

- The correlation between  $\text{Log } r_{\text{qmw}}$  from TVIS vial and the thermocouple temperature in a neighboring vial of the re-heating part of annealing step (Fig.2A) provides a predictive product temperature at primary drying process defined as T-FPEAK (Fig.2B).
- The decrease in  $\text{Op}_{\text{pr}} \text{TJ} 1.853 \text{ 0 Td (and) } \text{Tj} 2.0-0.0 \text{ (and) } \text{Tj} 2.0-0.0 \text{ (and) } (\text{rre})-3.50 \text{ 2767.5571 T3Ty} 2.0-0.0 \text{ (and) } \text{Tj Ea} 0 \text{ (ea)}$

