

Table of Contents

1	Introduction	9
1.1	Purpose.....	9
1.2	Scope.....	9
1.3	Structure of This Guidance	9
1.4	Background.....	10
2	Use of Ozone in the Pharmaceutical Industry	13
2.1	Introduction	13
2.2	Overview of Ozone Use Advantages and Disadvantages	13
3	Regulatory and Industry Guidance	17
3.1	Introduction	17
3.2	USP General Information Chapter <1231>.....	17
3.3	FDA and Other Regulatory Agencies	18
3.4	EP, JP, and EMA	18
3.5	ISPE.....	18
4	Ozone Characteristics	19
4.1	Introduction	19
4.2	What is Ozone?	19
4.3	Ozone and Free Radicals	20
4.4	Degradants Associated with Ozone Generation and Destruction	21
5	Effectiveness of Ozone for Microbial Control	25
5.1	Introduction	25
5.2	Ozone Use in Pharmaceutical Water Systems	25
5.3	Mechanisms and Targets of Ozone Attack.....	25
5.4	Factors Affecting Ozone Efficacy	26
5.5	Ozone Sanitization Strategies.....	26
5.6	Determining Ozone Sanitization Frequency	28
5.7	Summary Elements of Optimal Microbiological Control Using Ozone	28
6	Ozone Generation	31
6.1	Introduction	31
6.2	Corona Discharge Ozone Generation.....	31
6.3	Electrolytic Ozone Generation	36
6.4	Sizing an Ozone Generator	38
7	Ultraviolet Light for Ozone Destruction.....	43
7.1	Introduction	43
7.2	Electromagnetic Spectrum.....	43
7.3	Mercury Arc Lamps.....	44
7.4	Conventional Low Pressure Lamps	45
7.5	Amalgam Lamps.....	45
7.6	Medium Pressure Mercury Arc Lamps.....	46
7.7	Ozone Absorbance of UV Light.....	47
7.8	UV Dose.....	48
7.9	UV Destruct Unit Sizing	49
7.10	UV Intensity Monitors.....	49

7.11	UV Lamp Aging	49
7.12	UV Lamp Field Burn-in.....	51
7.13	UV Lamp Validation (Certified Lamps).....	51
7.14	UV and Water Temperature	51
7.15	Frequency of Lamp On/Off (Cycling) and Power Fluctuations.....	52
7.16	Flow and Pressure Related Concerns	52
8	Ozone Sensors.....	55
8.1	Introduction	55
8.2	Polarographic Sensors.....	55
8.3	UV Photometers.....	56
8.4	Ozone Sensor Properties and Related Term Definitions	57
8.5	Calibration.....	58
8.6	Sensor Verification	62
8.7	Servicing	62
9	System Design	65
9.1	Introduction	65
9.2	Storage Vessel Configuration and Ozone Introduction	65
9.3	Vent Filter.....	70
9.4	Vent Gas Destruction	74
9.5	Water Temperature Control.....	74
9.6	Ozone Sensor Location	75
9.7	Materials of Construction	75
9.8	Retrofitting Water Systems with Ozone Sanitization Capability.....	76
10	System Operation and Control.....	79
10.1	Introduction	79
10.2	Ozone Dispensing Options	79
10.3	Storage Tank Dissolved Ozone Levels	80
10.4	UV Operation for Ozone Destruction	81
10.5	Dissolved Ozone Monitoring and Verification of Removal	81
10.6	Distribution Loop Sanitization and Frequency	81
10.7	System Shock Sanitization Capability.....	83
10.8	Conductivity Monitoring.....	83
10.9	Total Organic Carbon (TOC) Monitoring	83
10.10	Point of Use Sampling and Maintenance for Microbiological Control	84
10.11	Safety.....	84
10.12	Ozone Related Process Parameter Summary.....	88
10.13	Rouge	88
11	Commissioning and Qualification.....	91
11.1	Introduction	91
11.2	Design Requirements	91
11.3	Commissioning/Verification.....	94
11.4	Installation Qualification/Verification	94
11.5	Operational Qualification/Verification	95
11.6	Performance Qualification.....	96
12	Ozone and Heat Sanitization Comparison.....	97
12.1	Introduction	97
12.2	Importance of Considering All User Requirements	97
12.3	Heat versus Ozone Sanitization Considerations.....	97
12.4	Life Cycle Cost Development.....	99

13	Ozone and Chemical Sanitization Comparison	101
13.1	Introduction	101
13.2	Need for Ozone Comparisons to Other Sanitization Approaches.....	101
13.3	Reasons for Considering Changes in Sanitization Approaches.....	101
13.4	Common Challenges of All Chemical Sanitants.....	102
13.5	Comparison of Parameters of Conventional Chemical and Ozone Sanitization Approaches.....	102
13.6	Conclusions	105
14	Appendix 1 – Additional Information for System Design, Operation, and Control....	107
14.1	Pharmaceutical Examples of Verifying Absence.....	108
14.2	Estimating a Lower Limit of Detection (LOD) for Sensors Using System Specific Data	110
14.3	System Sanitization Concept Comparisons.....	112
14.4	Worksheets for Comparing Capital and Operating Costs and Other Factors for Sanitization Approach Options.....	116
15	Appendix 2 – References	127
16	Appendix 3 – Glossary	131
16.1	Acronyms and Abbreviations	132
16.2	Definitions	134

