

- 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 $Q_{\text{pr}} = T_j - T_d - 1.853 \cdot \text{Log}(r_{\text{qmw}}) - 3.50 \cdot \text{Log}(T_j - T_d) - 2767.5571 / (T_j - T_d)$

