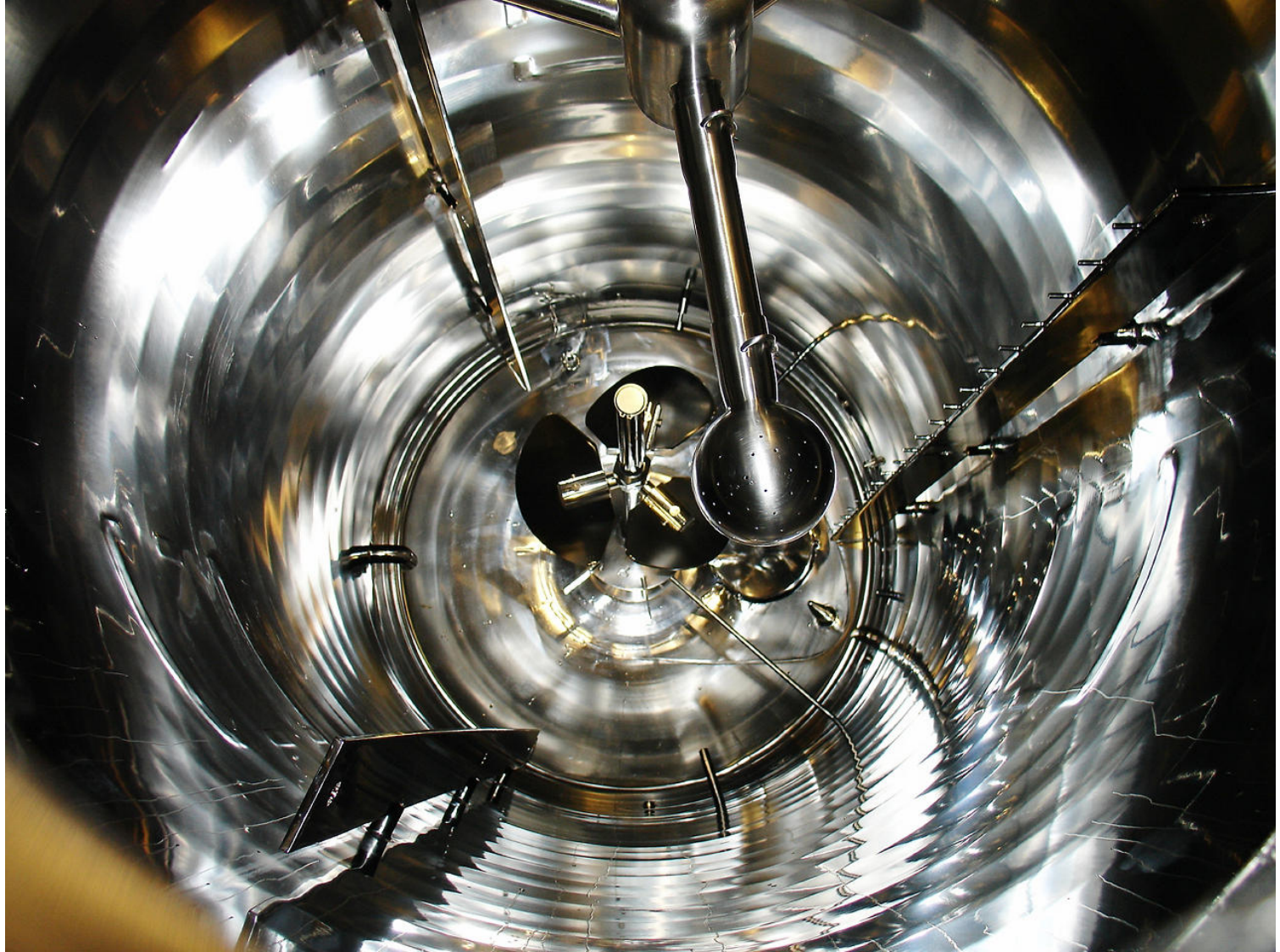




Application Note AN-NIR-099

# Quality Control of fermentation broths

## Multiparameter determination within one minute

Cell fermentation processes are a reliable production method for small molecules and protein-based active pharmaceutical ingredients (APIs), allowing pharmaceutical companies to optimize the production process and reduce time to market. The fermentation process requires monitoring of many different parameters to ensure optimal production. These quality parameters include (but are not limited to) pH, bacterial content, potency, glucose, and concentration of reducing sugars. Traditional

laboratory analysis takes a significant amount of time and requires different analytical techniques to monitor these quality parameters in the fermentation process.

Near-infrared spectroscopy (NIRS) offers a faster and more cost-efficient alternative to traditional methods for the determination of critical parameters in fermentation broths at any stage of the fermentation process.

## EXPERIMENTAL EQUIPMENT

Fermentation broth samples taken at different fermentation times were measured in reflection mode with the Metrohm DS2500 Solid Analyzer. Because the samples were dark in color (yellow-brown), they were measured without needing to use the gold reflector and required no sample preparation. The Metrohm software package Vision Air Complete was used for all data acquisition and prediction model development.

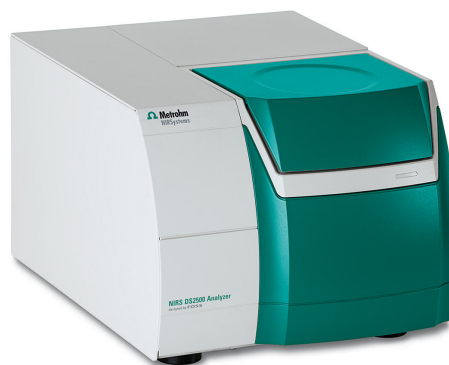


**Figure 1.** DS2500 Solid Analyzer.

**Table 1.** Hardware and software equipment overview

| Equipment                              | Metrohm number |
|----------------------------------------|----------------|
| DS2500 Solid Analyzer                  | 2.922.0010     |
| NIRS transflection vessel              | 6.7401.000     |
| NIRS Mini Sample Cup Holder for DS2500 | 6.7430.040     |
| Vision Air 2.0 Complete                | 6.6072.208     |

## RESULT

The obtained Vis-NIR spectra (**Figure 2**) were used to create prediction models for quantification of the bacterial, glucose, and reducing sugars concentration, as well as the pH and potency. The quality of the prediction models was evaluated using the correlation diagram, which displays a high correlation

between the Vis-NIR prediction and the reference values. The respective figures of merit (FOM) display the expected precision of a prediction during routine analysis. Potency (**Figures 7 and 8**) was measured with two different laboratory methods as described in **Table 8**.

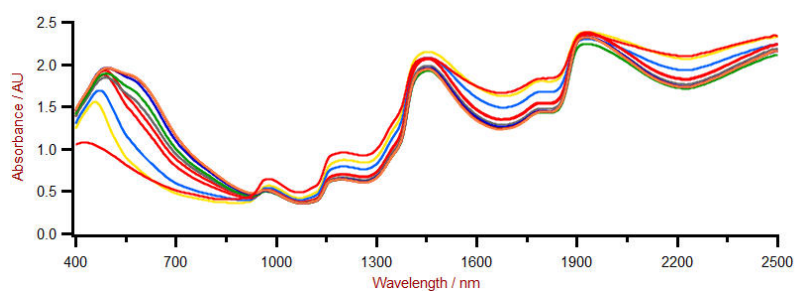


**Figure 2.** Vis-NIR spectra of fermentation broth samples taken at different fermentation times and analyzed on a DS2500 Solid Analyzer.

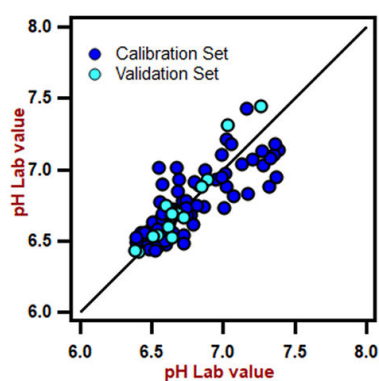


**Figure 3.** Correlation diagram for the prediction of pH in fermentation broth using a DS2500 Solid Analyzer. The lab value was evaluated using a pH meter.

**Table 2.** Figures of merit for the prediction of pH in fermentation broth using a DS2500 Solid Analyzer.

| Figures of merit                   | Value  |
|------------------------------------|--------|
| $R^2$                              | 0.6461 |
| Standard error of calibration      | 0.1645 |
| Standard error of cross-validation | 0.1686 |
| Standard error of validation       | 0.0997 |

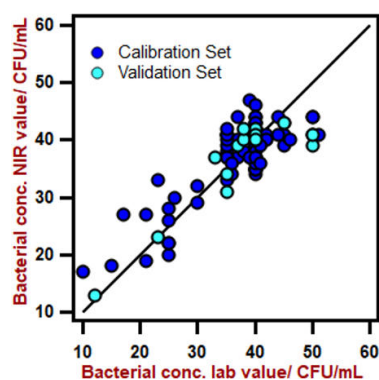


**Figure 4.** Correlation diagram for the prediction of bacterial concentration in fermentation broth using a DS2500 Solid Analyzer. The lab value was evaluated using UV-Vis spectrophotometry.

**Table 3.** Figures of merit for the prediction of bacterial concentration in fermentation broth using a DS2500 Solid Analyzer.

| Figures of merit                   | Value         |
|------------------------------------|---------------|
| $R^2$                              | 0.7086        |
| Standard error of calibration      | 4.6884 CFU/mL |
| Standard error of cross-validation | 4.7429 CFU/mL |
| Standard error of validation       | 5.0916 CFU/mL |

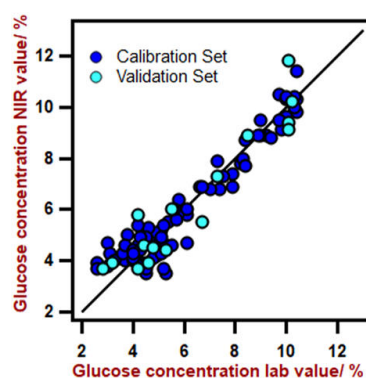


**Figure 5.** Correlation diagram for the prediction of glucose concentration in fermentation broth using a DS2500 Solid Analyzer. The lab value was evaluated using HPLC.

**Table 4.** Figures of merit for the prediction of glucose content in fermentatoin broth using a DS2500 Solid Analyzer.

| Figures of merit                   | Value   |
|------------------------------------|---------|
| $R^2$                              | 0.9165  |
| Standard error of calibration      | 0.6938% |
| Standard error of cross-validation | 0.7896% |
| Standard error of validation       | 0.8628% |

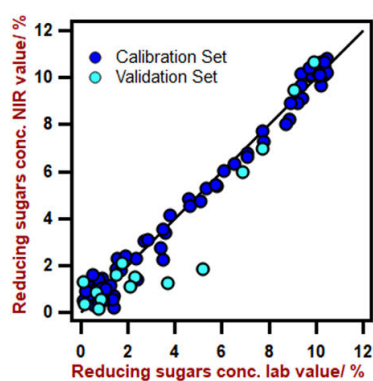


**Figure 6.** Correlation diagram for the prediction of reducing sugars in fermentation broth using a DS2500 Solid Analyzer. The lab value was evaluated using HPLC.

**Table 5.** Figures of merit for the prediction of sugars content in fermentation broth using a DS2500 Solid Analyzer.

| Figures of merit                   | Value   |
|------------------------------------|---------|
| $R^2$                              | 0.9863  |
| Standard error of calibration      | 0.4767% |
| Standard error of cross-validation | 0.6821% |
| Standard error of validation       | 1.2429% |

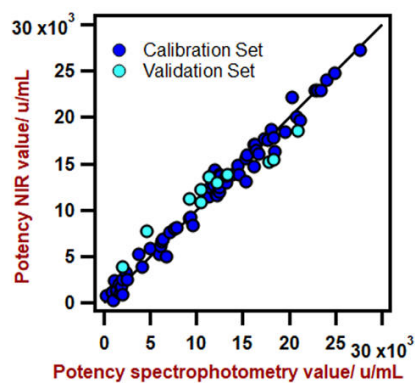


**Figure 7.** Correlation diagram for the prediction of potency in fermentation broth using a DS2500 Solid Analyzer. The lab value was evaluated using UV-Vis spectrophotometry.

**Table 6.** Figures of merit for the prediction of potency in fermentation broth using a DS2500 Solid Analyzer.

| Figures of merit                   | Value     |
|------------------------------------|-----------|
| $R^2$                              | 0.9083    |
| Standard error of calibration      | 2295 u/mL |
| Standard error of cross-validation | 2968 u/mL |
| Standard error of validation       | 2089 u/mL |

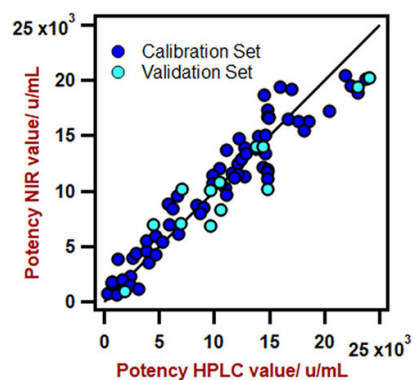


**Figure 8.** Correlation diagram for the prediction of potency in fermentation broth using a DS2500 Solid Analyzer. The lab value was evaluated using HPLC + PCR.

**Table 7.** Figures of merit for the prediction of potency in fermentation broth using a DS2500 Solid Analyzer.

| Figures of merit                   | Value     |
|------------------------------------|-----------|
| $R^2$                              | 0.9156    |
| Standard error of calibration      | 1913 u/mL |
| Standard error of cross-validation | 2172 u/mL |
| Standard error of validation       | 1168 u/mL |

## CONCLUSION

This application note demonstrates the feasibility to determine key parameters of the quality control of the fermentation process with NIR spectroscopy. The main advantages of Vis-NIR spectroscopy over wet

chemical methods are that running costs are significantly lower and time-to-result is significantly reduced. Additionally, no chemicals are required, and the technique is non-destructive to the samples.

**Table 8.** Time to result overview for the different quality parameters

| Parameter                                 | Method     | Time to result                                        |
|-------------------------------------------|------------|-------------------------------------------------------|
| pH                                        | pH Meter   | 3–5 minutes                                           |
| Bacterial concentration                   | UV-Vis     | 8 hours (sample preparation) + 1 minute (UV-Vis)      |
| Glucose and reducing sugars concentration | HPLC       | 30–45 minutes                                         |
| Potency                                   | UV-Vis     | 7minutes (sample preparation) + 1 minute (UV-Vis)     |
| Potency                                   | HPLC + PCR | 1 hour (sample preparation) + 20 minutes (HPLC + PCR) |

Internal reference: AW NIR CN-0017-112021

## CONTACT

Metrohm Suisse SA  
Industriestrasse 13  
4800 Zofingen

[info@metrohm.ch](mailto:info@metrohm.ch)



### DS2500 Solid Analyzer

**Spectroscopie proche infrarouge robuste pour le contrôle de la qualité en laboratoire et en environnement de production.**

L'analyseur DS2500 Analyzer est la solution éprouvée et souple destinée aux analyses de routine de matières solides, de crèmes et, en option, de liquides, tout au long de la chaîne de fabrication. Sa conception robuste fait du DS2500 Analyzer un appareil insensible à la poussière, à l'humidité, aux vibrations ainsi qu'aux variations de température, et donc particulièrement adapté aux rudes conditions d'un environnement de production.

Le DS2500 couvre l'ensemble de la gamme spectrale de 400 à 2 500 nm et fournit des résultats exacts et reproductibles en moins d'une minute. Le DS2500 Analyzer répond aux exigences de l'industrie pharmaceutique et représente une aide précieuse pour les opérations de routine quotidiennes grâce à sa simplicité d'utilisation.

Grâce à des accessoires parfaitement adaptés à l'appareil, il atteint des performances sans précédent avec tous les types d'échantillons, quel que soit le défi qu'ils opposent (matières solides à gros grains comme les granulats ou échantillons semi-solides ou liquides telles les crèmes). La productivité lors de mesures de matières solides peut encore être augmentée par l'utilisation du MultiSample Cup, lequel permet des mesures automatisées en série jusqu'à un maximum de 9 échantillons.



**Réceptier pour transflexion NIRS, optiquement plan**  
Réceptier pour transflexion optiquement plan pour la mesure spectrale des liquides. Peut se combiner avec les appareils suivants :

- NIRS DS2500 Analyzer (numéro de commande : **2.922.0010**)
- NIRS XDS MasterLab Analyzer (numéro de commande : **2.921.1310**)
- NIRS XDS MultiVial Analyzer (numéro de commande : **2.921.1120**)
- NIRS XDS RapidContent Analyzer (numéro de commande : **2.921.1110**)
- NIRS XDS RapidContent Analyzer – Solids (numéro de commande : **2.921.1210**)



#### **Support DS2500**

Support pour l'utilisation avec :

- des petits réceptiers d'échantillons (**6.7402.030**)
- DS2500 Iris (**6.7425.100**)



## Vision Air 2.0 Complete

Vision Air - logiciel universel de spectroscopie.

Vision Air Complete est une solution logicielle moderne et simple d'utilisation pour une application dans un environnement réglementé.

Aperçu des avantages de Vision Air :

- Des applications logicielles individuelles avec interface utilisateur adaptée sont le garant d'un maniement intuitif et simple
- Établissement et suivi simples des procédures de travail
- Base de données SQL pour une gestion sûre et simple des données

La version Vision Air Complete (66072208) comprend toutes les applications d'assurance qualité par spectroscopie Vis-NIR :

- Application de gestion des instruments et des données
- Application de développement de méthodes
- Application d'analyse de routine

Autres solutions Vision Air Complete :

- 66072207 (Vision Air Network Complete)
- 66072209 (Vision Air Pharma Complete)
- 66072210 (Vision Air Pharma Network Complete)