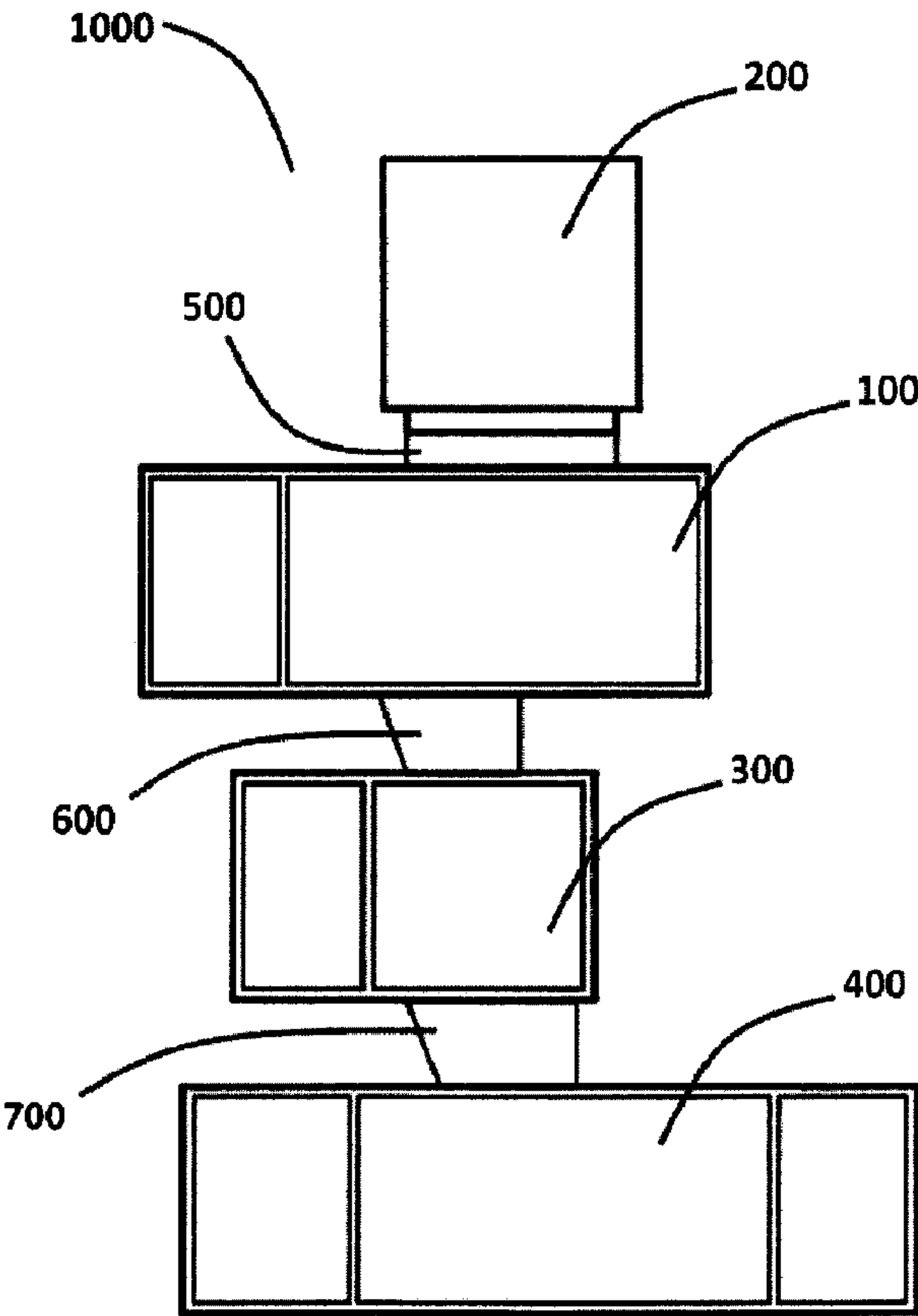




(86) Date de dépôt PCT/PCT Filing Date: 2017/04/12 (87) Date publication PCT/PCT Publication Date: 2017/10/19 (45) Date de délivrance/Issue Date: 2019/08/20 (85) Entrée phase nationale/National Entry: 2018/10/12 (86) N° demande PCT/PCT Application No.: IB 2017/000576 (87) N° publication PCT/PCT Publication No.: 2017/178895 (30) Priorité/Priority: 2016/04/12 (US15/097,254)	(51) Cl.Int./Int.Cl. <i>B65B 43/42</i> (2006.01), <i>A61J 1/00</i> (2006.01), <i>A61J 3/00</i> (2006.01), <i>A61J 3/02</i> (2006.01), <i>B25J 9/02</i> (2006.01), <i>B25J 9/12</i> (2006.01), <i>B65B 1/04</i> (2006.01) (72) Inventeurs/Inventors: NAING, JUVENAL, CA; PROCYSHYN, CHRISTOPHER, CA; SENGER, JOHN, CA (73) Propriétaire/Owner: VANRX PHARMASYSTEMS INC., CA (74) Agent: AVENTUM IP LAW LLP
--	---

(54) **Titre :** PROCEDE ET APPAREIL POUR CHARGER UN SYSTEME DE LYOPHILISATION
(54) **Title:** METHOD AND APPARATUS FOR LOADING A LYOPHILIZATION SYSTEM



(57) **Abrégé/Abstract:**
Disclosed are systems and methods for aseptically filling pharmaceutical containers with a pharmaceutical substance and then lyophilizing it. In one general aspect, the system and method can employ a lyophilizer loader subsystem having an interior chamber

(57) Abrégé(suite)/Abstract(continued):

in communication with an interior chamber of a lyophilizer subsystem via a portal with a sealable door, with the collective interior being aseptically sealable. An articulated robotic arm can be employed to batch transfer to the lyophilizer subsystem container nests bearing the pharmaceutical containers. In one embodiment, the nests may be transferred serially to the loader subsystem, with the articulated robotic arm being configured to transfer the nests of containers in batches to the lyophilizer subsystem. The articulated robotic arm can also be configured to be used to move batches of nests within the lyophilizer subsystem. One implementation includes two articulated arms and a joint rotary wrist driven by two rotary shoulders.

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property
Organization
International Bureau



WIPO | PCT



(10) International Publication Number

WO 2017/178895 A1

(43) International Publication Date
19 October 2017 (19.10.2017)

(51) International Patent Classification:

B65B 43/42 (2006.01) *B25J 9/02* (2006.01)
A61J 1/00 (2006.01) *B25J 9/12* (2006.01)
A61J 3/00 (2006.01) *B65B 1/04* (2006.01)
A61J 3/02 (2006.01)

(21) International Application Number:

PCT/IB2017/000576

(22) International Filing Date:

12 April 2017 (12.04.2017)

(25) Filing Language:

English

(26) Publication Language:

English

(30) Priority Data:

15/097,254 12 April 2016 (12.04.2016) US

(71) Applicant: VANRX PHARMASYSTEMS INC.

[CA/CA]; 3811 North Fraser Way #200, Burnaby, BC V5J 5J2 (CA).

(72) Inventors: SENGER, John; C/o Vanrx Pharmsystems

Inc., 3811 North Fraser Way #200, Burnaby, BC V5J 5J2

(CA). PROCYSHYN, Christopher; C/o Vanrx Pharmsystems Inc., 3811 North Fraser Way #200, Burnaby, BC V5J 5J2 (CA). NAING, Juvenal; C/o Vanrx Pharmsystems Inc., 3811 North Fraser Way #200, Burnaby, BC V5J 5J2 (CA).

(81) Designated States (unless otherwise indicated, for every

kind of national protection available): AE, AG, AL, AM, AO, AT, AU, AZ, BA, BB, BG, BH, BN, BR, BW, BY, BZ, CA, CH, CL, CN, CO, CR, CU, CZ, DE, DJ, DK, DM, DO, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN, HR, HU, ID, IL, IN, IR, IS, JP, KE, KG, KH, KN, KP, KR, KW, KZ, LA, LC, LK, LR, LS, LU, LY, MA, MD, ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PA, PE, PG, PH, PL, PT, QA, RO, RS, RU, RW, SA, SC, SD, SE, SG, SK, SL, SM, ST, SV, SY, TH, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

(84) Designated States (unless otherwise indicated, for every

kind of regional protection available): ARIPO (BW, GH, GM, KE, LR, LS, MW, MZ, NA, RW, SD, SL, ST, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, RU,

[Continued on next page]

(54) Title: METHOD AND APPARATUS FOR LOADING A LYOPHILIZATION SYSTEM

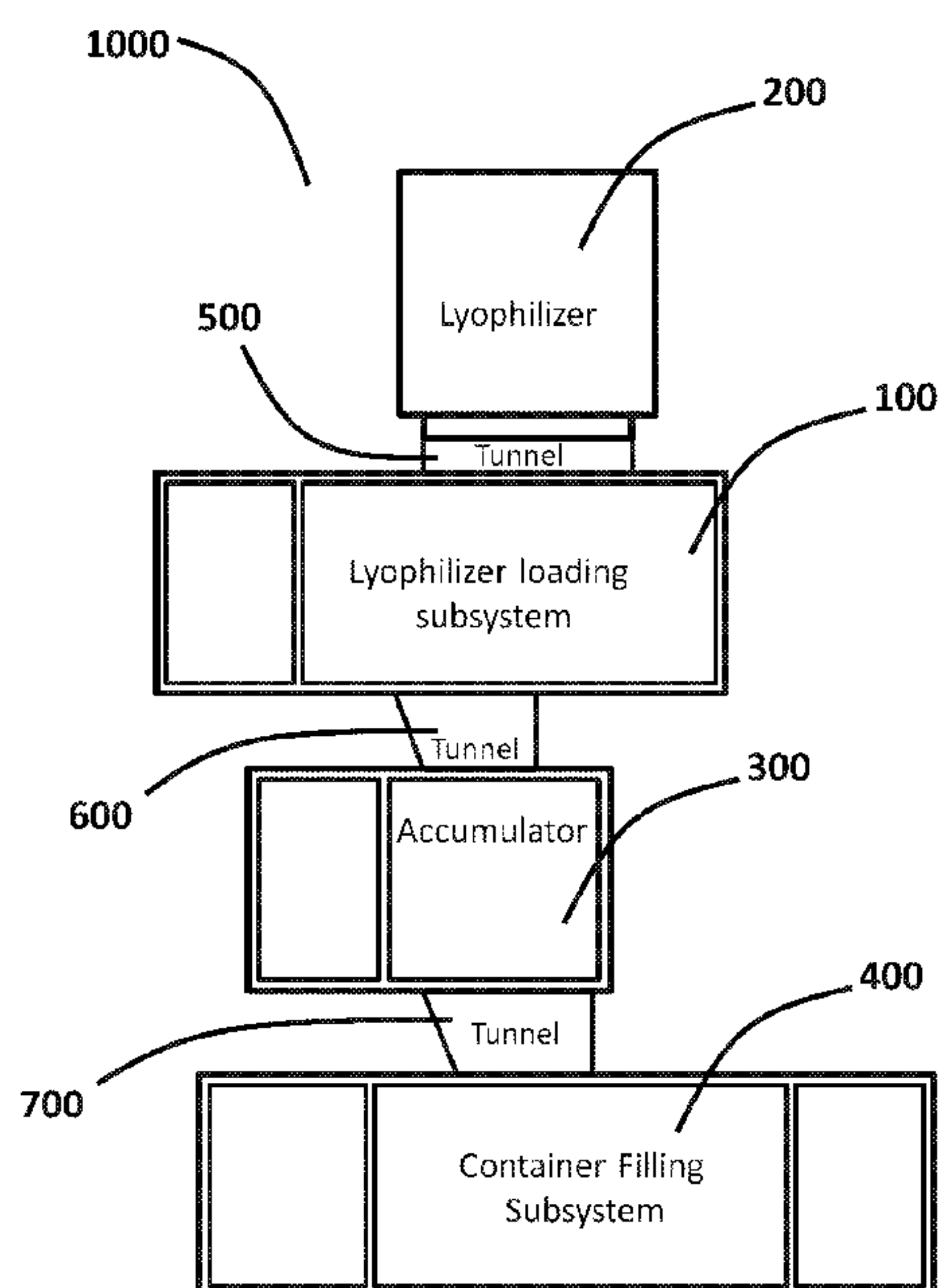


Fig. 1

(57) Abstract: Disclosed are systems and methods for aseptically filling pharmaceutical containers with a pharmaceutical substance and then lyophilizing it. In one general aspect, the system and method can employ a lyophilizer loader subsystem having an interior chamber in communication with an interior chamber of a lyophilizer subsystem via a portal with a sealable door, with the collective interior being aseptically sealable. An articulated robotic arm can be employed to batch transfer to the lyophilizer subsystem container nests bearing the pharmaceutical containers. In one embodiment, the nests may be transferred serially to the loader subsystem, with the articulated robotic arm being configured to transfer the nests of containers in batches to the lyophilizer subsystem. The articulated robotic arm can also be configured to be used to move batches of nests within the lyophilizer subsystem. One implementation includes two articulated arms and a joint rotary wrist driven by two rotary shoulders.

WO 2017/178895 A1

TJ, TM), European (AL, AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU, LV, MC, MK, MT, NL, NO, PL, PT, RO, RS, SE, SI, SK, SM, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, KM, ML, MR, NE, SN, TD, TG).

- Published:**
- *with international search report (Art. 21(3))*
 - *before the expiration of the time limit for amending the claims and to be republished in the event of receipt of amendments (Rule 48.2(h))*

METHOD AND APPARATUS FOR LOADING A LYOPHILIZATION SYSTEM

BACKGROUND OF THE INVENTION

Field of the Invention

[0001] The invention relates to methods and systems for loading pharmaceutical containers into a lyophilization system.

Description of the Related Art

[0002] Lyophilization, also referred to as freeze-drying, is employed in the field of medical technology to increase the shelf life of products such as vaccines and other injectables. By removing the water from the material and sealing the material in a vial or other container, the material can be easily stored, shipped, and later reconstituted to its original form for injection. Lyophilization is also employed to produce tablets or wafers, the advantage of which is less excipient as well as a rapidly absorbed and easily administered dosage form.

[0003] In prior art pharmaceutical container loading arrangements, the pharmaceutical containers are typically loaded sequentially into the lyophilizer. To this end, conveyor belt

systems are often employed, and the containers are entrained one behind the other for transfer to the lyophilizer.

SUMMARY OF THE INVENTION

[0004] In a first aspect, an integrated pharmaceutical processing system is presented comprising: a lyophilizing subsystem configured to lyophilize a pharmaceutical substance and having a lyophilizer interior chamber sealable from an ambient environment and a supply portal with a sealable door; and a lyophilizer loading subsystem having a loader interior chamber sealable from the ambient environment and in communication with the lyophilizer interior via the supply portal, the loading subsystem comprising within the loader interior chamber: a multi-nest support mechanism that includes a plurality of support structures that are each constructed to support one of a plurality of multi-container nests, and having a range of motion that extends between a nest loading station and a first location in the lyophilizer interior chamber, and a drive mechanism operatively connected to the multi-nest support mechanism and operative to drive the multi-nest support mechanism between the loading station and the first location in the lyophilizer interior chamber.

[0005] The multi-nest support mechanism may be configured to receive the plurality of container nests in series before transferring them in parallel. The multi-nest support mechanism may comprise an articulated robotic arm configured to engage simultaneously with the plurality of container nests and to place them via the supply portal at a first location in the lyophilizer interior chamber. The articulated robotic arm may be configured to move the plurality of container nests from the first location to a second location in the lyophilizer interior chamber. The articulated robotic arm may comprise a rotary end effector disposed at a distal end of the arm, wherein the rotary end effector includes the multi-nest support mechanism on a first side and a pushing surface on a second side.

[0006] The articulated robotic arm may further comprise a plurality of rotary joints all configured to rotate about parallel vertical rotary axes. The articulated robotic arm may

further comprise two rotary shoulders disposed at a proximal end of the articulated robotic arm, two rotary elbows, and a joint rotary wrist disposed at a distal end of the articulated robotic arm, wherein articulation of the arm is driven by the two rotary shoulders. The articulated robotic arm may be configured to allow the joint rotary wrist to pass between the rotary elbows to a position proximate a nest access location within the loader interior chamber.

[0007] The system may further comprise a pharmaceutical filling subsystem having a filling system interior chamber sealable from the ambient environment and comprising a filling station within the filling system interior chamber configured to fill with the pharmaceutical compound pharmaceutical containers held in the container nests. The system may further comprise an accumulator subsystem having an accumulator interior chamber sealable from the ambient environment and in communication with the loader interior chamber and the filling system interior chamber, the accumulator subsystem being configured to accumulate within the accumulator interior chamber from the filling subsystem container nests bearing containers at least partially filled with the pharmaceutical compound and to make the container nests available to the lyophilizer loading subsystem.

[0008] In a further aspect, a method is presented for aseptically processing a pharmaceutical substance, the method comprising: at least partially filling with the pharmaceutical substance under an aseptic condition within a sealed processing chamber a plurality of containers held in each of a plurality of container nests; batch transferring to a lyophilizer a plurality of the container nests bearing containers containing the pharmaceutical substance, and operating the lyophilizer to lyophilize the pharmaceutical substance.

[0009] The method may further include sealing an interior chamber of the integrated pharmaceutical processing system against an external environment; establishing in the interior chamber of the pharmaceutical processing system an aseptic condition before the step of at least partially filling; and wherein the step of batch transferring includes batch

relocating the plurality of container nests with their pharmaceutical containers to an interior chamber of the lyophilizer without unsealing the integrated pharmaceutical processing system; and sealing an interior chamber of the lyophilizer from a remainder of the integrated pharmaceutical processing system before the step of operating the lyophilizer. The relocating may comprise operating an articulated robotic arm to engage with the plurality of container nests; and operating the articulated robotic arm to place the plurality of container nests at a first location in the interior chamber of the lyophilizer.

[00010] The method may further comprise operating the articulated robotic arm to move the plurality of nests from the first location in the interior chamber of the lyophilizer to a second location in the interior chamber of the lyophilizer. The method may further comprise serially transferring within the processing system from the filling station to an interior chamber of an accumulator subsystem a plurality of container nests bearing containers containing the pharmaceutical substance; and serially transferring within the interior chamber of processing system the plurality of nests from the interior chamber of the accumulator subsystem to a nest access location in an interior chamber of a lyophilizer loading subsystem. The steps of filling and batch transferring may operate simultaneously on different container nests.

[00011] In a further aspect, an integrated pharmaceutical processing system is presented comprising an actuator assembly including: a housing having first and second shaft openings; at least one rotary actuator held in the housing; a first output shaft that passes through the first shaft opening in the housing, has a first end responsive to the at least one rotary actuator inside the housing, and has a second end outside the housing; a second output shaft located proximate that first output shaft, wherein the second output shaft passes through the second shaft opening in the housing, has a first end responsive to the at least one rotary actuator inside the housing, and has a second end outside the housing; a first upper arm having a first end connected to the second end of the first shaft and a having a second end so that it is at least generally perpendicular to an axis of rotation of the first shaft; a second upper arm having a first end connected to the second end of the second shaft and having a second end so that it is at least generally perpendicular to an axis of rotation of the second shaft; a first

forearm having a first end and a second end; a second forearm having a first end and a second end; a first articulation between the second end of the first upper arm and the first end of the first forearm; a second articulation between the second end of the second upper arm and the first end of the second forearm; a wrist member including: an articulation mount having an axis of rotation; at least one nest support structure to support a multi-container nest on one side of the axis of rotation of the articulation mount; a pushing surface located opposite the axis of rotation of the articulation mount from the nest support structure and is at least generally parallel to the axis of rotation of the articulation mount; a third articulation between the second end of the first forearm and the second end of the second forearm, wherein the axes of rotation of the first and second output shafts, and the axes of the first, second, and third articulations are at least generally parallel to define a five-bar linkage, and a rotary wrist actuator between the third articulation and the wrist member articulation mount.

[00012] The housing, housing openings, wrist actuator, and the first, second, and third articulations may all be sealed. The nest support structure may be a multi-nest support mechanism of support structures that are each constructed to support one of a plurality of multi-container nests. The integrated pharmaceutical processing system may be a lyophilizer loading system. The first and second forearms may be offset with respect to each other in the direction of the axes of rotation to allow them to pass next to each other and above the first and second output shafts. The apparatus may further include a lifting actuator operatively connected to the first and second output shafts to lift the nests during transfers.

[00013] Systems according to the invention can have the advantage that they load container nests in parallel instead of in series. This can help prevent issues that can occur in prior art systems in which an entrainment error of a single container can halt the lyophilization process, or at least require intervention in some way or other. This can fundamentally improve the throughput of the system and thereby the costs associated with the process. At the root of this matter lies the fact that such prior art solutions can be fundamentally serial systems.

[00013a] According to one aspect of the invention, there is provided an integrated pharmaceutical processing system comprising:

a lyophilizing subsystem configured to lyophilize a pharmaceutical substance and having a lyophilizer interior chamber sealable from an ambient environment and a supply portal with a sealable door; and

a lyophilizer loading subsystem having a loader interior chamber sealable from the ambient environment and in communication with the lyophilizer interior chamber via the supply portal, the loading subsystem comprising within the loader interior chamber:

a multi-nest support mechanism that includes a plurality of support structures that are each constructed to support one of a plurality of multi-container nests, and having a range of motion that extends between a nest loading station and a first location in the lyophilizer interior chamber, the multi-nest support mechanism also including an articulated robotic arm configured to engage simultaneously with the plurality of container nests and to place them via the supply portal at a first location in the lyophilizer interior chamber, wherein the articulated robotic arm comprises a rotary end effector disposed at a distal end of the articulated robotic arm, wherein the rotary end effector includes the multi-nest support mechanism on a first side and a pushing surface on a second side; and

a drive mechanism operatively connected to the multi-nest support mechanism and operative to drive the multi-nest support mechanism between the loading station and the first location in the lyophilizer interior chamber.

[00013b] According to a further aspect of the invention, there is provided a method for aseptically processing a pharmaceutical substance, the method comprising:

at least partially filling with the pharmaceutical substance under an aseptic condition within a sealed processing chamber a plurality of containers held in each of a plurality of container nests;

batch transferring to a lyophilizer the plurality of the container nests bearing containers containing the pharmaceutical substance by operation of a multi-nest support mechanism of a processing system that includes a plurality of support structures that are each constructed to support one of a plurality of multi-container nests;

serially transferring within the processing system from a filling station to an interior chamber of an accumulator subsystem the plurality of container nests bearing containers containing the pharmaceutical substance; and

serially transferring within the interior chamber of the processing system the plurality of container nests from the interior chamber of the accumulator subsystem to a nest access

location in an interior chamber of a lyophilizer loading subsystem; and operating the lyophilizer to lyophilize the pharmaceutical substance.

[00013c] According to a further aspect of the invention, there is provided an integrated pharmaceutical processing system, comprising:

an actuator assembly including:

a housing having first and second shaft openings;

at least one rotary actuator held in the housing;

a first output shaft that passes through the first shaft opening in the housing, has a first end responsive to the at least one rotary actuator inside the housing, and has a second end outside the housing;

a second output shaft located proximate the first output shaft, wherein the second output shaft passes through the second shaft opening in the housing, has a first end responsive to the at least one rotary actuator inside the housing, and has a second end outside the housing;

a first upper arm having a first end connected to the second end of the first output shaft and a having a second end so that it is at least generally perpendicular to an axis of rotation of the first output shaft;

a second upper arm having a first end connected to the second end of the second output shaft and having a second end so that it is at least generally perpendicular to an axis of rotation of the second output shaft;

a first forearm having a first end and a second end;

a second forearm having a first end and a second end;

a first articulation between the second end of the first upper arm and the first end of the first forearm;

a second articulation between the second end of the second upper arm and the first end of the second forearm;

a wrist member including:

an articulation mount having an axis of rotation;

at least one nest support structure to support a multi-container nest on one side of the axis of rotation of the articulation mount;

a pushing surface located opposite the axis of rotation of the articulation mount from the nest support structure and is at least generally parallel to the axis of rotation of the articulation mount;

a third articulation between the second end of the first forearm and the second end of the second forearm, wherein the axes of rotation of the first and second output shafts, and the axes of the first, second, and third articulations are at least generally parallel, and

a rotary wrist actuator between the third articulation and the wrist member articulation mount.

BRIEF DESCRIPTION OF THE DRAWINGS

[00014] The above mentioned and other features and objects of this invention, and the manner of attaining them, will become more apparent and the invention itself will be better understood by reference to the following description of an embodiment of the invention taken in conjunction with the accompanying drawings, wherein:

[00015] **FIG. 1** is a plan view schematic diagram of a system for filling pharmaceutical containers with a pharmaceutical material, accumulating the filled containers, and loading the filled containers into a lyophilization system.

[00016] **FIG. 2** is a more detailed plan view of the loading subsystem and lyophilizer subsystem of FIG. 1.

[00017] **FIG. 3** is an isometric view of an articulated robotic loading arm subsystem of the loading subsystem of FIG. 3.

[00018] **FIG. 4** is a side view of the articulated robotic loading arm subsystem of Figures 2 and 3, and lyophilizer subsystem of FIG. 1.

[00019] **FIG. 5** is a first flow chart for a method for loading pharmaceutical containers into a lyophilizer.

[00020] **FIG. 6** is a second flow chart for a method for loading pharmaceutical containers into a lyophilizer.

[00021] Corresponding reference characters indicate corresponding parts throughout the several views. Although the drawings represent embodiments of the present invention, the drawings are not necessarily to scale and certain features may be exaggerated in order to

better illustrate and explain the present invention. The flow charts and screen shots are also representative in nature, and actual embodiments of the invention may include further features or steps not shown in the drawings. The exemplification set out herein illustrates an embodiment of the invention, in one form, and such exemplifications are not to be construed as limiting the scope of the invention in any manner.

DESCRIPTION OF EMBODIMENTS OF THE PRESENT INVENTION

[00022] The embodiments disclosed below are not intended to be exhaustive or limit the invention to the precise form disclosed in the following detailed description. Rather, the embodiments are chosen and described so that others skilled in the art may utilize their teachings.

[00023] The present invention relates to a system and method for filling pharmaceutical containers with a pharmaceutical substance or other material to be lyophilized, accumulating the filled containers, and loading the filled containers into a lyophilization system. Whereas prior art systems typically serially entrain the containers and then transfer them one at a time serially to the lyophilizer, the present specification will describe below a system and method for handling the containers within nests which allow the several containers within the nests to be transferred simultaneously. At least one arrangement for such simultaneous transfer will be described, based on an articulated robotic arm system. As will be shown, the system allows for a plurality of nests of containers to be transferred simultaneously to the lyophilizer.

[00024] In the present specification, the term “pharmaceutical substance” is used to describe materials of organic or inorganic nature employed in the medical field.

[00025] **FIG. 1** shows a plan view schematic diagram of a pharmaceutical processing system **1000** for filling pharmaceutical containers with a pharmaceutical material, accumulating the

filled containers, and loading the filled containers into a lyophilization system. System **1000** comprises a pharmaceutical container loading subsystem **100**, a lyophilizer subsystem **200**, an accumulator subsystem **300**, and a pharmaceutical container filling subsystem **400**. Tunnels **500**, **600**, and **700** join respectively the lyophilizer subsystem **200** to the loading subsystem **100**, the loading subsystem **100** to the accumulator subsystem **300**, and the accumulator subsystem **300** to the filling subsystem **400**. An environmental condition is established in loading subsystem **100** and is maintained by means of the tunnels **500**, **600**, and **700** throughout accumulator subsystem **300** and loading subsystem **100**. Since lyophilizer subsystem **200** has to maintain a unique environmental condition different from that in the rest of system **1000**, lyophilizer subsystem **200** may be sealed off from the rest of system **1000** by means of a suitable door, as shown later in FIG. 4. Tunnel **500** nevertheless maintains the environmental condition of the rest of the system up to that door.

[00026] **FIG. 2** shows a more detailed plan view of tunnel **600**, loader subsystem **100**, tunnel **500**, and lyophilizer subsystem **200**. Loader subsystem **100** comprises articulated robotic arm subsystem **110** for batch transferring container bearing nests into lyophilizer subsystem **200** through tunnel **500**, at least one container nest pedestal **120** (four are shown in FIG. 2), and a transfer articulated robotic arm **130** for transferring container nests **800** serially from a source location in tunnel **600** to the at least one container nest pedestal **120**. In the present specification, we use the term “container nest access location” to describe a generalized location from which the robotic arm **130** may access a plurality of container nests **800**, including for example without limitation the set of pedestals **120**. The arrangement shown in FIG. 2 allows for the serial transfer of container nests **800** from accumulator subsystem **300** to lyophilizer loader subsystem **100**, articulated robotic arm **130** being configured for serially transferring container nests **800**. In other embodiments, a different means may be employed for the transfer of container nests **800** from accumulator subsystem **300** to lyophilizer loader subsystem **100**, and such arrangements may allow the batch transfer of container nests **800**. Other arrangements for container nest access locations may be employed. Articulated robotic arm subsystem **110** is disposed to engage with one or more container bearing nests on the at

least one container nest pedestal **120** and to transfer the nests to the lyophilizer subsystem **200**.

[00027] The term “batch relocating” or “batch transferring” is used in this specification to refer to a number of items, typically identical or similar, for example container nests **800**, being relocated or transferred simultaneously or “in parallel”. In this respect the process is distinguished from a process in which the same items are being “serially relocated” or “serially transferred”. In the latter case the items are relocated or transferred one at a time. The present invention comprises subsystems having means arranged for batch transfer of container nests, while other means are arranged for serial transfer. A means arranged for batch transfer can serially transfer individual container nests. However, means arranged for serial transfer of container nests cannot batch transfer pluralities of container nests.

[00028] **FIG. 3** shows articulated robotic arm subsystem **110** in more detail. Following the terminology suggested by the parallels with the human anatomy of shoulders, upper arms, forearms and joined or tied wrists, the articulating elements of the robotic arm subsystem **110** are left and right upper arms **113a** and **113b**, and left and right forearms **113c** and **113d**. Rotary elbows **112c** and **112d** join the left forearm **113c** to the left upper arm **113a**, and the right forearm **113d** to the right upper arm **113b** respectively. Actuator assembly **111**, disposed at a proximal end of robotic arm subsystem **110**, provides both the rotary action and the vertical motion of left rotary shoulder **112a** and right rotary shoulder **112b**. Forearms **113c** and **113d** are joined at rotary wrist **115** that allows forearms **113c** and **113d** to articulate with respect to each other. Rotary elbows **112c** and **112d** may be unpowered, all required power for the articulation being provided by actuator assembly **111**. The articulation of robotic arm subsystem **110** is therefore driven only at the proximal or shoulder end of robotic arm subsystem **110**.

[00029] The actuator assembly **111** can be implemented with left and right rotary actuators that respectively drive the output shafts that drive the shoulders, or with a single actuator and

a suitable rotary mechanism to drive the output shafts in opposite directions (e.g., a gearbox). The actuator assembly **111** is preferably enclosed in a housing to isolate the actuators from the inside of the loading subsystem **100**. The actuator assembly may also include one or more linear actuators to lift the output shafts, allowing the nests to be lifted and set down by the robotic arm subsystem **110**.

[00030] Rotary shoulders **112a** and **112b** rotate about shoulder rotational axes **119a** and **119b** respectively. Rotary elbows **112c** and **112d** rotate about elbow rotational axes **119c** and **119d** respectively. Rotary wrist **115**, located at the distal end of robotic arm subsystem **110**, rotates about wrist rotational axis **119e**. Rotary wrist **115** further allows fork-and-pusher baseplate **116** to rotate about rotary axis **119e**. To this end rotary wrist **115** is equipped with a suitable drive (not shown) to rotate baseplate **116**. Suitable drives may be, for example without limitation, a worm drive.

[00031] Robotic arm subsystem **110** is capable of rotating the forearms **113c** and **113d** “inward” to extend further in the proximal direction than the shoulders **112a** and **112b**. This allows robotic arm subsystem **110** to move fork-and-pusher baseplate **116** to container nest pedestal **120** of **FIG. 2** and **FIG. 4**, allowing fork-and-pusher baseplate **116** to pass between rotary elbows **112c** and **112d** and over rotary shoulders **112a** and **112b** in that process. The vertical extent of the rotary elbows **112c** and **112d** makes this articulation possible.

[00032] When left and right rotary shoulders **112a** and **112b** are rotated respectively anti-clockwise and clockwise (looking down on actuator assembly **111**), rotary elbows **112c** and **112d** separate further from each other and rotary wrist **115** bearing baseplate **116** is moved closer to the actuator assembly **111**. With reference to **FIG. 2** it may be seen that such an articulated action moves the baseplate **116** closer to the pedestals **120**. In order to collect nests **800** bearing containers **900** from the pedestals **120**, baseplate **116** may be fitted with a fork **117** disposed for engaging with the nests bearing the containers, as shown in **FIG. 4**. To the extent that different nests **800** of differing sizes and shapes may be employed, baseplate

116 may be fitted with different forks **117** to match the different nests **800**. Baseplate **116** may also be fitted with at least one pusher **118**, four pushers being shown in **FIG. 3**. The purpose and function of pushers **118** will become clear at the hand of **FIG. 4**.

[00033] Different detailed embodiments are possible for the upper arms and forearms of robotic articulated arm subsystem **110**. In **FIG. 3** rotary elbow **112c** is shown as greater in vertical extent than rotary elbow **112d**, such that forearms **113c** and **113d** are not articulating in the same horizontal plane, as is evident from the arrangement of rotary wrist **115**. In other embodiments, the rotary elbows may be identical and the forearms **113c** and **113d** articulate differently at rotary wrist **115**. In one embodiment, with the baseplate **116** and fork **117** in the orientation shown in **FIG. 3**, the empty fork **117** can pass under the forearms **113c** and **113d** and over the rotary shoulders **112a** and **112b** in order to reach the pedestals **120** shown in **FIG. 2** and **FIG. 4**.

[00034] In **FIG. 4**, fork **117** is shown depositing through portal **230** nest **800** bearing containers **900** on shelf **210** of lyophilizer subsystem **200**. To facilitate this action, lyophilizer door **220** is in the open position. Door **220** is capable of being sealed. As may be seen in **FIG. 4**, the vertical level of pedestal **120** is comparable to that of the shelf **210** of the lyophilizer **200** being supplied with nests **800**. This arrangement facilitates baseplate **116** and its attached pushers **118** and fork **117** in passing between the rotary elbows **112d** and **112c** (partly obscured behind **112d** in **FIG. 4**) in order to collect further nests of containers from the pedestal **120**. **FIG. 4** shows further shelves within lyophilizer subsystem **200**. Robotic arm subsystem **110** is therefore employed in a first orientation in placing nests **800** at a first location in lyophilizer subsystem **200** and then subsequently employed in a second orientation to move nests **800** to a second location in lyophilizer subsystem **200**. In order to vertically stack shelves **210**, shelves **210** may be mounted on an elevator system that moves them upward once loaded with container nests.

[00035] Once a container bearing nest **800**, or row of container bearing nests **800**, has been placed on shelf **210**, and fork **117** withdrawn from the nest(s) **800**, baseplate **116** may be rotated through 180 degrees so that pusher(s) **118** face(s) the nest(s) **800**. Actuator assembly **111** may then be operated to push nest(s) **800** further onto the shelf to predetermined or desired positions by means of pushers(s) **118**, thereby creating room for another nest **800** or row of nests **800** on shelf **210**. When a shelf **210** has been filled to a desired degree with nests **800**, the shelf **210** may be raised using the elevator system of the lyophilizer **200**.

[00036] Returning now to **FIG. 1**, pharmaceutical container filling subsystem **400** may be, for example, of the type described in detail in U.S. patent applications Ser. No. 12/393,183 and No. 13/744,408, both titled “Robotic filling systems and methods”. This general kind of system is also described in U.S. patent application Ser. No. 14/377,696, titled “Articulated arm apparatus and system”. Pharmaceutical containers **900** may be filled with a pharmaceutical substance in filling subsystem **400** while borne in nests **800**. Nests **800** suitable for use with the present invention include, but are not limited to, those described in WIPO patent application WO2015/023924(A2), titled “Method, device and system for filling pharmaceutical containers” and in WIPO patent application WO2013/166379(A1) titled “Cover removal system for use in controlled environment enclosures”.

[00037] Accumulator subsystem **300** may comprise a robotic arm (not shown) for obtaining nests **800** with filled containers **900** from filling subsystem **400** and for storage of such nests **800** of containers **900** in accumulator subsystem **300**. The arm, or another similar articulated robotic arm may be employed to place a nest **800** bearing containers **900** at the source location in tunnel **600**.

[00038] The embodiment shown in **FIG. 1** to **FIG. 4** allows for containers nests **800** to be batch transferred to lyophilizer subsystem **200** while other container nests **800** are at the same

time being serially transferred from the accumulator subsystem **300** to lyophilizer loader subsystem **100**, and yet further container nests **800** are at the same time having their containers **900** filled in filling subsystem **400**.

[00039] In a further aspect, described at the hand of the flow chart of **FIG. 5**, a method is presented for lyophilizing a pharmaceutical substance in an integrated pharmaceutical processing system, the method comprising: providing **[2100]** in the integrated pharmaceutical processing system **1000** a plurality of pharmaceutical containers **900** held in a plurality of container nests **800**; sealing **[2200]** an interior chamber of the integrated pharmaceutical processing system **1000** against an external environment; establishing **[2300]** in the interior chamber of the pharmaceutical processing system **1000** an aseptic condition; at a filling station within the interior chamber of the processing system **1000** depositing **[2400]** the pharmaceutical substance into at least a portion of the plurality of containers **900** in the at least one container nest **800**; batch relocating **[2700]** the plurality of container nests **800** with pharmaceutical containers **900** to an interior chamber of a lyophilizer **200** without unsealing the integrated pharmaceutical processing system **1000**; sealing **[2800]** an interior chamber of the lyophilizer **200** from a remainder of the integrated pharmaceutical processing system **1000**; and lyophilizing **[2900]** the pharmaceutical substance contained in the at least a portion of the plurality of containers **900** in the at least one container nest **800**.

[00040] The method may further comprise serially transferring **[2500]** within the processing system **1000** from the filling station to an interior chamber of an accumulator subsystem **300** a plurality of container nests **800** bearing containers **900** containing the pharmaceutical substance; and serially transferring **[2600]** within the interior chamber of the processing system **1000** the at least one container nest **800** from the interior chamber of the accumulator subsystem **300** to a nest access location **120** in an interior chamber of a lyophilizer loading subsystem **100**, wherein the at least one container nest **800** is at least one of the plurality of container nests.

[00041] The batch relocating may comprise operating a first articulated robotic arm **110** to engage with the plurality of container nests **800**; and operating the first articulated robotic arm **110** to place the plurality of container nests **800** at a first location in the interior chamber of the lyophilizer **200**. The batch relocating **[2700]** may further comprise operating the first articulated robotic arm **110** to move the plurality of nests **800** from the first location in the interior chamber of the lyophilizer **200** to a second location in the interior chamber of the lyophilizer **200**.

[00042] The batch relocating **[2700]** may comprise operating an articulated robotic arm **110** to engage with the container nests **800** at the nest access location **120**; and operating the first articulated robotic arm **110** to place the container nests **800** at a first location in the interior chamber of the lyophilizer **200**. The method may further comprise operating the first articulated robotic arm **110** to move the container nests **800** from the first location in the interior chamber of the lyophilizer **200** to a second location in the interior chamber of the lyophilizer **200**.

[00043] In a further aspect, described at the hand of the flow chart in **FIG. 6**, a method for lyophilizing a pharmaceutical substance comprises at least partially filling **[3100]** under an aseptic condition within a sealed processing chamber, for example the interior chamber of system **1000**, a first plurality of containers **900** with the pharmaceutical substance while the first plurality of containers **900** is held in a container nest **800**; batch transferring **[3200]** to a lyophilizer **200** a plurality of container nests **800** bearing containers **900** containing the pharmaceutical substance; and operating **[3500]** the lyophilizer **200** to lyophilize the pharmaceutical substance, wherein the plurality of container nests **800** comprises the at least one container nest containing the at least partially filled first plurality of containers **900**. The batch transferring to a lyophilizer **200** a plurality of container nests **800** may be undertaken under the aseptic condition.

[00044] The method may further comprise at least partially filling [3300] a second plurality of containers with the pharmaceutical substance while batch transferring [3200] to the lyophilizer the plurality of container nests. The method may further comprise sealing [3400] an interior chamber of the lyophilizer 200 from the interior of the processing chamber of the system 1000 while maintaining the aseptic condition in the processing chamber of the system 1000. The batch transferring [3200] may comprise operating an articulated robotic arm 110 to engage with the plurality of container nests 800; and operating the articulated robotic arm 110 to transfer the container nests 800 to a first location in the lyophilizer 200. The method may further comprise operating the articulated robotic arm 110 to move the container nests 800 from the first location in the lyophilizer 200 to a second location in the lyophilizer 200.

[00045] The arm actuators, doors, and other controllable parts of the system are preferably controlled by a control system. This control system can be implemented in connection with special-purpose software programs running on general-purpose computer platforms or application-specific controller platforms, but it could also be implemented in a variety of other ways including through the use of special-purpose hardware for some or all of the control system. And while the system can be broken into the series of modules and steps shown for illustration purposes, one of ordinary skill in the art would recognize that it is also possible to combine them and/or split them differently to achieve a different breakdown, and that the functions of such modules and steps can be arbitrarily distributed and intermingled within different entities, such as routines, files, and/or machines. Moreover, different providers can develop and even operate different parts of the system.

[00046] While this invention has been described as having an exemplary design, the present invention may be further modified within the spirit and scope of this disclosure. This application is therefore intended to cover any variations, uses, or adaptations of the invention using its general principles. Further, this application is intended to cover such departures from the present disclosure as come within known or customary practice in the art to which this invention pertains.

What is claimed is:

1. An integrated pharmaceutical processing system comprising:

a lyophilizing subsystem configured to lyophilize a pharmaceutical substance and having a lyophilizer interior chamber sealable from an ambient environment and a supply portal with a sealable door; and

a lyophilizer loading subsystem having a loader interior chamber sealable from the ambient environment and in communication with the lyophilizer interior chamber via the supply portal, the loading subsystem comprising within the loader interior chamber:

a multi-nest support mechanism that includes a plurality of support structures that are each constructed to support one of a plurality of multi-container nests, and having a range of motion that extends between a nest loading station and a first location in the lyophilizer interior chamber, the multi-nest support mechanism also including an articulated robotic arm configured to engage simultaneously with the plurality of container nests and to place them via the supply portal at a first location in the lyophilizer interior chamber, wherein the articulated robotic arm comprises a rotary end effector disposed at a distal end of the articulated robotic arm, wherein the rotary end effector includes the multi-nest support mechanism on a first side and a pushing surface on a second side; and

a drive mechanism operatively connected to the multi-nest support mechanism and operative to drive the multi-nest support mechanism between the loading station and the first location in the lyophilizer interior chamber.
2. The system of claim 1, wherein the multi-nest support mechanism is configured to receive the plurality of container nests in series before transferring them in parallel.
3. The system of claim 1, wherein the articulated robotic arm is configured to move the plurality of container nests from the first location to a second location in the lyophilizer interior chamber.
4. The system of claim 1, wherein the articulated robotic arm further comprises a plurality of rotary joints all configured to rotate about parallel vertical rotary axes.
5. The system of claim 4, wherein the articulated robotic arm comprises two rotary shoulders disposed at a proximal end of the articulated robotic arm, two rotary elbows, and a joint rotary wrist disposed at a distal end of the articulated robotic arm, wherein articulation of the articulated robotic arm is driven by the two rotary shoulders.
6. The system of claim 5, wherein the articulated robotic arm is configured to allow the joint rotary wrist to pass between the rotary elbows to a position proximate a nest access location within the loader interior chamber.
7. The system of claim 1, further comprising a pharmaceutical filling subsystem having a filling system interior chamber sealable from the ambient environment and comprising a filling station within the filling system interior chamber configured to fill, with the pharmaceutical substance, a plurality of pharmaceutical containers held in one of the plurality of multi-container nests.
8. The system of claim 7, further comprising an accumulator subsystem having an accumulator interior chamber sealable from the ambient environment and in communication with the loader interior

chamber and the filling system interior chamber, the accumulator subsystem being configured to accumulate within the accumulator interior chamber from the one of the plurality of container nests bearing containers at least partially filled with the pharmaceutical compound and to make the container nests available to the lyophilizer loading subsystem.

9. A method for aseptically processing a pharmaceutical substance, the method comprising:

at least partially filling with the pharmaceutical substance under an aseptic condition within a sealed processing chamber a plurality of containers held in each of a plurality of container nests;

batch transferring to a lyophilizer the plurality of the container nests bearing containers containing the pharmaceutical substance by operation of a multi-nest support mechanism of a processing system that includes a plurality of support structures that are each constructed to support one of a plurality of multi-container nests;

serially transferring within the processing system from a filling station to an interior chamber of an accumulator subsystem the plurality of container nests bearing containers containing the pharmaceutical substance; and

serially transferring within the interior chamber of the processing system the plurality of container nests from the interior chamber of the accumulator subsystem to a nest access location in an interior chamber of a lyophilizer loading subsystem; and

operating the lyophilizer to lyophilize the pharmaceutical substance.

10. The method of claim 9 further including:

sealing the interior chamber of the integrated pharmaceutical processing system against an external environment;

establishing in the interior chamber of a pharmaceutical processing system an aseptic condition before the step of at least partially filling; and wherein the step of batch transferring includes batch relocating the plurality of container nests with their pharmaceutical containers to an interior chamber of the lyophilizer without unsealing the integrated pharmaceutical processing system; and

sealing an interior chamber of the lyophilizer from a remainder of the integrated pharmaceutical processing system before the step of operating the lyophilizer.

11. The method of claim 9, wherein the transferring comprises:

operating an articulated robotic arm to engage with the plurality of container nests; and

operating the articulated robotic arm to place the plurality of container nests at a first location in an interior chamber of the lyophilizer.

12. The method of claim 11, further comprising operating the articulated robotic arm to move the plurality of container nests from the first location in the interior chamber of the lyophilizer to a second location in the interior chamber of the lyophilizer.

13. The method of claim 9, wherein the steps of filling and batch transferring operate simultaneously on different container nests.

14. An integrated pharmaceutical processing system, comprising:
- an actuator assembly including:
- a housing having first and second shaft openings;
 - at least one rotary actuator held in the housing;
 - a first output shaft that passes through the first shaft opening in the housing, has a first end responsive to the at least one rotary actuator inside the housing, and has a second end outside the housing;
 - a second output shaft located proximate the first output shaft, wherein the second output shaft passes through the second shaft opening in the housing, has a first end responsive to the at least one rotary actuator inside the housing, and has a second end outside the housing;
 - a first upper arm having a first end connected to the second end of the first output shaft and a second end so that it is at least generally perpendicular to an axis of rotation of the first output shaft;
 - a second upper arm having a first end connected to the second end of the second output shaft and having a second end so that it is at least generally perpendicular to an axis of rotation of the second output shaft;
 - a first forearm having a first end and a second end;
 - a second forearm having a first end and a second end;
 - a first articulation between the second end of the first upper arm and the first end of the first forearm;
 - a second articulation between the second end of the second upper arm and the first end of the second forearm;
 - a wrist member including:
 - an articulation mount having an axis of rotation;
 - at least one nest support structure to support a multi-container nest on one side of the axis of rotation of the articulation mount;
 - a pushing surface located opposite the axis of rotation of the articulation mount from the nest support structure and is at least generally parallel to the axis of rotation of the articulation mount;
 - a third articulation between the second end of the first forearm and the second end of the second forearm, wherein the axes of rotation of the first and second output shafts, and the axes of the first, second, and third articulations are at least generally parallel, and
 - a rotary wrist actuator between the third articulation and the wrist member articulation mount.
15. The apparatus of claim 14 wherein the housing, housing openings, wrist actuator, and the first, second, and third articulations are all sealed.

16. The apparatus of claim 14 wherein the nest support structure is a multi-nest support mechanism of support structures that are each constructed to support one of a plurality of multi-container nests.
17. The apparatus of claim 14 wherein the integrated pharmaceutical processing system is a lyophilizer loading system.
18. The apparatus of claim 14 wherein the first and second forearms are offset with respect to each other in the direction of the axes of rotation to allow them to pass next to each other and above the first and second output shafts.
19. The apparatus of claim 14 further including a lifting actuator operatively connected to the first and second output shafts to lift the nests during transfers.

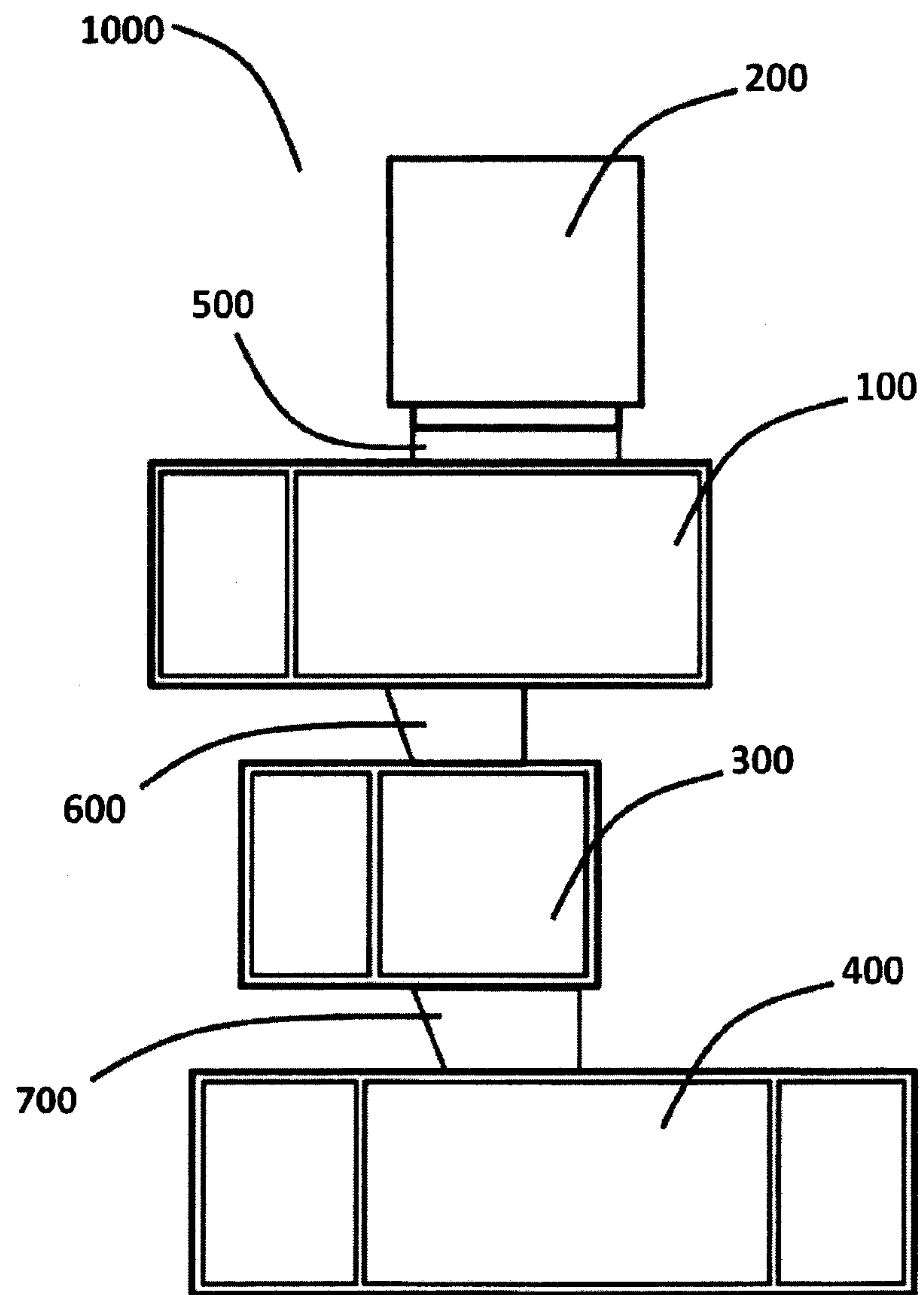


Fig. 1

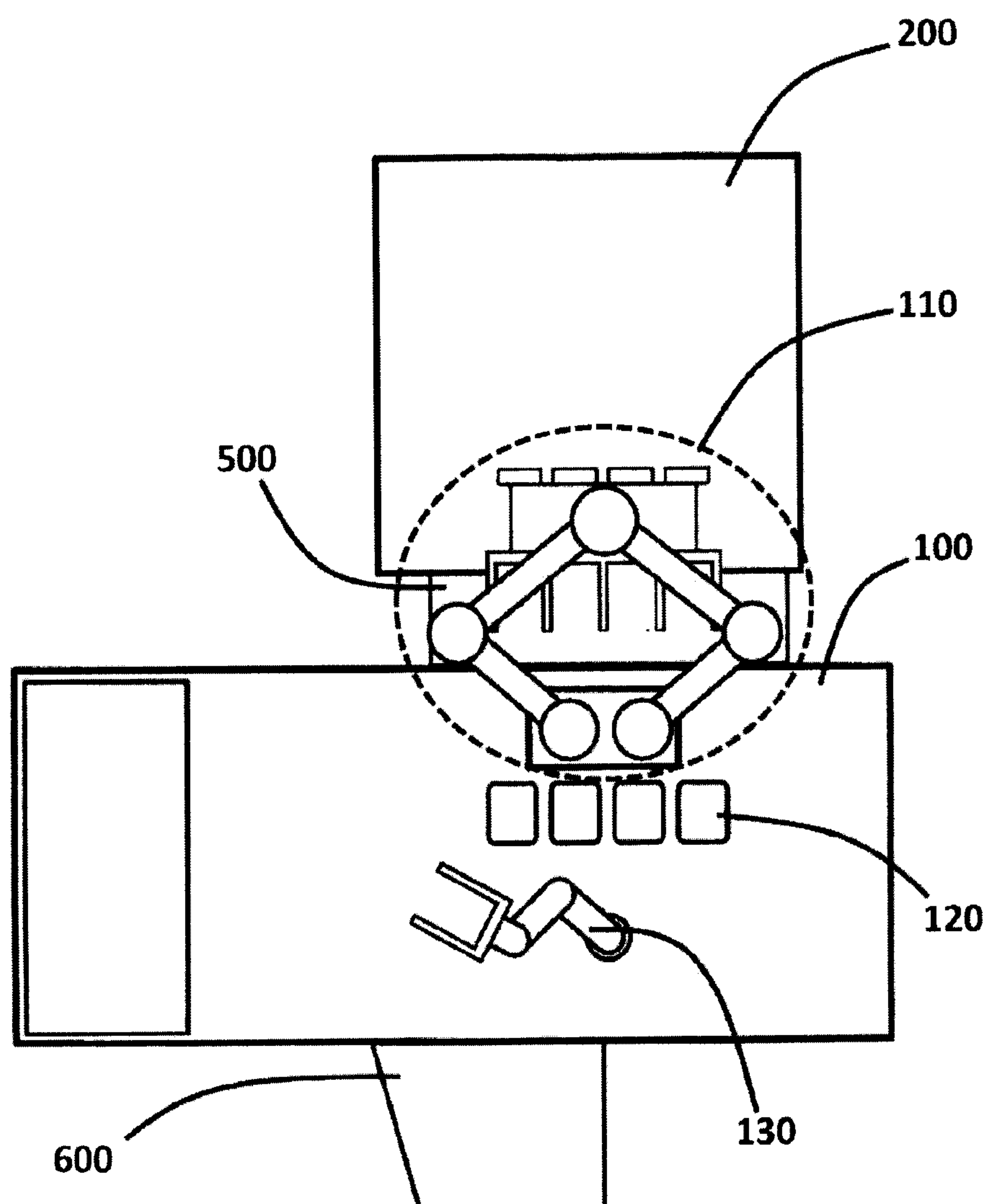


Fig. 2

4/6

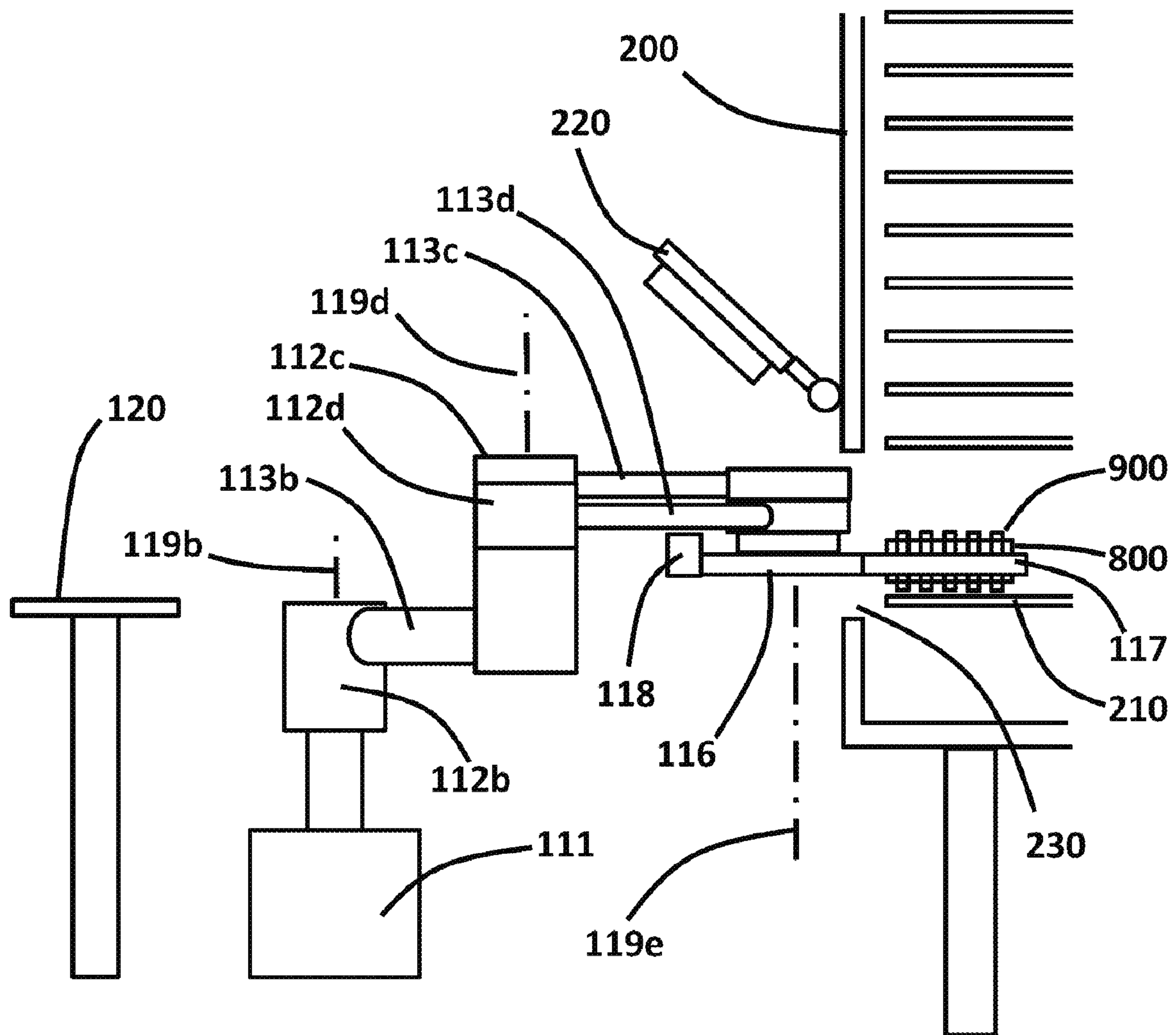
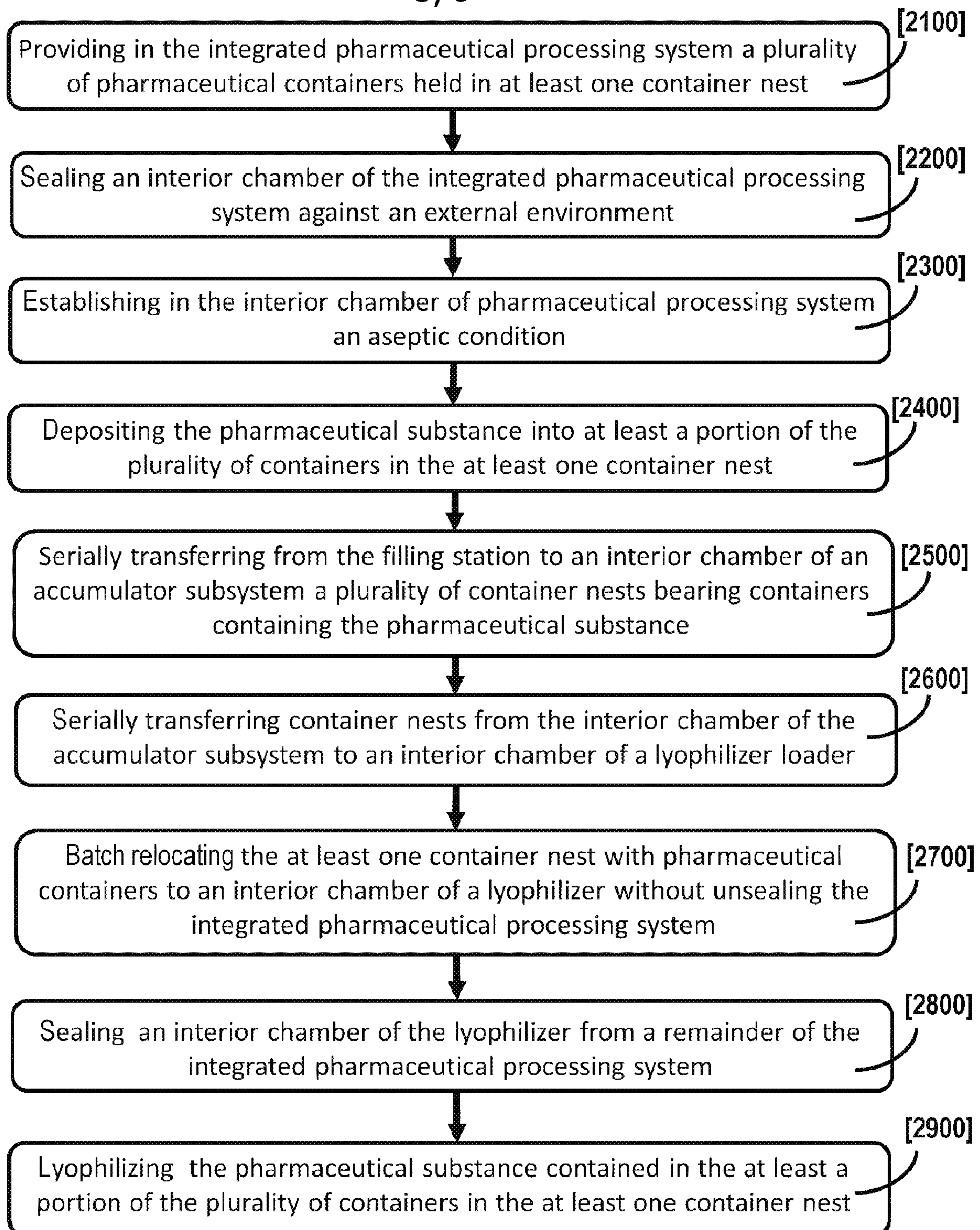
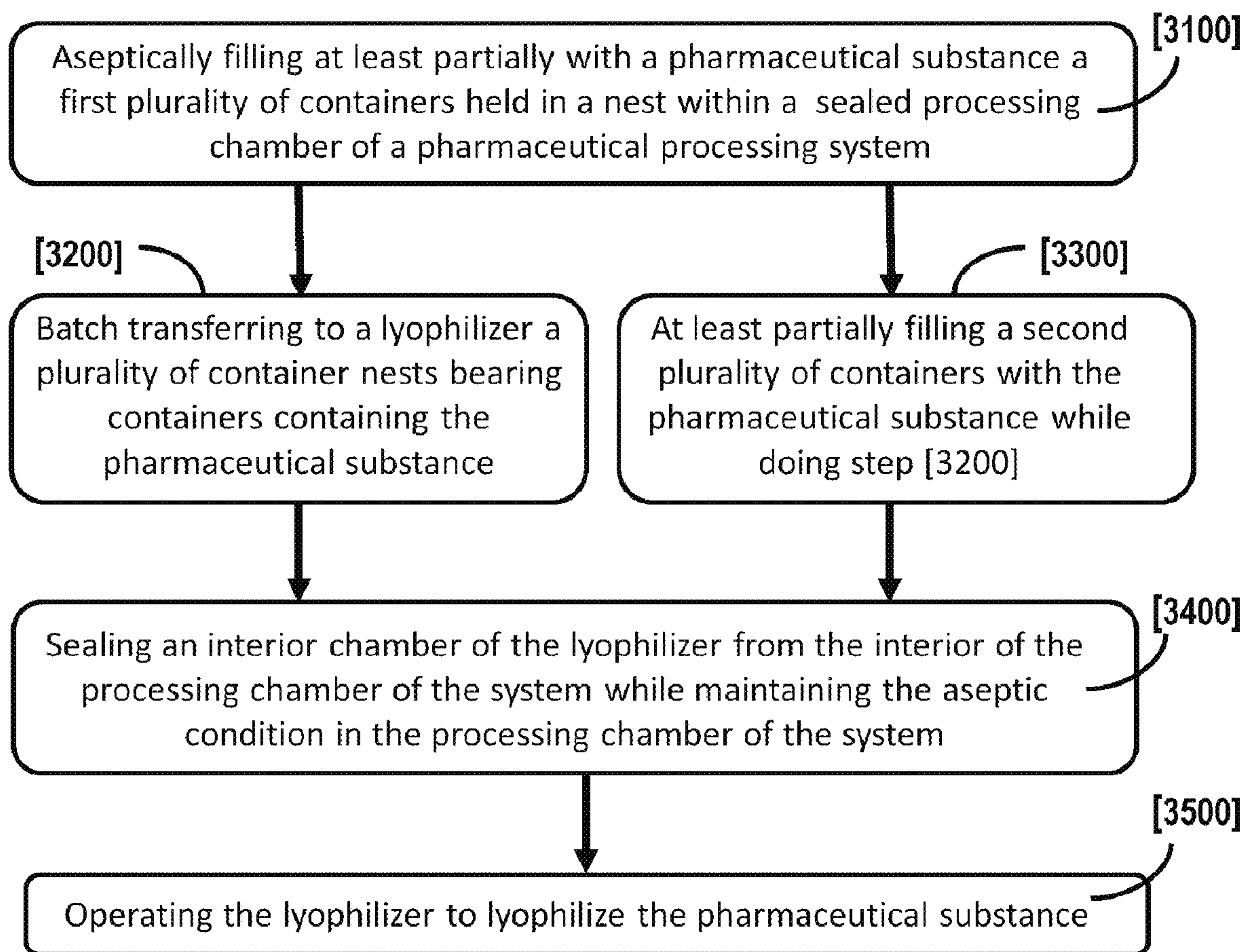


Fig. 4

5/6

**Fig. 5**

6/6

**Fig. 6**

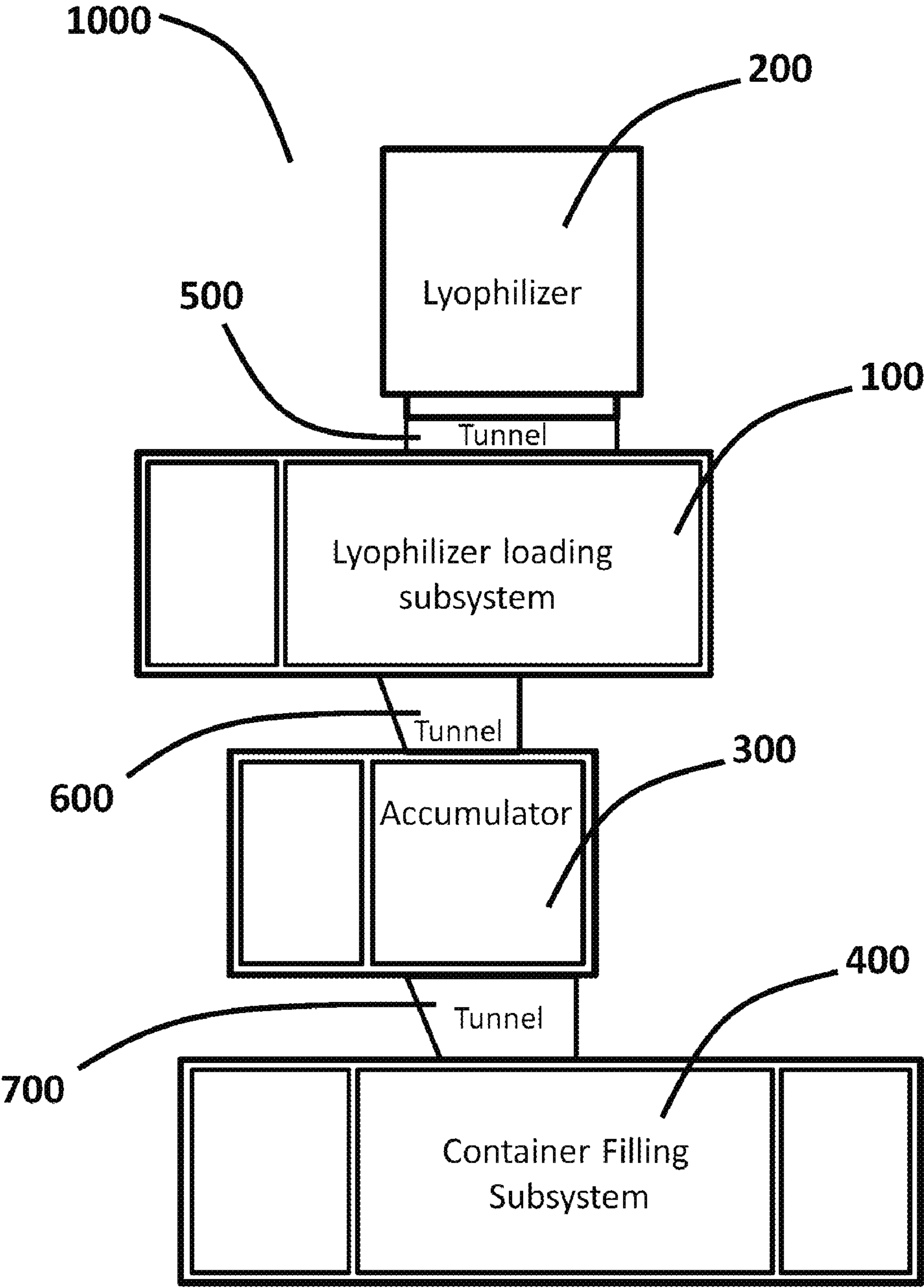


Fig. 1