

Production system

We will prove worthy of users' trust with dedicated drug manufacturing, while also establishing a global production system.



Four Basic Policies toward the Enhancement of the Production System

Takeda is promoting the improvement of its production system; based on the following four policies:

1. Establishing a globally optimized production system
2. Enhancing the ability of quality control, including that of contract manufacturers, by improving its global quality assurance system
3. Strengthening the technical capabilities of bulk manufacturing process, analytical and formulation research & development
4. Inheriting and enhancing the production technology of domestic and overseas production plants

Global Quality Assurance Department

In order to provide customers with reliable Takeda products, it is vital to ensure products high quality, while we must comply with the applicable laws and ordinances as well as rules and regulations in the course of all business activities including production, as well as research, clinical trials, collection and provision of information on product

Development of the Global Optimum Production System

Takeda is promoting the development of production bases, both at home and abroad, with the goal of "achieving sales of consolidated ethical products of 2 trillion yen in fiscal 2015."

Takeda Pharma Ireland Limited, which commenced operations in April 2007 with the production of drug substance of *Rozerem* (generic name: ramelteon) as an overseas production base of drug substance, will strive to further enhance its productivity in order to expand the role with the production of new products in mind together with Takeda Ireland Limited—a production base of drug formulation. In Japan, Takeda promotes the development of production bases toward the smooth supply of new products into the market via the twin manufacturing bases of the Hikari and Osaka plants.

As for contract manufacturing, we will continue to strategically utilize contract manufacturers as part of our strategy to establish a more effective and cost-reductive production system, while also reflecting a balance with in-house production.

Takeda's Production Bases



safety and efficacy. The Global Quality Assurance Department is committed to living up to the trust of society toward Takeda products from a quality perspective to ensure all executives and employees comply with the Quality Policy by overseeing and supervising the quality assurance activities of Takeda group worldwide.