

Providing high-quality drugs for people worldwide; we are establishing a global production system.

Takeda is promoting the further enhancement of the production system to support "achieving sales of in-house ethical products of 2 trillion yen in fiscal 2015." At the same time, Takeda wholeheartedly implements Takeda-ism through the "Production Division Standards for Employees Conduct" and "Basic Purchasing Policy," and provides pharmaceutical products, with high ethical standards responding to the public's trust.



FOUR BASIC POLICIES TOWARD THE ENHANCEMENT OF THE PRODUCTION SYSTEM

Takeda promotes the further globalization of its production system; based on the following four policies in the 2006-2010 Medium-Term Management Plan:

1. Pursuing a cost minimum approach by establishing a globally optimized production system.
2. Enhancing the ability of quality control, including overseas manufacturing plants and toll-manufacturers, by improving its global quality assurance system.
3. Developing drug formulations that meet the market needs as well as enhancing the technical capabilities of the CMC* research laboratories.
4. Inheriting and enhancing the production technology of both domestic and overseas production plants.

* Chemistry, Manufacturing and Controls: research on bulk manufacturing process, drug formulation, physicochemical property, testing method and quality control



Takeda Pharma Ireland Limited (TPI)

DEVELOPMENT OF THE GLOBAL PRODUCTION SYSTEM

The production operation at Shonan Plant (Fujisawa City, Kanagawa Pref.) was terminated at the end of March 2006, streamlining the domestic production system by shifting toward two manufacturing bases of the Hikari (Hikari City, Yamaguchi Pref.) and Osaka (Osaka City) Plants. Meanwhile, Takeda Pharma Ireland Limited will shortly start operations as Takeda's first overseas bulk pharmaceutical plant and is scheduled to start providing bulk compounds of major products for Western markets, including *Rozerem*. Another manufacturing facility of Takeda in Ireland, the drug formulating plant Takeda Ireland Limited, has been rapidly expanding production in response to the sales growth in Western markets since starting operations in 1999. We aim to further improve the efficiency of our production activities by realizing integrated manufacturing from bulk compounds to drug formulations in the same country.

