From Clinical Promise to Scalable Reality: How CMC Challenges Are Shaping the Future of Autologous Cell Therapies

Marianna Sabatino
VP Process Sciences, Analytics and Technology

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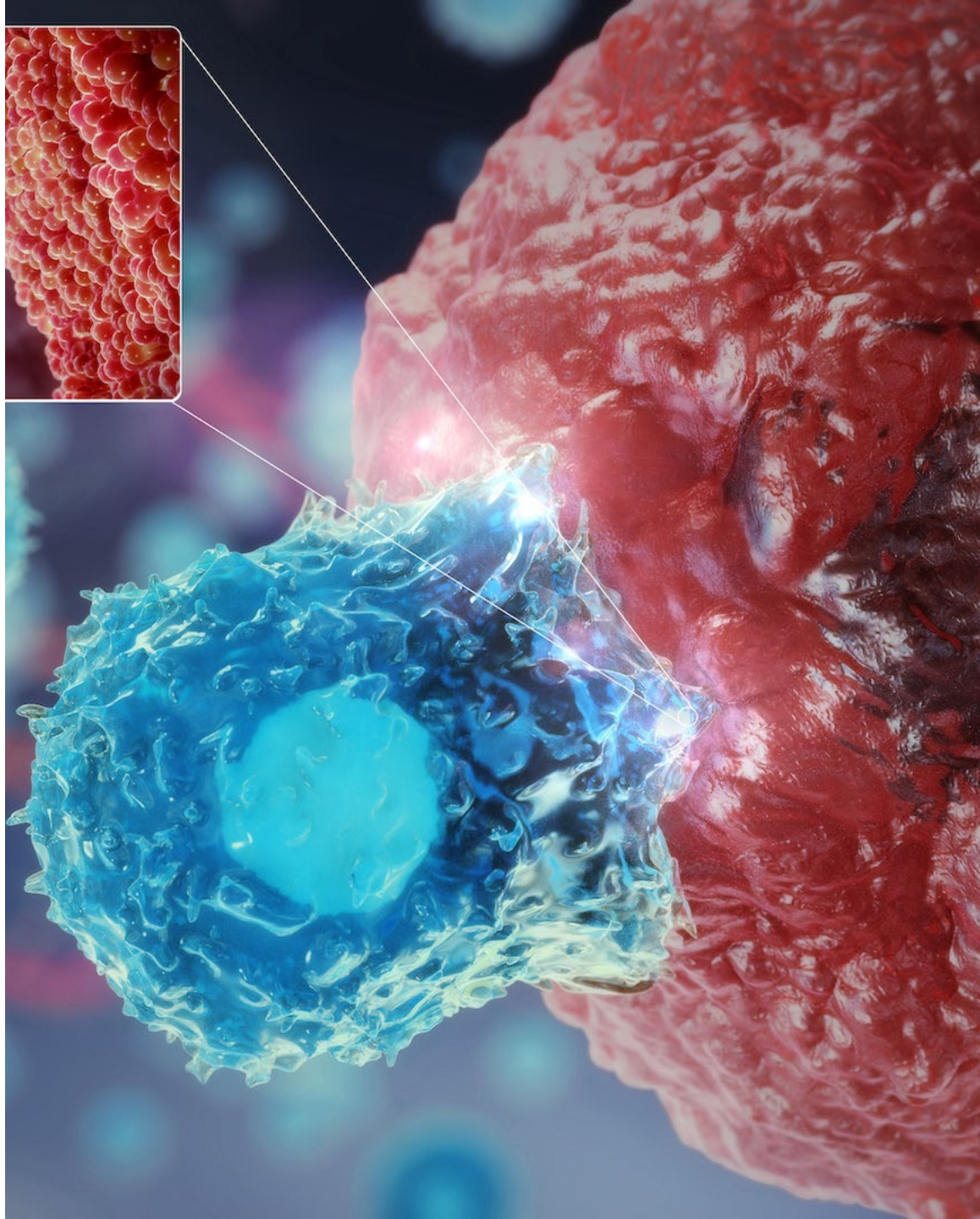


Autologous Cell Therapies: From Oncology Breakthrough to Broader Precision Medicine

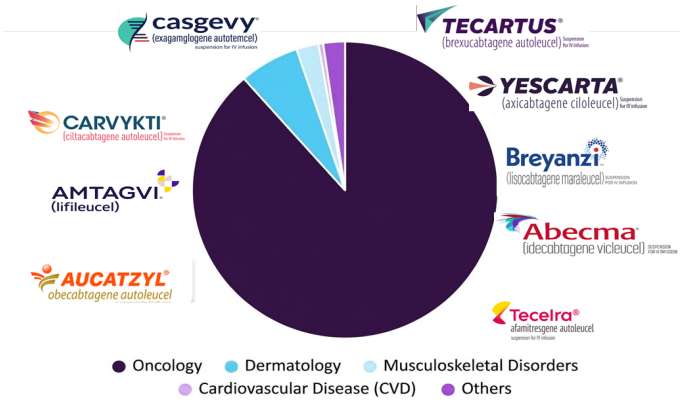
Oncology

T-cell therapies has reshaped oncology treatments, transforming outcomes in hematologic malignancies and unlocking new potential in solid tumors

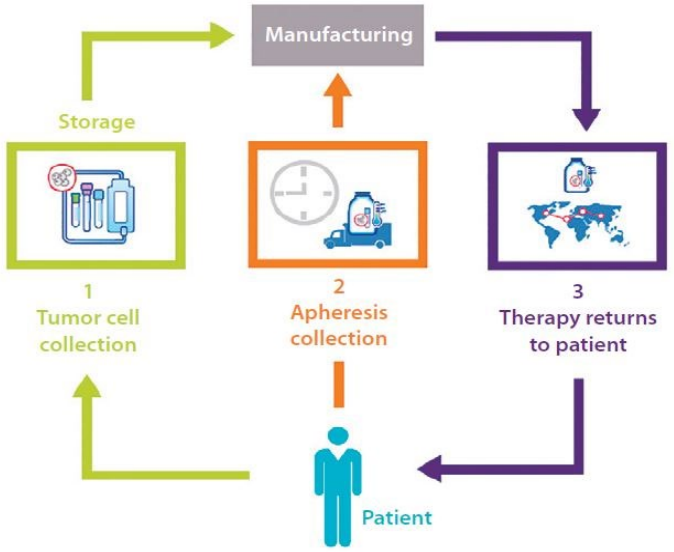
Non- Oncology

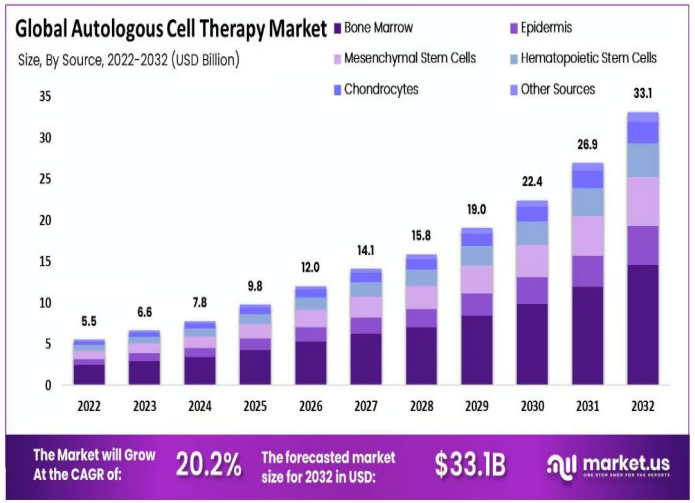
Autologous cell therapies are opening new frontiers beyond oncology, with the potential to reset the immune system and regenerate damaged tissue

Indications



Autologous Cell Therapies: Personalized Medicine Transforming Patient Care



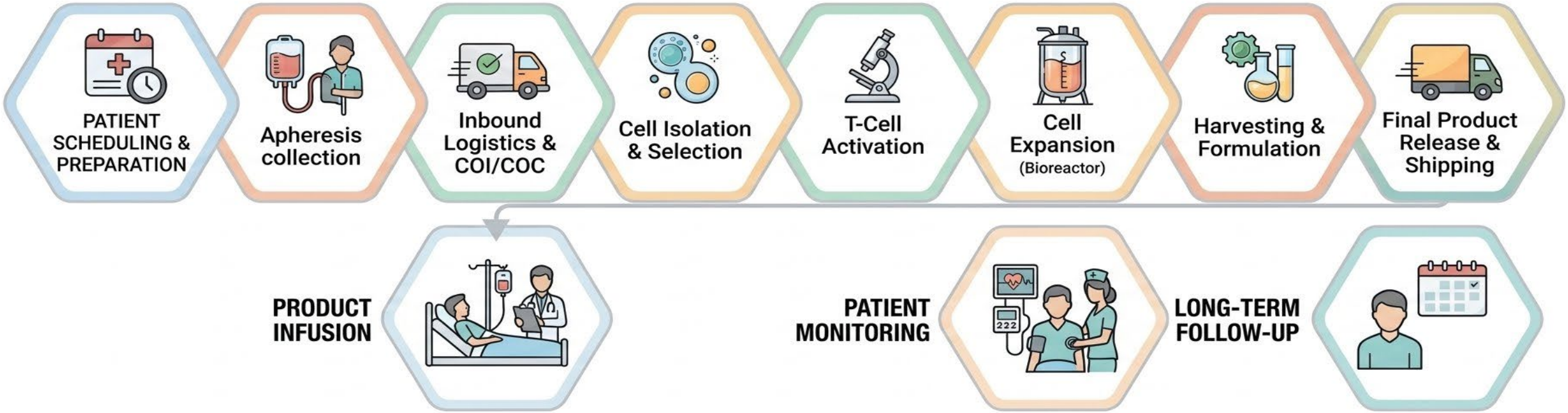


- The patient's own cells are both the starting material and the medicine, requiring a fundamentally different CMC model.
- As the field expands beyond niche indications, the limiting factor is increasingly not proof of concept, but the ability to deliver robust, scalable, and controllable manufacturing
- CMC excellence becomes the key enabler of reliable delivery, regulatory success, and patient access

From Batch Manufacturing to One-Lot-per-Patient

Feature	Monoclonal Antibodies (mAb)	Autologous Cell therapies
Starting Material	Standardized, banked cell lines	Primary cells directly from the patient
Manufacture	**Scale-up**: One massive batch treats thousands	**Scale-out -** a different capacity, labor, and facility model
Release	**Fixed release criteria**	**Highly individualized, time critical**
Logistics	**Traditional cold-chain**	**Hyper-complex:** Strict cryogenic transport ≤ -150°C with rigid "**chain of identity**" and "**chain of custody**" tracking from patient-to-manufacturing-to-patient.
Variability	**Low:** Process is heavily characterized, automated, and strictly controlled for maximum consistency	**High:** Inherently variable starting material based on patient disease state, prior treatments, and age.
Cost profile	Economical per dose due to mass production	Extremely expensive, not sustainable for large indications

Logistics as product quality and patient safety challenge



Autologous cell therapies are redefining what "manufacturing" means in biopharma: success depends not on producing a standardized batch, but on controlling a patient-specific, time-critical, end-to-end system.

CMC challenges in living medicine manufacturing

Biological & Technical Challenges

- Starting material variability
- Material and reagent variability
- Manufacturing consistency
- Analytical testing constraints

Operational & Supply Chain

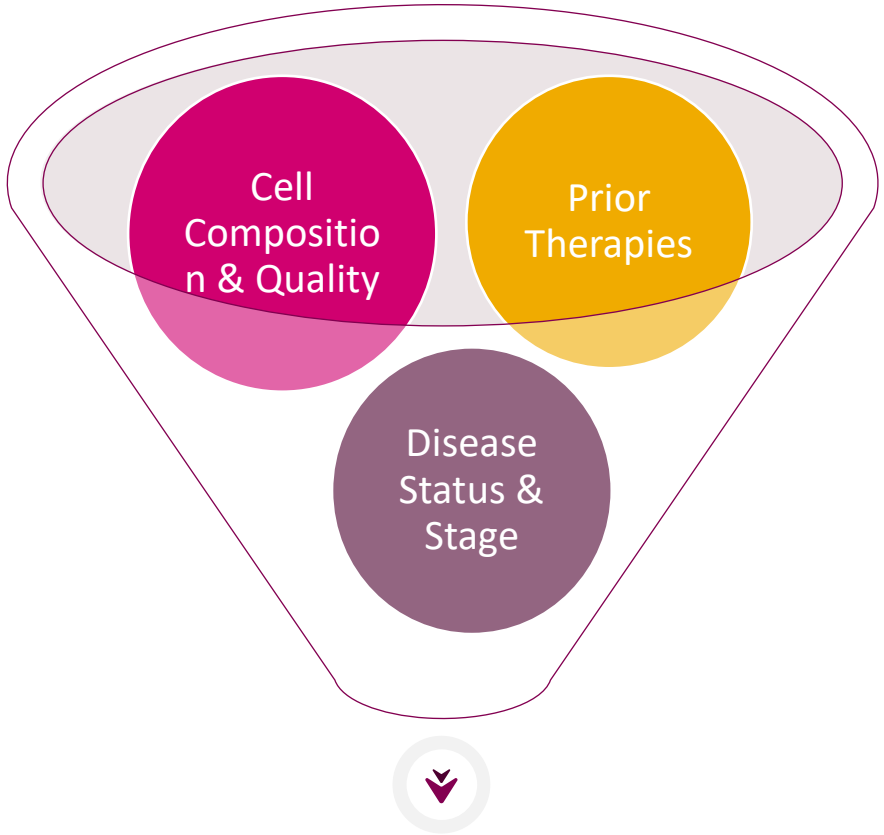
- Scale-out rather than scale-up
- Long and complex vein-to-vein time
- Logistics complexity
- Deviations and manufacturing failures

Embracing Patient Variability as the Foundation for Resilient Manufacturing

Patient Heterogeneity
Cell quality, cell count, and biological vitality vary based on patient's age, disease stage, and previous lines of intensive treatments (e.g., chemotherapy). **Variability is uncontrollable.**

Unpredictable Kinetics
This severe cell-to-cell variability causes highly unpredictable cellular expansion rates and genetic modification/transduction efficiencies during manufacturing

Out-of-Specification Risks
Increased risk of failed batches or Out-of-Specification (OOS) products, leading to lost manufacturing slots and a tragic failure to return a clinical dose back to a waiting patient.

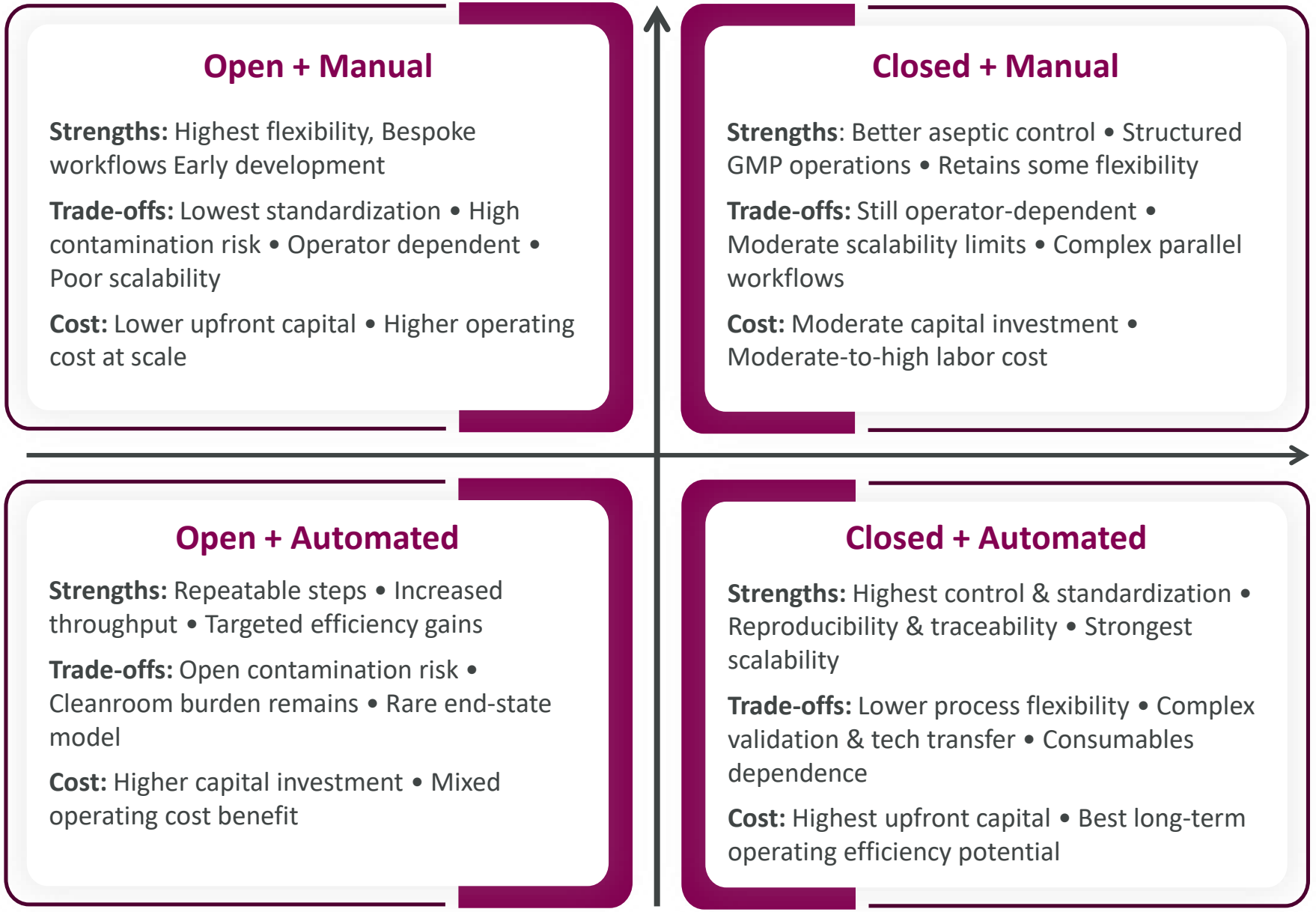


Process understanding to drive CMC models designed for resilience, adaptive control rather than fixed inputs

Raw materials are major drivers of product quality, process robustness, & supply continuity

Critical Raw materials	Key Challenges	Strategy Response
• Viral vectors • Cytokines/growth factors • Activation reagents • Culture media/serum substitutes • Gene editing reagents • Cryoprotectants	• **Supplier variability** • **Limited GMP-grade supply** • **Animal-origin concerns** • **Changes in reagent formulation** can alter process performance unexpectedly • **Qualification burden** is high due to complexity, variability, and clinical impact	• **Risk-rank raw materials** based on quality, safety, and process impact • **Qualify suppliers early** • **Apply fit-for-purpose testing** aligned to material criticality • **Plan lifecycle management early** to manage changes and maintain control

Manufacturing Platform Choices: Open, Closed, Manual, and Automated Systems: Strategic Trade-offs in Product Lifecycle



Autologous Cell Therapies Release Strategy Must Balance Patient Need, Product Risk, and Test Feasibility

Patient Need

- **Time-critical treatment :** Patients may have rapidly progressing disease and limited ability to wait for extended release testing
- **Patient-specific product**: Each batch is unique, reducing flexibility for repeat manufacturing or replacement
- **Access considerations**: Release strategy should support timely product availability without unnecessary delay

Product Risk

- **Patient safety first**: Release must assure control of key risks such as sterility, identity, viability, and purity
- **Variable starting material**: Autologous inputs can differ significantly, increasing batch-to-batch variability
- **Risk-based control**: Testing and specifications should focus on critical quality attributes linked to clinical performance.

Test Feasibility

- **Limited sample availability**: Small batch size constrains the number and type of assays that can be performed
- **Short shelf life**: Long assay turnaround times may not fit the clinical delivery window
- **Method limitations**: Some functional assays are complex, variable, or unsuitable for routine lot release

Digital Infrastructure Is Becoming a Core CMC Capability for Scale

Drivers for digital shift

- **Scheduling**
- **Securing Chain of Identity (COI) and Chain of Custody (COC)**
- **Equipment integration**
- **Electronic batch records**
- **Accelerating Batch Release**
- **Deviation management**
- **Trend analysis**

Key Component

- **Digital Orchestration Platforms**: Connect scheduling with manufacturing capacity so patient cell collection aligns perfectly with open facility time slots
- **Artificial Intelligence and Digital Twins:** Manufacturers are leveraging virtual models (Digital Twins) fed by biosensor data to simulate “what-if” scenarios, optimize bioreactor yields, and predict failures before they happen
- **Cloud-Native Modular Architectures:** Provide secure, encrypted environments to process highly sensitive patient health data while complying with global data privacy regulations and strict GxP validation standards

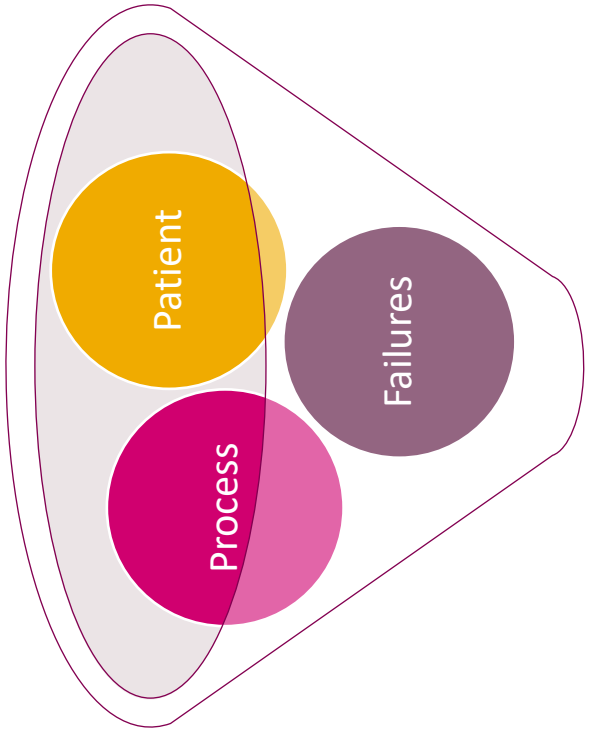
Digital infrastructure is now a core enabler of control, traceability, and scale

Regulatory Frameworks Are Adapting, but Expectations for Control Remain High

Expectations	What Recent Feedback Signals	Implications for Developers
• Control of critical quality attributes • Clinically relevant potency • Comparability after process or site changes • Sterility / aseptic assurance for short-lived products • Chain of identity and chain of custody	• High starting-material variability does not reduce CMC expectations • End-product testing alone is not sufficient • Potency should be supported by integrated, multi-measure evidence • Manufacturing changes require stronger comparability planning • Traceability and data integrity are under increasing scrutiny	• Build phase-appropriate but science-based specifications • Develop potency strategy early and evolve it over time • Strengthen raw material, process, and change control • Plan comparability proactively before major changes • Invest in digital traceability and manufacturing data systems

Autologous cell therapies programs need flexible operations, but not flexible control

The CMC Strategy Is Becoming More Risk-Based, Integrated, and Lifecycle Oriented



CMC Learnings

- Earlier focus on manufacturability
- Platform-based process design
- Stronger raw material governance
- Closed and automated systems
- Integrated analytical strategies
- Risk-based release frameworks
- Early comparability planning
- Lifecycle control strategy development from Phase 1 onward

Early feasibility → **Platforming** → **Process Understanding** → **Control Strategy** → **Commercial Ready**

From boutique treatment to industrial scaling

Novel Clinical Indication

- **Autoimmune Reset:** Shifting focus to severe B-cell-driven diseases like Lupus (SLE) and scleroderma.
- **Solid Tumor Breakthroughs:** Advancing TILs and armored CARs to penetrate hostile tumor microenvironments.
- **Chronic & Neuro Diseases:** Deploying autologous iPSCs for localized neuron replacement in Parkinson's

Biological Architecture

- **Logic-Gated Design:** Engineering AND/NOT circuits to ensure cells destroy tumors but spare healthy tissue.
- **Armored Payloads:** Equipping cells to secrete their own cytokines to resist immunosuppression.
- **Persistence Engineering:** Maximizing long-term cellular survival to prevent disease recurrence.

Manufacture Evolution

- **Increased automation and closed processing**
- **More modular manufacturing platforms**
- **Better use of multivariate data and advanced analytics**
- **Faster microbiological and release methods**

CMC Priorities Shift Across the Development Lifecycle, Plan with Scalability as the End Point

Early Phase

Demonstrate feasibility Establish basic safety/identity controls Flexible process

Mid Phase

Improve robustness Strengthen potency approach Reduce variability Prepare for comparability demands

Late Phase/Commercial

Lock critical process parameters Validate methods strengthen supply chain establish continued process verification improve throughput and reliability

Key take-home messages

Autologous cell therapies are clinically transformative, but its future will be determined by whether CMC can convert personalization into reliable, scalable delivery

The most important issues are variability, logistics, potency, release, comparability, and scale-out versus scale up

These challenges are driving a new manufacturing model built on platforming, automation, digitalization, and science-based control strategies

Future success will depend on platforming, automation, digitalization, and stronger science-based control strategies

In this field, CMC is no longer downstream support for the clinic; it is a strategic driver of patient access, regulatory success, and commercial sustainability

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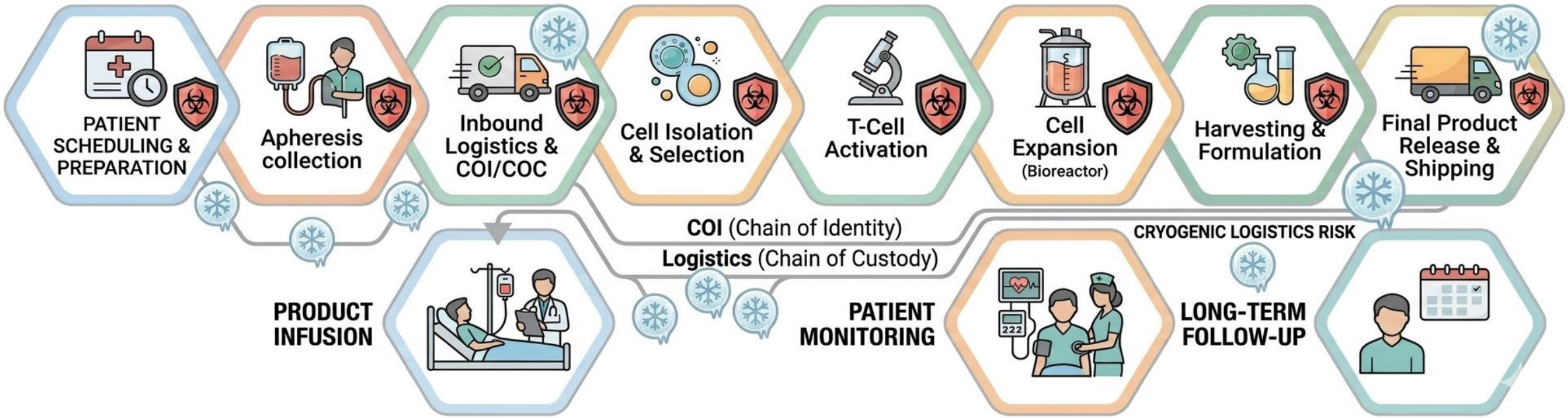

Release strategies must combine risk-based testing, in-process controls, platform knowledge, and post-release risk mitigation where appropriate