

TERVISHOIUTOODETE ASEPTILINE TÖÖTLEMINE. OSA
1: ÜLDNÕUDED

Aseptic processing of health care products - Part 1:
General requirements (ISO 13408-1:2023)

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

<p>See Eesti standard EVS-EN ISO 13408-1:2024 sisaldab Euroopa standardi EN ISO 13408-1:2024 ingliskeelset teksti.</p> <p>Standard on jõustunud sellekohase teate avaldamisega EVS Teatajas.</p> <p>Euroopa standardimisorganisatsioonid on teinud Euroopa standardi rahvuslikele liikmetele kättesaadavaks 24.04.2024.</p> <p>Standard on kättesaadav Eesti Standardimis- ja Akrediteerimiskeskusest.</p>	<p>This Estonian standard EVS-EN ISO 13408-1:2024 consists of the English text of the European standard EN ISO 13408-1:2024.</p> <p>This standard has been endorsed with a notification published in the official bulletin of the Estonian Centre for Standardisation and Accreditation.</p> <p>Date of Availability of the European standard is 24.04.2024.</p> <p>The standard is available from the Estonian Centre for Standardisation and Accreditation.</p>
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ICS 11.080.01

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EUROPEAN STANDARD

EN ISO 13408-1

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Aseptic processing of health care products - Part 1: General requirements (ISO 13408-1:2023)

Traitement aseptique des produits de santé - Partie 1:
Exigences générales (ISO 13408-1:2023)

Aseptische Herstellung von Produkten für die
Gesundheitsfürsorge - Teil 1: Allgemeine
Anforderungen (ISO 13408-1:2023)

This European Standard was approved by CEN on 2 July 2023.

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EUROPÄISCHES KOMITEE FÜR NORMUNG

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

European foreword

This document (EN ISO 13408-1:2024) has been prepared by Technical Committee ISO/TC 198 "Sterilization of health care products" in collaboration with Technical Committee CEN/TC 204 "Sterilization of medical devices" the secretariat of which is held by BSI.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by October 2024, and conflicting national standards shall be withdrawn at the latest by October 2024.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN ISO 13408-1:2015.

This document has been prepared under a standardization request addressed to CEN by the European Commission. The Standing Committee of the EFTA States subsequently approves these requests for its Member States.

For the relationship with EU Legislation, see informative Annex ZA and ZB, which is an integral part of this document.

Any feedback and questions on this document should be directed to the users' national standards body/national committee. A complete listing of these bodies can be found on the CEN website.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Türkiye and the United Kingdom.

Endorsement notice

The text of ISO 13408-1:2023 has been approved by CEN as EN ISO 13408-1:2024 without any modification.

Contents

	Page
Foreword	vi
Introduction	viii
1 Scope	1
2 Normative references	1
3 Terms and definitions	1
4 General	8
5 Principles of aseptic processing	9
5.1 General.....	9
5.2 Use of an aseptic process.....	9
5.3 Core elements.....	10
5.4 Aseptic processing zones.....	11
5.4.1 General.....	11
5.4.2 Critical processing zone.....	11
5.4.3 Direct support zones.....	11
5.4.4 Indirect support zones.....	12
6 Process design, development and risk management	12
6.1 General.....	12
6.2 Process design.....	13
6.3 Risk assessment.....	14
6.4 Identification of critical control points and process parameters.....	14
6.5 Handling and processing.....	15
6.6 Environment and air handling.....	15
6.7 Materials.....	16
6.8 Personnel.....	16
6.8.1 General.....	16
6.8.2 Training.....	16
6.8.3 Health.....	17
6.8.4 Interventions.....	17
6.8.5 Service personnel.....	17
6.8.6 Cleanroom clothing systems.....	17
6.9 Aseptic processing equipment.....	18
6.9.1 General.....	18
6.9.2 Automated processes and robotics.....	19
6.9.3 Single use systems and connecting devices.....	19
6.9.4 Auxiliary equipment and utilities.....	19
6.10 Components.....	20
6.11 Product related safety requirements.....	20
6.12 Aseptic final packaging process.....	20
6.13 Flow management.....	20
6.13.1 Containment.....	20
6.13.2 Cross contamination.....	21
6.13.3 Item introduction.....	21
6.13.4 Egress.....	21
6.13.5 Waste management.....	21
6.14 Manufacturing process duration.....	22
7 Contamination control strategy (CCS)	22
7.1 General.....	22
7.2 Cleaning and disinfection programs.....	22
7.2.1 General.....	22
7.2.2 Cleaning.....	23
7.2.3 Disinfection.....	23
7.2.4 Equipment used for cleaning and disinfection in APA.....	24

7.2.5	Cleaning process validation	24
7.2.6	Disinfection process validation	25
7.2.7	Cleaning and disinfection of equipment	25
7.2.8	Cleaning and disinfection procedures	25
7.3	Sterilization	26
7.3.1	General	26
7.3.2	Sterilization processes	26
7.3.3	Sterilization equipment	26
7.3.4	Sterilization procedures	26
7.3.5	Post aseptic lethal treatments	27
7.3.6	Endotoxin control	27
7.3.7	Depyrogenation process	27
7.4	Maintenance of sterility	28
7.5	Maintenance and calibration programs	30
7.5.1	Service personnel	30
7.5.2	Planned maintenance activities	30
7.5.3	Unplanned maintenance	31
7.5.4	Calibration of equipment	31
7.6	Environmental monitoring	31
7.6.1	General	31
7.6.2	Sampling for non-viable particulate monitoring	32
7.6.3	Sampling for microbiological environmental monitoring	32
7.7	Containment of highly potent or toxic substances	33
8	Demonstration of the effectiveness	33
8.1	Equipment qualification and validation	33
8.1.1	General	33
8.1.2	User requirements specification	33
8.1.3	Design qualification	34
8.1.4	Installation qualification (IQ)	34
8.1.5	Operational qualification (OQ)	34
8.1.6	Performance qualification (PQ)	34
8.1.7	Requalification	34
8.2	Aseptic process validation	35
8.2.1	General	35
8.2.2	Establishment and management of interventions	35
8.2.3	Process simulation	35
8.2.4	Initial aseptic qualification	38
8.2.5	Periodic performance requalification	38
8.2.6	Repeat of initial aseptic qualification	39
8.2.7	Documentation of process simulations	39
8.2.8	Disposition of filled product	40
8.2.9	Aseptic process lifecycle considerations	40
8.3	Maintenance of process	41
8.3.1	General	41
8.3.2	Review of the manufacturing process	41
8.3.3	Changes or developments to the manufacturing process	41
9	Product release	42
9.1	General	42
9.2	Testing for sterility	42
9.3	Testing for bacterial endotoxins	42
9.4	Testing for mycoplasma	43
9.5	Rapid and alternative microbiological methods	43
	Annex A (informative) Aseptic processing — Typical elements	44
	Annex B (informative) Risk management	45
	Annex C (informative) Typical processing zones	52

Annex D (informative) Comparison of classification of cleanrooms and filters	57
Annex E (informative) Example of an aseptic process flow chart	60
Annex F (informative) Closed systems and robotics	61
Annex G (informative) Sterile cleanroom clothing system qualification	64
Annex H (informative) Rapid and alternative microbiological methods	68
Bibliography	70

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

ISO draws attention to the possibility that the implementation of this document may involve the use of (a) patent(s). ISO takes no position concerning the evidence, validity or applicability of any claimed patent rights in respect thereof. As of the date of publication of this document, ISO had not received notice of (a) patent(s) which may be required to implement this document. However, implementers are cautioned that this may not represent the latest information, which may be obtained from the patent database available at www.iso.org/patents. ISO shall not be held responsible for identifying any or all such patent rights.

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 198, *Sterilization of health care products*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 204, *Sterilization of medical devices*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This third edition cancels and replaces the second edition (ISO 13408-1:2008) which has been technically revised. It also incorporates ISO 13408-1:2008/Amd 1: 2013.

The main changes are as follows:

- a complete restructuring of the document;
- inclusion of a diagram to explain the relationship between the ISO 13408 series and ISO 18362;
- revision of the normative references;
- alignment of definitions with ISO 11139:2018;
- positioning of the document to recognize current and future advances in sterile manufacturing technology, acknowledging that new approaches to aseptic processing are transforming classical aseptic processing;
- promotion of aseptic processing principles and the systematic implementation of quality risk management (QRM), including for aseptic process design, and microbiological contamination and particulate contamination control;
- provision of guidance for different types of aseptic processing, for example, manual processing systems to automated robotic processing systems;

- deletion of tables from the previous edition of this document referring to acceptance criteria for process simulation (media fill) qualification and requalification;
- encouraging adoption of advanced aseptic processing technologies and continuous process improvement to improve assurance of sterility;
- recognition that alternative or rapid microbiological methods (RMMs) provide timely microbiological data vital for process monitoring and control, and for product release;
- inclusion of a series of informative annexes providing guidance on defining an aseptic process, including risks to be considered, aseptic processing areas (APAs), classification of cleanrooms, aseptic process flow, closed systems and robotics, and qualification of a cleanroom clothing system.

A list of all parts in the ISO 13408 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Introduction

Wherever possible, health care products intended to be sterile should be terminally sterilized in their final sealed container by a terminal sterilization process, which has been validated to achieve a specified sterility assurance level (SAL). ISO/TC 198 has developed standards for terminal sterilization of health care products, for example (but not restricted to): the ISO 11137 series (radiation sterilization), ISO 17665-1 (moist heat sterilization), ISO 20857 (dry heat sterilization), ISO 11135 (ethylene oxide sterilization) and ISO 14160 (liquid chemical sterilization).

Where a health care product is intended to be sterile and cannot withstand terminal sterilization in its final container, aseptic processing provides an acceptable alternative for product manufacture.

ISO/TC 198 also developed ISO/TS 19930, which provides guidance on aspects of a risk-based approach to assuring sterility of terminally sterilized, single-use health care product that is unable to withstand processing to achieve maximally a 10^{-6} SAL.

Aseptic processing produces a sterile product in its final container by the assembly of component parts (e.g. product, container and container closure) that have been sterilized separately by validated and controlled processes suitable for each component part. Each of these assembly processes can introduce error that can result in product contamination. Furthermore, contamination can be introduced from the personnel, equipment or environment when the sterilized components are brought together to create the final product. It is important to control all possible sources of contamination so that the aseptic manufacturing process maintains sterility of previously-sterilized components during product filling or assembly, and sealing. Fundamentally, aseptic processing minimises the probability of a chance event of microbial contamination occurring. The rationale to use aseptic processing is product dependent and is not based solely on manufacturing considerations.

Examples of applications in which aseptic processing is used include:

- aseptic handling and filling of solutions, suspensions, semisolids and powders;
- aseptic handling, transfer and packaging of solid products including solid medical devices;
- aseptic handling, transfer and packaging of combination products;
- aseptic handling of tissues or biological production systems (e.g. vaccines).

Sterilization processes for product and components used as a prerequisite for aseptic processing are established and validated separately to aseptic processing activities.

Traditionally, aseptic processing has been carried out in cleanrooms and associated controlled environments to provide an environment in which the air supply, materials, equipment and operators are regulated to maintain sterility of previously-sterilized components. Advances in aseptic processing include systems that prevent the direct intervention of operators with open-product containers or exposed-product contact surfaces in the critical processing zone, for example, the use of fully enclosed barrier systems (e.g. isolators), automation and robotics. This can mean that a traditional cleanroom is not always appropriate for aseptic processing activities.

To provide assurance of sterility for an aseptically processed product, this document identifies three key activities in the development and operation of an aseptic process to reduce and control particulate and microbial contamination risks:

- process design;
- risk assessment;
- contamination control strategy (CCS).

An effective risk management approach is an essential tool for the development, validation and control of aseptic processing. Only when risks of particulate and microbiological contamination have been

identified, and where possible eliminated, or minimized and controlled, can an aseptic process be considered suitable for its intended purpose.

Controls for some infectious agents, e.g. protozoa or parasites, can require a multifaceted approach to assure component or product safety. These types of infectious agents are not considered in the ISO/TC 198 standards for terminal sterilization or aseptic processing. Guidance can be found in ISO 18362 applicable good manufacturing practice (GMP) regulations and the EDQM guide^[28].

This document describes the fundamental requirements of aseptic processing regardless of the nature of the aseptic process, e.g. small-scale versus large-scale, open- versus closed-processing, single-use, disposable sterile systems, traditional cleanroom versus isolator systems, manual versus automated or robotic systems, autologous sterile products, processes with post-aseptic lethal treatments and processes using real-time microbiological monitoring. It does not, however, describe the requirements for other manufacturing processes upstream or downstream of aseptic processing activities. This document acknowledges the different geographical regulatory approaches to aseptic processing and recognizes that new approaches to aseptic processing are transforming classical aseptic processing. It recognizes that future improvements in aseptic processing rely on improved use of technology for both existing and new products, for example, sterile advanced therapy medicinal products.

To encourage adoption of suitable, advanced aseptic processing technologies and continuous process monitoring, this document introduces the concept of recognising efforts in risk-based process design, particulate and microbiological contamination control and risk management, to justify consideration of alternative approaches to demonstrating ongoing process effectiveness, for instance reduced frequency of requalification, sampling, or for real-time release of finished product.

Assurance of sterility for an aseptically processed product should not be confused with the term, 'sterility assurance level (SAL)'. SAL is a mathematical extrapolation applicable only to a validated and controlled terminal sterilization process of known microbial lethality and which is delivered to each individual sealed unit of product subject to that process. Due to the variability and chance nature of occurrence of microbial contamination during aseptic processing, aseptic process simulation (APS) does not result in a mathematical probability of there being a single, viable microorganism in a contaminated unit, but rather results in an indication of what can happen in the routine processing of subsequent product batches (see ISO/TS 19930:2017, Clause 4).

This document specifies the requirements for general aspects of aseptic processing of health care products. Requirements and guidance for other processes often employed during aseptic processing are specified in ISO 13408-2 to ISO 13408-7, i.e. sterilizing filtration (ISO 13408-2), lyophilization (ISO 13408-3), clean-in-place (CIP) technologies (ISO 13408-4), sterilization in place (SIP) (ISO 13408-5), isolator systems (ISO 13408-6) and alternative processes for medical devices and combination products (ISO 13408-7).

ISO 18362 specifies the minimum requirements for, and provides guidance on, a risk-based approach for the processing of cell-based health care products (CBHPs) requiring control of viable and non-viable microbial contamination. It is applicable to CBHPs labelled 'sterile', as well as to those that are not labelled 'sterile'. For aseptic processing of CBHPs to be labelled sterile, ISO 18362 refers normatively to this document and ISO 13408-7. A CBHP that incorporates non-sterile starting material cannot meet the ISO 11139 definition of aseptic processing, which amongst other things, requires the use of sterile product and components. ISO 18362, therefore also includes requirements and guidance for the processing of such products to reduce and control microbial contamination risks.

The relationship between the ISO 13408 series and ISO 18362 is shown in [Figure 1](#).

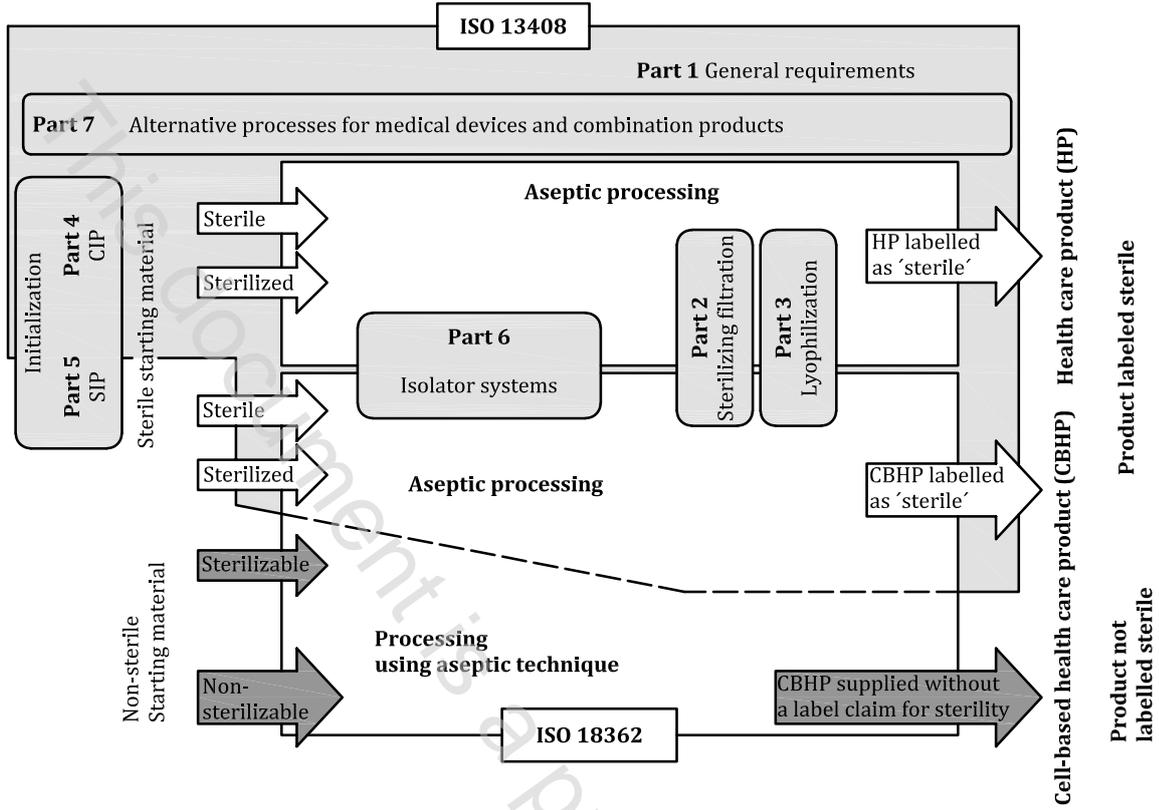


Figure 1 — Relationship between the ISO 13408 series and ISO 18362

Aseptic processing of health care products —

Part 1: General requirements

1 Scope

This document specifies the general requirements for, and offers guidance on, processes, programs and procedures for development, validation and routine control of aseptic processing of health care products.

This document includes requirements and guidance relative to the overall topic of aseptic processing.

Specific requirements and guidance on various specialized processes and methods related to sterilizing filtration, lyophilization, clean-in place (CIP) technologies, sterilization in place (SIP) and isolator systems are given in the other parts of the ISO 13408 series.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 13408-2, *Aseptic processing of health care products — Part 2: Sterilizing filtration*

ISO 13408-6, *Aseptic processing of health care products — Part 6: Isolator systems*

ISO 14644-1:2015, *Cleanrooms and associated controlled environments — Part 1: Classification of air cleanliness by particle concentration*

ISO 14644-2, *Cleanrooms and associated controlled environments — Part 2: Monitoring to provide evidence of cleanroom performance related to air cleanliness by particle concentration*

ISO 14644-4, *Cleanrooms and associated controlled environments — Part 4: Design, construction and start-up*

ISO 14644-7, *Cleanrooms and associated controlled environments — Part 7: Separative devices (clean air hoods, gloveboxes, isolators and mini-environments)*

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

ISO and IEC maintain terminology databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <https://www.electropedia.org/>

3.1

action level

value from monitoring that necessitates immediate intervention

[SOURCE: ISO 11139:2018, 3.5]