# ISO 11135:2014-07 (E)

## Sterilization of health-care products - Ethylene oxide - Requirements for the development, validation and routine control of a sterilization process for medical devices

## Contents

Page


Foreword ..... v

Introduction ..... vi

1 Scope ..... 1
1.1 Inclusions ..... 1
1.2 Exclusions ..... 1

2 Normative references ..... 2

3 Termsanddefinitions ..... 3

4 Quality management systems ..... 11
4.1 Documentation ..... 11
4.2 Management responsibility ..... 11
4.3 Product realization ..... 11
4.4 Measurement, analysis and improvement -- Control of nonconforming product ..... 11

5 Sterilizing agent characterization ..... 11
5.1 General ..... 11
5.2 Sterilizing agent ..... 12
5.3 Microbicidal effectiveness ..... 12
5.4 Material effects ..... 12
5.5 Safety and the environment ..... 12

6 Process and equipment characterization ..... 12
6.1 General ..... 12
6.2 Process characterization ..... 12
6.3 Equipment characterization ..... 13

7 Productdefinition ..... 14
7.1 General ..... 14
7.2 Product safety, quality and performance ..... 15
7.3 Microbiological quality ..... 15
7.4 Documentation ..... 15

8 Processdefinition ..... 15

9 Validation ..... 16
9.1 General ..... 16
9.2 Installation qualification, IQ ..... 17
9.3 Operational qualification, OQ ..... 17
9.4 Performance qualification, PQ ..... 18
9.5 Review and approval of validation ..... 20

10 Routine monitoring and control ..... 22

11 Product release from sterilization ..... 23

12 Maintaining process effectiveness ..... 23
12.1 General ..... 23
12.2 Maintenance of equipment ..... 24
12.3 Requalification ..... 24
12.4 Assessment of change ..... 24
12.5 Assessment of equivalence ..... 25

Annex A (normative) Determination of lethal rate of the sterilization process -- Biological indicator/bioburden approach ..... 26

Annex B (normative) Conservative determination of lethal rate of the sterilization process -- Overkill approach ..... 27

Annex C (informative) Temperature sensors, RH sensors and biological indicator numbers ..... 29

Annex D (informative) Guidance on the application of the normative requirements ..... 32

Annex E (normative) Single Lot Release ..... 74

Bibliography ..... 76