



SLOVENSKI STANDARD
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Sterilizatorji za uporabo v medicini - Sterilizatorji s paro nizke temperature in s formaldehidom - Zahteve in preskušanje

Sterilizers for medical purposes - Low temperature steam and formaldehyde sterilizers - Requirements and testing

Sterilisatoren für medizinische Zwecke - Niedertemperatur-Dampf-Formaldehyd-Sterilisatoren - Anforderungen und Prüfung

Stérilisateur à usage médical - Stérilisateur à la vapeur et au formaldéhyde à basse température - Exigences et essais

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Sterilizers for medical purposes - Low temperature steam and formaldehyde sterilizers - Requirements and testing

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Contents		Page
Foreword.....		3
Introduction		4
1	Scope	5
2	Normative references	5
3	Terms and definitions.....	6
4	Technical requirements.....	11
5	Process control	21
6	Performance requirements	24
7	Sound power and vibration.....	26
8	Packaging, marking and labelling	27
9	Information to be supplied by the manufacturer	28
10	Service and local environment.....	30
Annex A (normative) Test methods.....		33
Annex B (normative) Sterilizer classification and testing.....		39
Annex C (normative) Test equipment.....		42
Annex D (normative) Determination of formaldehyde residuals in a filter indicator		45
Annex E (informative) Formaldehyde residues on medical devices.....		48
Annex F (informative) Environmental aspects		50
Annex ZA (informative) Relationship between this European Standard and the Essential Requirements of EU Directive 93/42/EEC on medical devices		53
Bibliography		59

Foreword

This document (prEN 14180:2012) has been prepared by Technical Committee CEN/TC 102 “Sterilizers for medical purposes”, the secretariat of which is held by DIN.

This document is currently submitted to the CEN Enquiry.

This document will supersede EN 14180:2003+A2:2009.

This document has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directive.

For relationship with EU Directive(s), see informative Annex ZA, which is an integral part of this document.

Annexes A, B, C and D are normative and form part of this European Standard.

Annexes E, F and ZA are for information only

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Introduction

This European Standard specifies minimum requirements and test methods for sterilizers working below ambient atmospheric pressure performing a low temperature steam and formaldehyde (LTSF) process.

LTSF sterilizers are primarily used for the sterilization of medical devices in health care facilities, but may also be used during the commercial production of medical devices.

LTSF processes are specified by physical parameters and verified using physical, chemical and microbiological means. The sterilizers operate automatically using pre-set cycles.

The test methods and test equipment given may also be applicable to validation and routine control.

Validation and routine control of sterilization processes are essential to ensure their efficacy. This standard does not cover validation and routine control of a LTSF process. Criteria for validation and routine control of LTSF sterilization processes are given in EN ISO 25424.

At the present state of knowledge, LTSF sterilizers should not be assumed to deliver processes effectively inactivating the causative agents of spongiform encephalopathies such as scrapie, Bovine Spongiform Encephalopathy and Creutzfeld-Jakob Disease. Specific recommendations have been produced in particular countries for the processing of materials potentially contaminated with these agents. See also EN ISO 25424:2011, 1.2.1.

Planning and design of products applying to this standard should consider not only technical issues but also the environmental impact from the product during its life-cycle. Environmental aspects are addressed in Annex F of this standard.

NOTE Risk analysis methods, e. g. in EN ISO 14971, pay attention to environmental aspects.

Specifications on operator safety are addressed in EN 61010–1, EN 61010–2–040 and are not repeated in this standard. EN 60204–1 may also give valuable guidelines.

1 Scope

This European Standard specifies requirements and tests for LTSF sterilizers, which use a mixture of low temperature steam and formaldehyde as sterilizing agent, and which are working below ambient pressure only.

These sterilizers are primarily used for the sterilization of heat labile medical devices in health care facilities.

This European Standard specifies minimum requirements:

- for the performance and design of sterilizers to ensure that the process is capable of sterilizing medical devices;
- for the equipment and controls of these sterilizers necessary for the validation and routine control of the sterilization processes.

2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 764-7, *Pressure equipment — Part 7: Safety systems for unfired pressure equipment*

EN 867-5, *Non-biological systems for use in sterilizers — Part 5: Specification for indicator systems and process challenge devices for use in performance testing for small sterilizers Type B and Type S*

EN 868-5, *Packaging for terminally sterilized medical devices — Part 5: Sealable pouches and reels of porous materials and plastic film construction — Requirements and test methods*

EN 980, *Symbols for use in the labelling of medical devices*

EN 13445 (series), *Unfired pressure vessels*

EN 14222, *Stainless steel shell boilers*

EN 60584-2, *Thermocouples — Part 2: Tolerances (IEC 60584-2:1982 + A1:1989)*

EN 60751, *Industrial platinum resistance thermometer sensors (IEC 60751:1983 + A1:1986)*

EN 61010-1:2010, *Safety requirements for electrical equipment for measurement, control and laboratory use — Part 1: General requirements (IEC 61010-1:2010)*

EN 61010-2-040:2005, *Safety requirements for electrical equipment for measurement, control, and laboratory use — Part 2-040: Particular requirements for sterilizers and washer-disinfectors used to treat medical materials (IEC 61010-2-040:2005)*

EN 61326-1:2006, *Electrical equipment for measurement, control and laboratory use — EMC requirement — Part 1: General requirements (IEC 61326-1:2005)*

EN 61672-1:2003, *Electroacoustics — Sound level meters — Part 1: Specifications (IEC 61672-1:2002)*

EN 61672-2:2003, *Electroacoustics — Sound level meters — Part 2: Pattern evaluation tests (IEC 61672-2:2003)*

EN ISO 228-1, *Pipe threads where pressure-tight joints are not made on the threads — Part 1: Dimensions, tolerances and designation (ISO 228-1)*

EN ISO 14971:2009, *Medical devices — Application of risk management to medical devices (ISO 14971:2007)*

prEN 14180:2012 (E)

EN ISO 3746:2010, *Acoustics — Determination of sound power levels and sound energy levels of noise sources using sound pressure — Survey method using an enveloping measurement surface over a reflecting plane (ISO 3746:2010)*

EN ISO 11138-1, *Sterilization of health care products — Biological indicators — Part 1: General requirements (ISO 11138-1)*

EN ISO 11138-5, *Sterilization of health care products — Biological indicators — Part 5: Biological indicators for low-temperature steam and formaldehyde sterilization processes (ISO 11138-5)*

3 Terms and definitions

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

3.1**access device**

means used to enable access to restricted parts of equipment

Note 1 to entry: This may be a dedicated key, code or tool.

3.2**aeration**

part or parts of the sterilization process in which defined conditions are used such that formaldehyde and its reaction products are desorbed from the medical device, and which can be performed within the sterilizer, within a separate room or chamber, or by a combination of the two

3.3**air removal**

removal of air from the sterilizer chamber and sterilization load to facilitate sterilant penetration

3.4**automatic controller**

device that, in response to pre-determined cycle variables, operates the sterilizer sequentially through the required stages of the operating cycle

3.5**biological indicator**

test system containing viable microorganisms providing a defined resistance to a specified sterilization process

[SOURCE: ISO/TS 11139:2006, 2.3]

3.6**chamber pre-heating**

heating of inner sterilizer-chamber surfaces to achieve predetermined temperatures prior to the commencement of a sterilization cycle

3.7**conditioning**

treatment of product within the sterilization cycle, but prior to the holding time, to attain a predetermined temperature and humidity throughout the sterilization load

3.8**cycle complete**

indication that the operating cycle has been - completed according to programme and that the sterilized load is ready for removal from the sterilizer chamber

[SOURCE: EN 285+A2:2009, 3.9]

3.9**cycle parameter**

specified value for a cycle variable

3.10**cycle variable**

physical property that influence the efficacy of the sterilization cycle

Note 1 to entry: For LTSF-sterilizers, the cycle variables include, but may not be limited to temperature, pressure, time, sterilant concentration.

3.11**desorption**

removal of the sterilant from the chamber and the load at the end of the exposure time

3.12**double-ended sterilizer**

sterilizer in which there is a door at each end of the sterilizer chamber

[SOURCE: EN 285+A2:2009, 3.11]

3.13**equilibration time**

period which elapses between the attainment of the sterilization temperature at the reference measuring point and the attainment of the sterilization temperature at all points within the load

3.14**exposure time**

period between introducing the sterilant into the chamber and the start of the desorption phase

3.15**holding time**

period for which the temperature, the steam pressure and the formaldehyde concentration of the steam are held within pre-set values and their tolerances to achieve the required inactivation efficacy in the sterilizer chamber

Note 1 to entry: The holding time follows immediately after the equilibration time.

3.16**inoculated carrier**

supporting material on or in which a defined number of viable test organisms have been deposited

[SOURCE: EN ISO 11138-1:2006, 3.10]

3.17**installation qualification****IQ**

process of obtaining and documenting evidence that equipment has been provided and installed in accordance with its specification

[SOURCE: ISO/TS 11139:2006, 2.22]

3.18**loading door**

door in a double-ended sterilizer through which the sterilizer load is put into the sterilizer chamber prior to sterilization

[SOURCE: EN 285+A2:2009, 3.17]

Note to entry: See also 3.43 unloading door.

prEN 14180:2012 (E)**3.19****medical device**

any instrument, apparatus, appliance, material or other article, whether used alone or in combination, including the software necessary for its proper application, intended by the manufacturer to be used for human beings for the purpose of:

- diagnosis, prevention, monitoring, treatment or alleviation of, disease,
- diagnosis, monitoring, treatment, alleviation of or compensation for, an injury or handicap,
- investigation, replacement or modification of the anatomy or of a physiological process,
- control of conception,

and which does not achieve its principal intended action in or on the human body by pharmacological, immunological or metabolic means, but which may be assisted in its function by such means

[SOURCE: EN ISO 13485:2000, 3.1]

3.20**microbicidal solution**

aqueous solution containing formaldehyde to feed the vaporiser for generating sterilant in the sterilizer

3.21**operating cycle**

the automatic sequence of operating stages performed in a sterilizer

[SOURCE: EN 1422:1997, 3.24]

3.22**operational qualification****OQ**

process of obtaining and documenting evidence that installed equipment operates within predetermined limits when used in accordance with its operational procedures

[SOURCE: ISO/TS 11139:2006, 2.27]

3.23**operator**

person operating equipment for its intended purpose

3.24**override**

means intended only for maintenance or safety, by which the operating cycle can be interrupted or modified

3.25**post-cycle flushing**

stage after "cycle complete" indication, during which the sterilization load is left in the closed chamber and the internal chamber atmosphere is exchanged

3.26**pressure vessel**

vessel consisting of the sterilizer chamber, door(s) and other components that form a permanent unit with the sterilizer chamber and that are pressurised by the same pressure

3.27**process challenge device****PCD**

item designed to constitute a defined resistance to a sterilization process and used to assess performance of the process

Note 1 to entry: The device is so constituted that a biological or chemical indicator can be put in the place which is the most difficult to reach by sterilizing agent(s). The indicator should not interfere with the function of the process challenge device.

[SOURCE: ISO/TS 11139:2006, 2.33]

3.28**production test**

series of tests performed to demonstrate compliance of each sterilizer with its type test performance

3.29**reference measuring point**

point where the temperature sensor for the sterilization cycle control is located

3.30**requalification**

repetition of part of validation for the purpose of confirming the continued acceptability of a specified process

[SOURCE: ISO/TS 11139:2006, 2.40]

3.31**risk assessment**

overall process comprising a risk analysis and a risk evaluation

[SOURCE: EN ISO 14971:2009, 2.18]

3.32**risk control**

process in which decisions and measures are implemented by which risks are reduced to, or maintaining risks within, specified levels

[SOURCE: EN ISO 14971: 2009, 2.19]

3.33**software validation**

confirmation and provision of objective evidence that the requirements for a specific intended use or specification of the software have been fulfilled

Note 1 to entry: ISO 9000, modified.3.34.

3.34**sterilant**

microbicidal agent composed of steam containing formaldehyde

3.35**sterilant injection**

single or repeated stage beginning with the introduction of sterilant into the evacuated sterilizer chamber and ending when the set operating pressure has been attained

3.36**sterile**

free from viable microorganisms

prEN 14180:2012 (E)

[SOURCE: ISO/TS 11139:2006, 2.43]

3.37**sterilization**

validated process used to render product free from viable microorganisms

Note 1 to entry: In a sterilization process, the nature of microbial inactivation is exponential and thus the survival of a microorganism on an individual item can be expressed in terms of probability. While this probability can be reduced to a very low number, it can never be reduced to zero.

[SOURCE: ISO/TS 11139:2006, 2.47]

3.38**sterilizer**

apparatus designed to achieve sterilization

[SOURCE: EN 285+A2:2009, 3.35]

3.39**sterilizer chamber**

part of the sterilizer which receives the sterilizer load

[SOURCE: EN 285+A2:2009, 3.36]

3.40**sterilization cycle**

predetermined sequence of operating stages performed in a sterilizer for the purpose of sterilization and desorption

3.41**sterilization load**

product to be, or that has been, sterilized together using a given sterilization process

[SOURCE: ISO/TS 11139:2006, 2.48]: [s.iteh.ai/catalog/standards/sist/9ec50dbd-b588-4cde-bc90-b61267d2311f/sist-en-14180-2014](https://standards.iteh.ai/catalog/standards/sist/9ec50dbd-b588-4cde-bc90-b61267d2311f/sist-en-14180-2014)

3.42**sterilization process**

series of actions or operations to achieve the specified requirements for sterility

Note 1 to entry: This series of actions includes pre-treatment of product (if necessary), exposure under defined conditions to the sterilizing agent and any necessary post treatment. The sterilization process does not include any cleaning, disinfection or packaging operations that precede sterilization.

3.43**sterilization temperature**

minimum temperature on which the evaluation of the sterilization efficacy is based

[SOURCE: EN 285+A2:2009, 3.33]

3.44**sterilization temperature band**

temperature tolerance range for the load and the reference measuring point, the minimum of which is the sterilization temperature

Note 1 to entry: These temperatures are usually stated in whole degrees Celsius.

[SOURCE: EN 285+A2:2009, 3.34]

3.45**theoretical sterilant temperature**

temperature of the sterilant, calculated from the temperature versus vapour pressure relationship of the sterilant

Note 1 to entry: This value is calculated from the beginning of the exposure time until the beginning of aeration.

3.46

unloading door

door in a double-ended sterilizer through which the sterilizer load is removed from the sterilizer chamber after a sterilization cycle

[SOURCE: EN 285+A2:2009, 3.41]

Note 1 to entry: See also 3.18 loading door.

3.47

usable space

space inside the sterilizer chamber, which is not restricted by fixed parts and which is, according to the manufacturer's specification, available to accept the sterilization load

3.48

validation

documented procedure for obtaining recording and interpreting the results required to establish that a process will consistently yield product complying with predetermined specifications

[SOURCE: EN ISO 11139:2006, 3.35]

3.49

verification

confirmation through provision of objective evidence that specified requirements have been fulfilled

[SOURCE: EN 62304:2006, 2.55]

4 Technical requirements

4.1 Sterilizer chamber

4.1.1 Materials

4.1.1.1 The surfaces of the materials for the pressure vessel (including, for example, welds) that can come into contact with process chemicals shall be of materials which, under the designed operating conditions, are not impaired by these chemicals. They shall not release any substances known to be toxic in such quantities that can create a health or environmental hazard.

NOTE When dissimilar metals are used in contact, this can cause contact corrosion and differential expansion.

4.1.1.2 Materials for sterilizer furniture including load supporting systems shall be selected to avoid corrosion and galvanic attack.

4.1.2 Chamber size

For the usable space the following dimensions shall be specified in millimetres, as applicable:

a) for cylindrical horizontal or cylindrical vertical usable spaces: 000 x 000 in which:

- the first three digits give the diameter of the usable space; and
- the last three digits give the depth of the usable space;

b) for rectangular parallelepiped usable spaces: 000 x 000 x 000 in which:

- the first three digits give the width of the usable space;

prEN 14180:2012 (E)

- the next three digits give the height of the usable space; and
 - the final three digits give the depth of the usable space;
- c) for other configurations the usable space shall be specified in analogy to a) or b);
- d) if any dimension exceeds 1000 mm then four digits shall be used, without a decimal point.

4.1.3 Doors and interlocks of the sterilizer chamber

4.1.3.1 Sterilizer chambers shall be provided with one or two doors.

4.1.3.2 After closing the sterilizer door, it shall be possible to open it before a cycle has been started.

4.1.3.3 It shall not be possible to open a sterilizer door(s) during a cycle.

4.1.3.4 In case of an interrupted cycle (e. g. due to a fault), opening of the sterilizer door e. g. to gain access to the load shall require the use of an access device.

4.1.3.5 The design shall allow easy and safe maintenance of the door seal(s) according to the instructions of the manufacturer.

4.1.3.6 For double-ended sterilizers it shall not be possible to open the unloading door until a "cycle complete" indication is obtained.

4.1.3.7 For operating cycles dedicated for test or maintenance purposes only, the cycle complete indication shall be different from that of a normal sterilization cycle. For double-ended sterilizers such cycle complete indications shall not permit the unloading door to be opened.

4.1.3.8 The control used to start the automatic operating cycle shall be located at the loading side of the sterilizer.

4.1.3.9 Except for maintenance purposes it shall not be possible to open both doors simultaneously on double-ended sterilizers.

4.1.3.10 For double-ended sterilizers both ends of the sterilizer shall be fitted with a device to indicate whether the door at that end can be opened.

4.1.3.11 The indication "cycle complete" shall be cancelled when a door is opened. For double-ended sterilizers the loading door shall remain locked until the unloading door has been opened, closed and locked again.

4.1.4 Heating and insulating the sterilizer chamber

4.1.4.1 Inner sterilizer chamber surfaces shall be heated to achieve pre-set temperatures. Initiation of the sterilization cycle shall not be possible until this condition has been fulfilled.

4.1.4.2 Where hot outer surfaces of the sterilizer chamber can cause a hazard and to reduce heat transmission to the environment, these surfaces shall be isolated, except where this will interfere the intended function of the sterilizer. This applies as well to dedicated steam supply systems, if integral part of the sterilizer.

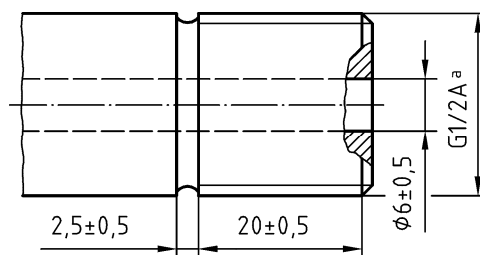
4.1.5 Test connections

4.1.5.1 The sterilizer chamber shall be provided with a test connection, which is used for the connection of a test pressure measuring instrument. This connection shall be at a point of easy access, but not in a pipe for media transport or evacuation, and shall terminate in a pipe thread EN ISO 228-1–G1/2A. An example is given Figure 1.

The test connection shall be provided with a cap marked PT (Pressure Test) and sealed with a sterilant proof and mechanically resistant O-ring seal or flat seal.

NOTE If national regulations require the calibration of all pressure instruments connected to the pressure vessel, test tees and valve cocks with sealing plugs can be required to permit connection of reference instruments.

Dimensions in millimetres



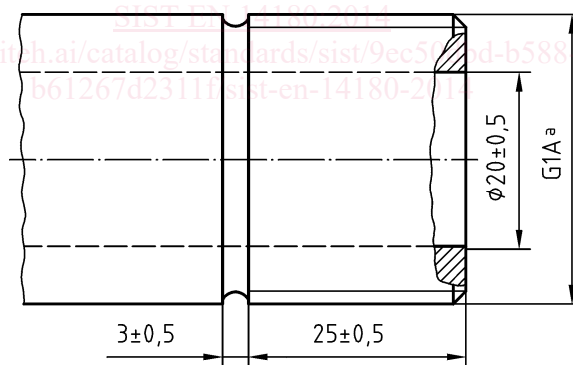
^apipe thread EN ISO 228-1 -G1/2A

Figure 1 — Example of the connection for test instruments

4.1.5.2 The sterilizer chamber shall be provided with a straight thermometry entry connection. An example is given in Figure 2. This connection shall be at a point of easy access.

The connection shall be provided with a cap marked TT (Temperature Test) and sealed with a sterilant proof and mechanically resistant O-ring seal or flat seal.

Dimensions in millimetres



^apipe thread EN ISO 228-1 G1A

Figure 2 — Example of thermometry entry connection

4.2 Design and construction

4.2.1 Risk control and usability

4.2.1.1 Risk assessment and risk control for sterilizer design and software shall be performed following the procedures and requirements given in EN ISO 14971. Specific requirements and results shall be established and documented.