

ISO 11137-1:2025-04 (E)

Sterilization of health care products - Radiation - Part 1: Requirements for the development, validation and routine control of a sterilization process for medical devices

Contents	Page
Foreword.....	iv
Introduction.....	viii
1 Scope.....	1
2 Normative references.....	2
3 Terms and definitions.....	2
4 General.....	9
5 Sterilizing agent characterization.....	9
5.1 Sterilizing agent.....	9
5.2 Microbicidal effectiveness.....	9
5.3 Material effects.....	10
5.4 Environmental considerations.....	10
6 Process and equipment characterization.....	10
6.1 Process.....	10
6.2 Equipment.....	10
7 Product definition.....	11
8 Process definition.....	12
8.1 Establishing the maximum acceptable dose, $D_{\max,acc}$	12
8.2 Establishing the sterilization dose, D_{ster}	12
8.3 Specifying the maximum acceptable dose and the sterilization dose.....	12
8.4 Transference of maximum acceptable, verification or sterilization dose between radiation sources.....	13
8.4.1 Transference of maximum acceptable dose.....	13
8.4.2 Transference of verification dose or sterilization dose.....	13
9 Validation.....	13
9.1 Installation qualification (IQ).....	13
9.2 Operational qualification (OQ).....	13
9.3 Performance qualification (PQ).....	14
9.4 Review and approval of validation.....	15
10 Routine monitoring and control.....	16
11 Product release from sterilization.....	17
12 Maintaining process effectiveness.....	17
12.1 Demonstration of continued effectiveness.....	17
12.1.1 General.....	17
12.1.2 Frequency of determinations of bioburden.....	17
12.1.3 Frequency of sterilization dose audits.....	18
12.2 Recalibration.....	19
12.3 Maintenance of equipment.....	19
12.4 Requalification of equipment.....	19
12.5 Assessment of change.....	20
Annex A (informative) Guidance on this document.....	21
Bibliography.....	37