

THE SCIENCE, MANUFACTURE AND FUTURE OF VACCINES



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Agenda

- Introduction
- Basic Immunology
- Historical Perspective
- Vaccine Manufacturing Case Studies
- Futures

Vaccine Development

WHY??



The spread of SARS: A worldwide problem

Severe acute respiratory syndrome was first reported in the Guangdong province of China and quickly spread across the globe. Scientists say a lack of knowledge about the syndrome and the Chinese government's initially slow and incomplete reporting of the disease have made it more difficult to contain the problem. A look at the spread of the disease, its cause and how it is being fought worldwide:

27 countries, 259 deaths: Total number of probable SARS cases*

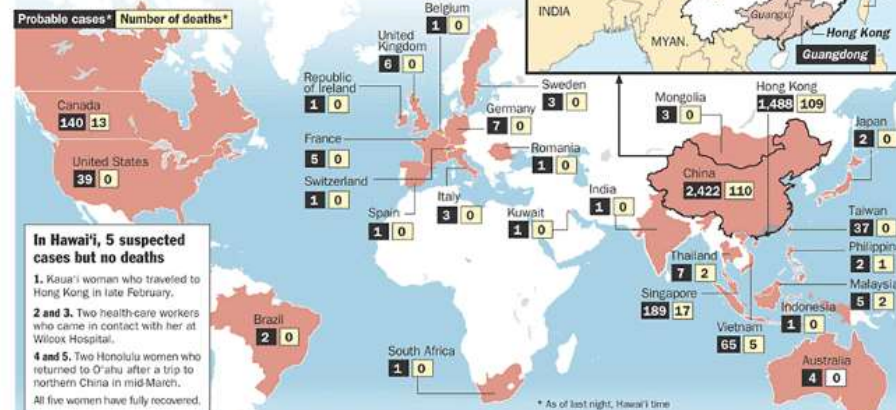
4,443 people are suspected of having severe acute respiratory syndrome; of those 259 have died from the disease. The numbers change daily as more SARS cases are confirmed or cases mistakenly diagnosed as SARS are reclassified.



A masked pedestrian in Guangzhou, Guangdong Province, where the mysterious illness was first reported.

Was China the source?

The virus may have originated in the Guangdong Province in mid-November. The province, which is densely populated and has humans and animals living in close contact, provided an ideal breeding ground for the new virus. It migrated to Hong Kong, the launching pad to the rest of the world.



In Hawai'i, 5 suspected cases but no deaths

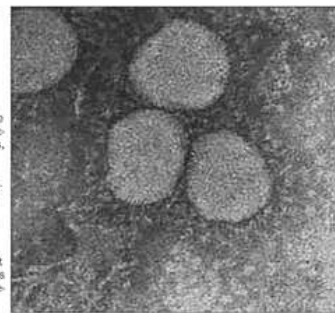
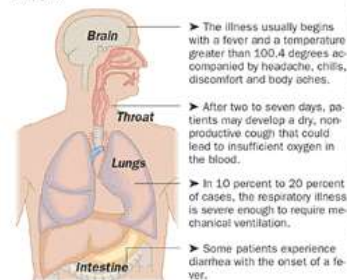
1. Kauai'i woman who traveled to Hong Kong in late February.
 - 2 and 3. Two health-care workers who came in contact with her at Wilcox Hospital.
 - 4 and 5. Two Honolulu women who returned to O'ahu after a trip to northern China in mid-March.
- All five women have fully recovered.

The cause of SARS: A new coronavirus

Working separately, scientists in Vancouver and the Centers for Disease Control and Prevention fully mapped the genome of a brand-new coronavirus, using viruses isolated from SARS cases in Asia and Canada. Tests on monkeys confirmed that the coronavirus causes SARS, according to the World Health Organization. The genetic information about the coronavirus could lead to more accurate diagnostic tests, more specific treatment and eventually, a vaccine.

Symptoms and treatment

Patients receive treatment similar to what would be used for community-acquired atypical pneumonia of unknown cause. Treatment regimens include antibiotics, antiviral agents and steroids. Presently, the most effective treatment regimen is unknown.

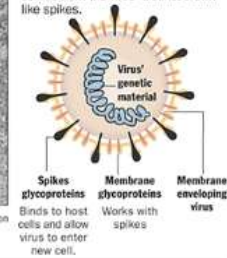


Particles of the SARS coronavirus.

World Health Organization

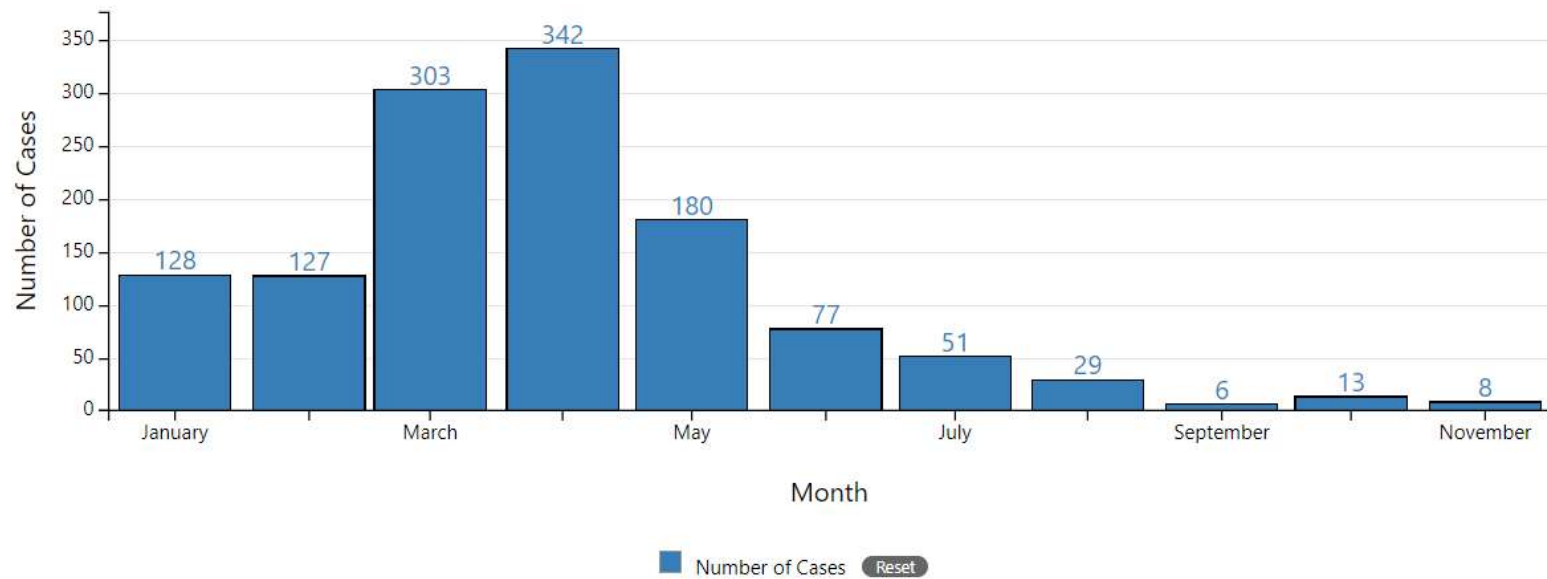
What is a coronavirus?

First isolated from chickens in 1937, there are now about 15 species in this family. Coronaviruses are what cause the common cold. They infect not only humans but cattle, pigs, rodents, cats, dogs and birds. The name "corona" comes from the virus' distinct crown-like spikes.



Vaccine Development

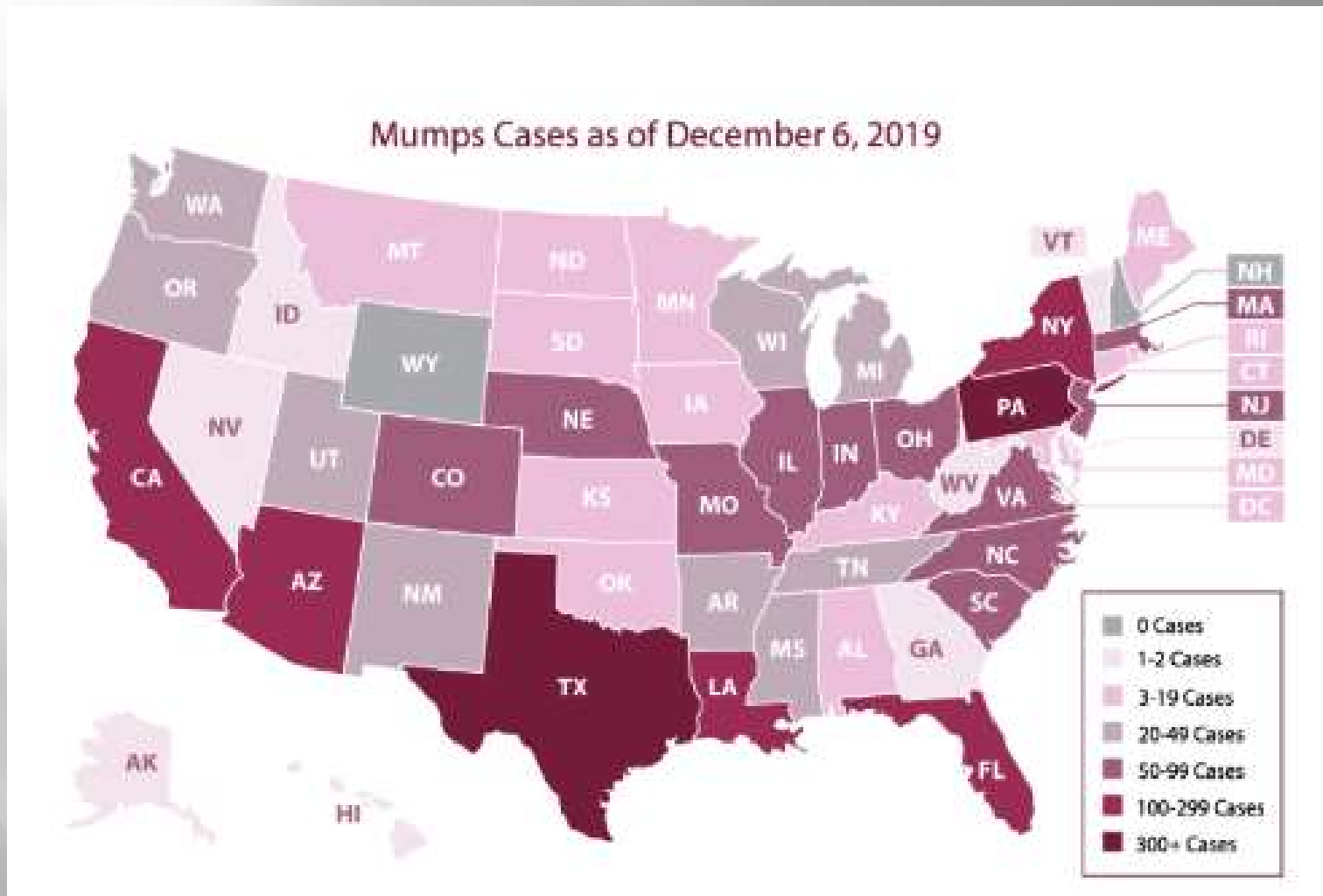
Measles Cases Reported by Month in 2019*



- From 1-Jan thru 5 December 2019: 1,276 cases in the US
- Most cases since 1992
- >75% of cases linked to outbreak in NY

Source: CDC

Vaccine Development



Source: CDC



Emerging Diseases



Emerging Diseases



Emerging Diseases



Emerging Diseases



Dennis'



CRASH COURSE

Immunology

A word cloud of immunology terms. The words are arranged in various orientations and colors (purple, orange, green, yellow, red). The terms include: Thymus, Lymphatic, Adaptive, Passive, Edema, Lymphocytes, MAb, Xenotransplantation, Innate, ABO, Complement, Spleen, Marrow, Interleukins, T-Cells, Clonal, Active, Primary, Vaccination, Allergies, Cytokines, Secondary, Rh, Immunoglobulins, Antibody, Interferons, MHC, IgG, and BCR.

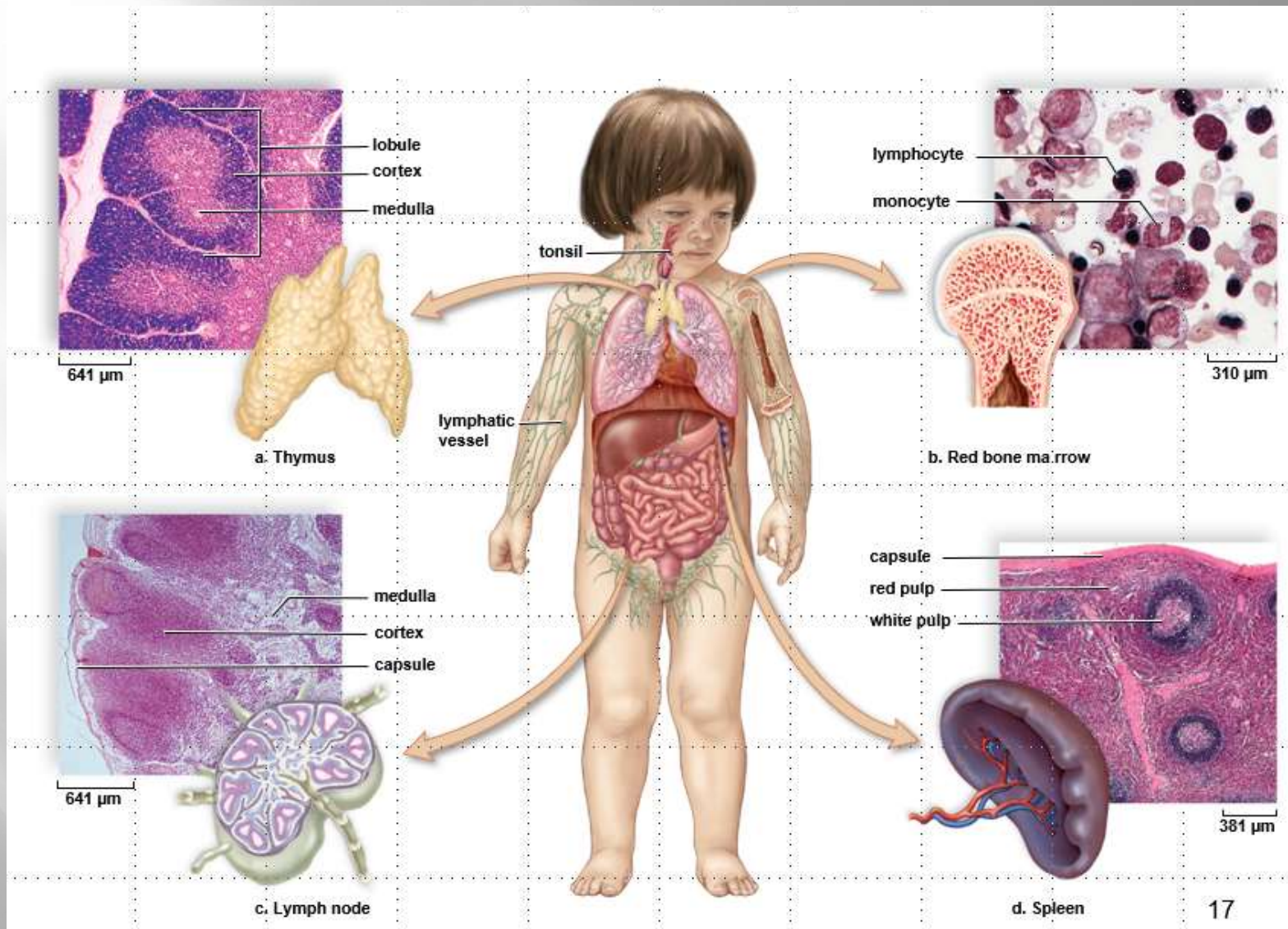
Definitions

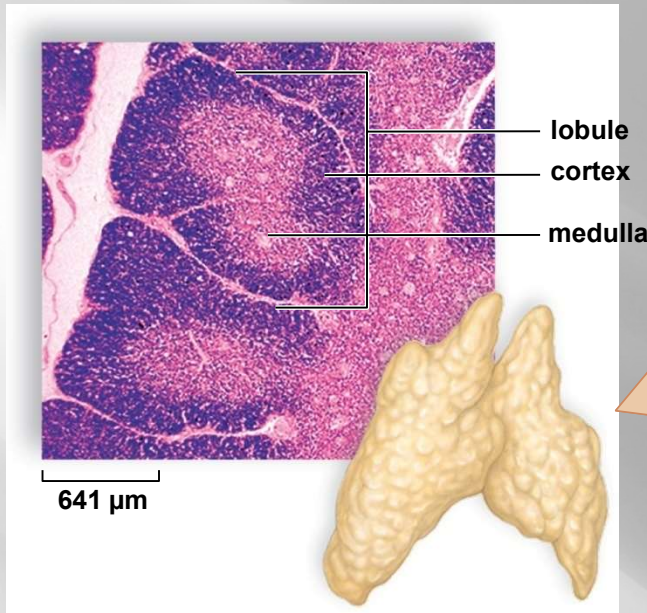
- Immune System: Cells, tissues, and molecules that mediate resistance to infections
- Immunology: Study of the structure and function of the immune system
- Immunity: Resistance of a host to pathogens and their toxic effects
- Immune Response: Collective and coordinated response to the introduction of foreign substances in an individual mediated by the components of the immune system.

Lymphatic System

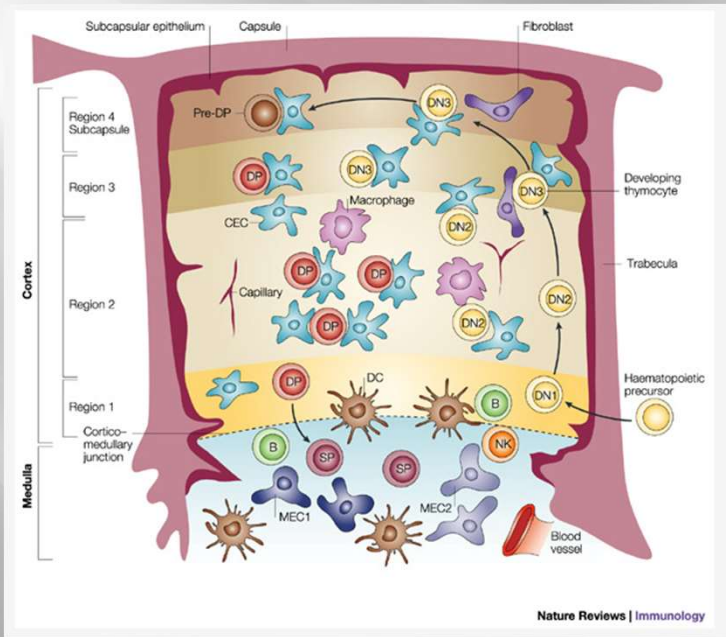
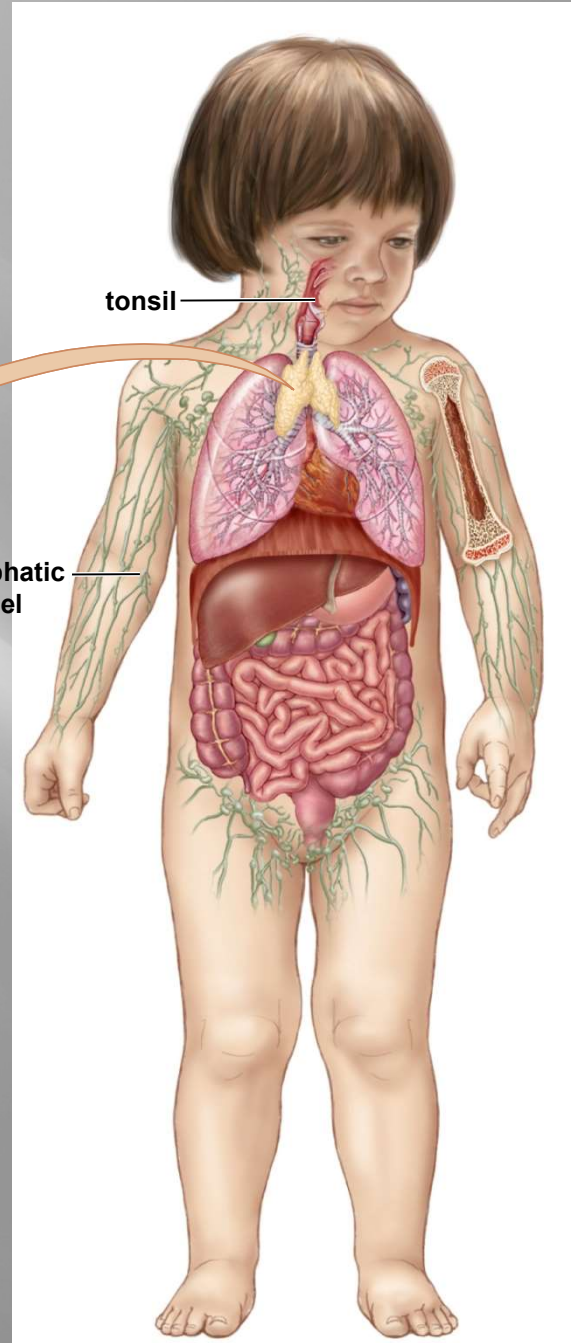
- **Primary** lymphoid organs
 - Red bone marrow
 - Thymus
- **Secondary** lymphoid organs
 - Spleen
 - Lymph nodes

Lymphatic System

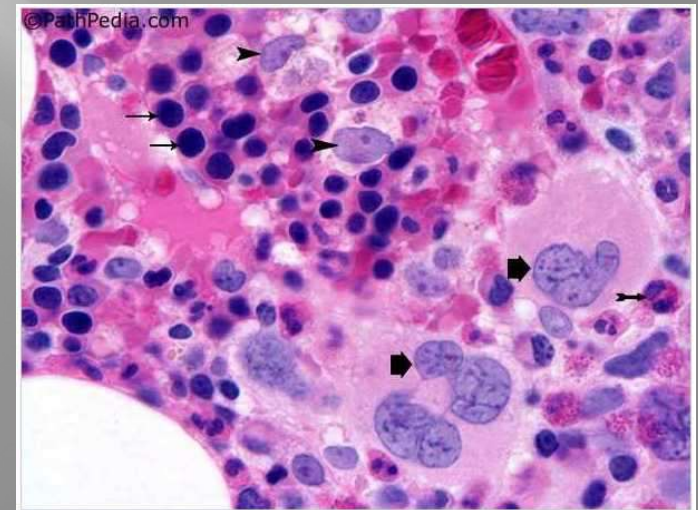
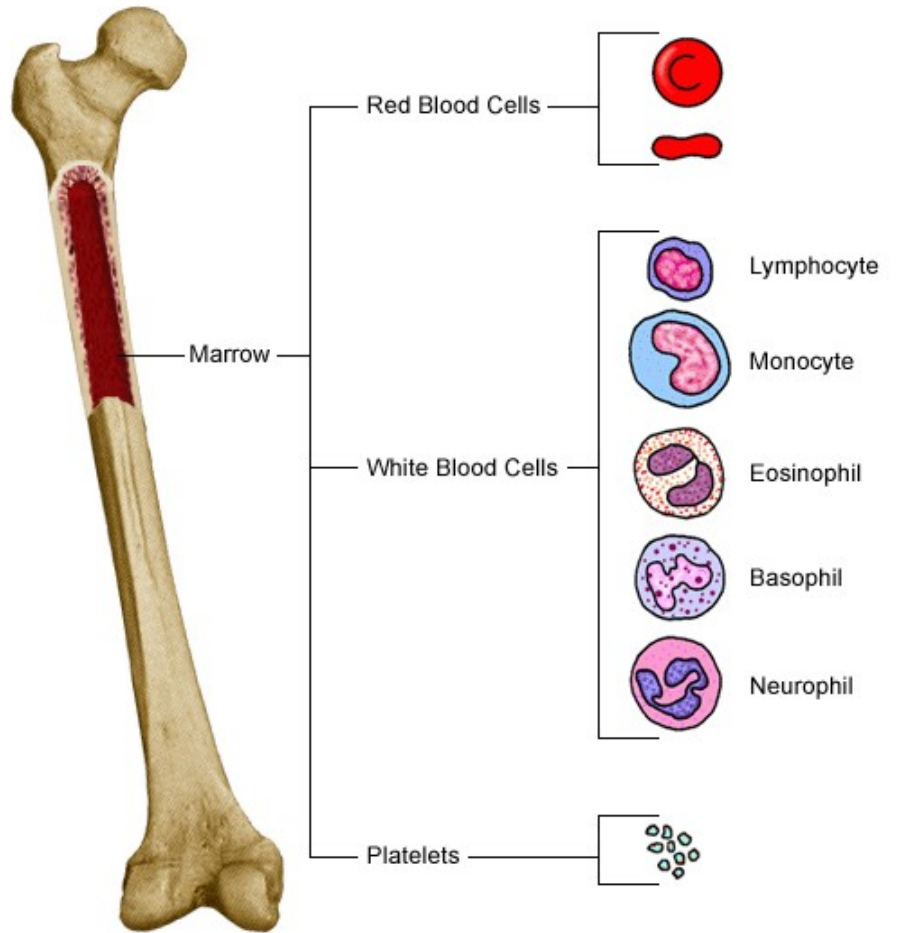




a. Thymus



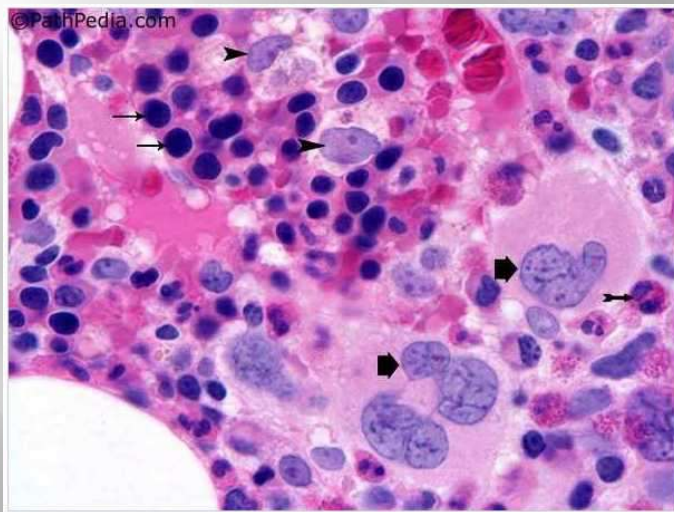
Bone Marrow



Bone Marrow

CHILDREN

- Most bones contain red bone marrow



ADULT

- Present only in the bones of:
 - Skull
 - Sternum
 - Ribs
 - Clavicle
 - Pelvic bones
 - Vertebral column

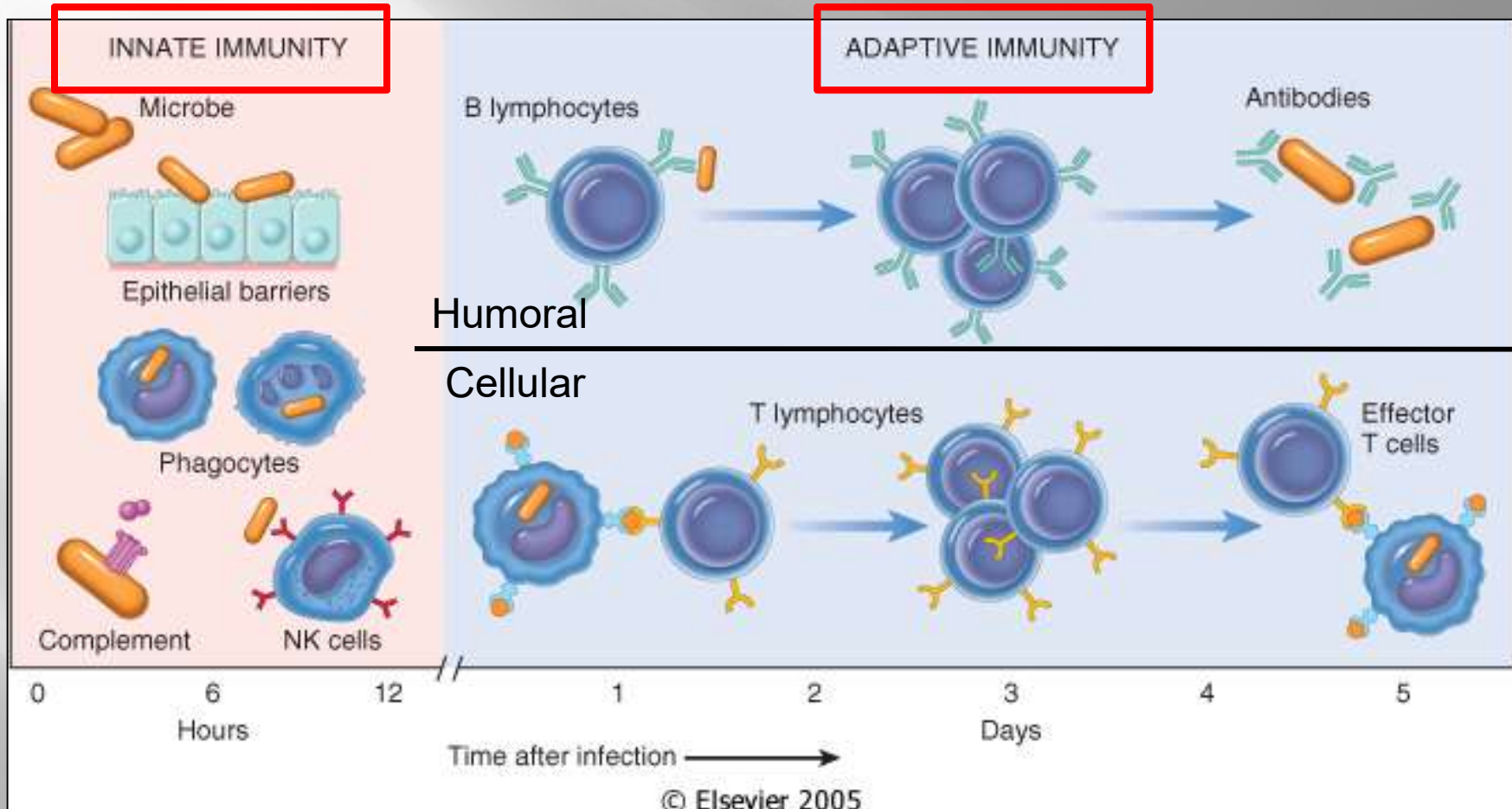
Characteristics of Innate and Adaptive Immunity

Characteristic	Innate	Adaptive
Species	All metazoans	Vertebrates only
Specificity	Molecular patterns	Pathogen specific
Chronology	Immediate	Days-weeks
Antigen contact	Irrelevant	Required
Memory	<i>No</i>	<i>Yes</i>

Arms of the Immune System

Broad range

Highly specific



Innate and Adaptive Immunity

- **Immunity** is the body's capability of removing or killing foreign substances, pathogens, and cancer cells
- **Innate immunity** mechanisms are fully functional **without previous** exposure to an unwanted substance
- **Adaptive immunity** is **dependent upon exposure** to specific **antigens**
 - **Antigen:** *Any molecule that stimulates an immune response*

Innate immunity

- Inborn
- First line of defense
- Components:
 - Physical barriers
 - Macrophages, natural killer cells, antigen-presenting cells
 - Soluble mediators

Innate Immunity

- **Physical and Chemical Barriers**
 - **Skin** and **mucous membranes** are mechanical barriers
 - Upper respiratory tract has **cilia** to remove mucus and trapped particles
 - **Oil glands** in the skin secrete chemicals to weaken or kill some bacteria
 - Stomach is acidic
 - Normal bacteria in the intestines and other areas out compete potential pathogens

Innate Immunity

- **Inflammation**
 - Inflammatory reaction caused by physical or chemical **damage to tissue**
 - Tends to wall off infections and increase exposure to immune system
 - **Four signs**
 - Redness, heat, swelling, and pain
 - Inflammatory reaction that persists may become harmful

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Adaptive [Acquired] Immunity

- **Antigen**
 - A substance (molecule) that the body identifies as **foreign** and it mounts an immune response.
 - It is also known as an immunogen
 - Most antigens are **proteins** and their structure is complex. Large proteins may have several epitopes or antigenic determinants
 - Some are glycoproteins, nucleoproteins, or polysaccharides.

Adaptive [Acquired] Immunity

- **Antibody**
 - Antibodies are molecules that are produced as a response to foreign invaders
 - It is **specific for an antigen**
 - It has the capacity to **bind to the antigen.**

Adaptive [Acquired] Immunity

- **Adaptive Immunity**
 - These defenses **do not** ordinarily react to our own normal cells
 - Immune system is able to distinguish “**self**” from “**non-self**”
 - Usually take **5 to 7** days to become fully activated
 - *The immunity may last for years*

Adaptive [Acquired] Immunity

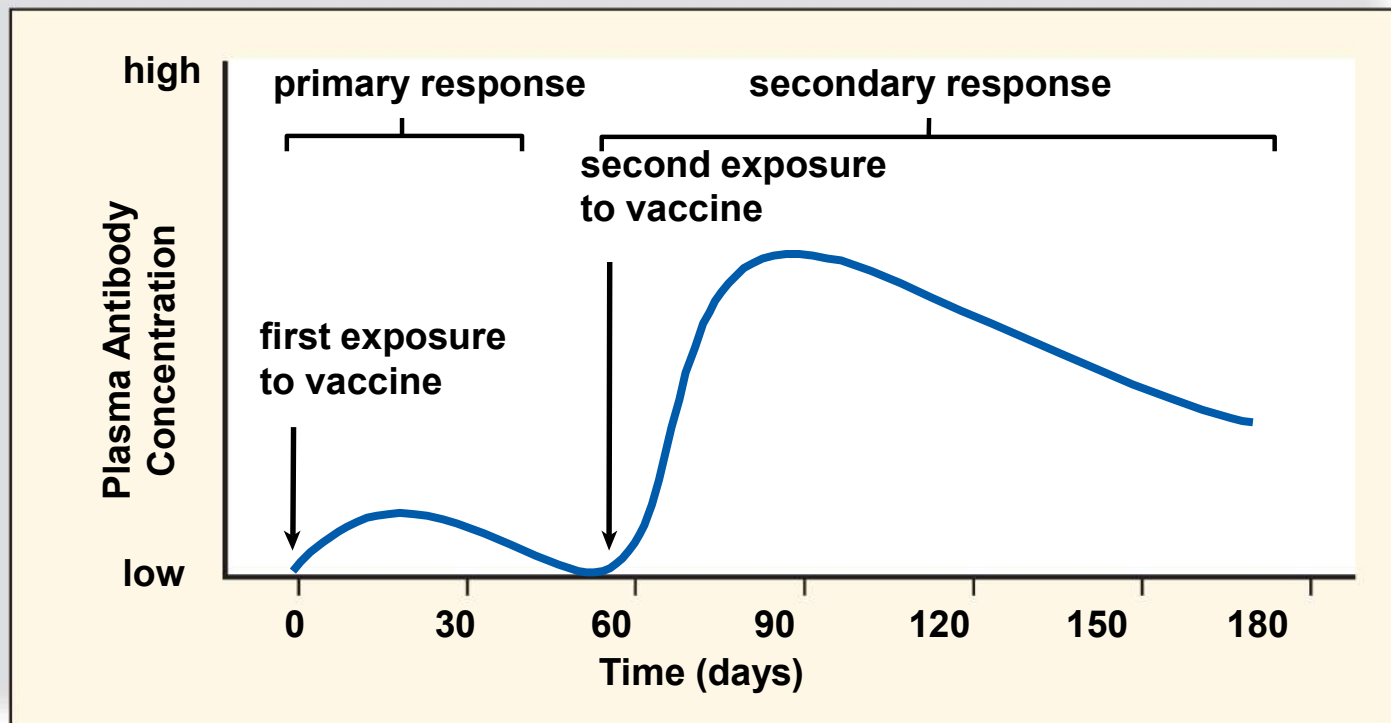
- **B cells**
 - Give rise to plasma cells which **produce antibodies**
 - Antibodies combine with and **neutralize** particular antigens hence the term **neutralizing antibodies**.
 - After the binding of the antigen to the antibody, the B cells process the antigen by breaking it into tiny fragments.
- **T cells**
 - **Do not** produce antibodies
 - Differentiate into
 - **Helper T cells** - release chemicals [cytokines] to regulate immune system
 - **Cytotoxic T cells** - attack and kill virus-infected or tumor cells

What is a Vaccine?

- **Vaccine:** A preparation of microorganisms (e.g., bacterium, virus), or their antigenic components administered for the prevention, amelioration or treatment of an infectious disease
 - Biologic preparation that elicits immune response with **memory**
 - Generates **humoral** (antibody) and/or **cellular** (cytotoxic or killer T-cell) response to eliminate pathogen or pathogen infected cell
 - The immune system is then **primed** to mount a **secondary immune** response with strong and immediate protection upon **future exposure** to the pathogen

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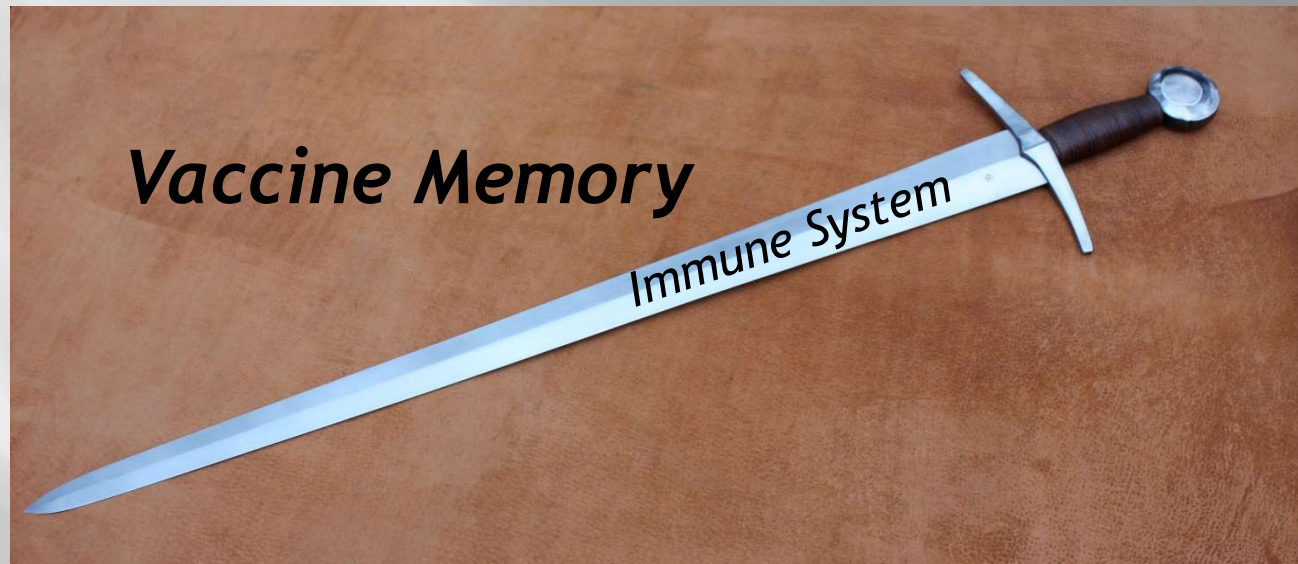


- Follow immune response using antibody titer
 - 1st exposure - titer rises slowly
 - 2nd exposure - titer rises rapidly and to a higher level

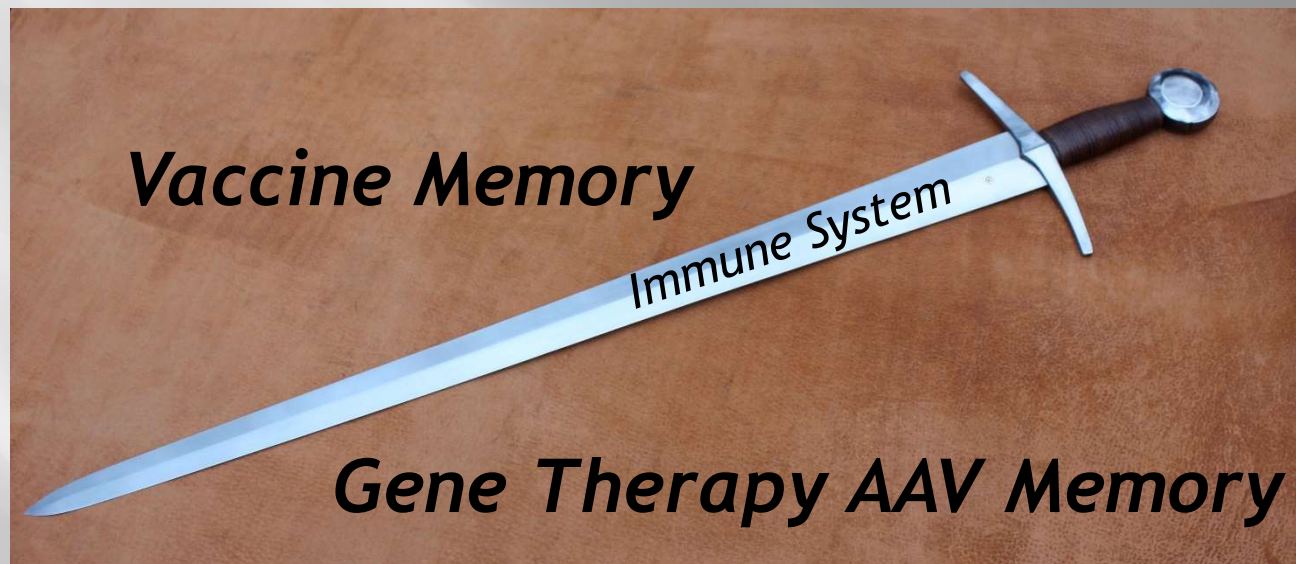
Memory: The Two-Edged Sword



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Memory: The Two-Edged Sword



Vaccines: Forms

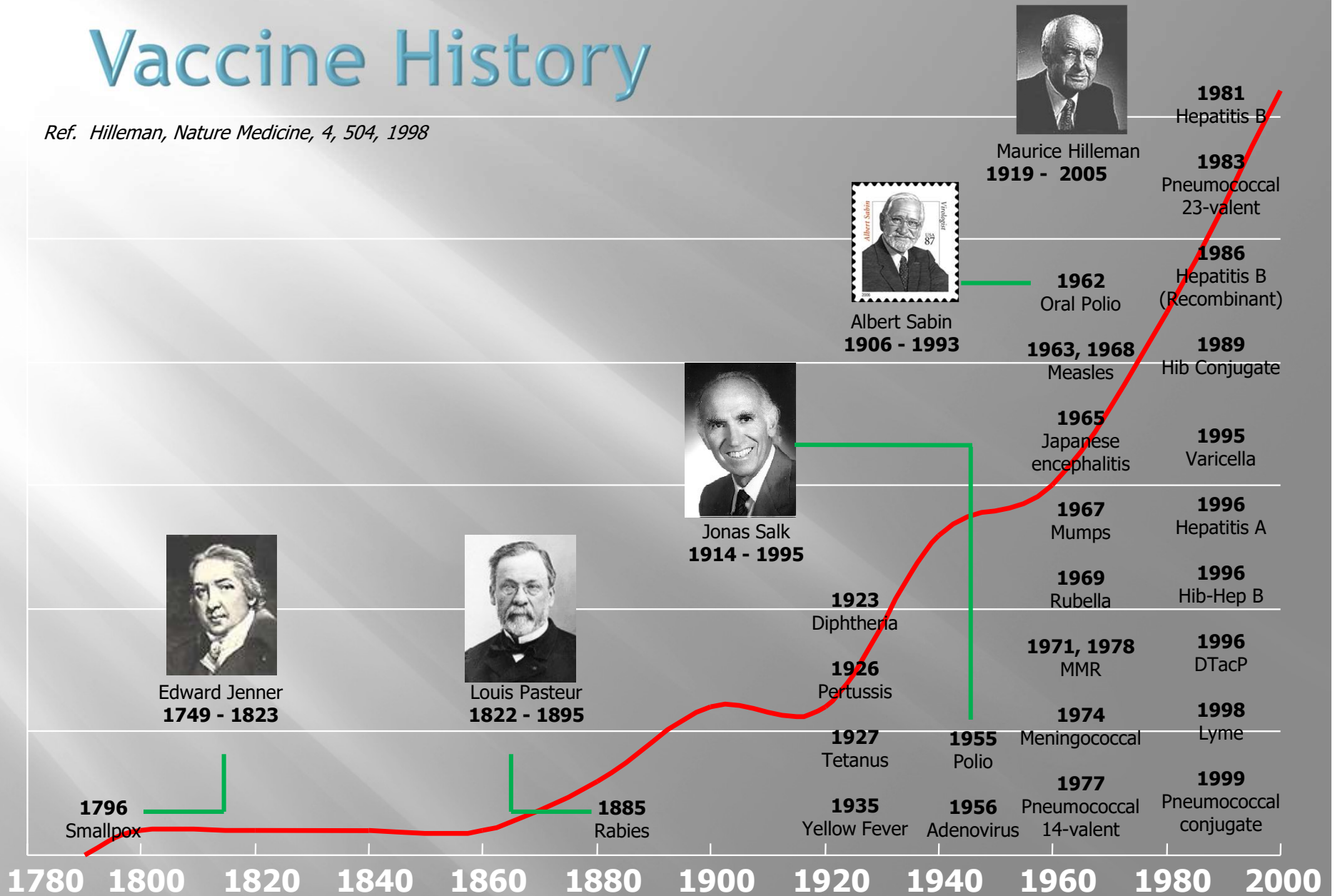
- **Vaccines**
 - Attenuated: M-M-R, Rotavirus, Varicella, Zostavax
 - Killed or Inactivated: IPV, HepA, Flu
 - Toxoids: Diphtheria, Tetanus
 - Sub-unit: HepB, acellular Pertussis, HPV
 - Vector-based vaccine: Canary pox, Adenovirus,
 - DNA: In research phase
 - Peptide vaccine: Epitope vaccine, peptide immunogens (HER-2/neu);

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Vaccine History

Ref. Hilleman, *Nature Medicine*, 4, 504, 1998



Historical Perspective

- Smallpox
- Pertussis
- Polio
- Hepatitis B
- Influenza



Portrait eines Cholera-Präservativ-Mannes.
nach Saphir.

Die Cholera, welche in Asien, Afrika, und Amerika vorkommt, ist eine sehr gefährliche Krankheit, die in kurzer Zeit das Leben raubt. Sie ist durch einen bestimmten Stoff, den Cholera-Präservativ, zu vermeiden. Dieser Stoff wird in kleinen Dosen eingenommen, und bewirkt, dass der Körper sich gegen die Cholera-Keime schützt. Die Cholera-Präservativ-Männer sind daher sehr geschätzt, da sie den Menschen vor dieser Krankheit bewahren. Sie tragen einen besonderen Hut, um sich vor der Cholera zu schützen, und sind immer bereit, den Menschen zu helfen. Die Cholera-Präservativ-Männer sind daher sehr wichtig für die Gesundheit der Menschheit.



Portrait einer Cholera-Präservativ-Frau.
von G. Wagner.

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Protection from Cholera

Picture courtesy of Wellcome Library, London

Smallpox - 1796

Live Virus

- 1796 - Edward Jenner
 - Vaccine made from pus of cowpox patients and milk maids
 - Coined the term “vaccination”
 - First recognized use of a vaccine

- *No purification!*



Smallpox - 1796

Live Virus

- 17th century Chinese practice
 - Vaccinating with scabs from smallpox patients
- 1796 - Edward Jenner
 - Vaccine made from pus of cowpox patients and milk maids
 - Coined the term "vaccination"
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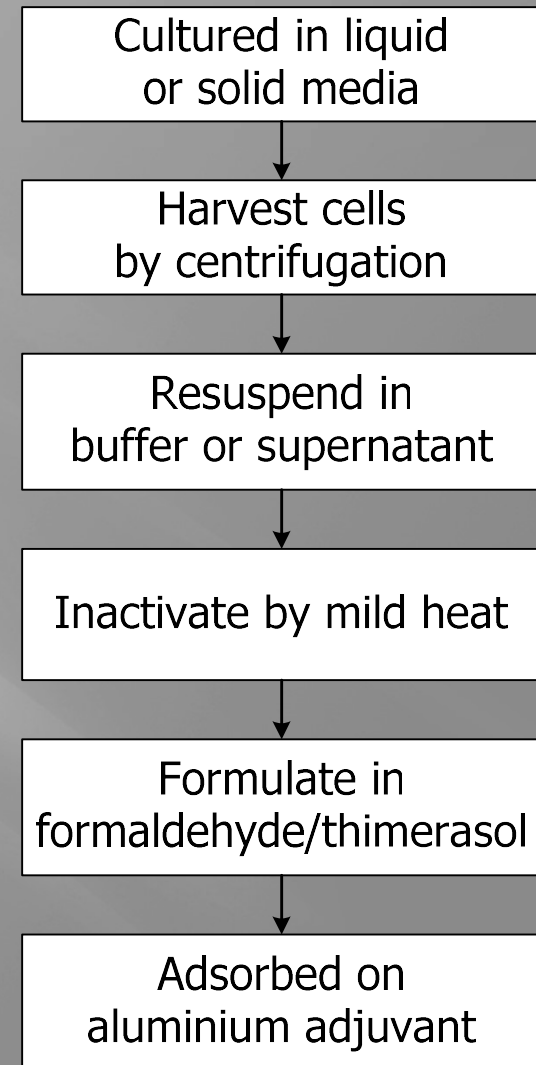


11 Substances in development: Antivirals and Vaccines

Pertussis (1914)

Inactivated Bacteria

- **Whooping cough** caused by *B. pertussis*, a small gram-negative bacteria
- Vaccine - suspension of killed whole cells of bacteria
- Whole cell pertussis vaccine first licensed in the US in 1914
 - Later combined with diphtheria and tetanus toxoids (DTP) in 1942
- Lack of purity caused some side effects
 - Led to the development of acellular pertussis (subunit vaccine)



Polio Vaccines

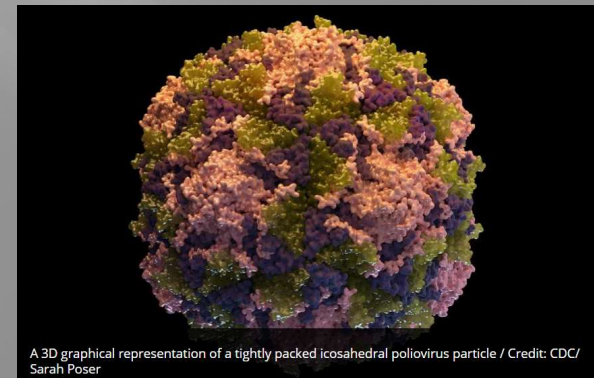
Inactivated and Live Attenuated Viruses



An Egyptian stele thought to represent a polio victim, 18th Dynasty (1403-1365 BC)



A girl with a deformity of her right leg due to polio



A 3D graphical representation of a tightly packed icosahedral poliovirus particle / Credit: CDC/ Sarah Poser

Polio Vaccines

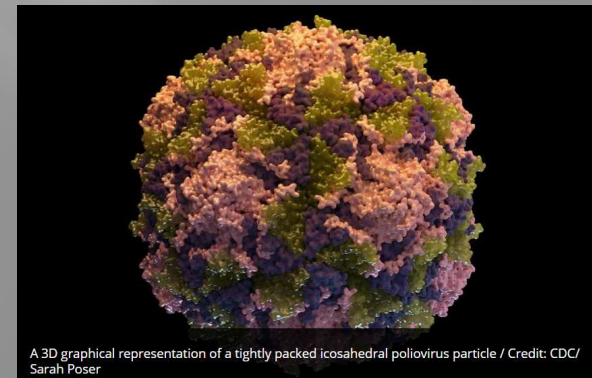
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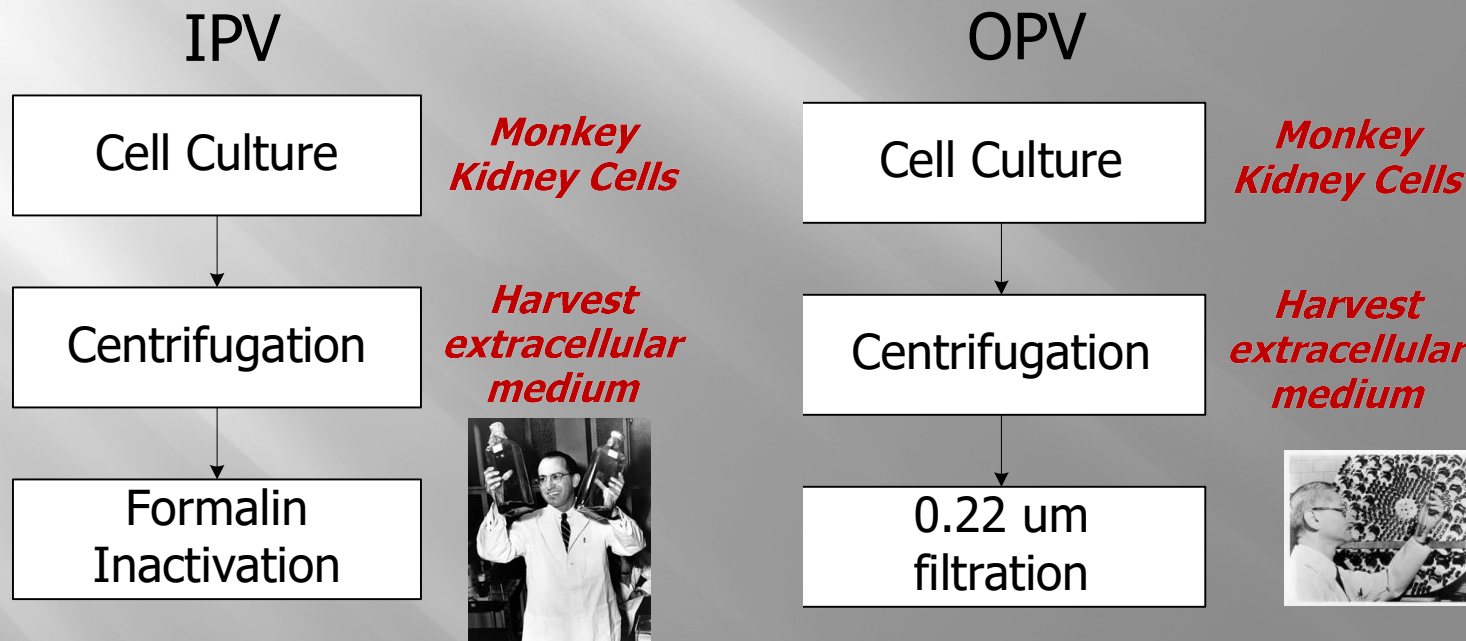


A 3D graphical representation of a tightly packed icosahedral poliovirus particle / Credit: CDC/ Sarah Poser

Polio Vaccines

Inactivated and Live Attenuated Viruses

- *Enders* successfully cultivated virus in tissue culture (1949)
- Inactivated virus developed by *Salk* (1955)
- Oral polio (Live virus) developed by *Sabin* (1963)
 - Less expensive and simple to use



Ref. Salk, JAMA, 151, 1081, 1953

Ref. Aunins, in Encyclopedia of Cell Tech., Ed. Spier, Wiley & Sons, NY, 2000

Polio Vaccines

Inactivated and Live Attenuated Viruses

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- Inactivated virus developed by *Salk* (1955)



IPV

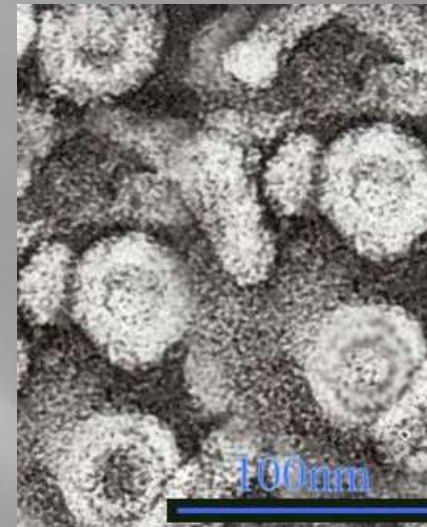


- Cutter departed from Salk's safe production protocols
- Lots of vaccine shipped containing live virus
- 40,000 children became ill
- 200 permanently paralyzed
- 10 died
- Tests for live virus were not sensitive enough

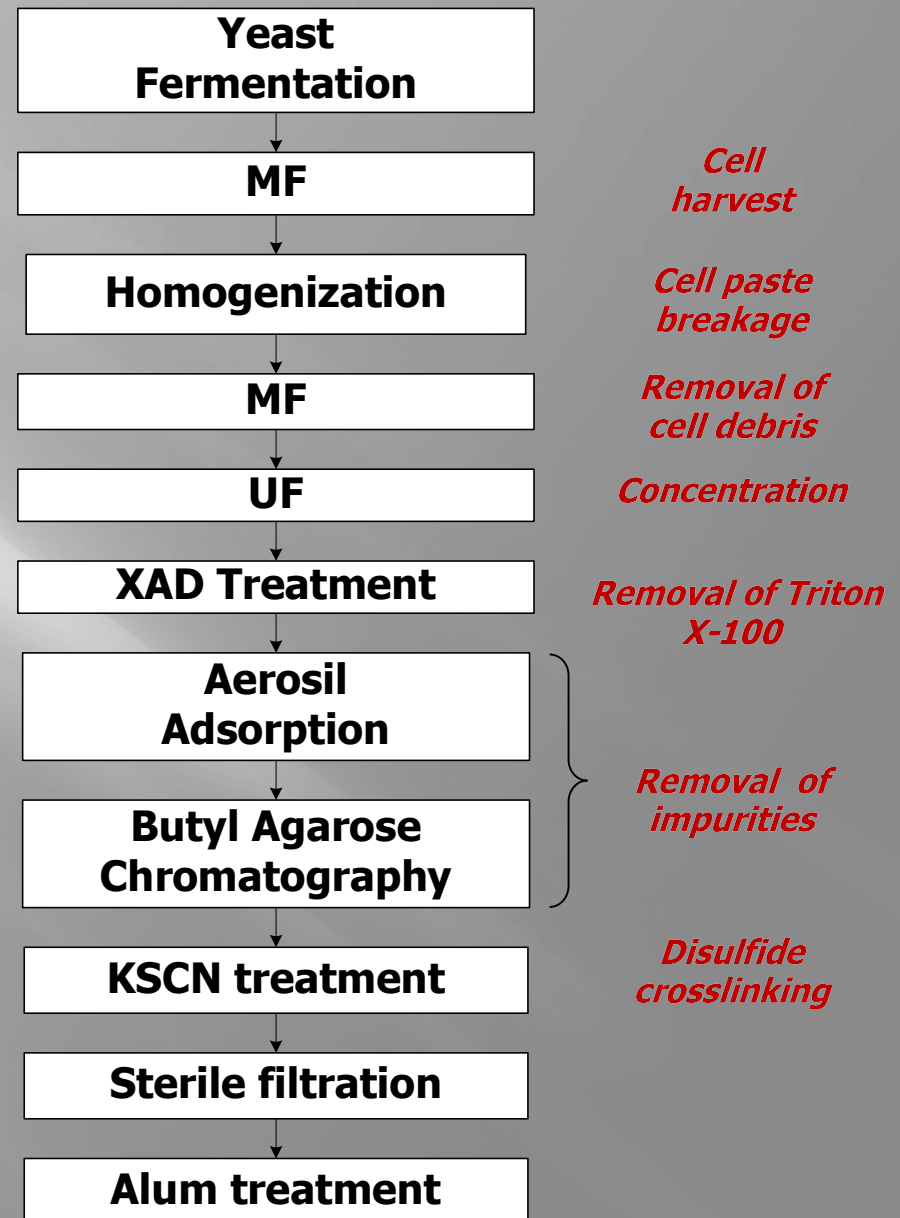
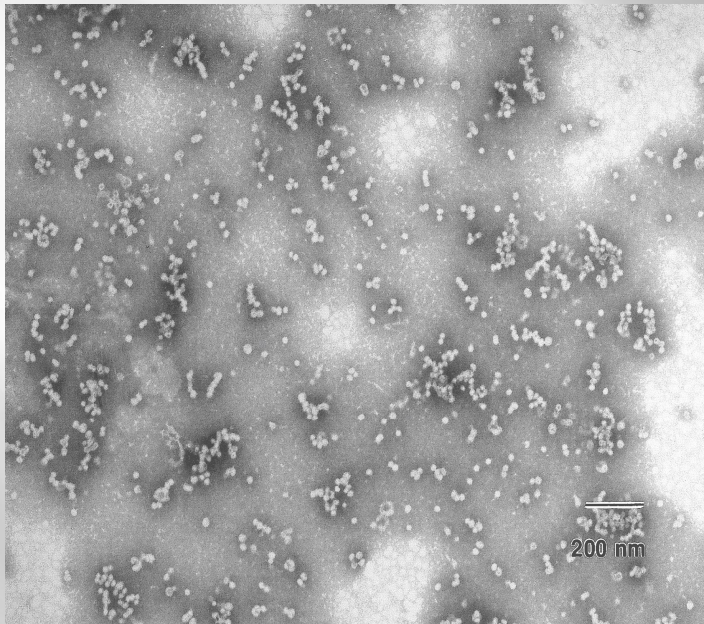


HEPATITIS B DISEASE

- Abdominal pain
- Dark urine
- Fever
- Joint pain
- Loss of appetite
- Nausea and vomiting
- Weakness and fatigue
- Yellowing of your skin and the whites of your eyes (jaundice)



Hepatitis B (1986) RECOMBIVAX-HB®



Ref. Sitrin et al., in Hepatitis B Vaccines in Clinical Practice, Ed. Ellis, R. W., Marcel Dekker, NY, 1993

Chromatography



Centrifugation



Centrifugation



Centrifugation



... to viral vaccine manufacture



K3 rotor

**INFLUENZA VIRUS VACCINE
K3 ROTOR**
System: KII
Rotor: K3 (2,2 L)
Flow rate: 20 L/h
Gradient: 0-65% (w/w) sucrose
Volume: 150 L
Capture rate: 95%
Recovery: 70%
Purification factor: x 60

**RABIES VIRUS VACCINE
K3 ROTOR**
System: KII
Rotor: K3 (2,2 L)
Flow rate: 16 L/h
Gradient: 0-65% (w/w) sucrose
Volume: 40 L
Capture rate: 95%
Recovery: 90%
Purification factor: x 60

... to viral vector manufacture

**ADENOVIRUS VECTOR
K3 ROTOR**
System: P10
Rotor: FK3 - 1600
Flow rate: 10 L/h
Gradient: 0-40% Nyodenz
Volume: 20 L
Capture rate: 95%
Recovery: 70%
Purification factor: x 20



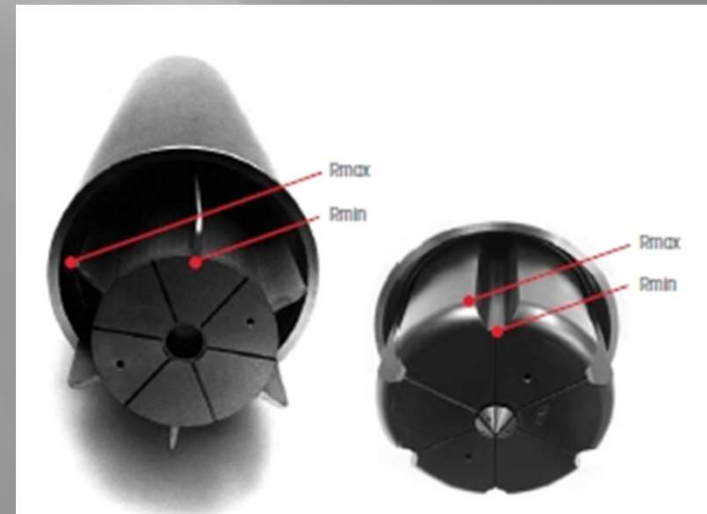
K5 rotor

**HEPATITIS B
K5 ROTOR**
System: KII
Rotor: K5
Flow rate: Batch
Gradient: 0-55% (w/w) sucrose
Volume: 5 L
Capture rate: 100%
Recovery: 85%
Purification factor: x 10

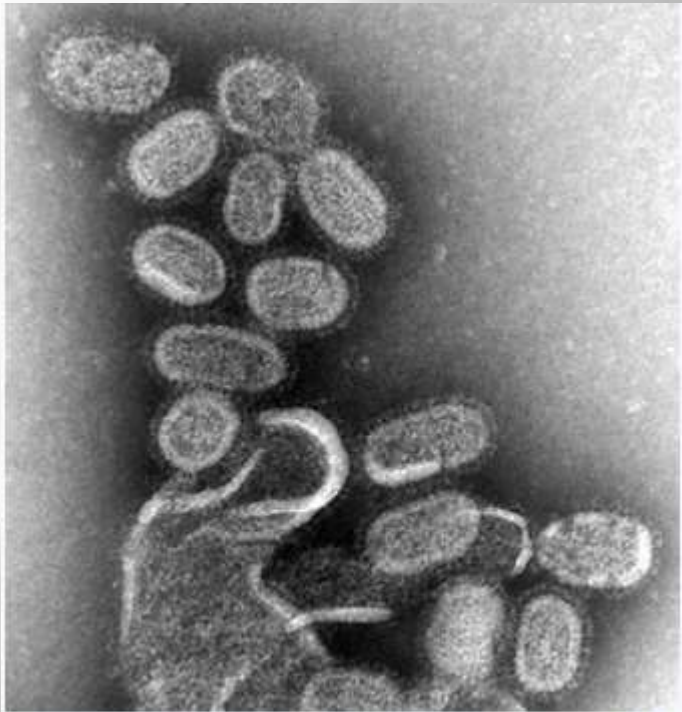
Protocols using the KII Centrifuges

EXAMPLES OF VIRUS ISOLATION PROTOCOLS

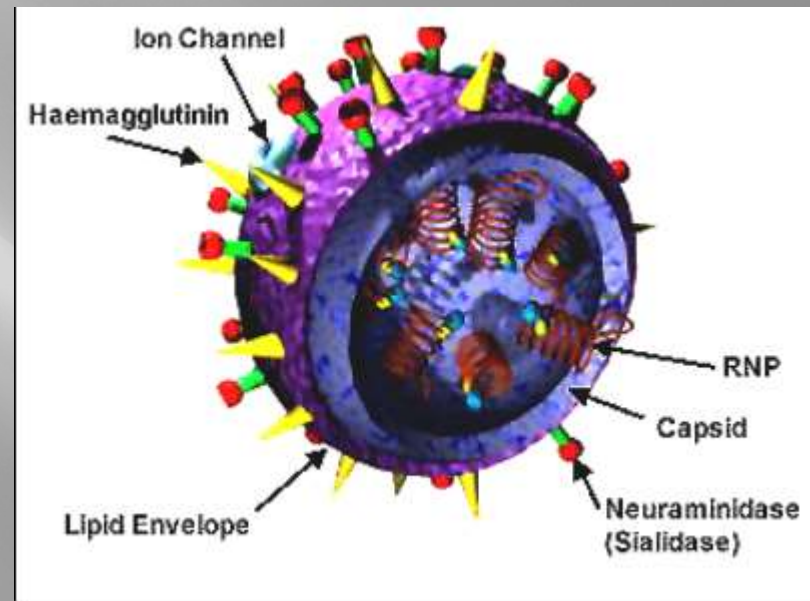
ADENOVIRUS - Adenoviridae
HEPATITIS B - Hepanoviridae
HBV - Herpesviridae
INFLUENZA - Orthomyxoviridae
RABIES - Rhabdoviridae
NDV, MUMPS - Paramyxoviridae
RSV, MLV, MOMV, AKRMV - Betanoviridae
JAPANESE ENCEPHALITIS - Flaviviridae
POLIO - Picornaviridae
VACCINIA - Poxviridae



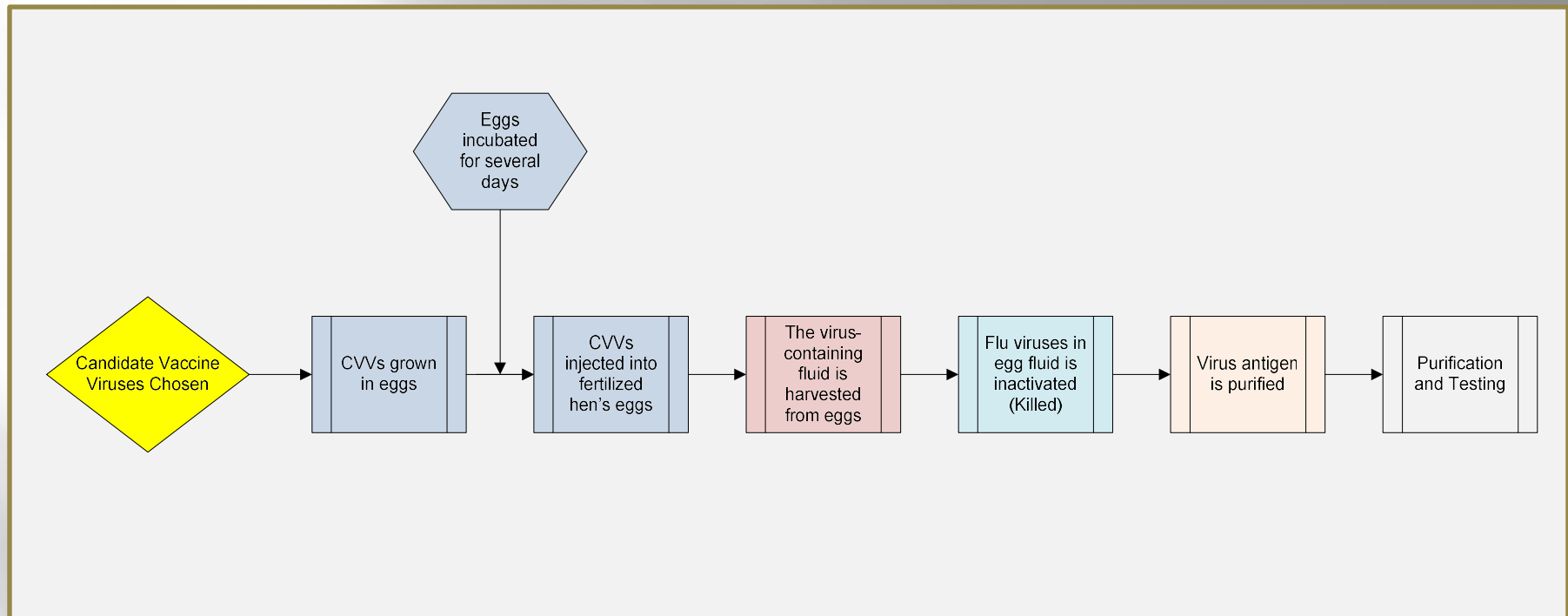
Influenza



Influenza virus, magnified approximately 100,000 times

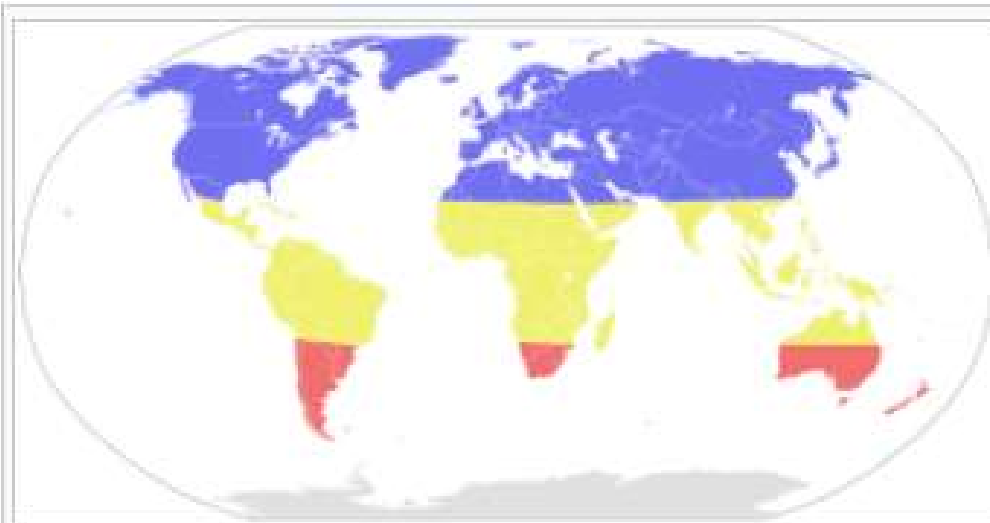


Flu Vaccine Production



Source: CDC

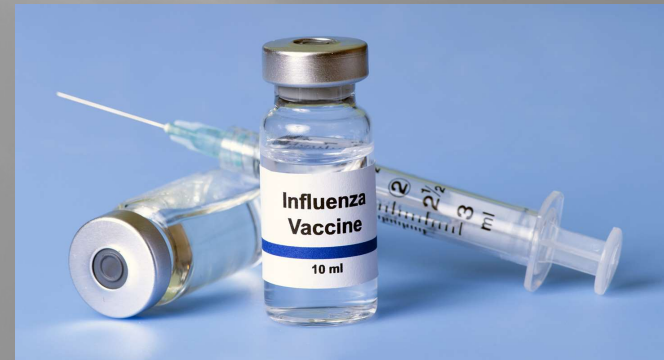
Influenza



Seasonal risk areas for influenza: November-April (blue), April-November (red), and year-round (yellow).



Flu Vaccine Production



Methodology for Production: Current and Future Techniques

sanofi pasteur
Egg-based Facility
No bioreactors - 600K eggs/day
100M doses/year
140K square feet
\$150M
Existing site and infrastructure



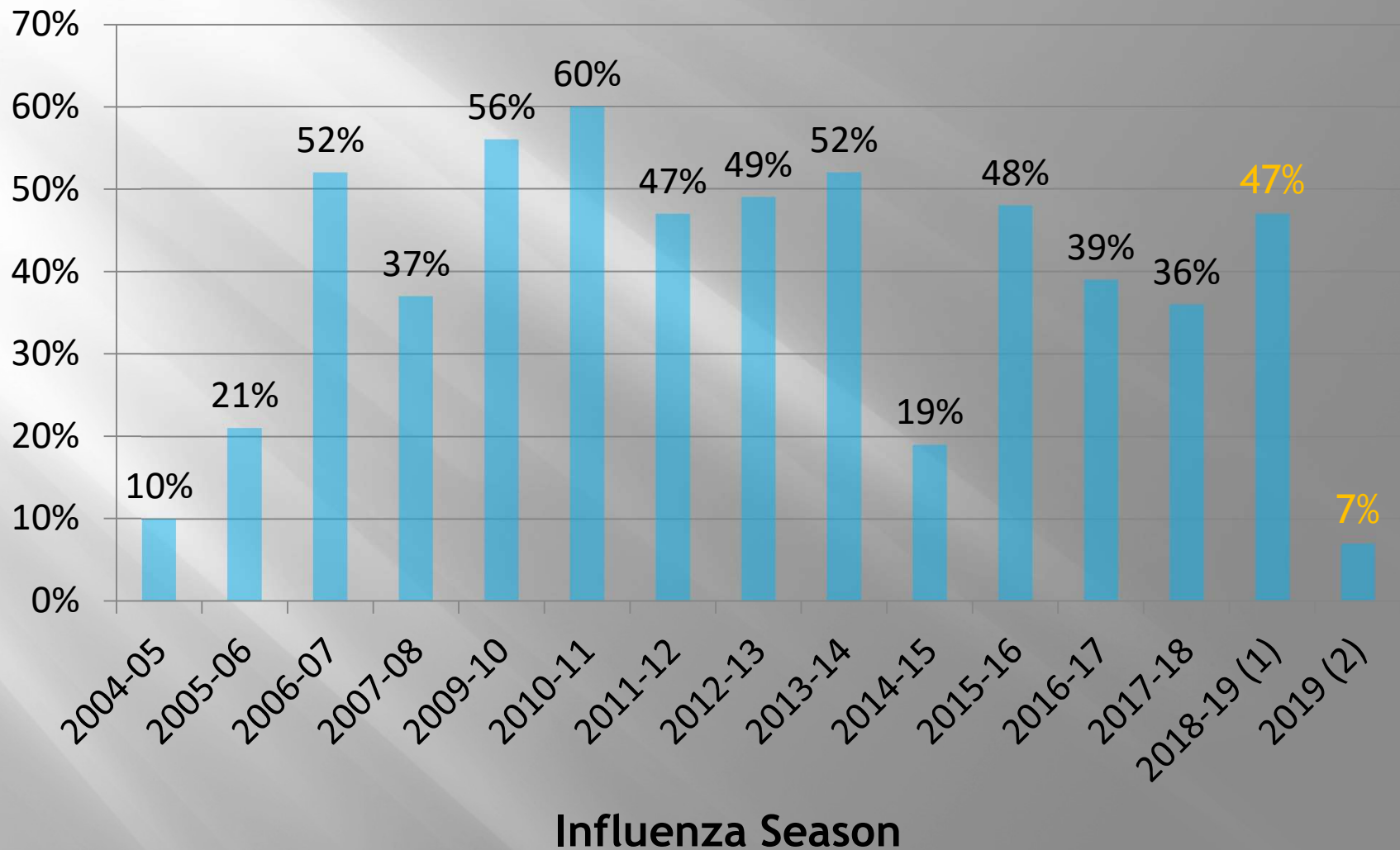
From Clone to Commercial®

Ref: J. Trazzino, BIO2010

> BioProcess
Technology
Consultants®

Adjusted Vaccine Efficacy for Flu Vaccine

Adjusted Overall Vaccine Efficacy



Source: CDC

Flexible Facilities: The Future?

- **Seqirus/CSL (Holly Springs, NC)**
 - Growing flu vaccine in canine kidney cells
 - Capacity of 200 MM doses in 6 months
 - 20 MM doses to be made this year
 - US HHS contributed \$700MM to facility construction
 - 1/2 the cost (\$3.50 for egg-based) of traditional vaccine
 - Approved by FDA in May 2016 (4 strain vaccine)
- **Protein Sciences (Rockland County, NY)**
 - Cells from caterpillars
 - Faster than egg-based systems
 - However, 5-10X the cost of egg-based vaccines.
 - Can make 5MM doses this year but expects to sell only 900,000

Methodology for Production: Current and Future Techniques

sanofi pasteur
Egg-based Facility
No bioreactors - 600K eggs/day
100M doses/year
140K square feet
\$150M
Existing site and infrastructure

Novartis
Mammalian Cell Culture Facility
Stainless steel bioreactors
50M doses/year
140K square feet
\$600M
New site and infrastructure

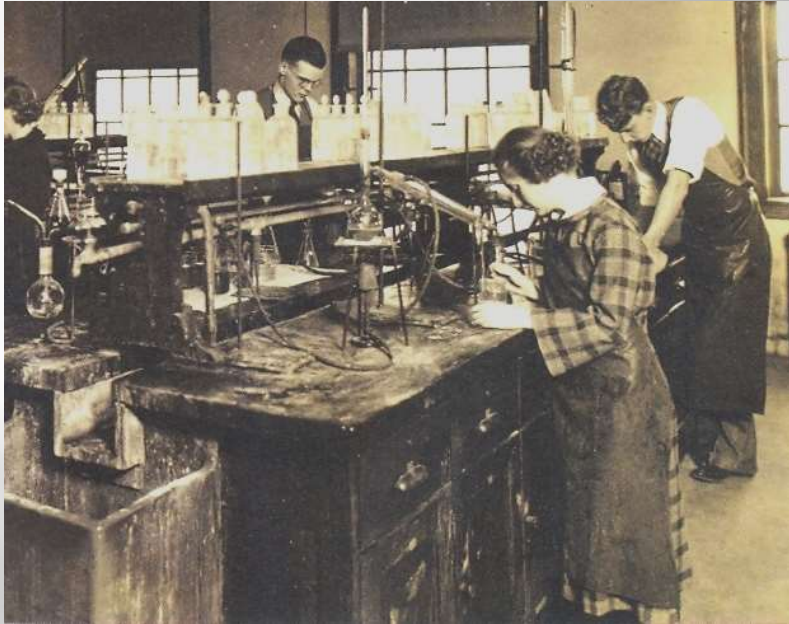
Novavax
Insect Cell Culture Facility
Single-use bioreactor
75M doses/year
55K square feet
\$40M
New site and infrastructure

From Clone to Commercial®

Ref: J. Trazzino, BIO2010

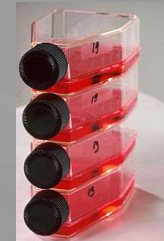
> BioProcess
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Consultants®

How Do You Make This

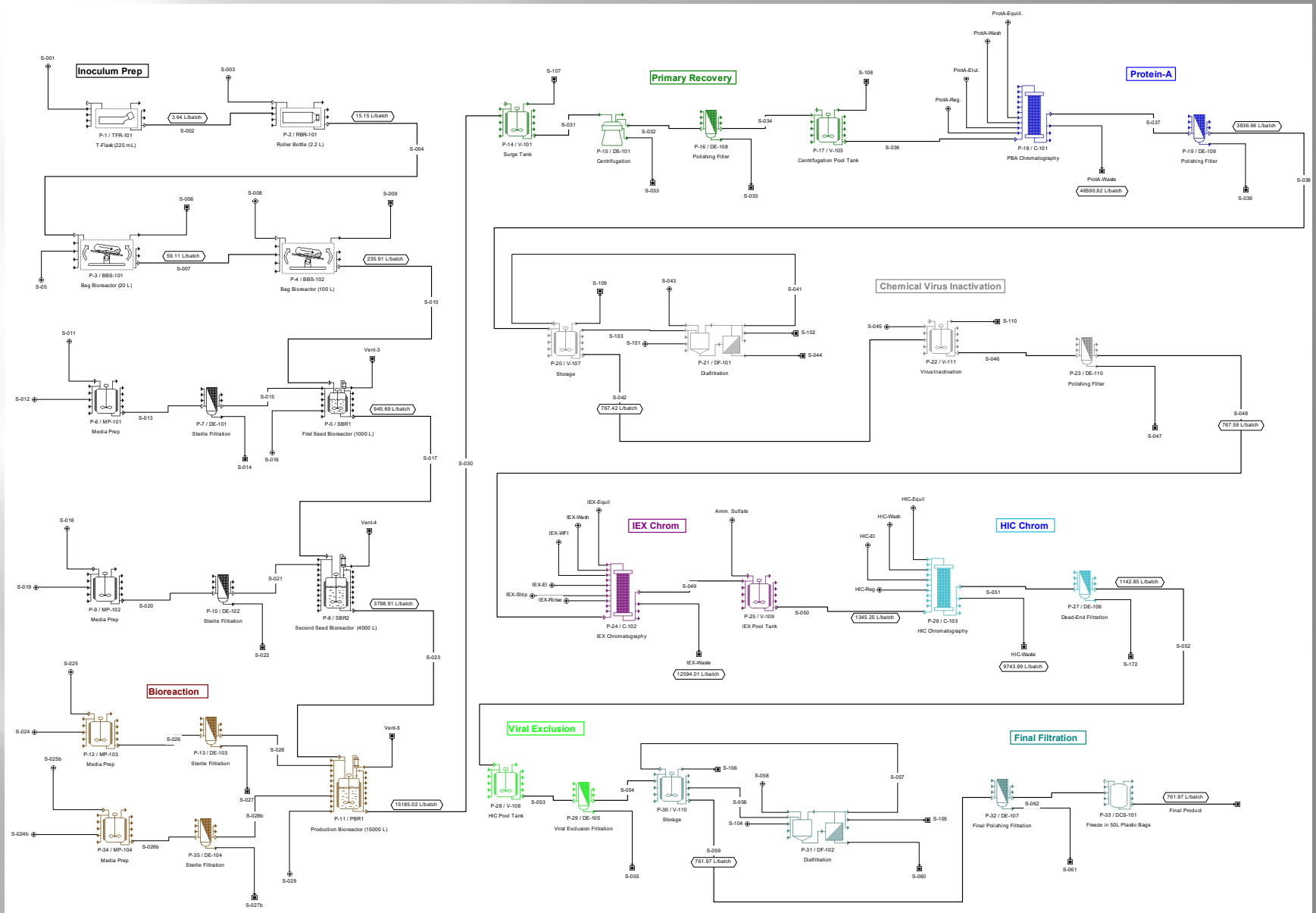


Bioreactor Technologies

- **Small-scale** (<10 L)
 - - Flasks (T-flasks, Erlenmeyer, Spinners)
 - - Roller Bottles
- **Mid-scale** (10 - 250 L)
 - - Roller Bottles (automated handling)
 - - Nunc Cell Factories and Costar Cell cubes
 - - “Small” continuous stirred reactors
 - - Wave Bioreactors



Making a Biologic Product

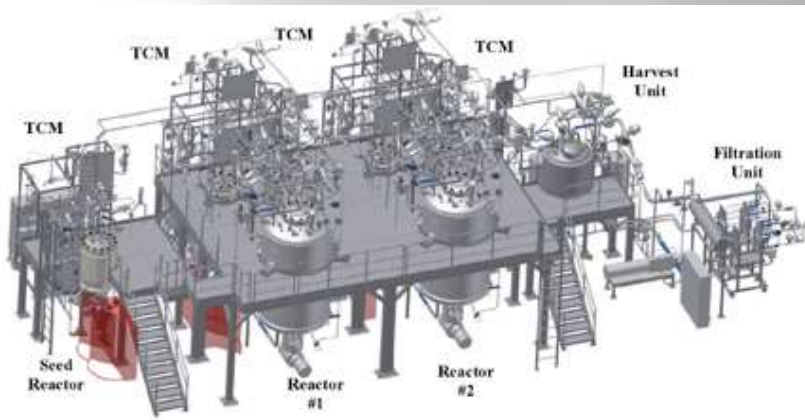




▪ **Large scale** (> 250 L) engineered systems.



*Images: Copyright Sanofi Pasteur , Amgen,
and New York Times*



What's Next?



Emerging Diseases

Chinese Authorities Continue Work To Identify Cause Of Pneumonia Outbreak In Wuhan

[BloombergQuint](#): China Pneumonia Outbreak Widens to 59 Amid Hunt for Source

"A pneumonia outbreak in China that's infected 15 more people doesn't appear to be spreading from human to human, officials said, after ruling out SARS as a potential cause of the mysterious disease. As of Sunday morning, 59 people had been diagnosed with pneumonia, the cause of which is unknown, the Wuhan Municipal Health Commission said in a statement late Sunday. That's up from 44 on Friday..." (Gale, 1/6).

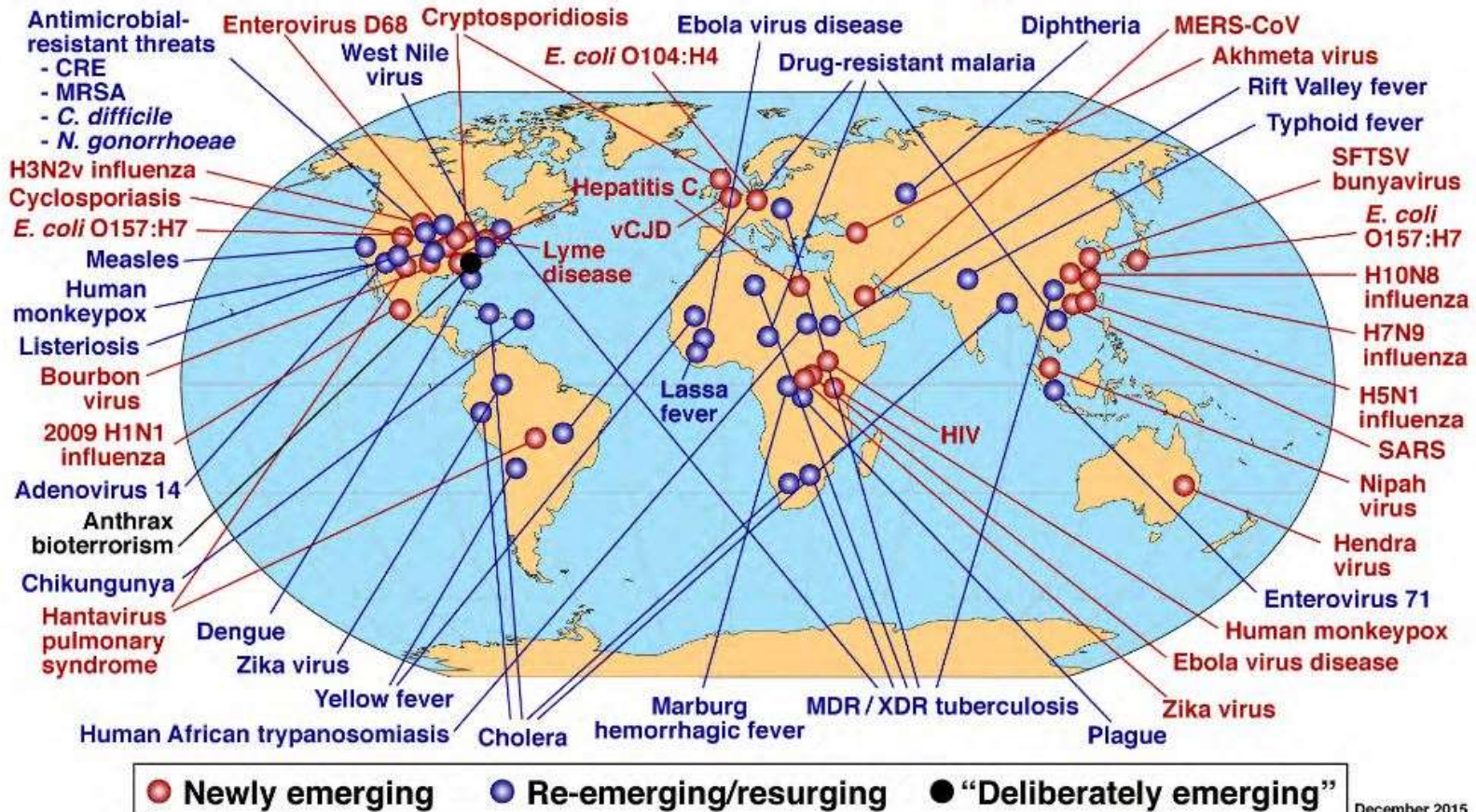
[Reuters](#): Chinese authorities say viral pneumonia outbreak is not SARS, MERS or bird flu

"Chinese healthcare authorities in Wuhan said an outbreak of *viral pneumonia was not Severe Acute Respiratory Syndrome (SARS), Middle East respiratory syndrome (MERS), or bird flu, and that they were still working to identify the cause and source...*" (Li/Woo, 1/5).

[STAT](#): Experts search for answers in limited information about mystery pneumonia outbreak in China

"...*The infections are linked to a large seafood market where it is believed some exotic animals were also sold for consumption.* The World Health Organization has said little about the outbreak beyond that it is in close contact with China authorities on the issue..." (Branswell, 1/4).

Global Examples of Emerging and Re-Emerging Infectious Diseases

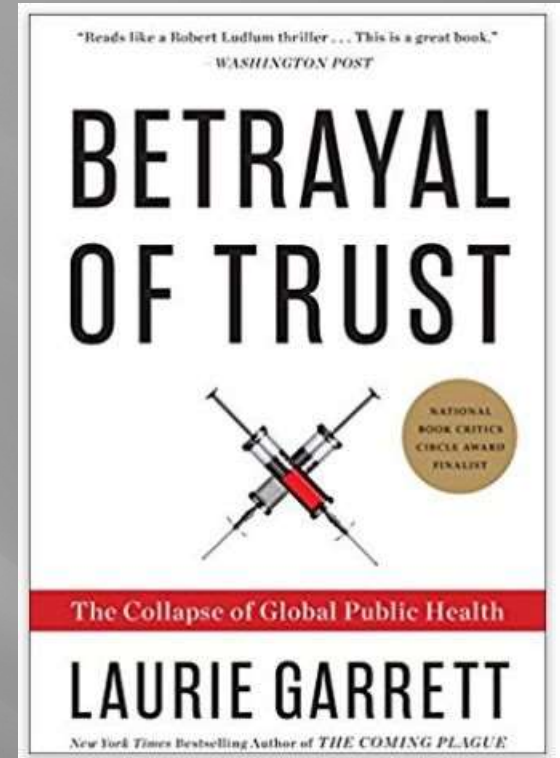
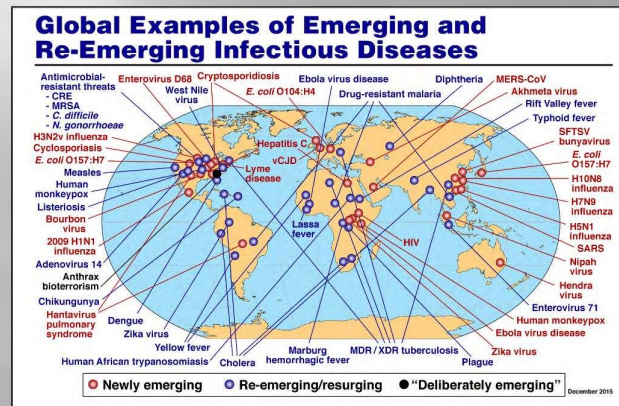
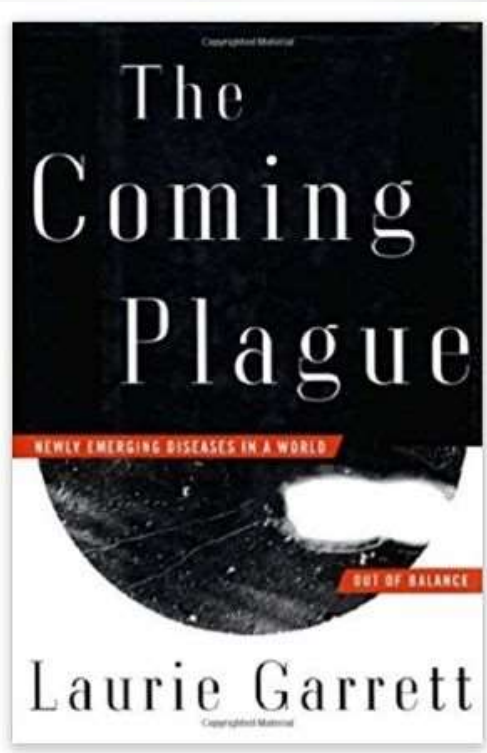


December 2015

Emerging Diseases



Emerging Diseases





▪ **Large scale** (> 250 L) engineered systems.



*Images: Copyright Sanofi Pasteur , Amgen,
and New York Times*

Scaling the Process: Single Use Systems



Source: Xcellerex, Sartorius,
Pall

Flexible Facilities: The Future?

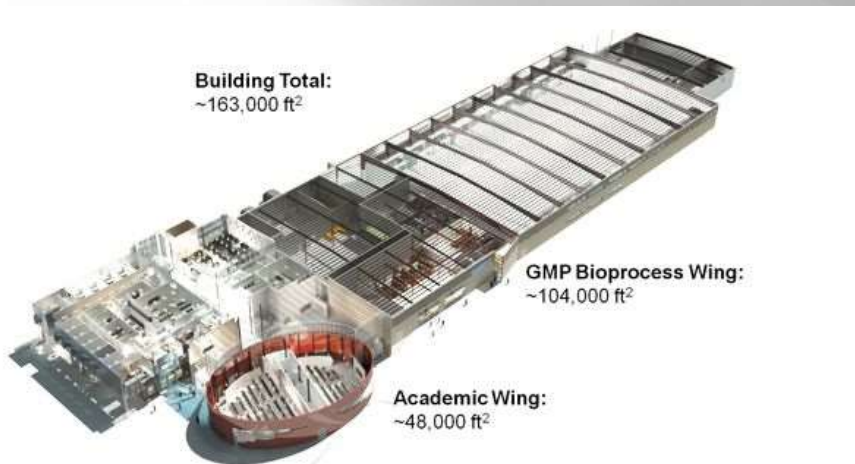
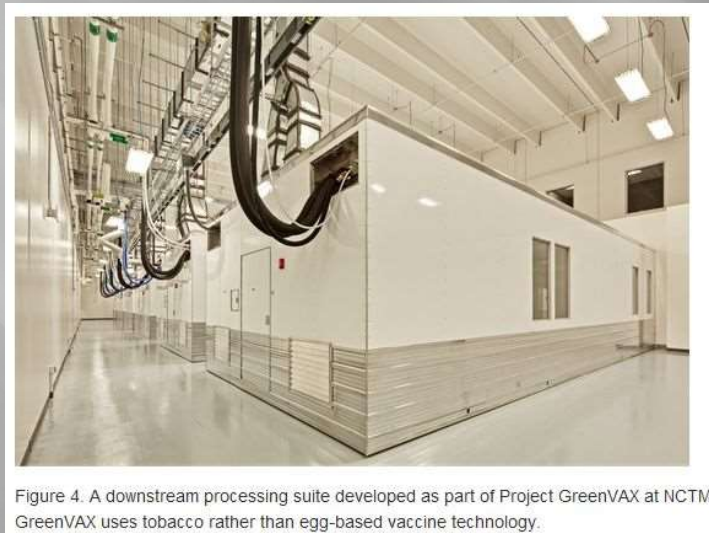
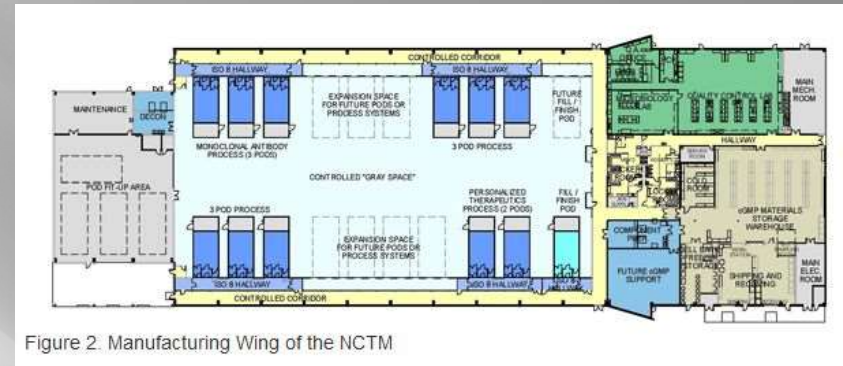


Figure 1. National Center for Therapeutics Manufacturing, designed and built based on Flexible Manufacturing Criteria



The Future of Vaccines





“Predictions are difficult to make, especially about the future”

Yogi Berra

The Future of Vaccines

- Vaccine developers are currently under immense pressure as the uptake of vaccines falls in many countries as a result of negative comments in press stories or misinformed social media exchanges.
- This decreasing appreciation of the benefits and the AEs associated with vaccination programs has converged to create the anti-vaxer movement.
- As a consequence, rubella, mumps and especially measles are re-emerging even though we once thought they were on the path to eradication.

The Future of Vaccines

- The public needs to be better informed about the relevant risk & benefit analyses as they have lost their historical knowledge regarding vaccine preventable diseases.
- It is largely due to childhood vaccination programs with wider public health programs that led to smallpox being eradicated and polio on the verge of extinction.

The Future of Vaccines

- The success of vaccination is troublesome as it is difficult to *celebrate the absence of a disease*.
- This is in sharp contrast to the acceptance and appreciation of antimicrobials as they cure a tangible, frequently visible illness.

The Future of Vaccines

"The Earth is round, gasoline is flammable, and vaccines are safe and effective, all the rest are dangerous lies."

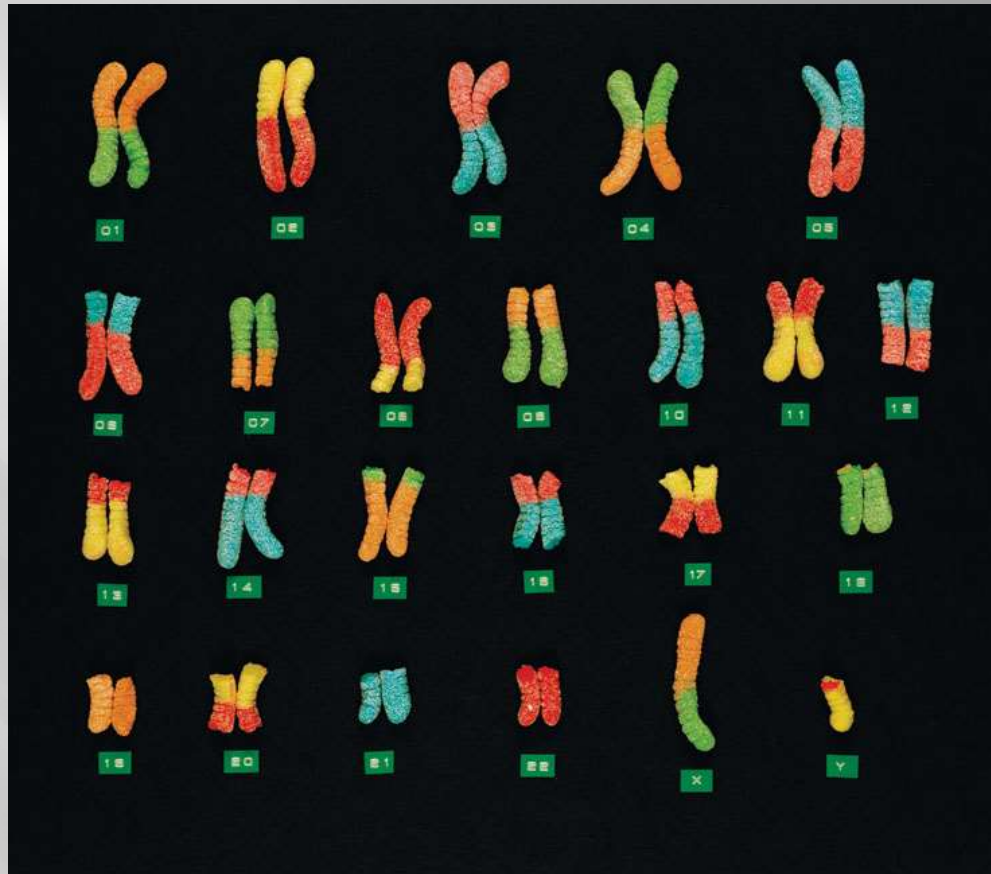
*Roberto Burioni, MD, PhD
Vita-Salute San Raffaele University*

The Future of Vaccines

“ It is hard to un-ring a bell”

*Paul A. Offit, MD
CHOP*

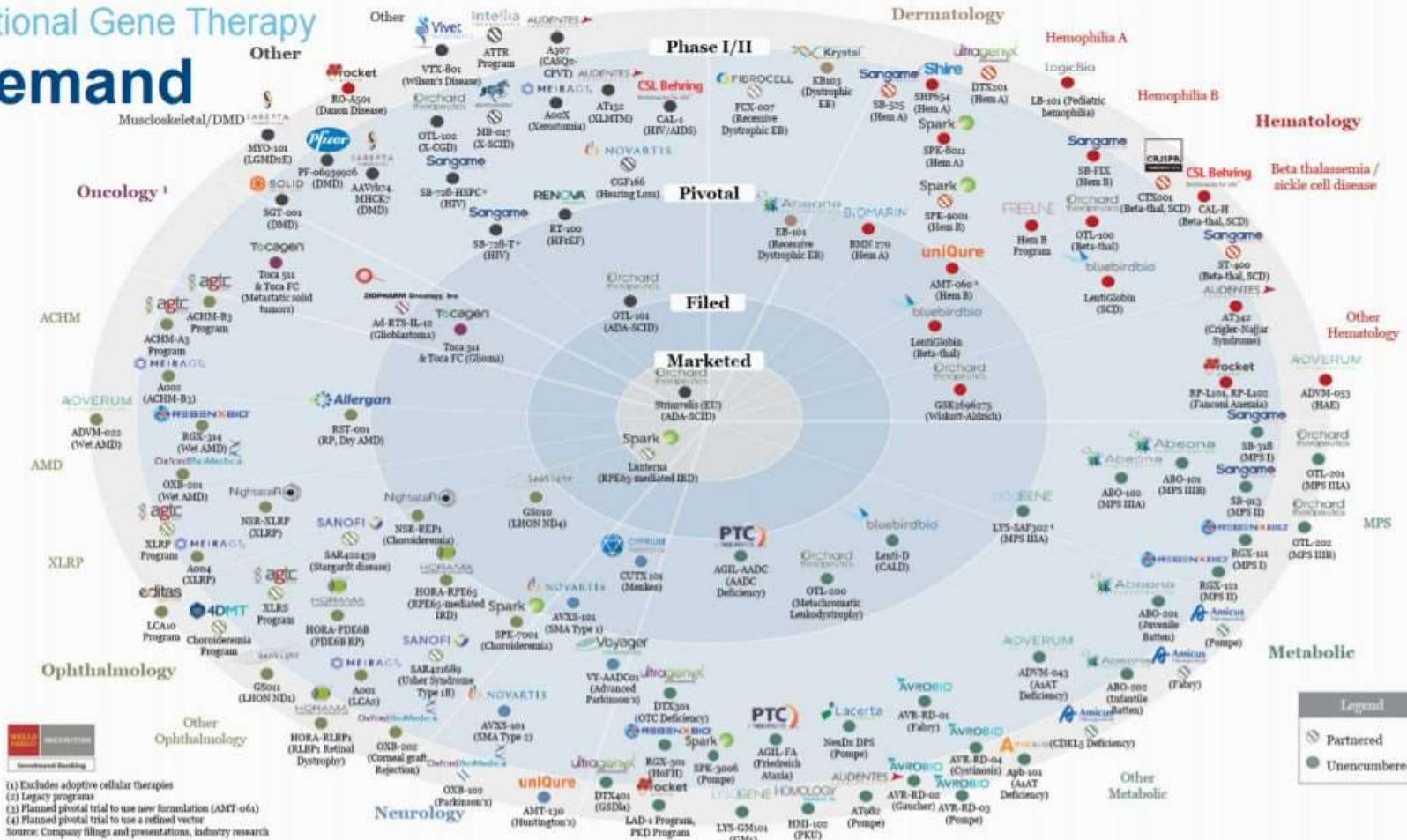




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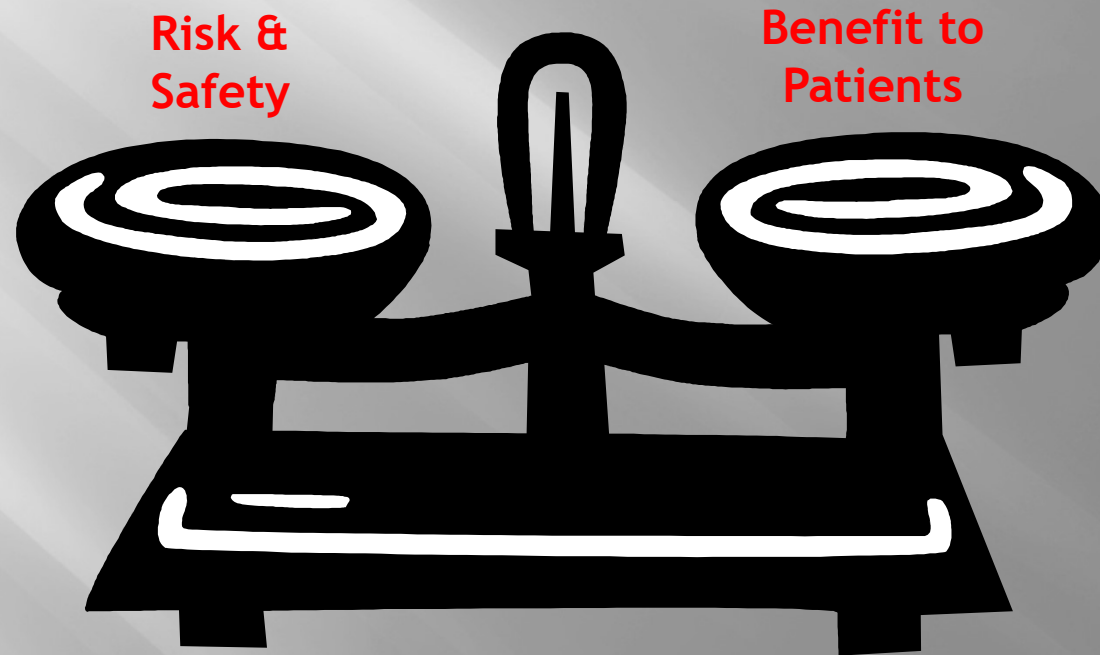
National Gene Therapy Demand



Adaptive (acquired) immunity

- Develops in response to microbial contact
- Recognizes features of specific pathogens
- Immunologic memory
- Humoral and cellular arms:
 - Humoral immunity: antibodies
 - Cellular immunity: cytotoxicity
- Characteristic of vertebrates

Agency Responsibility



Differences Between Drugs and Biologics

- **Drugs**
- **Pre-clinical**
 - Toxicology in rodent and something else
 - Hepatic microsome for CYP enzyme metabolism
 - Safety pharmacology (*CNS, cardiovascular, respiratory studies ICH S7*)
 - Carcinogenicity (*Ames Test*)
- **Clinical**
 - Drug-drug interactions
 - Food-drug interactions for oral administration
 - Effect on QT/QTc & arrhythmic potential

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▪ Drugs

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▪ Biologics

- **Pre-Clinical**
 - Toxicology in relevant animal species
 - Very difficult learning curve at the moment
 - Don't always get NOAEL (*No Observed Adverse Event Level*)
- **Clinical**
 - PK and bioavailability but not metabolism
 - Concomitant use (*vaccines*)
 - Off-target incorporation of material (*DNA Vaccines*)

Potential Safety Concerns

- Inherent toxicity of the vaccine
- Toxicity of impurities/contaminants
- Toxicity due to interaction of components
- Toxicity linked to the immune response induced
- Unknown unknowns (*Black Swans*)

Toxicity Assessment: Animal Model

- “Relevant” animal species
 - An animal species susceptible to respond to the test article activity, e.g., development of an immune response after vaccination
 - Ideally, species should be sensitive to the pathogenic organism or toxin
 - One relevant animal species in general is sufficient
 - Exceptions on a case-by-case
 - Non-human primates not generally necessary
 - Group size dependent on the animal model



Toxicity Assessment: ROA/Dosing

- Route of administration (ROA) and dose should correspond to clinically intended ROA and dose(s), *e.g.*, oral, SC, IM, Nasal
- Total number of doses equal to or exceed number of clinically administered doses
 - [“N plus 1”]
- Episodic dosing, *e.g.*, weeks between doses

Clinical Drug Development Process

**IND/
CTA** →

- **Phase I - *First-into-Human***
 - 20-100 normal healthy volunteers
 - Determine safety and tolerability
- **Phase IIa/IIb - *Therapeutic Exploration***
 - 100-300 patients
 - Evaluate efficacy
 - Determine dose range and adverse events (AEs)
- **Phase III - *Therapeutic Confirmation***
 - 1,000 to 15,000 patients
 - Verify efficacy, monitor AEs and effect in usual therapy and special populations
- **Phase IV - *Post-Approval***
 - Postmarketing surveillance
 - Monitor long term risks and benefits, outcomes and pharmacoeconomics
- **Phase V**
 - Postmarketing studies (Potentially thousands of patients)
 - New indications: “Megatrials”



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NDA/
WMA/
BLA →

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 - *Possibly 60-70,000 for a vaccine*
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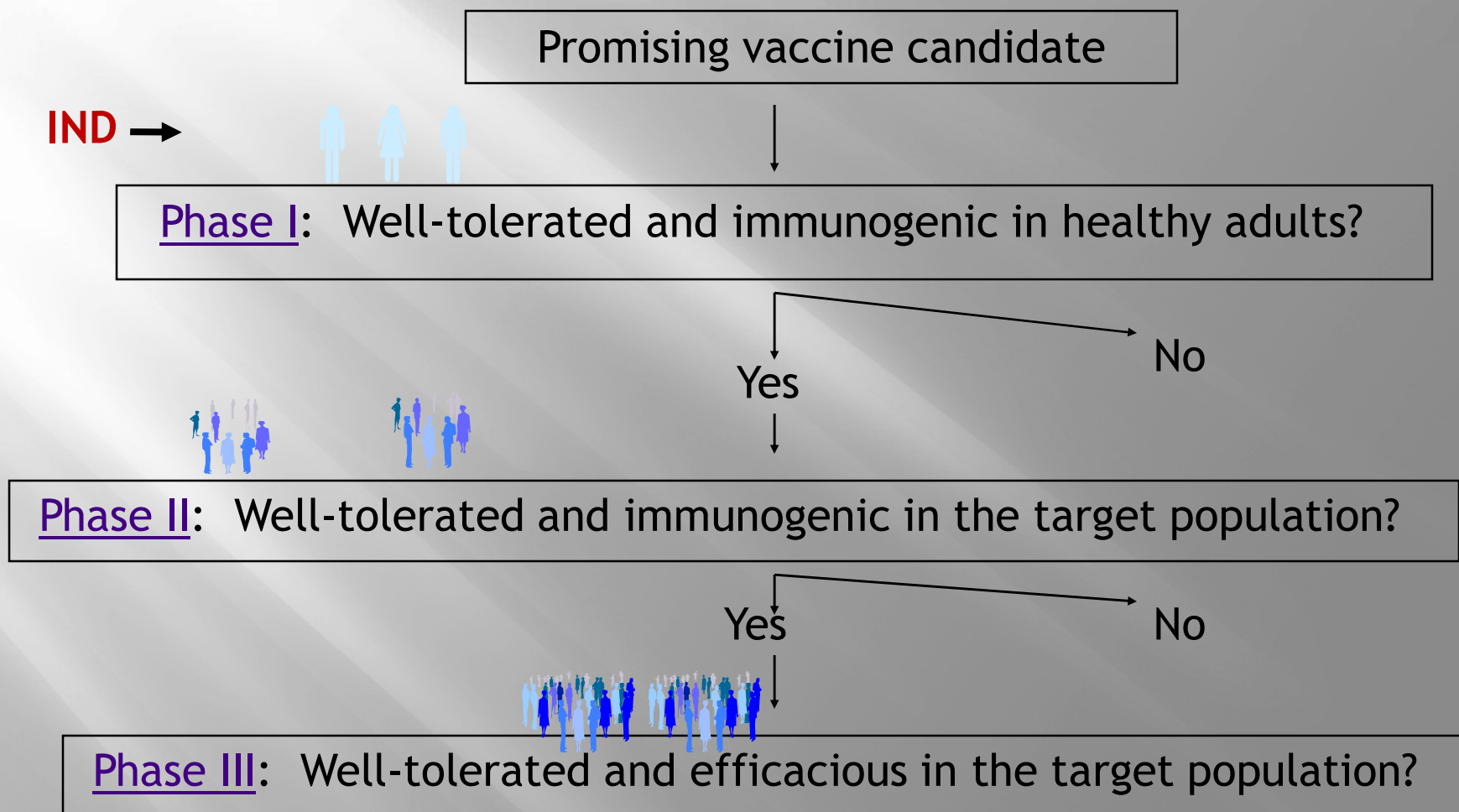
CLINICAL POPULATIONS FOR THE DEVELOPMENT OF VACCINES

- **ROTATEQ®** : Rotavirus vaccine- 70,000 patients in the pivotal trials worldwide
- **ZOSTAVAX®** : Shingles vaccine- 68,000 patients in the pivotal trials worldwide.

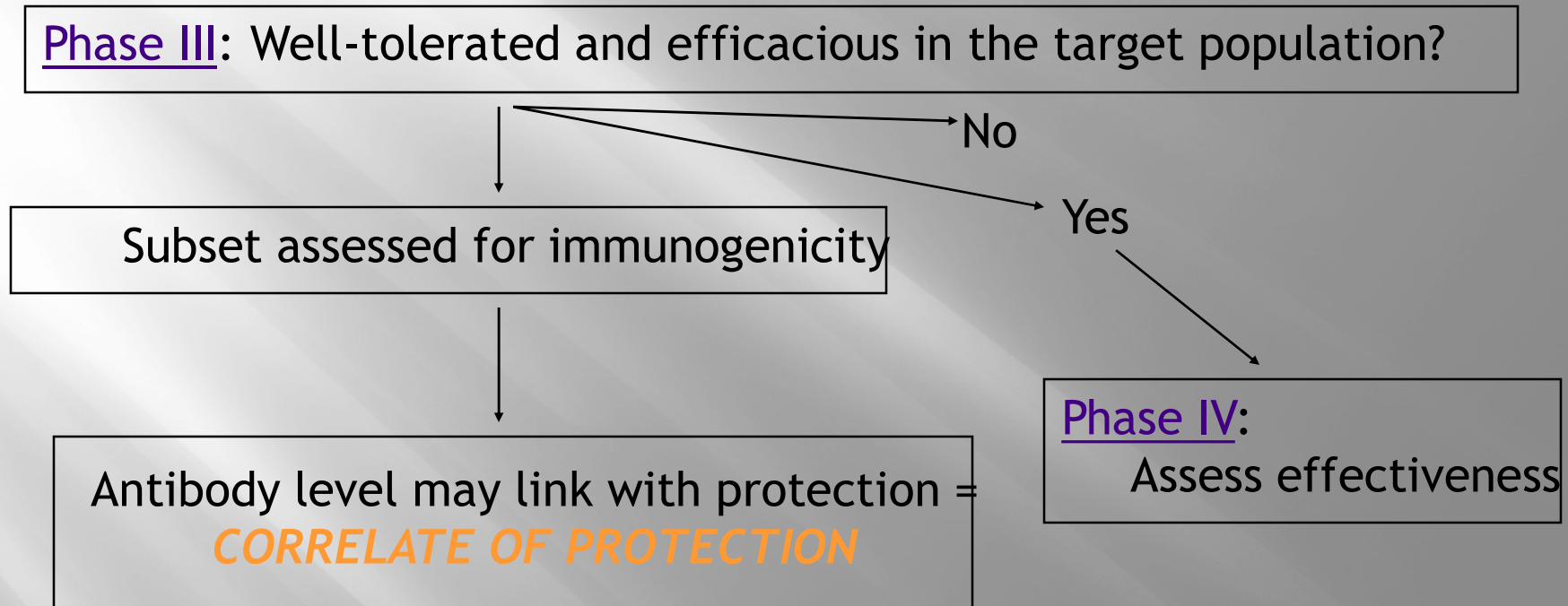
EVALUATING A VACCINE

Sources: Clemens et al. *JAMA* 1996;275:390-7

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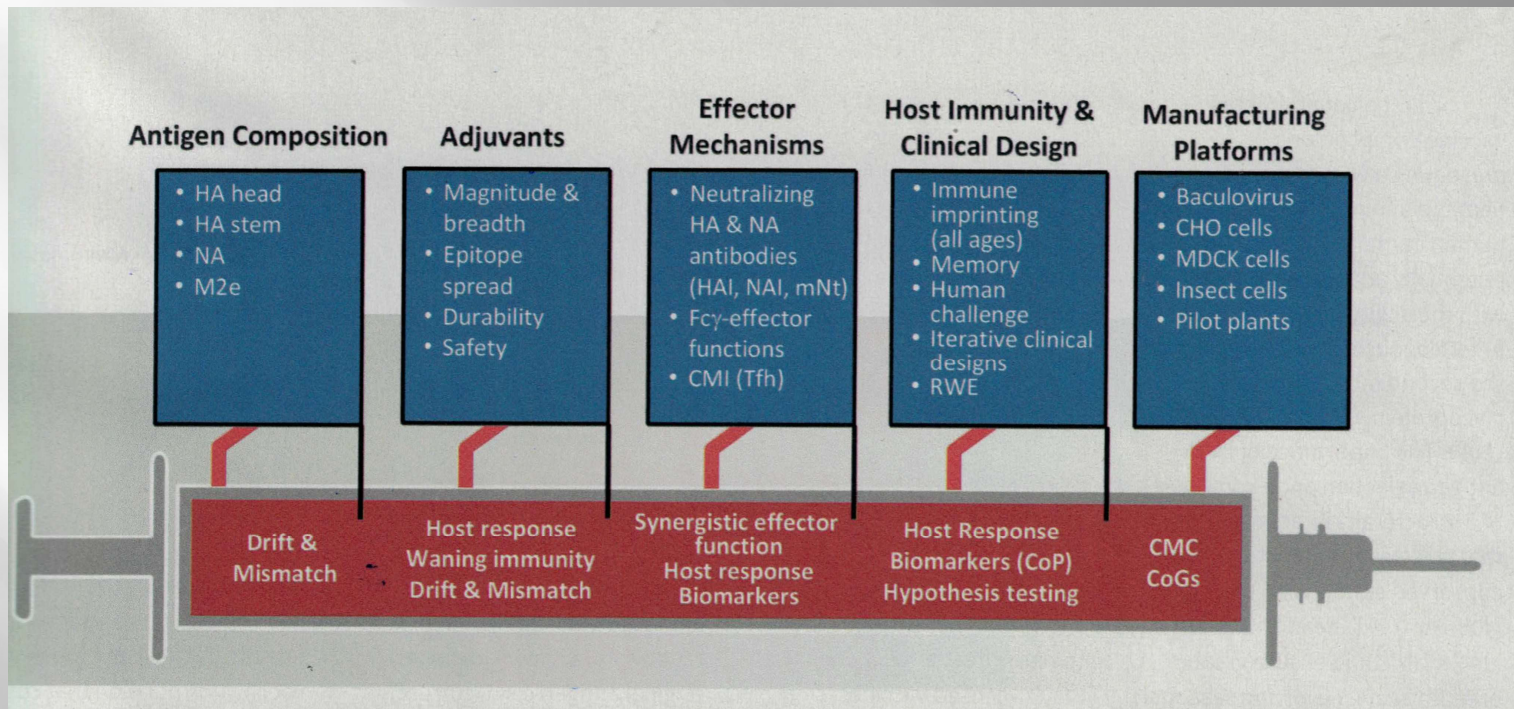
EVALUATING A VACCINE

- An **Efficacy** trial provides a more direct measurement of protection
- **Efficacy**- the protective effect of a vaccine against the target disease

$$\text{Protective Efficacy} = \left[1 - \left(\frac{\text{incidence of disease in vaccinees}}{\text{incidence of disease in nonvaccinees}} \right) \right] \times 100\%$$

Sources: [VacciNews 2002;1\(6\):1-4](#) Clemens et al. [JAMA 1996;275:390-7](#)

Methodology for Production: Future Flu Vaccines



Arms of the Immune System

