	NORTH AMERICA	SOMERSET, NJ	ALLENDALE, NJ	KANSAS CITY, MO	MADISON, WI	MT. LAUREL, NJ	PHILADELPHIA, PA	RESEARCH TRIANGLE PARK, NC	ST. PETERSBURG, FL	WINCHESTER, KY	WOODSTOCK, IL	EUROPE	APRILIA, ITALY	BATHGATE, UK	BOLTON, UK	DEESIDE, UK	SWINDON, UK	BEINHEIM, FRANCE	LIMOGES, FRANCE	BRUSSELS, BELGIUM	EBERBACH, GERMANY	SCHORNDORF, GERMANY	LATIN AMERICA	BUENOS AIRES, ARGENTINA	SOROCABA, BRAZIL	ASIA PACIFIC	KAKEGAWA, JAPAN	SINGAPORE	BRAESIDE, AUSTRALIA
DEVELOPMENT																													
Biologics: GPEx® Cell Line Engineering & Biomanufacturing					•																								
Biopharmaceutical Lab Services				•	•			•																					
Pharmaceutical Lab Services				•				•		•	•						•		•	•	•	•							
Pre-formulation & Formulation		•		•				•	•	•	•		•				•	•			•	•		•	•		•		•
Solid State Services: Optiform™ Technology								•																					
Regulatory Consulting		•	•	•	•	•	•	•	•	•	•		•	•	•	•	•	•	•	•	•	•		•	•		•	•	•
DELIVERY																													
Blow/Fill/Seal Technology											•																		
Consumer Health Solutions		•					•		•	•	•		•				•	•			•	•		•	•		•		•
Controlled Release Technology		•		•						•												•							
Immediate Release Technology		•		•						•												•							
Inhalation								•																					
Injectables								•											•	•									
OptiMelt™ Hot Melt Extrusion Technology		•								•												•							
Softgel & Vegicaps® Capsules		•							•				•					•			•			•	•		•		•
Stick Pack Granulations & Liquids																						•							
Zydis® & Lyopan® Fast-Dissolve Technology		•															•												
SUPPLY																													
Clinical Supply Services			•	•		•	•							•	•	•						•						•	
Oral Dose Form Manufacturing		•		•				•	•	•			•				•	•			•	•		•	•		•		•
Packaging & Supply Chain Solutions			•	•		•	•				•		•	•	•	•						•		•	•		•		•
Sterile Dose Form Manufacturing								•			•								•	•									