	DEPARTMENT O	F HEALTH AND HUMA	N SERVICES		
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FIRM NAME		SIREE	ADDRESS		
Exela Pharma S	ciences LLC	1245	Blowing Rock Blvd		
CITY, STATE, ZIP CODI	E, COUNTRY	TYPE E	STABLISHMENT INSPECTED		
Lenoir, NC 286	45	Outso	ourcing Facility / Sterile Dr	านอ	
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This document lists obs	servations made by the FDA representa	ative(s) during the inspec	tion of your facility. They are inspec	ctional observations	
and do not represent a	final Agency determination regarding	g your compliance. If yo	ou have an objection regarding an o	observation, or have	
implemented, or plan t	to implement, corrective action in resp	oonse to an observation,	you may discuss the objection or a	ction with the FDA	
	g the inspection or submit this inform	nation to FDA at the ad	dress above. If you have any quest	ions, please contact	
FDA at the phone num	ber and address above.				
DUDING AN INCORGO		ED.			
DURING AN INSPECT	FION OF YOUR FIRM I/WE OBSERV	ED:			
OBSERVATIO	N 1				
	of investigations into unex	nlained discrena	ncies do not always inclu	do tho	
		planicu uiserepa	neres do not arways meru		
conclusions and	follow-up. Specifically,				
503B Outsourcin					
A. (b) (4) media lot (b) (4) used for release sterility testing of					
Sodium Acetate	odium Acetate failed initial growth promotion testing. Your firm invalidated two tests of this lot of				
	nd passed the third test without scientific justification. The initial test was performed on				
(1) (()		ific justification.	-	<i>(</i> ,) <i>(</i> ,)	
(b) (4) retes	sted on (b) (4) and retes	sted (b) (4)	with passing results o	n (b) (4) 🔤	
Your firm's inve	stigation, QE-000487, states				
1100 Date: 1000					
	d testing events. Your firm s		* *		
investigation. Yo	ur firm did not document an	y specific human	error identified when testin	g the FTM	
media. FTM Lot	(b) (4) was used in ste	rility testing of So	dium Acetate lot (b) (4)	
	(b) (4) Your firm released				
	(D) (4) Tour mini released		ulli Acetate foi distribution	i as ionows.	
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	EMPLOYEE(S) SIGNATURE	EMPLOYEE(S) NAME AN	D TITLE (Print or Type)	DATE ISSUED	
	I food a Milling			11/15/2024	
	Salar Wind	Logan Williams, In	vestigator	11, 10, 2024	
SEE REVERSE	SMITTI	Santos Camara, In	vestigator		
OF THIS PAGE	11 -= -				
	mu sol	Megan Ziegler, Inv	estigator		
	MITTA C	Joan Cantellops, C	hemist		
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FORM FDA 483 (09/08)	PREVIOUS EDITION OBSOLETE	INSPECTIONAL OBS	ERVATIONS	PAGE 1 OF 18 PAGES	

DISTRICT OFFICE ADDRESS AND PHONE NUMBER 60 Eighth Street NE Atlanta, GA 30309 (404)253-1161 Fax: (404)253-1202 MME AND TILE OF INDIVIDUAL TO WHOM REPORT IS ISSUED Artuna Koganti, Vice President Clinical and Regulatory Affairs TO MME AND TILE OF INDIVIDUAL TO WHOM REPORT IS ISSUED Artuna Koganti, Vice President Clinical and Regulatory Affairs TO TIME AND TILE OF INDIVIDUAL TO WHOM REPORT IS ISSUED Artuna Koganti, Vice President Clinical and Regulatory Affairs TO TIME AND TILE OF INDIVIDUAL TO WHOM REPORT IS ISSUED Artuna Koganti, Vice OF COUNTRY TYPE ESTABLISHMENT INSPECTED Outsourcing Facility/ Sterile Drug Manufacturing Facility/ Compounded lot of Sodium Acetate Date Released Date(s) shipped BUD 11/30/2024 12/31/20	DEPARTMENT OF HEALTH AND HUMAN SERVICES FOOD AND DRUG ADMINISTRATION						
60 Eighth Street NE THUMBER Atlanta, GA 30309 3008563008 (404)253-1161 Fax:(404)253-1202 3008563008 MME AND TITLE OF NONVOLUL TO WHOM REPORT IS ISSUED Artuna Koganti, Vice President Clinical and Regulatory Affairs TO: TO: PRIM.NAME EXcla Pharma Sciences LLC Excla Pharma Sciences LLC 1245 Blowing Rock Blvd Corr. STATE ZP CODE, COUNTRY TYPE ESTABLISHMENT INSPECTED Compounded lot of Sodium Acetate Date Released Of Sodium Acetate Date Released Of Sodium Acetate Date Released Obj (4) and (b) (4) Obj (4) In addition, the following other test media were inadequately investigated after failing growth promotion results, as documented in investigation QE-000487. (b) (4) ot (b) (4) In addition, the following other test media were inadequately investigated after failing growth promotion results, as documented in investigation QE-000487. No root cause was determined for any of the growth promotion failures. Drag Manufacturer (b) (4) Int (b) (4) These growth promotion media were released once with musting at CAPA. Retesting of the [10] (4) System. Review of your EM Trend Analysis excursions Quality Events (QE) reports of the [10] (4) yes for your EM fight fig	DISTRICT OFFICE ADD				DATE(S) OF INSPECTION	0004	
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	FORM FDA 483 (09/08)	PREVIOUS EDITION OBSOL	ETE INSPECTION	IAL OBSE	ERVATIONS		PAGE 2 OF 18 PAGES
	FORM FDA 483 (09/08)	PREVIOUS EDITION OBSOLI	ETE INSPECTION	IAL OBSE	ERVATIONS		PAGE 2 OF 18 PAGES

	DEPARTMENT OF HEALTH AND HUMAN SERVICES FOOD AND DRUG ADMINISTRATION				
DISTRICT OFFICE ADDRESS AND PHONE NUMBER	DATE(S) OF INSPECTION				
	11/04/2024-11/15/2024				
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Atlanta, GA 30309	3008563008				
(404)253-1161 Fax:(404)253-1202					
NAME AND TITLE OF INDIVIDUAL TO WHOM REPORT IS ISSUED					
Aruna Koganti, Vice President Clinical and Regulatory	Affairs				
TO: FIRM NAME	STREET ADDRESS				
Exela Pharma Sciences LLC	1245 Blowing Rock Blvd				
CITY, STATE, ZIP CODE, COUNTRY	TYPE ESTABLISHMENT INSPECTED				
Lenoir, NC 28645	Outsourcing Facility / Sterile Drug				
0	Manufacturing Facility				

C. Root cause analyses in some of the laboratory investigations Quality Events such as QE-000594 and QE-000622 were found to be deficient. These records lack scientific rationale and supporting evidence to support the root cause established due to the investigational process that was used.

D. During the review of the laboratory investigations in (b) (4) System since July 2024, I observed that 48% out of a total of 89 Quality Events (QE); 43 of the laboratory investigations resulted in invalidated test results due to human error. Failure to establish and maintain adequate laboratory controls do not ensure the accuracy and reliability of test results.

OBSERVATION 2

The responsibilities and procedures applicable to the quality control unit are not fully followed. Specifically,

Drug Manufacturer

Your firm filled Sodium Bicarbonate Injection, USP lot (b) (4) ANDA 211091, in Augusta facility grade A, B, C, and D areas that were tagged as "QA HOLD". This lot was filled in Augusta facility on 11/6/2024. Quality hold was placed on the entrance to the '(b) (4) ' line on (b) (4) The quality hold was placed on the room while waiting for (b) (4) HEPA certification to be completed and reviewed.

	EMPLOYEE(S) SIGNATURE	EMPLOYEE(S) NAME AND TITLE (Print or Type)	DATE ISSUED
	LTW	Logan Williams, Investigator	11/15/2024
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	Danie ,	Megan Ziegler, Investigator	
	Opene	Joan Cantellops, Chemist	

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TO: FIRM NAME		STREET	ADDRESS		
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	gned to prevent microbiolo			porting to be	
sterile are not es	stablished, written, and folle	owed. Specifically	/,		
Drug Manufactu	irer				
A. Your firm	n failed to adequately perform	n Disinfectant Effi	cacy Studies for ()	o) (4) 🛛 🗍	
and	(b) (4) on Sterile	Nitrile Gloves, RI	PT-002136, Version: 1.0 E	Effective Date:	
24 March	2022. No contact time was c				
	ution error was carried over th		-		
due to a	b) (4) og reduction (Log	other than Log	b) (4) _{log reduction was a}		
	eterial concentration.		, () log reduction was a	allinduleu lo a	
IOwer Dac	cterial concentration.				
Drug Manufactu	urer				
	has not demonstrated that	(b) (4)	lisinfectant is adequa	tely used For	
AND THE REPORT OF THE REPORT O	Surface Disinfectant Efficacy				
testing of					
U U	or test surfaces:			o) (4)	
			(b) (4)		
	(b) (4) and	(b) (4)	. The disinfectant		
	or all other surfaces challenge				
	to use at your facility for the	6.0534			
restricting		disinfectant we	re not instructed in your p	rocedures for	
	(b) (4) a	nd (b) (4)	surfaces.		
		2			
Drug Manufacti	urer				
C. Your firm	n failed to detect leaks found	in (b) (4) water syst	em in the (b) (4) Facilit	y. I observed	
the (b) (4) and the ^{(b) (4)} holding tank ((b) (4) leaking with water puddles					
				Panaroo	
	EMPLOYEE(S) SIGNATURE	EMPLOYEE(S) NAME AND	TITLE (Print or Type)	DATE ISSUED	
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		Joan Cantellops, C	hemist		
FORM FDA 483 (09/08)	PREVIOUS EDITION OBSOLETE	INSPECTIONAL OBSE	RVATIONS	PAGE 4 OF 18 PAGES	

DEPARTMENT OF HEALTH AND HUMAN SERVICES FOOD AND DRUG ADMINISTRATION				
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accumula	ted around tank and under th	ne tank. (b) (4) water	tank supplies the compou	nding tank
	tch production of aseptic and		products.	0
U	alasimi Kanan abadasi pusasitsiyasisti dadka Kunduti masing			
503B Outsourci	ng Facility and Drug Manu	facturer		
	n failed to detect visible da		erility (b) (4)	For example,
	sual inspection of the sterilit			
10 NOT	on it. Microbiology Manage	~ \ / \ /		1) is performed
(b) (4) Sterility Test (b) (4) Cleanroom Technology Asset#				
(b) (4)	is used to perform sterilit	v testing of finish		
	an ISO Class 5 environme			
	ally, procedure "SOP-00055			ance Program,
	sion: 4.0, Effective Date: 02			
	nce of the (b)		Exela Asset (b) (4) Do	20
	Date: 20 Sep 2024" do not i			
only requ			(D) (4) min damag	e inspection, it
omy requ				
Drug Manufacti	12.72			
		moto monogeneol mo	uitanina denina acat dara	s
	n failed to demonstrate adeq			U 1
	ufacturing of Ephedrine Sul (b) (4) ine (b) (4) I	100 March 100 Ma		
		Lot $(b) (4)$ Da		ample, in room
		-	ning cleaning of floors, ins	<i>(</i> ,) <i>(</i> ,)
	ity(b) (4) The operator swe			
	served operators' finger, has $(b) (d)$			\
	pling via (b) (4) efore explicitly (A)	(1) (1) (2)		by
()	(((((((((((((((((((o) (4) Operator		on the (b) (4)
	(b) (4)	During pers	onnel monitoring, I notice	d that (D) (4)
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		Joan Cantellops, C	hemist	
FORM FDA 483 (09/08)	PREVIOUS EDITION OBSOLETE	INSPECTIONAL OBSE	RVATIONS	PAGE 5 OF 18 PAGES

DEPARTMENT OF HEALTH AND HUMAN SERVICES FOOD AND DRUG ADMINISTRATION				
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Lenoir, NC 286	45		ourcing Facility / Sterile D	rug
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plate was	not firmly pressed <u>on operat</u> ling the operators (b) (4) fing	tor's head and cont	act time was very brief. D	uring the finger
samp	ling the operators (D) (4) fing	gers but the palm o	of the hand did not seem t	o be efficiently
sampled o	on RODAC plate.			
				19
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		Joan Cantellops, C	hemist	
FORM FDA 483 (09/08)	PREVIOUS EDITION OBSOLETE	INSPECTIONAL OBS	RVATIONS	PAGE 6 OF 18 PAGES

DEPARTMENT OF HEALTH AND HUMAN SERVICES FOOD AND DRUG ADMINISTRATION				
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NAME AND TITLE OF INDIVIDUAL TO WHOM REPORT IS ISSUED				
Aruna Koganti, Vice President Clinical and Regulatory	Affairs			
TO: FIRM NAME	STREET ADDRESS			
Exela Pharma Sciences LLC	1245 Blowing Rock Blvd			
CITY, STATE, ZIP CODE, COUNTRY	TYPE ESTABLISHMENT INSPECTED			
Lenoir, NC 28645	Outsourcing Facility / Sterile Drug			
1	Manufacturing Facility			

OBSERVATION 4

Laboratory records do not include the initials or signature of a second person showing that the original records have been reviewed for accuracy and completeness. Specifically,

503B Outsourcing Facility and Drug Manufacturer

Your firm failed to perform contemporaneous two-person check during reading and data entry of environmental (b) (4) plates in the (b) (4) system. A single operator reads environmental plate counts, takes pictures of positive counts (no pictures are taken of negative counts), enters results in the (b) (4) system and later results are reviewed and verified by QC personnel. There is no assurance that the operator has entered data accurately (missed or misread plates counts) at time of reading. In addition, miscounted plates were observed in the microbiology lab on 11/6/2024. Miscounted colony forming units are as follows:

Plate number	Sample location	Sample	date	Sample type	Number of Colony Forming Units (cfu) on plate	Analyst count
(b) (4)	(b) (4)	10/31/20	24	Active viable air	10cfu	8cfu
-	-	10/31/20	24	Active viable air	11cfu	10cfu
-	-	10/31/20	24	Active viable air	4cfu	3cfu
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FORM FDA 483 (09/08)	PREVIOUS EDITIO	N OBSOLETE	INSP	ECTIONAL OBSERVATIO	I	PAGE 7 OF 18 PAGES

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Appropriate cor	trols are not exercised ove	r computers or re	lated systems to assure t	hat changes		
	ction and control records	CALMPERTING AND APPENDED APPENDED AND APPENDED APPENDE	The second			
		of other records a	re instituted only by auti	Iorizeu		
personnel. Speci	ifically,					
Drug Manufactu	<i>urer (</i> (b) (4)					
A Your firm	failed to generate accurate	and complete reco	rds in a legible original or	a true conv of		
		-		(, , , , , , , , , , , , , , , , , , ,		
electronic	records suitable for inspect	ion and review. Du	iring the implementation o	1 (D) (4)		
System, v	version (b) (4) completed of	on (b) (4) und	ler the following change co	ontrols:		
	hange Control # (b)	(4) and (0)	ler the following change co E-000194- (b) (4) for Pha	(b) (4)		
		(b) (4)		isc		
b. C	R-12459 (b) (4) for Ph	ase				
c. Q.	E-000584 (b) (4) for Phase	(b) (4)				
The affec	ted data transition from (b	(4) system dur	ing Phase and complete	$d_{on}(h)(4)$		
(b) (4).		(+) system, dur	and completed			
(S) (T) it w	as noted that the format used	l to present laborat	ory investigations, deviation	ons, change		
	and other critical quality doc					
	x •			Nature (2014) And And 2014		
informati	on presented is displayed in	metadata format in	a tabular layout, which do	bes not assure		
that the d	ata is readable and complete					
8	1					
	(b) (4)					
B. The imple	ementation of Phase ⁶⁰⁴ was d	eficient is due to fa	ailure to perform complete	back up of the		
	was previously generated un					
	version (b) (4) This deficie					
records. A	A true copy of the original da	ata (which includes	associated metadata) and	should be in		
NY NY 10 10		151				
original format compatible with the original data during the transition from (b) (4) software						
to(b) (4) System on (b) (4)						
	EMPLOYEE(S) SIGNATURE	EMPLOYEE(S) NAME AND	TITLE (Print or Type)	DATE ISSUED		
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INSPECTIONAL OBSERVATIONS

PAGE 8 OF 18 PAGES

FORM FDA 483 (09/08)

PREVIOUS EDITION OBSOLETE

	DEPARTMENT OF HEALTH AND HUMAN SERVICES FOOD AND DRUG ADMINISTRATION				
DISTRICT OFFICE ADDRESS AND PHONE NUMBER	DATE(S) OF INSPECTION				
	11/04/2024-11/15/2024				
60 Eighth Street NE	FEI NUMBER				
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NAME AND TITLE OF INDIVIDUAL TO WHOM REPORT IS ISSUED					
Aruna Koganti, Vice President Clinical and Regulatory	Affairs				
TO: FIRM NAME	STREET ADDRESS				
Exela Pharma Sciences LLC	1245 Blowing Rock Blvd				
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C. Your firm uses a non-validated system (Excel workbooks) to manage the stability samples inventory, these controls should include audit trails to ensure accuracy and integrity of data presented on these workbooks. In addition, the same issue was observed for the storage of drug product defects. It is not acceptable to store electronic records that allows for manipulation without creating a permanent record.

OBSERVATION 6

The calibration of instruments and recording devices is not done at suitable intervals in accordance with an established written program. Specially,

Drug Manufacturer (b) (4)

- A. Calibration certificates for the Analytical balances (Asset ID # QC2209 and Asset ID # QC2493) and Top loading balance (Asset ID#(b) (4) located in the QC Chemistry Laboratory, were found to be deficient. The reproducibility test in the calibration certificates for these balances do not meet the required specifications to ensure suitability of the balances before use. These analytical and top loading balances are used for weighing reference standards and solution preparation for testing of raw materials, in-process, and finished products.
- B. Analytical balance, (Asset ID# QC2209), located in the QC Chemistry Laboratory was observed to have poor maintenance (i.e. appeared to have rust/corrosion, displayed defective side doors that did not open as expected). This analytical balance is used for weighing reference standards and samples used for evaluation and release of manufactured products that use data generated by analytical balance (i.e. raw data weights).
- C. pH meter (Asset ID# (b) (4) located in the R&D Laboratory was not evaluated for the offset requirements as per reference test method. A review of the pH meter calibration logbook ID: (b) (4) from 05 JUN 24 to current showed that in multiple instances the offset results failed to

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	PMC	Megan Ziegler, Investigator	
		Joan Cantellops, Chemist	
FORM FDA 483 (09/08)	PREVIOUS EDITION OBSOL		PAGE 9 OF 18 PAG

	DEPARTMENT OF HEALTH AND HUMAN SERVICES FOOD AND DRUG ADMINISTRATION				
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Maintena Version: calibration	meet acceptance criteria (b) (4) According to SOP-000454: "Use, Calibration, and Maintenance of the (b) (4) Document Version: 4.0, Effective Date: 22 Aug 2024, only the slope criteria was used during the pH meter calibration, while the offset requirement is not considered as part of the calibration requirements to determine the suitability of the instrument before use.				
D. Storage conditions and controls of laboratory reference standards were found to be inadequate. For example, laboratory reference standards located in the dry reagent room and in the laboratory refrigerator Asset ID# QC2456 were not segregated from reagents and test solutions to prevent possible mix-ups and contamination. Additionally, no traceability of the reference standards were used in the analytical test's reports (Bottle ID), only lot number was used. Furthermore, no written procedure is in place for the use of (b) (4) System for the distribution and procurement of standards.					
E. Dry reagent room lacks temperature mapping studies and temperature monitoring system to ensure storage conditions remain unaffected and uniform to avoid possible impact to reference standards stored in the room. Currently, there is no assurance that the room remains uniformly at room temperature conditions. Analytical Chemistry Director stated that there is no temperature mapping studies performed for the reagent room.					
 F. Sample management room used for storage of laboratory raw material, in-process, release, and stability samples for chemical testing. Analytical Chemistry Director stated that the room had been previously mapped but not fully implemented. Temperature monitoring is performed with a (b) (4) and document (b) (4) and (b) (4) 					
accurately	(b) (4) The y detected and documented.	ere 18 no assurance	that temperature excursio	ns are	
	[
	10010	EMPLOYEE(S) NAME AND	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	DATE ISSUED 11/15/2024	
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FORM FDA 483 (09/08)	FORM FDA 483 (09/08) PREVIOUS EDITION OBSOLETE INSPECTIONAL OBSERVATIONS PAGE 10 OF 18 PAGES				

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DISTRICT OFFICE ADDRESS AND PHONE NUMBER	DATE(S) OF INSPECTION
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Exela Pharma Sciences LLC	1245 Blowing Rock Blvd
CITY, STATE, ZIP CODE, COUNTRY	TYPE ESTABLISHMENT INSPECTED
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G. Retain Sample Room SMRY-1599 report for temperature mapping studies and temperature verification monitoring system is inadequately installed. Your system cannot assure that retain samples maintain uniform conditions in the area. Locations of temperature probes have not been properly placed to accurately detect uniformity in the room. Current mapping study could lead to undetected temperature variations that may impact the integrity of samples stored in the room.

OBSERVATION 7

Laboratory records do not include complete records of any testing and standardization of laboratory standard solutions. Specifically,

Drug Manufacturer

Your firm failed to have analytical data to support the stability of Resolution Solution used during the sample analysis of a sterile product identified as: Tranexamic Acid Injection, 10mg/mL, 100 mL IV Bag (i.e. Lot# (b) (4) Released on: 13 AUG 2024. According to laboratory record (Book: (b) (4) the resolution stock solution was prepared in ^{(b) (4)} and it has been used for the evaluation and further release of manufactured batches of this Tranexamic Acid Injection. This resolution solution is a combination of Tranexamic Acid Related (b) (4) and Tranexamic Acid for which the Tranexamic Acid standard solution has been identified as stable for (b) (4) (Document: QCMET-000179). Your firm indicated that as per SOP-QC-000075: "Procurement, Receipt, Storage, and Expiration Dating of Laboratory Chemicals", Document Version 2.0, Effective Date: 09 Feb 2021. As per Table 1 – General Expiration Dating Guidelines the Resolution/Identification/Sensitivity Solutions Expiration Date is Indefinite (with suitable chromatography and chromatographic requirements met), or if it is indicated in analytical test method or compendial procedure. There is no scientific rationale to support that a resolution solution is stable indefinitely, such as a continuous monitoring nor assessment of the

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	pre	Joan Cantellops, Chemist	

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chromatographic behavior of this resolution solution since the initial use on 2021 to support that statement and stability of the resolution solution.

OBSERVATION 8

Established laboratory control mechanisms are not followed and documented at the time of performance. Specifically,

Drug Manufacturer (b) (4)

A. Retain samples for commercial products and raw materials were not stored in their designated locations as required by SOP-000024: "Quality Assurance Retain Management", Document Version: 8.0, Effective Date: 16 May 2024. Samples identified in (b) (4) inventory log as being located on the (b) (4) and (b) (4) shelves were not found. Your Retain Manager was unable to locate it. Additionally, the room was cluttered, with retain samples and raw materials stored in a packed manner, which may have contributed to the difficulty in locating the samples and increased the risk of misplacement or improper storage. For example:

		Product Name		Exela Lot Number	Qty	Storage Location
		idine Isethionate for Injec fill)300mg/vial, 10mL Vi Product)		(h)		(4)
	Strep	tomycin for Injection, US 1g/vial, 10mL vial (Fini	\sim		/	('/
	20m	L Vial, Clear, Type I Gla Material)	ss Tube (Raw			
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FORM FDA	483 (09/08)	PREVIOUS EDITION OBSOLI	ETE INSPECTIONAL O	BSERVATIONS		PAGE 12 OF 18 PAGES

DEPARTMENT OF HEALTH ANI FOOD AND DRUG ADMIN	
DISTRICT OFFICE ADDRESS AND PHONE NUMBER	DATE(S) OF INSPECTION
	11/04/2024-11/15/2024
60 Eighth Street NE	FEINUMBER
Atlanta, GA 30309	3008563008
(404)253-1161 Fax:(404)253-1202	
NAME AND TITLE OF INDIVIDUAL TO WHOM REPORT IS ISSUED	
Aruna Koganti, Vice President Clinical and Regulatory	Affairs
TO: FIRM NAME	STREET ADDRESS
Exela Pharma Sciences LLC	1245 Blowing Rock Blvd
CITY, STATE, ZIP CODE, COUNTRY	TYPE ESTABLISHMENT INSPECTED
Lenoir, NC 28645	Outsourcing Facility / Sterile Drug
	Manufacturing Facility

B. Your firm failed to have GMP equipment segregated from Research and Development (R&D). For example, during the review of analytical data of Tranexamic Acid Injection, 10mg/mL, 100 mL IV Bag (i.e. Lot# (b) (4) Released on (b) (4) and Sodium Bicarbonate Injection, USP, 84 mg/mL, (1 mEq/mL), 50 mL Vial (i.e. Lot# (b) (4), Released on: (b) (4) I observed analyst used pH meter (Asset ID# RD9058) located in the R&D laboratory. Instrument is used for the evaluation and lot release of manufactured drug product batches. The inductively coupled plasma optical emission spectroscopy (ICP-OES, Asset ID# QC2514) is used for R&D but is located in the QC Raw Material Laboratory. It was not identified as R&D equipment.

C. (b) (4) Stability Chamber (Asset ID# QC2489) located in the Clinical Lab Room is not limited to authorized personnel only. Uncontrolled room allows access to Corporate, QA-India, API, Facilities, Utilities, Validation, and other personnel. Stability chamber (Asset ID# QC2489) was found unlocked, allowing easy access to drug manufacture stability sample products stored in chamber. Additionally, (b) (4) Stability Room (Chamber) located in the ground floor of Stability Room was also found to be accessible to unauthorized personnel from Facilities, Corporate and other departments to access the stability samples located in room.

OBSERVATION 9There is no written testing program designed to assess the stability characteristics of drug products. Specifically,

503B Outsourcing Facility

Your firm does not have stability data to support a 6-month expiration date for Sodium Chloride Injection 0.9% Injection, USP packaged in 500mL polypropylene IV bags. Your firm produced (b) (4) (b) (4) batches of Sodium Chloride in (b) (4) IV bags in (b) (4) and placed them on stability for potential

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	LTW	Logan Williams, Investigator	11/15/2024
SEE REVERSE OF THIS PAGE	mT2	Santos Camara, Investigator	
	21	Megan Ziegler, Investigator	
	PAC.	Joan Cantellops, Chemist	

DEPARTMENT OF HEALTH AND FOOD AND DRUG ADMIN	
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503B compounding. This study was performed using (b) (4) bag size with a fill volume of (b) (4) This study data was produced using different equipment, compounding/filling rooms, and packaging configurations than the current Sodium Chloride Injection 0.9%, USP being compounded at your firm. The current Sodium Chloride Injection 0.9% USP batches are packaged in 500mL polypropylene IV bags with a 500mL fill volume and a batch size of (b) (4) Your firm used the data from the 2017 study to justify a 6-month expiration on the current Sodium Chloride Injection 0.9% USP being compounded. In addition, your firm has not performed any sterility testing on Sodium Chloride IV bags currently being compounded.

OBSERVATION 10

Employees engaged in the manufacture and processing of a drug product lack the training required to perform their assigned functions. Specifically,

503B Outsourcing Facility (b) (4)

- A. Your firm's visual inspection qualification^{(b) (4)} s inadequate.
 - i. Your firm's visual inspection kit used during qualification is not representative of the visual inspection process. Your firm's visual inspection ^{(b) (4)} s comprised of ^{(b) (4)}/vials of a variety of vials sizes ranging from (b) (4) These vials also contain a variety of products depending on the vial size. During visual inspection of a production batch the visual inspection process is performed on (b) (4) and (b) (4)
 - ii. Your firm's qualification ^{(b) (4)} does not contain all defects found in production lots. For example, your firm's defect classifications are missing from the following vial qualification ^{(b) (4)} The clear vial inspection ^{(b) (4)} does not include critical defects; gross high fill and gross low fill. The clear vial inspection kit does not include major defect: empty unit. The clear vial inspection ^{(b) (4)} does not include minor defects: check/chip in container and air lines in container. Your firm's IV bag qualification ^{(b) (4)} does not include critical

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		Santos Camara, Investigator	
	THC	Megan Ziegler, Investigator	
	OME	Joan Cantellops, Chemist	
FORM FDA 483 (09/08)	PREVIOUS EDITION OBSOL		PAGE 14 OF 18

DEPARTMENT OF HEALTH AND HUMAN SERVICES FOOD AND DRUG ADMINISTRATION				
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FIRM NAME Exela Pharma S	ciences LLC	1244	5 Blowing Rock Blvd	
CITY, STATE, ZIP CODE		TYPE	ESTABLISHMENT INSPECTED	
Lenoir, NC 286	45	Outs	sourcing Facility / Sterile D	rug
		Man	ufacturing Facility	
 Invaluacuing Facility defects: gross high fill, gross low fill, and discolored solution. Your firm's IV bag qualification kit does not include major defect: damaged hanger eyelet. B. Your firm's visual inspection qualification process is inadequate. Your firm pulls challenge defect vials to be used for qualification from a pool of defects (b) (4) with no process to assure that visual inspectors are qualified on an appropriate range of defects found in products. During review of your firm's visual inspection qualification documents for visual inspectors, your firm did not qualify each visual inspector for all defects found in production including fill volume, discolored solution, glass particulate matter, missing crimp, white particulate matter, and black fiber. ii. The visual inspection speed was not appropriately qualified for speed. Your firm's procedure requires an inspection (b) (4) per vial. During qualification one inspector finished inspecting vials in an average of (b) (4) er vial, which is faster than the inspection procedure requires. In addition, during inspection of production vials/IV bags your firm does not document the total number of vials/IV bags inspected by each inspector to confirm that time spent inspecting vials is within the qualified speed. 				
			10 1 I II	1.0
1512	n's library of defects is not in	ndexed and 1s not	verified to have all represe	ntative defects
from proc	luction.			
OBSERVATIO	N 11			
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		Joan Cantellops,	Chemist	
FORM FDA 483 (09/08)	PREVIOUS EDITION OBSOLETE	INSPECTIONAL OB	SERVATIONS	PAGE 15 OF 18 PAGES

DEPARTMENT OF HEALTH AND HUMAN SERVICES FOOD AND DRUG ADMINISTRATION				
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Aruna Koganti, Vice President Clinical and Regulatory	Affairs			
TO: FIRM NAME	STREET ADDRESS			
Exela Pharma Sciences LLC	1245 Blowing Rock Blvd			
CITY, STATE, ZIP CODE, COUNTRY	TYPE ESTABLISHMENT INSPECTED			
Lenoir, NC 28645	Outsourcing Facility / Sterile Drug			
	Manufacturing Facility			

The statistical quality control criteria fail to include appropriate rejection levels. Specifically,

<u>503B Outsourcing Facility</u> Your firm has a (b) (4) overall reject limits for visual inspection, individual defect categories do not have reject limits. Your firm does not open investigations unless an overall^{(b) (4)}visual inspection reject rate is reached. Your firm rejected 69 cracked vials, which are considered a critical defect, from lot (b) (4) of Sodium Acetate Injection, 100mL vials without opening any investigation. Your firm also rejected 79 cracked vials from lot (b) (4) of Sodium Acetate Injection, 100mL vials without opening any investigation.

OBSERVATION 12

Separate or defined areas to prevent contamination or mix-ups are deficient regarding operations related to the holding of rejected components, drug product containers and closures before disposition. Specifically,

Drug Manufacturer

Your firm failed to properly handle reject drug products. For the example, during the inspectional walkthrough of your Reject Room (Reject Cage), I found you did not have a logbook or a physical inventory in place of materials stored in the cage. Your Quality Assurance Manager, stated material (b) (4) stored in cage is verified However, it is not documented nor there is written (b) (4) instructions for in your procedure "Handling of Rejects, SOP-000035 Doc Version: 4.0 Effective Date: 01 Aug 2024". Additionally, In-process rejects or finished rejects cannot be physically identified due to incorrect labels affixed on rejects. Your SOP lacks a defined list of reject materials that can be stored in the area. For example, Media Fill rejected samples were found in the area but not included as one that should be in that area. Furthermore, among the

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FORM FDA 483 (09/08)	PREVIOUS EDITION OBSOL	ETE INSPECTIONAL OBSERVATIONS	PAGE 16 OF 18 PAGES

DEPARTMENT OF HEALTH AND HUMAN SERVICES FOOD AND DRUG ADMINISTRATION				
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Aruna Koganti, Vice President Clinical and Regulatory Affairs				
TO:	STREET ADDRESS			
FIRM NAME				
Exela Pharma Sciences LLC	1245 Blowing Rock Blvd			
CITY, STATE, ZIP CODE, COUNTRY	TYPE ESTABLISHMENT INSPECTED			
Lenoir, NC 28645	Outsourcing Facility / Sterile Drug			
	Manufacturing Facility			

rejected In-process drug products, there was a red reject rectangular box labeled Sodium Chloride 0.9%, 500 mL IV Bag, (b) (4) Batch, Line Augusta, 503B, Catalog # (b) (4) Lot# (b) (4) ocated on the second shelf of the cage that was directly dripping (leaking) on a pallet with a Finished Product Inventory Log sheet FRM-000156, Doc Version: 4.0, Effective Date: 29 Jul 2024, Controlled Copy ID# CC-FRM-000156-(b) (4) placed on top of the pallet

OBSERVATION 13

Separate or defined areas to prevent contamination or mix-ups are deficient regarding operations related to the receipt, identification, storage, and withholding from use of components, drug product containers, and closures pending sampling, testing, or examination by the quality control unit before release for manufacturing or packaging. Specifically,

Drug Manufacturer

Your firm failed to record storage conditions during the receipt of Active Pharmaceutical Ingredients (APIs). There is no assurance that drug substance has been kept under the right temperature conditions before and after receipt. During review of the Raw Material Disposition Report (FRM-000046 Doc Version: 12.0, Effective Date: 28 Dec 2023, Controlled Copy ID# CC-FRM-000046-(b)(4) I found storage conditions are not indicated as required in the report. Warehouse operator stated that raw material is not received with a data logger and no time entry is recorded upon receipt of drug substance (only date). Manufacturer's label on raw material indicates raw material API should be kept refrigerated at (b)(4)

OBSERVATION 14

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	LTW	Logan Williams, Investigator	11/15/2024
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DEPARTMENT OF HEALTH AND HUMAN SERVICES FOOD AND DRUG ADMINISTRATION				
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FIRM NAME Exela Pharma S	Sciences LLC	1245 Blowing Rock Blvd		
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Lenoir, NC 286	645	Outsourcing Facility	U	
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The labels of vo	ur outsourcing facility's dr	ug products are deficient		
The labels of yo	ur outsoureing facility s ur	ug products are deficient.		
503B Outsourci	ng Facility			
		's drug products do not include in	formation required by	
		the following information is not for		
product la	abels:	5 LD65 155895		
a. T	he dosage form			
		pels that do not contain this inform	nation, include but are not	
limite	a to:			
	• Midazolam HCl in 0.8	% Sodium Chloride 50mI		
 Midazolam HCl in 0.8% Sodium Chloride 50mL Midazolam HCl in 0.8% Sodium Chloride 100mL 				
OBSERVATIO				
		ocedures are not followed in the	execution of	
production and	process control functions.	Specifically,		
Vour firm's pros	(h) (4) and (b) (4)		
-	cess validation for (D) (USP were performed using	$\begin{array}{c} \text{(b) (4)} \\ \text{(b) (4)} \\ \end{array} \qquad \begin{array}{c} \text{(b) (4)} \\ \text{and not using p} \end{array}$	Sodium Chloride roduct. There is no data	
	e sterilization process is effect		erformed on compounded	
drug products.	stormzation process is errec		errormed on compounded	
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(Tues), 11/13/2024 (Wed), 11/14/2024 (Thu), 11/15/2024 (Fri)				
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FORM FDA 483 (09/08)	PREVIOUS EDITION OBSOLETE	INSPECTIONAL OBSERVATIONS	PAGE 18 OF 18 PAGES	

The observations of objectionable conditions and practices listed on the front of this form are reported:

- 1. Pursuant to Section 704(b) of the Federal Food, Drug and Cosmetic Act, or
- 2. To assist firms inspected in complying with the Acts and regulations enforced by the Food and Drug Administration.

Section 704(b) of the Federal Food, Drug, and Cosmetic Act (21 USC 374(b)) provides:

"Upon completion of any such inspection of a factory, warehouse, consulting laboratory, or other establishment, and prior to leaving the premises, the officer or employee making the inspection shall give to the owner, operator, or agent in charge a report in writing setting forth any conditions or practices observed by him which, in his judgment, indicate that any food, drug, device, or cosmetic in such establishment (1) consists in whole or in part of any filthy, putrid, or decomposed substance, or (2) has been prepared, packed, or held under insanitary conditions whereby it may have become contaminated with filth, or whereby it may have been rendered injurious to health. A copy of such report shall be sent promptly to the Secretary."