MEDISCA® NETWORK INC.
TECHNICAL SUPPORT SERVICES
FORMULATION CHEMISTRY DEPARTMENT
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Suggested Formula	Aminophylline 25 mg/mL Intramuscular Injection (Solution, 100 mL)	FIN	F 000 740V2

SUGGESTED FORMULATION

Ingredient Listing	Qty.	Unit	NDC #	Supplier	Lot Number	Expiry Date
Aminophylline, USP	2.500	g				
Sterile Water For Injection, USP	90.0	mL				
Sterile Water For Injection, USP	q.s. to 100.0	mL				
Ethylenediamine 10% Solution †	As required					
† Ethylenediamine 10% Solution						
Ethylenediamine, USP	5.0	mL				
Sterile Water For Injection, USP	45.0	mL				

SPECIAL PREPARATORY CONSIDERATIONS

Ingredient-Specific Information

Light sensitive *(protect from light whenever possible):* *Aminophylline*

Suggested Preparatory Guidelines

☐ Non-Sterile Preparation ■ Sterile Preparation

Processing Error / Testing Considerations: To account for processing error, pH testing, sterility and endotoxin testing considerations during preparation, it is suggested to measure an additional **5 to 9%** of the required quantities of ingredients.

Special Instruction: This formula must be prepared within the appropriate facilities under adequate environmental conditions, following the necessary guidelines and procedures as stated within *USP 797*. Only trained and qualified personnel must prepare this formula.

All heat stable, reusable materials and equipment must be sterilized and depyrogenated by dry heat sterilization at 250°C for 2 hours prior to use.

Every batch of final product compounded using this procedure must be sterility and endotoxin tested before being dispensed.

Protective apparel, such as a sterile gown, sterile gloves, shoe covers, head cap, eyewear and face-masks should always be worn. In addition, proper personnel cleansing must be done before entering the buffer or clean area.

Filter integrity must be validated by performing a filter stress test. If the test demonstrates that the filter might be defective, the solution must be discarded and remade.

This procedure requires the use of very small quantities of ingredients. All calculations and preparation techniques must be verified before dispensing the final product.

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SUGGESTED PREPARATION (for 100 mL)

Weigh and / or measure the following ingredients when appropriate:

Ingredient Listing	Qty.	Unit	Multiplication factor (*): ____	Processing Error	Qty. to measure
Aminophylline, USP §	2.500	g			
Sterile Water For Injection, USP §	90.0	mL			
Sterile Water For Injection, USP §	q.s. to 100.0	mL			
Ethylenediamine 10% Solution § †	As required				
† Ethylenediamine 10% Solution					
Ethylenediamine, USP §	5.0	mL	---	---	
Sterile Water For Injection, USP §	45.0	mL	---	---	

* Takes into account increased batch size conversions and density conversions, if required.
§ Weigh / measure just prior to use.

Preparatory Instruction **IMPORTANT: All preparatory procedures must be performed using proper Aseptic Technique**	
1.	**Equipment sterilization:** Following the manufacturer's specifications, sterilize and depyrogenate all heat stable, reusable materials and equipment, then return to ambient temperature.
2.	**Ethylenediamine 10% Solution preparation:** A. Combine and mix the following ingredients together until homogeneously dispersed: - Ethylenediamine (5.0 mL) - Sterile Water For Injection (45.0 mL) End result: Homogeneous liquid-like solution.
3.	**Powder to liquid integration:** A. Incrementally add the following ingredient to the Sterile Water For Injection (90.0 mL plus processing error adjustments): - Aminophylline Specifications: Continuously mix until all solid particles have completely dissolved. End result: Homogeneous liquid-like solution.

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4. **pH testing:**

A. Draw an appropriate amount of the mixture (Step 3A).

B. Test the pH of the sample. It should lie between 8.6 and 9.0.

C. If the pH < 8.6, carefully add in a dropwise manner the Ethylenediamine 10% Solution to the mixture:

1. Draw and transfer 1 or 2 drops of the Ethylenediamine 10% Solution to the mixture.
2. Stir for at least 5 minutes to evenly disperse the Ethylenediamine 10% Solution.
3. Re-test the pH.
4. Continue to add the Ethylenediamine 10% Solution until the pH of 8.6 to 9.0 is obtained.

IMPORTANT: Do not allow the pH to rise above 9.0.

5. **Filling to volume:**

A. Add additional Sterile Water For Injection to the above mixture to fill to the required batch size (100.0 mL *plus* processing error adjustments).

Specifications: Continuously mix.

End result: Homogeneous liquid-like solution.

6. **Filtering and transferring:**

A. Aseptically filter the solution through a 0.22-µm sterile filter into the recommended dispensing container (see Packaging requirements). Transfer the remainder into a separate dispensing container. This is to be used as the Test sample for sterility and endotoxin testing.

B. Flush the remaining airspace of the vial with Nitrogen gas before sealing. This will reduce exposure to air, thus preventing turbidity and crystal formation.

7. **Filter integrity test:**

Validate filter integrity by performing a filter stress test. If the test demonstrates that the filter might be defective, the solution must be discarded and remade.

8. **Sterility testing:**

Validate the Test sample for sterility and endotoxins, in accordance to current USP 797 regulatory guidelines.

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SUGGESTED PRESENTATION

Estimated Beyond-Use Date		14 days BUD based on a successful sterility and endotoxin test result.	Packaging Requirements	Sterile, light-resistant, unit dose injection vials.	
Auxiliary Labels	1	Use as directed. Do not exceed prescribed dose.	5	Protect from light.	
	2	Keep out of reach of children.	6	Discard container after use.	
	3	Discard in the presence of particulate matter.	7	Keep at room temperature (20 – 23°C).	
	4	Do not use if discolored.	8	**Consult your health care practitioner if any prescription or over-the-counter medications are currently being used or are prescribed for future use.**	
Pharmacist Instructions	Add any auxiliary labels specific to the API to the dispensing container as deemed necessary.				
Patient Instructions	Contact your pharmacist in the event of adverse reactions.				

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REFERENCES

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3. Aminophylline (Monograph). In: O'Neil MJ. *The Merck Index 13th Edition*. Whitehouse Station, NJ: Merck & Co, Inc.; 2001: 81.
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5. Aminophylline (Monograph). US Pharmacopeial Convention, Inc. *United States Pharmacopeia XXV / National Formulary 20.* Rockville, MD: US Pharmacopeial Convention, Inc; 2001: 15.
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