbo)		ASTM F-392	Passes

**Protection of stored liquids from oxidation, change in pH and change in concentration of critical components:** with high barrier properties for Oxygen (O<sub>2</sub>), Carbon dioxide (CO<sub>2</sub>) and water vapour (WV)

Test	Reference Standard	Average Values
O <sub>2</sub> Transmission Rate	ASTM D3985-05	0.168 cc/m <sup>2</sup> /day
CO <sub>2</sub> Transmission Rate	ASTM F 2476	<1.0 cc/m <sup>2</sup> /day
WV Transmission Rate	ASTM F1249-13	0.879 g/m <sup>2</sup> /day



### Biocompatibility for media storage and cell growth:

AseptiFlex film is made of plastics of Non Animal Origin and is validated for Biological Reactivity tests as per USP

Test	Reference Standard	Result
Intracutaneous Toxicity	Biological Reactivity Tests, <i>In Vivo</i> , as per USP <88>	Passes
Acute Systemic Toxicity		Passes
Muscle Implantation		Passes
Cytotoxicity	Biological Reactivity Tests, <i>In Vitro</i> , USP <87>	Passes

**No impact on purity of process fluids:** Very low extractable profile

Test	Reference Standard	Result
Non Volatile Residue	as per USP <661>	Passes
Heavy Metals	as per USP <661>	Passes
Buffering Capacity	as per USP <661>	Passes
Effect on WFI	as per USP <1231>	Passes

# AseptiBag Gold

## Datasheet

### Unique Features and Applications

AseptiBag Gold is made from AseptiFlex-D film offering multiple advantages such as:

- Very low extractable profile for low 'Product' risk
- Long term storage of media and cell growth
- Stability at very low temperatures of up to -80°C
- Higher strength and flexibility

#### Unique Features

- 100% integrity tested with pressure leak test
- High barrier properties for protection of product molecule, product pool and media components
- Robust and flexible with high burst strength
- Easy inlet and outlet quick connections
- User friendly easy to hold/hang design
- Custom designed to suit user specific process applications

#### Applications

MDI AseptiBag Gold systems are used for critical biopharmaceutical process steps such as:

- Long term aseptic storage of sterile media, buffers and drug substances at low temperatures
- Transfer of sterile media to bioreactors
- Transfer of process intermediates between process areas
- Aseptic transfer of drug substance to formulation facilities



**Easy Inlet/outlet  
Quick Connections**



**Easy to Hold/Hang**



**Validated Pinch Clamps**



**Leak Proof Ties**

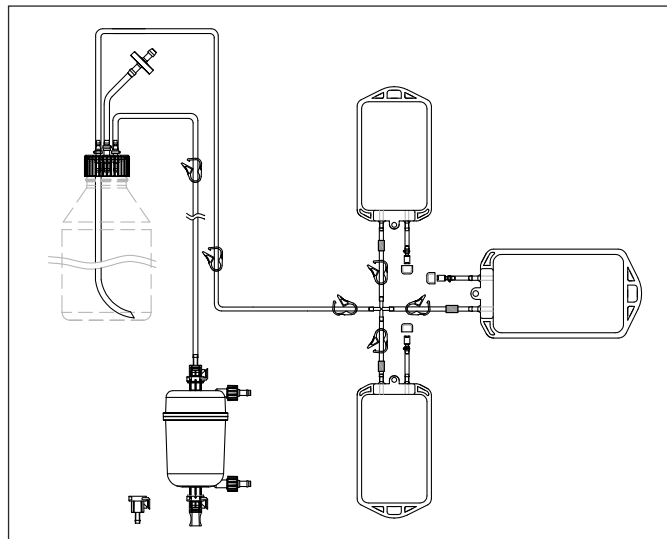


## Customized Single Use Systems

MDI works closely with the process owners in biopharmaceutical manufacturing to understand their application requirements in order to establish the technical feasibility of a single use system (SUS) in terms of size, pressure, temperature, complexity of the system as well as compatibility, and to design customized systems by integrating *AseptiBag Gold* with a wide range of pre-qualified components such as membrane capsule filters, connectors, tubing and fittings.

All the system components are deeply characterized and validated for microbial retention, bio-burden, bacterial endotoxins, biosafety and extractables etc to minimize 'product risk' and maximize regulatory compliance.

These customized systems are realized from user approved drawings with detailed definitions of materials of constructions, pore size and dimensions.



### Components

#### Sterilizing grade membrane capsule filters

MDI capsule filters with PES and hydrophilic PVDF membranes are available in different pore sizes, sizes and end connections for sterile filtration of cell culture media, buffers, drug substance and drug formulations. To know more, visit the link:

<http://www.mdimembrane.com/microfiltration/product-by-type/capsule-filter>

#### Tubing

MDI offers multiple tubing options of thermoplastic elastomers (TPE) as well as platinum cured silicone. These are available in a wide range of internal and outer diameters to meet the process requirements with respect to fitment into peristaltic pump and to different size hose connections.

TPE tubing offers chemical compatibility with a wide range of organic solvents and buffers. These are heat weldable to allow leak free sterile connections for sampling and storage applications.

Platinum cured silicone tubing offers enhanced flexibility for easy integration into single use systems and for use in peristaltic pumps.

#### Fittings

A wide range of MDI gamma stable fittings such as cross connections, T connections, Y connections and reducers are available to support various plumbing requirements within these customized single use systems.

### Quality Assurance

MDI quality management system emphasizes on quality by design rather than by end product testing only. Robust processes are developed for product manufacturing and are continuously monitored to ensure that the products meet their predetermined specifications and lot to lot reproducibility is ensured.

MDI *AseptiBag* Gold single use storage and transfer systems are produced by trained personnel in validated ISO class 7 facilities under ISO 9001 quality management systems using validated production processes.

Each lot has well compiled batch manufacturing records that ensure complete traceability of raw materials, machines, in process controls, personnel and quality control test data.

These are tested and validated as per international standards and guidelines such as CFR, ASTM, ISO and USP and supported by well designed, state of art physical, chemical and microbiology laboratories.

#### **100% Integrity Tested**

Each *AseptiBag* Gold is tested for integrity to comply with validated Acceptable Integrity Test Specifications.

#### **Pressure, Temperature Endurance**

*AseptiBag* Gold systems are validated to endure operating pressure and wide temperature conditions which may be encountered during use.

These bags are also validated for burst pressure with liquid to ensure user as well as product safety in case of inadvertent pressure build-up.

#### **Bioburden Testing**

Device bioburden is tested as per ISO 11737-1 and assured to be <1000 cfu/bag.

#### **Biosafety**

Passes Biological Reactivity test, In-Vivo, as per USP <88> for Class VI plastics

Passes the Biological Reactivity Tests, In Vitro for Cytotoxicity as described in USP <87>

#### **Endotoxin Testing**

Aqueous extracts exhibit < 0.125 EU/ml as established by Limulus Amebocyte Lysate (LAL) Test

#### **Extractables**

Extractables/leachables from sterile containers, used at various stages of a biopharmaceutical manufacturing process, will add on and may impact the impurity profile of the desired product.

*AseptiBag* Gold systems are validated to exhibit very low extractables under harsh extraction conditions.

#### **Package Integrity**

*AseptiBag* Gold systems are double packed in polybags to ensure package integrity during transit as well as to prevent contamination while transferring to clean room assembly or process areas.

#### **Certificate of Quality**

Each lot is accompanied with a Certificate of Quality and the lot number is mentioned on the packaging of each *AseptiBag* Gold storage and transfer system to ensure traceability at the user's end.

# AseptiBag Gold

## Specifications

# Datasheet

### Materials of Construction

<b>Bag Film</b>	AseptiFlex-D film type FBG-1
<b>Connection ports</b>	Polysulfone/Polycarbonate
<b>Clamps</b>	Polyester
<b>Tubing</b>	Platinum cured silicone

### Storage Temperature

-80°C to 45°C

### Sterilization

Gamma Sterilizable upto 50 kGy

### Sterility

The gamma sterilization process has been validated as per ISO 11137 to ensure a sterility assurance level(SAL) of  $10^{-6}$

### Bacterial Endotoxin

Aqueous extracts exhibit < 0.125 EU/ml as established by Limulus Amebocyte Lysate (LAL) Test as per USP <85>

### Biosafety

Passes the Biological Reactivity Tests, *In Vivo* for Class VI plastics as described in USP <88>.

Passes the Biological Reactivity Tests, *In Vitro* for Cytotoxicity as described in USP <87>.

### Fiber Release

Passes test as per USP and comply with USFDA 21 CFR Part 210.3(b)(6) for fiber release

### Particle Release

Complies with USP <788> test for particulate matter in injections

### Extractables with WFI

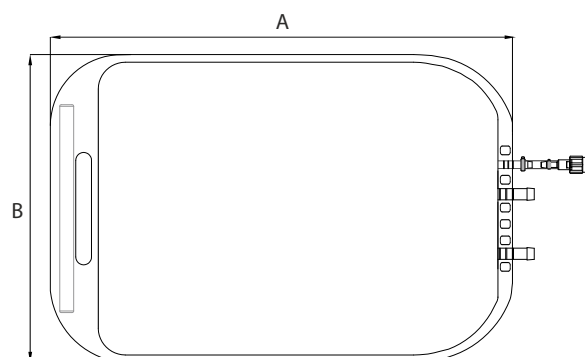
Does not affect the quality of Water for Injection (passes tests as per USP <661>)

### Available Sizes

100 mL, 250 mL, 1 L, 2 L, 5 L, 10 L, 20 L and 50 L

### Dimensions

Bag Size	A	B
<b>100 mL</b>	154 mm	86 mm
<b>250 mL</b>	189 mm	134 mm
<b>1 Litre</b>	275 mm	200 mm
<b>2 Litre</b>	350 mm	200 mm
<b>5 Litre</b>	375 mm	319 mm
<b>10 Litre</b>	590 mm	322 mm
<b>20 Litre</b>	490 mm	580 mm
<b>50 Litre</b>	775 mm	582 mm



### End Connections

Size	100 mL, 250 mL	1 L to 50 L
<b>Inlet/Outlet</b>	Female Luer Lock	Male Quick Connector
	Male Luer Lock	

### Sampling Port

Needleless

### Tube Length

Tube	Length	
	100 mL and 250 mL	1 L to 50 L
Inlet	4 Inch	6 Inch
Outlet	4 Inch	6 Inch
Sampling	4 Inch	6 Inch

### Customization:

The 1 litre to 50 litre storage bags can be customized to suit user requirements. Female quick connector can be provided for inlet port/outlet port and rubber septum for sampling port.

# AseptiBag Gold

## Datasheet

### Chemical Compatibility

Different samples of MDI AseptiBag Gold were filled with specific chemicals/reagents for a specified time period @ 40°C. Post exposure the bags were visually inspected and tested for any leakages, film weight and thickness. These tests were conducted on 250 mL bags.

#### Acceptance Criteria

- ◆ Visual: Color changes, stress marks and clarity
- ◆ Change in weight:  $\pm 7\%$
- ◆ Change in thickness:  $\pm 10\%$
- ◆ Leakage: No Leakage @ 5 psi

Chemical/ Reagents	Exposure	Compatibility
95% Ethanol	7 Days	■
0.5% Chloroform (in IPA)	1 Month	■
100% Ethyl Acetate	7 Days	■
100% Glycerol	7 Days	■
30% Isopropanol	7 Days	■
50% Acetic acid	7 Days	■
1% Citric Acid	7 Days	■
10% HCl	7 Days	■
40% Nitric Acid	7 Days	■
25% Phosphoric Acid	1 Month	■
100% Ethylene Dichloride	7 Days	●

Chemical/ Reagents	Exposure	Compatibility
30% Sulfuric Acid	7 Days	■
Buffer pH 4	7 Days	■
Buffer pH 10	7 Days	■
1M Ammonium Chloride	7 Days	■
2M Sodium Acetate	1 Month	■
0.3M Sodium Acetate	1 Month	■
4M Sodium Chloride	7 Days	■
30% Hydrogen Peroxide	7 Days	■
4-6% Sodium Hypochlorite	7 Days	■
100% Methanol	7 Days	■
100% Chloroform	7 Days	●

- Resistant
- Not Resistant
- Limited Resistance

# AseptiBag Gold

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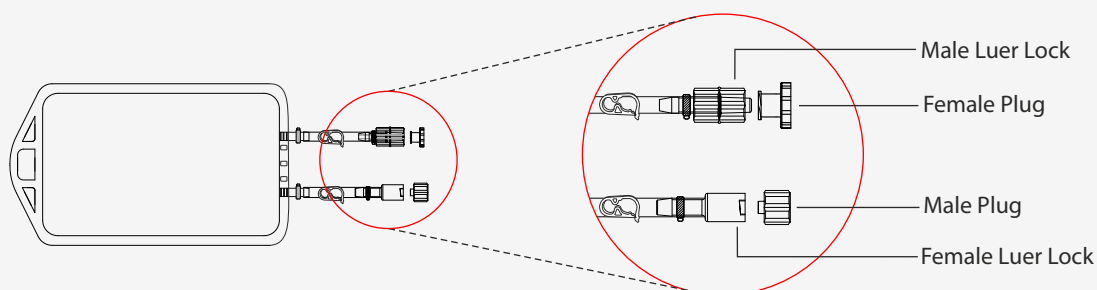
## Ordering Information

### For 100 mL and 250 mL Storage Bags

Type		Bag Size		Inlet Port		Outlet Port		XXX	Tube		X	Sterility			Pack Size	
	Code		Code		Code		Code			Code			Code		Code	
AseptiBag Gold	ABDX	100 ml	A	Female Luer Lock	M	Male Luer Lock	L		Platinum Cured Silicone	X		Gamma Sterile	3	10	02	
		250 ml	B													

#### Example

ABDX	B	M	L	XXX	X	X	3	02
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### For 1L to 50L Storage Bags

Type		Bag Size		Inlet Port		Outlet Port		Sampling Port		XX	Tube		X	Sterility			Pack Size	
	Code		Code		Code		Code		Code			Code			Code		Code	
AseptiBag Gold	ABDX	1 L	C	Male Quick Connector	J	Male Quick Connector	J	Needleless	N		Platinum Cured Silicone	X		Gamma Sterile	3	10	02	
		2 L	D															
		5 L	E															
		10 L	F															
		20 L	G															
		50 L	H															

#### Example

ABDX	C	J	J	N	XX	X	X	3	02
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