



# Steam Sterilization

Hollow fiber cartridges for membrane separations

Handbook

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# 1 Introduction

## About this handbook

This handbook describes how to assemble, install, and steam sterilize Cytiva STM, SMO, and MSM membrane filter cartridges.

You can download this handbook from the Cytiva Web site.

## Target audience

This handbook is intended for experienced users of microfiltration and ultrafiltration membrane filter cartridges. Specifically, the handbook addresses the needs of scientists, process engineers, and technicians who operate research, laboratory, pilot, and production filtration systems.

Cytiva recommends that this product is handled only by those who have been trained in laboratory techniques and that it is used in accordance with the principles of good laboratory practice. For assistance. See [Getting help, on page 3](#).

## Where to find more information

This handbook is a supplement to the Operating Handbook, Hollow fiber cartridges for membrane separations. In addition, Cytiva publishes easy-to-use handbooks related to its cross flow filtration equipment. You can view and download these handbooks from our Web site, [cytiva.com](http://cytiva.com)

Other handbook in the cartridge filter documentation set is Selection Handbook, Hollow fiber cartridges and systems for membrane separations, a downloadable handbook posted on our Web site and available in hard copy from Cytiva and its distributors.

## Getting help

Contact Cytiva customer and technical support teams by going to <http://cytiva.com> "contact us" page and finding your local Cytiva office.

## Return authorization

To return a cartridge purchased from Cytiva, contact your local Cytiva supplier.

## Warranty

Cytiva warrants its hollow fiber cartridges to be free from defects in workmanship and materials for a period of 30 days after the date of shipment from Cytiva or its authorized dealers, provided that the cartridges have been operated in accordance with Cytiva published specifications and good engineering practices.

Cytiva shall have no liability under this warranty or otherwise for improper application or abuse of the subject cartridge or cartridges. This warranty is exclusive of all other implied warranties including merchantability or fitness for a particular purpose.

The information contained in this handbook is not intended to constitute any representation of warranty by Cytiva.

## 2 Safety

When using any laboratory, pilot scale, or production filtration equipment, the potential exists for personal injury unless you follow established safety procedures. When using Cytiva test procedures and products, you should follow OSHA, federal, state, and local safety mandates and regulations. You should follow your company's safety procedures and the safety instruction provided in this handbook.

This handbook uses highlighted text with safety flags to provide safety information and expert advice:

**WARNING**

**WARNING** indicates a hazardous situation which, if not avoided, could result in death or serious injury. It is important not to proceed until all stated conditions are met and clearly understood.

**Tip:** *An expert advice tip flag provides information to use your hollow fiber membrane cartridge and system efficiently to achieve the best results.*

### Safety precautions

Potentially, the heat or pressure of steam can rupture a weakened or improperly assembled connection, kinked hoses or lines, and other system components. Such a rupture can expose personnel to high pressure steam and cause severe injury.

To avoid the unexpected rupture of a filter system or connection due to improper assembly or overpressurization you should:

- Ensure you read the entire handbook before sterilizing a cartridge with steam.
- Ensure all system components can be steam sterilized.
- Ensure all system components are assembled correctly.
- Know—and do not exceed—the maximum operating pressure of your system components

The Operating Handbook, Hollow fiber cartridges for membrane separations, describes the maximum operating pressure of the cartridge filters (visit [cytiva.com](https://www.cytiva.com)). To avoid exceeding the maximum operating pressure and to monitor the sterilization process effectively, it is critical that you install pressure gauges on the system as described in this handbook.

**WARNING**

To avoid injury in the event of an unexpected steam leak, wear appropriate personal protection gear in accordance with your company's safety policy (or national or regional regulations).

# 3 Housing design and assembly

## In this chapter

<b>Section</b>		<b>See page</b>
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3.2	How to install a membrane filter cartridge element in a housing	8
3.3	Where and how to install the filter	13

## 3.1 Overview

### Housing and cartridge design

Cytiva manufactures three models of steamable housings and membrane filter cartridge elements identified by model designations STM, SMO, and MSM. The SMO and STM families are based on a 7.6 cm (3 in) diameter element. SMO cartridges have an open face and a single O-ring seal at each end. STM units have end caps at each face that neck down to a double O-ring seal for connection to stainless steel end fittings. Larger MSM steam-in-place (SIP) elements have a nominal 10.2 cm (4 in) diameter and an open face configuration.

### Housing design

Housings are constructed of stainless steel and accept steamable, replaceable membrane filter cartridge elements. O-rings and end plates seal the membrane filter cartridge element in the housing. Sanitary connectors on the housing end plates enable connection to your filtration system (Fig 2).

Additional 1.27 cm (0.5 in) sanitary connections are used for low point condensate drain and steam trap installation.

### Membrane filter cartridge element design

Hollow fiber membranes are cast of polysulfone, and are designed and tested for the temperatures and pressures required for autoclaving and steam-in-place sterilizing as described in this handbook. Membrane filter cartridges are machined of polysulfone also. The fiber bundles are held within the cartridge by coarse polypropylene screens. Fibers are potted at each end in CFR-listed food grade epoxy. All components conform to USP XXVII Class VI Biological Test for Plastics.

Cytiva supplies three families of steam-in-place designs: STM, SMO, and MSM. The SMO and STM designs have a diameter of 7.6 cm (3 in), while the MSM design is 10.2 cm (4 in). Each design is unique and requires a dedicated, matching membrane filter cartridge and housing. These devices are not interchangeable, although each of the designs incorporates similar features.

## 3.2 How to install a membrane filter cartridge element in a housing

### Installing an STM cartridge element in an STM housing

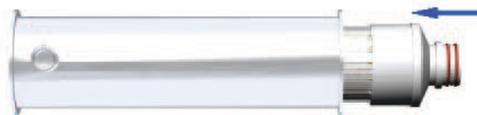
Follow these steps to install an STM cartridge element into an STM housing:

Step	Action
------	--------

- |   |  |
|---|--|
| 1 | Install double O-rings at each end of the cartridge. |
|---|--|

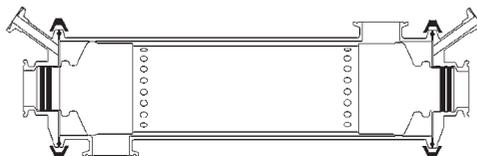


- |   |  |
|---|--|
| 2 | Place the stainless steel housing horizontally on a work bench and slide the cartridge element into the housing. |
|---|--|



- |   |  |
|---|--|
| 3 | Holding the cartridge at one end, push a retentate end cap with 7.6 cm (3 in) gasket over the double O-rings at the other end of the element. Repeat this process to install the gasket and retentate end cap on the other end of the element. |
|---|--|

- |   |  |
|---|--|
| 4 | Clamp the housing using the supplied 7.6 cm (3 in) Tri-Clamp®. |
|---|--|



### Installing an SMO cartridge element in an SMO housing

Follow these steps to install an SMO cartridge element into an SMO housing:

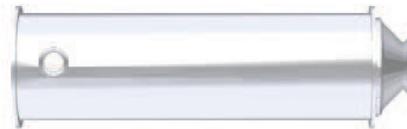
**Step Action**

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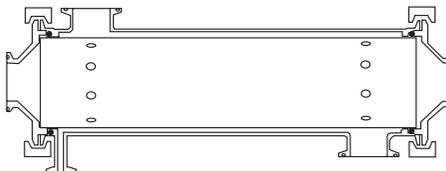
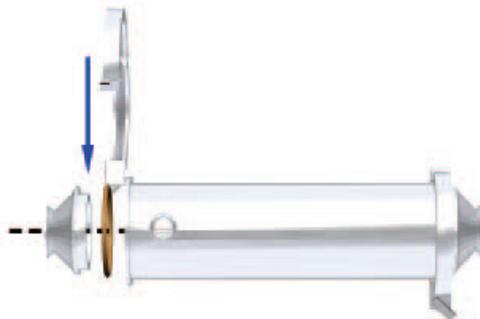
- 1 Place the stainless steel housing horizontally on a workbench.
- 2 Position an O-ring around one end of the cartridge and push it into place using an end cap.



- 3 Slide membrane filter cartridge (which now has one O-ring in position) into one end of housing. Clamp end cap.



- 4 Add a second O-ring as shown below and clamp end cap.



## Installing an MSM cartridge element in an MSM housing

Follow these steps to install an MSM cartridge element into an MSM housing:

Step	Action
------	--------

- |   |   |
|---|---|
| 1 | Install an O-ring on the groove at one end of the cartridge element. If the O-ring seems snug, moisten the O-ring with high purity water for lubrication. |
|---|---|



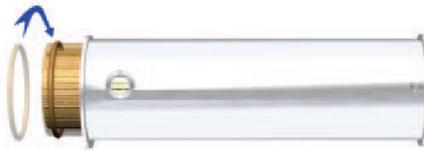
- |   |   |
|---|---|
| 2 | To properly center the membrane filter cartridge inside the housing, place the housing on a protective surface in a vertical orientation. Pushing down on the face of the cartridge, force the cartridge into the housing until the lower face makes contact with the surface of the table. |
|---|---|



**Step    Action**

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- 3       Lay the cartridge in a horizontal position and continue to push the cartridge into the housing until the O-ring groove emerges from the other end.



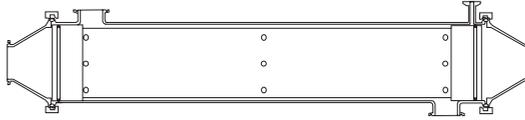
- 4       Place the second O-ring in the groove and return the cartridge to a vertical orientation (housing down/cartridge up) and push the cartridge down until centered in the housing.



- 5       Secure the endplates with Tri-Clamp gaskets and clamps.



MaxCell™ MSM cartridge and housing The design of the MSM housing and retentate end cap requires a Tri-Clamp gasket between the housing and end cap.

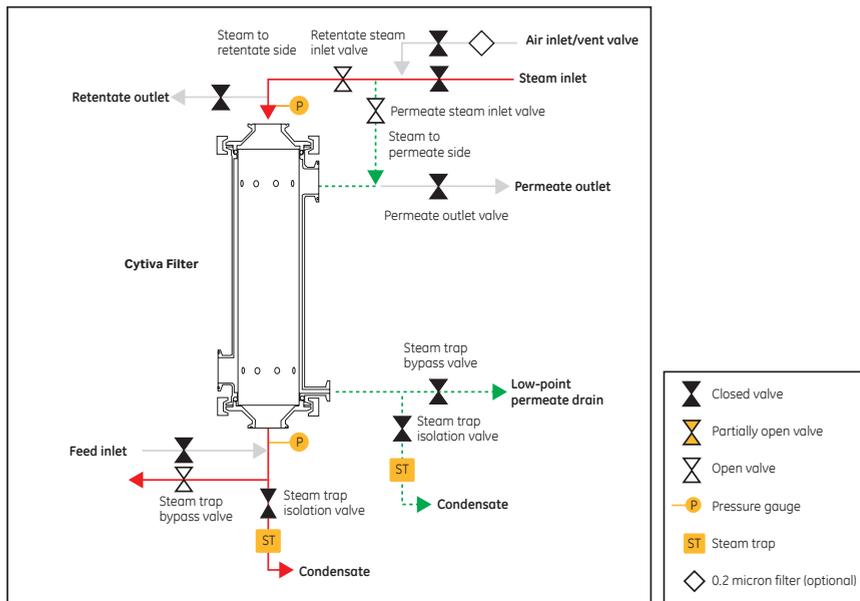


**Tip:** *Do not strike the cartridge face. Use only hand pressure to apply a steady downward force.*

## 3.3 Where and how to install the filter

### Where to install the housing

To complete steam-in-place sterilization, you must integrate steam lines, steam traps, additional valves, and instrumentation into the filtration system. Specific installation requirements and design can vary according to process variables; however, a typical setup includes a steam line piped into the retentate port and a steam condensate line with a steam trap and isolation valve piped into the feed line (image below).



**Tip:** We recommend that you connect the vent valve to an air line pressurized to about 0.103 MPa (1.03 barg, 15 psig) to permit the use of an air “overpressure” condition at the end of the cycle, to ensure that no unsterilized air can infiltrate the system.

You should place a hydrophobic 0.2-micron microporous filter in the vent line to maintain sterility.

You may be able to use steam traps as small as 0.25 in, depending upon the size of your system.

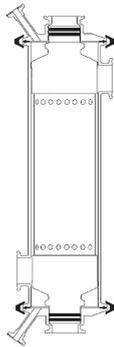
### How to install the housing

Pipe the housing into your system using established standards for piping and pipe support. Consult national, regional, local, and your company’s piping regulations and guidelines.

Steamable housing models STM, SMO, and MSM use sanitary connectors to connect feed, retentate, permeate, drain, and vent ports. Connect the ports to your system using sanitary connectors, O-rings, and Tri-Clamps.

## 3 Housing design and assembly

### 3.3 Where and how to install the filter

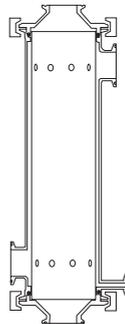


#### **Housing 35STM**

Length = 43.4 cm (17.1 in)  
Diameter = 9.1 cm (3.6 in)  
Permeate ports = 1.5-in Tri-Clamp  
Feed/retentate ports = 1.5-in Tri-Clamp  
Drain/vent ports = 0.5-in Tri-Clamp

#### **Housing 55STM**

Length = 75.2 cm (29.6 in)  
Diameter = 9.1 cm (3.6 in)  
Permeate ports = 1.5-in Tri-Clamp  
Feed/retentate ports = 1.5-in Tri-Clamp  
Drain/vent ports = 0.5-in Tri-Clamp

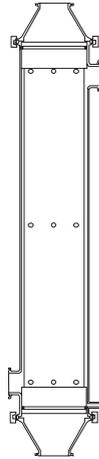


#### **Housing 35SMO-DP**

Length = 37.3 cm (14.7 in)  
Diameter = 9.1 cm (3.6 in)  
Permeate ports = 1.5-in Tri-Clamp  
Feed/retentate ports = 1.5-in Tri-Clamp  
Drain port = 0.5-in Tri-Clamp

#### **Housing 55SMO-DP**

Length = 69.3 cm (27.3 in)  
Diameter = 9.1 cm (3.6 in)  
Permeate ports = 1.5-in Tri-Clamp  
Feed/retentate ports = 1.5-in Tri-Clamp  
Drain port = 0.5-in Tri-Clamp



#### **Housing 45MSM-DP**

Length = 52.8 cm (20.8 in)  
Diameter = 11.4 cm (4.5 in)  
Permeate ports = 1.5-in Tri-Clamp  
Feed/retentate ports = 2-in Tri-Clamp  
Drain port = 0.5-in Tri-Clamp

#### **Housing 65MSM-DP**

Length = 75.7 cm (29.8 in)  
Diameter = 11.4 cm (4.5 in)  
Permeate ports = 1.5-in Tri-Clamp  
Feed/retentate ports = 2-in Tri-Clamp  
Drain port = 0.5-in Tri-Clamp

#### **Housing 85MSM-DP**

Length = 134 cm (52.7 in)  
Diameter = 11.4 cm (4.5 in)  
Permeate ports = 1.5-in Tri-Clamp  
Feed/retentate ports = 2-in Tri-Clamp  
Drain port = 0.5-in Tri-Clamp

Optional elbow adapters are available for  
85MSM stainless steel housing  
(SS-85MSM-EL-DP)

## 4 Expert tips

### Introduction

In many cross flow filtration applications—particularly in the pharmaceutical and biotechnology fields—the sterility of the filter must be ensured before using it. Steaming-in-place is one method to sterilize cartridge filters. Steaming-in-place requires the proper equipment, operated properly and consistently, to ensure complete sterilization and validation. Therefore, the goal of this chapter is to provide recommendations and techniques to help ensure efficient and effective steam sterilization.

### Streamlining the steam-in-place process

From an operational standpoint, here are some steps that can be taken to streamline the steam-in-place process:

Step	Action
1	Permanently install the steam-in-place components on the filtration system to save setup time and not disturb the process system.
2	Ensure all components in the system, such as valves and pressure gauges, are steampable by reviewing equipment specifications. Using steampable process equipment ensures safety and minimizes component replacement and maintenance.

### Process design for effective sterilization

Cartridge integrity and proper sterilizing steps are required to help ensure sterilization. Establish, through trials, a sterilization procedure that provides the desired results. Validate this procedure, and write and use standard operating procedures (SOPs) for consistency.

Superheated steam can overheat the cartridge, causing damage to the cartridge or influencing membrane performance. Ensure the temperature and quality of the steam is consistent.

As part of your SOP, check all valve positions before operating or steam cleaning your system.

Do not induce a backpressure on the membrane cartridge.

# 5 Steam sterilization procedure

## Important considerations

- Make sure all lines and components of your system are compatible with steam sterilization.
- Do not run steam through retentate side only. Steam must be introduced equally on retentate and permeate sides—see [Chapter 5 Steam sterilization procedure, on page 16](#) for complete steam sterilizing procedure.
- Make sure that no crimping, blockage, or unwanted valve shutoff occurs, to prevent rupture or component failure.
- Make sure that steam traps are positioned at low point drains to prevent condensate from cooling in the recirculation loop or permeate at any point.
- Do not exceed—the maximum operating pressure of your system components.
- Monitor pressure with appropriate instrumentation during sterilization.
- Install cartridges with all requisite O-rings, connectors, and clamps.
- Develop and enforce standard operating procedures for effective sterilization.
- Check membrane filter cartridge and housing integrity after sterilization—see [Stage 4—Check filter integrity, on page 20](#) for details.
- Make sure that all system valves, lines, and configurations are set for processing before transitioning from sterilization to production.
- Steam that undergoes an abrupt expansion at high flow rates can carry latent heat, commonly called “superheated steam.” The high temperatures in superheated steam can cause damage to polymers and elastomers. Superheated steam can be avoided by properly reducing pressure through a sequence of regulators. The steam pressure on the upstream side of the regulator used to control the pressure on these membranes should not exceed 0.2 MPa (2 barg, 30 psig).

## Overview

To steam sterilize a Cytiva STM, SMO, or MSM cartridge assembly in a steam-in-place application, inject steam into both the feed and permeate ports using the steps and process conditions described below. Steam penetrates both sides of the filter membrane and condensate exits from two low-point steam traps.

There are five stages:

1. Configure system for steaming
2. Introduce steam, flush, and hold
3. Cool and pressurize
4. Check filter integrity
5. Configure system for processing

**CAUTION**

**Risk of rupturing!** Make sure all components in the system are compatible with steam sterilization. Components of the system that do not comply with this requirement, are susceptible to rupture and can cause injury from projectiles and live steam.

Cytiva filter cartridges and stainless steel housings are steam sterilized. If other components in your filtration system are not designed to withstand steaming, they can rupture, causing injury from projectiles and live steam. To prevent injury due to rupturing, ensure all components in the system— such as valves and pressure gauges —are steam sterilized. Confirm that the equipment can be steam sterilized by reviewing equipment specifications. If a steam leak occurs and personnel are not wearing proper personal protection, severe injury can result.

**WARNING**

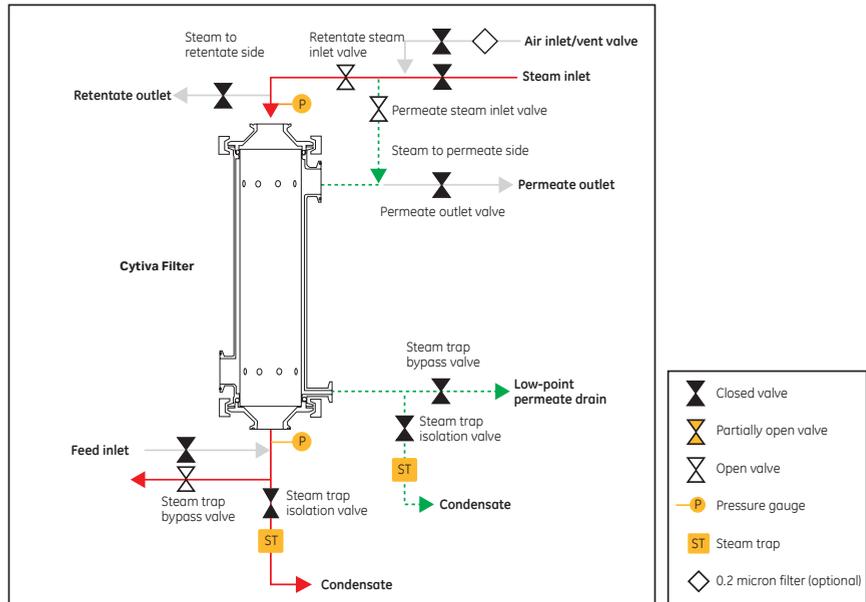
Always use appropriate Personal Protective Equipment (PPE) during operation and maintenance of this product.

The following procedure is specific to steam-in-place of the cartridge and housing only. When steaming-in-place large process vessels or process systems with a large void volume, it is recommended that the steam line be introduced separately from the filter. It is possible to introduce steam into small process systems via one steam line, however this must be done very carefully and slowly to prevent reverse steam pressure on the filter cartridge.

## Stage 1—Configure system for steaming

Follow the steps below to configure the system for steaming:

Step	Action
1	Remove all glycerine from ultrafiltration cartridges.
2	Isolate the steam traps.
3	Close the feed inlet, permeate outlet, low-point permeate drain, retentate outlet, and air inlet/vent valves.
4	Open the retentate and permeate inlet steam valves.
5	Open the feed steam trap bypass valve.
6	Close the permeate steam trap bypass valve.



## Stage 2—Introduce steam, flush, and hold

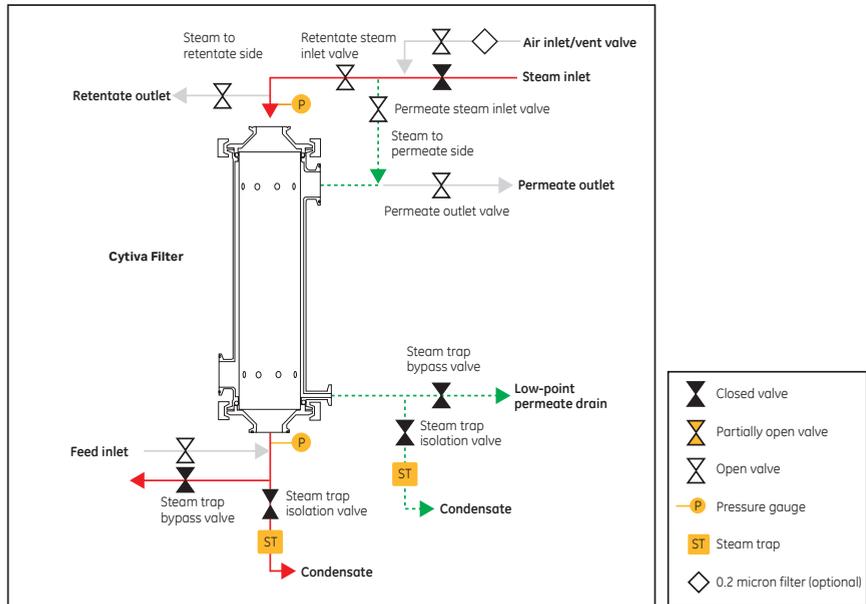
Follow the steps below to steam the cartridge:

Step	Action
------	--------

- |   |  |
|---|--|
| 1 | <p><b>Introduce steam</b></p> <ol style="list-style-type: none"> <li>Crack open the steam inlet valve or adjust regulator to 0.007 MPa (0.07 barg, 1 psig). Steam and water should trickle from the steam trap bypass valve (feed). Adjust the steam inlet valve so that the system outlet temperature reaches about 100°C (212°F) in five to ten minutes (Fig 8).</li> <li>Once the system outlet temperature reaches 100°C, wait five minutes and open the permeate steam trap bypass valve. Wait five more minutes. Close both steam trap bypass valves.</li> <li>Open the steam trap isolation valves, maintaining steam flow into both sides (retentate and permeate) of the filter. Condensate will drain from the steam traps.</li> </ol> |
| 2 | <p><b>Steam flush—slowly increase the pressure</b></p> <ol style="list-style-type: none"> <li>Open the process retentate valve slightly.</li> <li>Slowly open the main steam inlet valve.</li> <li>Let the pressure increase, but do not exceed 0.103 MPa (1.03 barg, 15 psig).</li> </ol>   |



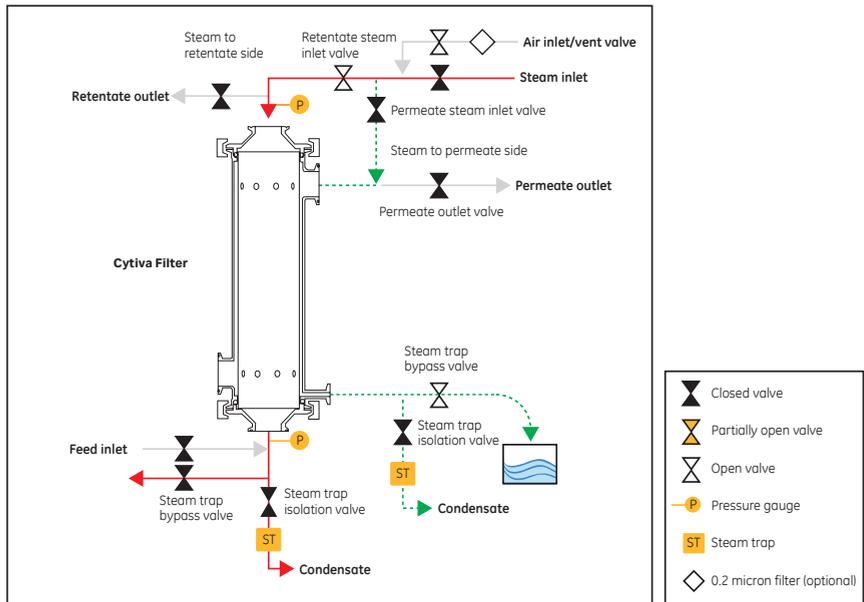
**Note:** It is recommended that the vent valve be connected to air pressure adjusted to approximately 0.103 MPa (1.03 barg 15 psig). Maintaining positive pressure will assure that no unsterilized air infiltration will occur anywhere in the system. A sterile, 0.2 micron hydrophobic filter must be positioned in the vent line to maintain sterility.



## Stage 4—Check filter integrity

Checking the integrity of the filter is optional, but recommended and sometimes required in many applications. See the Cytiva Integrity testing handbook for additional details. The basic steps to complete integrity testing include:

Step	Action
1	Close all valves except the air inlet/vent valve, retentate steam inlet valve, and permeate steam trap bypass valve.
2	Attach flexible tubing to permeate steam trap bypass valve and immerse in a beaker of water.
3	Perform pressure hold integrity test by introducing air at approximately 0.034 MPa (0.34 barg, 5 psig) through the air vent. Watch for bubbles emanating from the permeate drain.
4	If only small bubbles emanate, the cartridge has integrity.

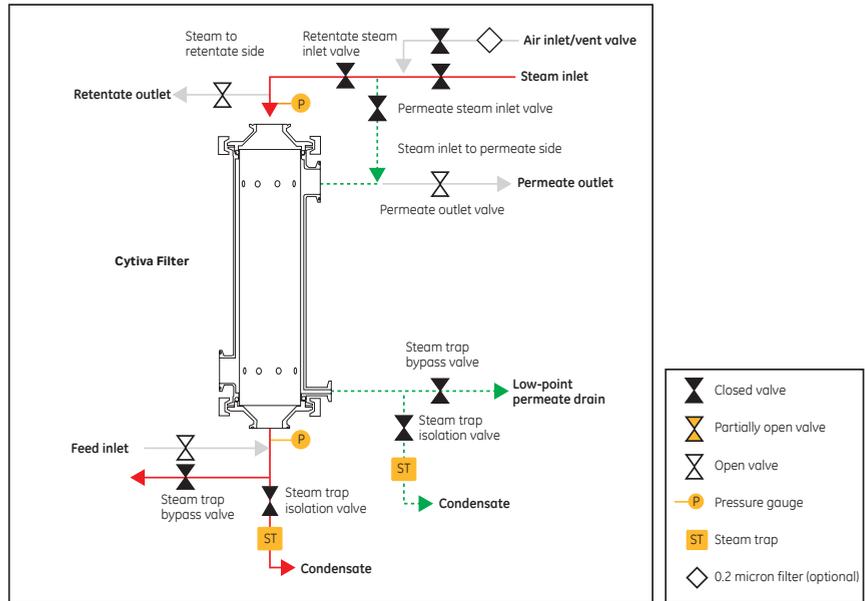


## Stage 5—Configure system for processing

Follow the steps below to configure the system for processing:

Step	Action
1	Close the air inlet/vent valve, retentate, and permeate steam inlet valves, steam trap isolation valves, and steam trap bypass valves.
2	Open feed inlet valve, permeate outlet valve, and retentate outlet valve.
3	The system is now ready for processing.

## 5 Steam sterilization procedure



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