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Aseptična proizvodnja izdelkov za zdravstveno nego - 1. del: Splošne zahteve (ISO/DIS 13408-1:2021)

Aseptic processing of health care products - Part 1: General requirements (ISO/DIS 13408-1:2021)

Aseptische Herstellung von Produkten für die Gesundheitsfürsorge - Teil 1: Allgemeine Anforderungen (ISO/DIS 13408-1:2021)

Traitement aseptique des produits de santé - Partie 1: Exigences générales (ISO/DIS 13408-1:2021)

Ta slovenski standard je istoveten z: prEN ISO 13408-1

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ICS:

11.080.01 Sterilizacija in dezinfekcija na splošno Sterilization and disinfection in general

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Aseptic processing of health care products —

Part 1: General requirements

Traitement aseptique des produits de santé —

Partie 1: Exigences générales

ICS: 11.080.01

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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).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

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*.

This third edition cancels and replaces the second edition (ISO 13408-1:2008) which has been technically revised.

The main changes compared to the previous edition 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 through 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 provide timely microbiological data vital for process monitoring and control, and for product release; and

inclusion of a series of informative annexes providing guidance on defining an aseptic process, including risks to be considered, aseptic processing areas, 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.

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Introduction

Wherever possible, healthcare products intended to be sterile should be terminally sterilized in their final sealed container. 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. 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.

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 could 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. 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.

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, automation and robotics. This can mean that a traditional cleanroom is not always appropriate for aseptic processing activities.

The primary aims of this revision to ISO 13408-1 were:

- to promote the systematic implementation of quality risk management (QRM) as a fundamental principle;
- to provide guidance for different types of aseptic processing; and
- to position the document to recognise current and future advances in sterile manufacturing technology.

To provide assurance of sterility for an aseptically processed product the revised document identifies three critical cornerstones:

- process design;
- risk assessment;
- contamination control strategy;

to primarily reduce and control particulate and microbial contamination risks.

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

been identified, 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, parasites can require a multifaceted approach to assure component or product safety. These types of infectious agents are not considered in the standards for terminal sterilization or aseptic processing. Guidance can be found in ISO 18362, applicable GMP regulations and EDQM *Guide to the quality and safety of tissues and cells for human application*.

This edition of ISO 13408 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. The 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, the revised 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 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 could happen in the routine processing of subsequent product batches (see ISO 19930, clause 4).

ISO 13408-1 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 technologies (ISO 13408-4), Sterilization in place (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 labelled to be sterile ISO 18362 refers normatively to ISO 13408-1 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](#).

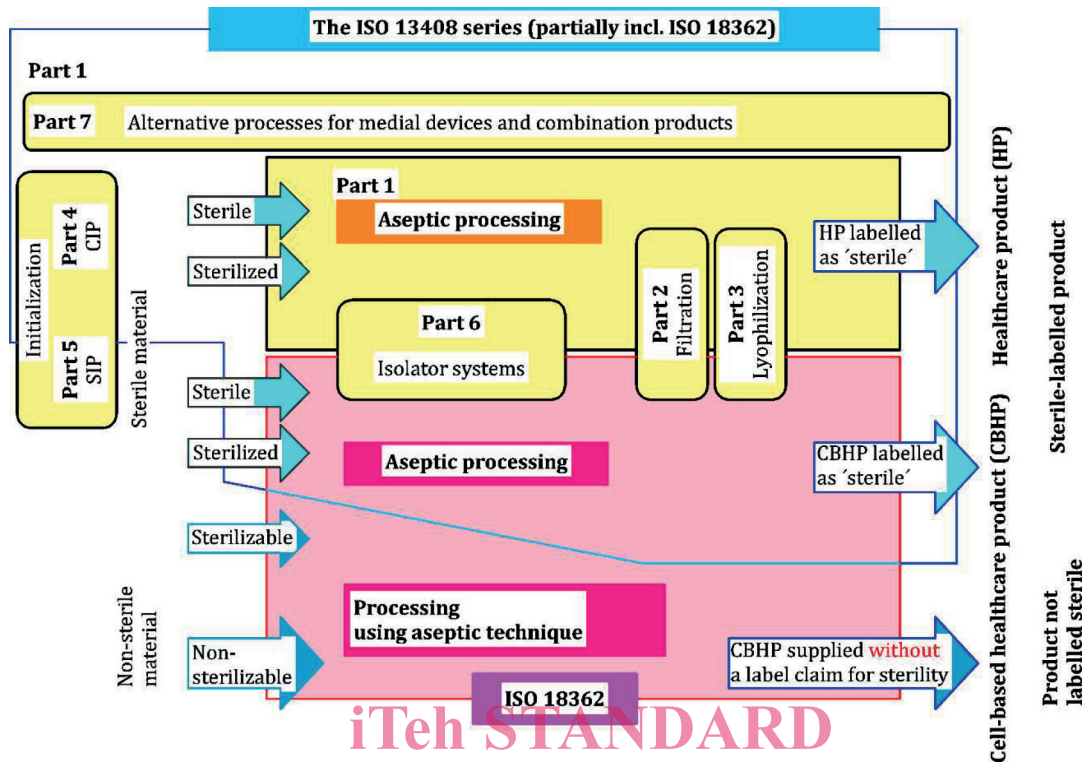


Figure 1 — Relationships of the ISO 13408 series and ISO 18362
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Aseptic processing of health care products —

Part 1: General requirements

1 Scope

This part of ISO 13408 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 part of ISO 13408 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 other parts of ISO 13408.

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 13408-3, *Aseptic processing of health care products — Part 3: Lyophilization*

ISO 13408-4, *Aseptic processing of health care products — Part 4: Clean-in-place technologies*

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 14644-2:2015, *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 terms and definitions given in ISO 11139 and the following apply.

ISO and IEC maintain terminological 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/>

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- 3.1
action level**
value from monitoring that necessitates immediate intervention
[SOURCE: ISO 11139:2018, 3.5]
- 3.2
airlock**
enclosure with interlocked doors designed to maintain pressure control between adjacent areas
[SOURCE: ISO 11139:2018, 3.10]
- 3.3
alert level**
value from monitoring providing early warning of deviation from specified conditions
[SOURCE: ISO 11139:2018, 3.11]
- 3.4
aseptic processing**
handling of sterile product, containers and/or devices in a controlled environment in which the air supply, materials, equipment and personnel are regulated to maintain sterility
[SOURCE: ISO 11139:2018, 3.14]
- 3.5
aseptic processing area
APA**
facilities for *aseptic processing* (3.4), consisting of several zones
[SOURCE: ISO 11139:2018, 3.15]
- 3.6
bioburden**
population of viable microorganisms on or in a product and/or sterile barrier system
[SOURCE: ISO 11139:2018, 3.23 – modified. Note 1 added.]
- Note 1 to entry: For the purposes of aseptic processing, the bioburden of concern is that on or in the product including all factors affecting it such as raw materials, intermediates, other components and equipment.
[SOURCE: ISO 11139:2018, 3.23 – modified. Note 1 added.]
- 3.7
bio-decontamination**
removal and/or reduction of biological contaminants to an acceptable level
[SOURCE: ISO 11139:2018, 3.27]
- 3.8
cleaning**
removal of contaminants to the extent necessary for further processing or for intended use
[SOURCE: ISO 11139:2018, 3.46]
- 3.9
cleanroom clothing system**
Combination of reusable or single-use cleanroom garments and other accessories (e.g. undergarments, footwear, socks, head coverings, face masks, eye coverings, gloves, etc) designed to minimize the risk of contamination during interventions performed in an aseptic environment
Note 1 to entry: The cleanroom clothing system can also protect personnel against other hazards (e.g. chemical, biological, etc.) depending on the products handled in the aseptic environment.

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3.10**closed system**

<aseptic processing> means to prevent egress of hazardous agents and ingress of extrinsic contamination

[SOURCE: ISO 11139:2018, 3.50]

3.11**combination product**

entity presented as a single health care product that physically, chemically, or otherwise brings together or mixes items regulated under separate legislation

Note 1 to entry: The entity could be a combination of medical device and medicinal product or biopharmaceutical product.

[SOURCE: ISO 11139:2018, 3.54]

3.12**correction**

action to eliminate a detected nonconformity

Note 1 to entry: A correction can be made in advance of, in conjunction with or after a corrective action.

Note 2 to entry: A correction can be, for example, rework or regrade.

[SOURCE: ISO 9000:2015; 3.12.3]

3.13**corrective action**

action to eliminate the cause of a nonconformity and to prevent recurrence

Note 1 to entry: There can be more than one cause for a nonconformity.

Note 2 to entry: Corrective action is taken to prevent recurrence whereas *preventive action* (3.32) is taken to prevent occurrence.

Note 3 to entry: This constitutes one of the common terms and core definitions for ISO management system standards given in Annex SL of the Consolidated ISO Supplement to the ISO/IEC Directives, Part 1. The original definition has been modified by adding Notes 1 and 2 to entry.

[SOURCE: ISO 9000:2015, 3.12.2]

3.14**critical control point**

point, step or procedure of an aseptic process at which control can be applied and is essential to prevent or eliminate a hazard or reduce it to an acceptable level

[SOURCE: ISO 5667-13:2011, 3.3, modified — Added "of an aseptic process" to the definition.]

3.15**critical processing zone**

location within the aseptic processing area in which product and critical surfaces are exposed to the environment

[SOURCE: ISO 11139:2018, 3.67]

3.16**critical surface**

surface that might come into direct contact with a product, including its containers or closures, posing a risk of contamination

[SOURCE: ISO 11139:2018, 3.68]