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Arg Val Thr Ser Pro Asn Ile Thr Val Thr Leu Lys
1               5                   10


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Lys Gly Phe Ile Ile Ser Asn Ala Thr Tyr Lys
1               5                   10


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Lys Leu Val Leu Asn Cys Thr Ala Arg
1               5


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Lys Asn Ser Thr Phe Val Arg
1               5
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1. A method of producing an aflibercept composition having a target value of aflibercept variants expressed in a host cell cultured in a chemically defined medium (CDM), comprising:

(a) providing said host cell genetically engineered to express aflibercept;

(b) culturing said host cell in said CDM under suitable conditions in which said host cell expresses aflibercept to produce an aflibercept sample;

(c) clarifying and harvesting the aflibercept sample produced by said host cell, wherein the target value of aflibercept variants is obtained by using:

i. a cumulative concentration of iron in said CDM of less than or equal to about 55.0 μM;

ii. a cumulative concentration of copper in said CDM of less than or equal to about 0-8 μM;

iii. a cumulative concentration of nickel in said CDM of less than or equal to about 0.4 μM;

iv. a cumulative concentration of zinc in said CDM of less than or equal to about 56.0 μM;

v. a cumulative concentration of cysteine in said CDM of less than or equal to about 10.0 mM; and/or

vi. cumulative concentration of an anti-oxidant in the CDM of about 0.001 mM to about 10 mM for any