

DIN ISO 21881:2020-12 (E)

Sterile packaged ready for filling glass cartridges (ISO 21881:2019)

Contents		Page
National foreword		4
National Annex NA (informative) Bibliography		5
Foreword		7
Introduction		8
1 Scope		9
2 Normative references		9
3 Terms and definitions		9
4 Quality system		11
4.1 General		11
4.2 Testing		11
5 Process description and requirements		11
5.1 Washing		11
5.2 Drying		11
5.3 Lubrication		11
5.4 Capping and crimping		12
5.5 Plunger insertion		12
5.6 Packaging		12
5.7 Sterilization		12
6 Requirements for glassware		12
6.1 General		12
6.2 Material		12
6.3 Dimensions		13
6.4 Particles		13
6.4.1 Visible particles		13
6.4.2 Sub-visible particles		13
6.5 Bacterial endotoxin level		13
7 Requirements for packaging system		14
7.1 General		14
7.2 Nest and tub configuration		15
7.3 Tray configuration		15
7.4 Nest		15
7.5 Tub and tray		16
7.6 Insert liner		16
7.7 Sealing lid		16
7.8 Protective bag		16
7.9 Information to be provided by the manufacturer		17
8 Marking of the tub or tray		17
9 Labelling		18

Annex A (informative) Design of tub	19
Annex B (informative) Design of nest	20
Annex C (informative) Design of tray	21
Annex D (normative) Glide force test method to evaluate cartridge lubrication	22
Annex E (informative) Schematic illustrations of examples for the orientation of tubs or trays within the protective bag	24
Annex F (normative) Closure systems liquid leakage	27
Annex G (informative) Sample preparation for endotoxin and particulate determination	29
Annex H (informative) Product and packaging configuration	33
Bibliography	36