

CONTENTS

Foreword	vii
Statements of Policy	viii
Committee Roster	ix
Summary of Changes	xii
Part GR General Requirements	
GR-1 Introduction	1
GR-2 Scope	1
GR-3 Inspection	1
GR-4 Inspector/Examiner	1
GR-5 Responsibilities	1
GR-6 Access for Inspectors	2
GR-7 Manufacturer's Quality Assurance Program	2
GR-8 Metric	2
GR-9 References	2
GR-10 Terms and Definitions	3
Part SD Design for Sterility and Cleanability	
SD-1 Introduction	8
SD-2 Scope and Purpose	8
SD-3 General Guidelines	8
SD-4 Specific Guidelines	19
SD-5 Testing and Inspection	44
SD-6 Documentation	46
SD-7 Responsibilities	46
Part DT Dimensions and Tolerances for Stainless Steel Automatic Welding and Hygienic Clamp Tube Fittings and Process Components	
DT-1 Scope	47
DT-2 Pressure Rating	47
DT-3 Marking	47
DT-4 Materials	47
DT-5 Metal Thickness	47
DT-6 Fitting Dimensions	47
DT-7 Tests	48
DT-8 Tolerances	48
DT-9 Welding Ends	48
DT-10 Hygienic Clamp Ends	48
DT-11 Heat Treatment	48
DT-12 Surface Condition	48
DT-13 Packaging	48
DT-14 Minimum Examination Requirements	48
Part MJ Material Joining	
MJ-1 Scope	66
MJ-2 Materials	66
MJ-3 Joining Processes and Procedures	66
MJ-4 Weld Joint Design and Preparation	67
MJ-5 Filler Material	67
MJ-6 Weld Acceptance Criteria	67
MJ-7 Inspection, Examination, and Testing	69
MJ-8 Procedure Qualification	73

MJ-9	Performance Qualification	73
MJ-10	Documentation Requirements	73
MJ-11	Passivation	74
Part SF	Stainless Steel and Higher Alloy Product Contact Surface Finishes	
SF-1	Scope	75
SF-2	Objective	75
SF-3	Applications	75
SF-4	Material	75
SF-7	Inspection and Techniques Employed in the Classification of Product Contact Surface Finishes	75
SF-8	Description of Various Surfaces Available on Stainless Steel and Higher Alloys	75
Part SG	Equipment Seals	
SG-1	Scope and Purpose	82
SG-2	Seal Classes	82
SG-3	General Provisions for Seals in Bioprocessing Service: User Basic Design Requirement	82
SG-4	Special Provisions for Seals in Bioprocessing Service	89
Part PM	Polymer-Based Materials	95
PM-1	Introduction	95
PM-2	Design Considerations for Polymeric Piping, Tubing, Fittings, Valve Bodies, and Other Components	95
PM-3	Polymer Material Joining	97
PM-4	Polymer Interior Product Contact Surfaces of Piping, Tubing, Fittings, Valve Bodies, and Coated or Lined Vessels	101
PM-5	Materials of Construction	101
Figures		
SD-1	Hygienic Connections	10
SD-2	Non-Hygienic Connections	12
SD-3	Flat Gasket Applications	13
SD-4	Recommended and Preferred Drop Designs	17
SD-5	Double Block-and-Bleed Valve Assembly	18
SD-6	Instrument Location Detail: Hygienic Design	19
SD-7	Flexible Hygienic Hose Design	20
SD-8	Tank/Vessel Vent Filters	22
SD-9	Nozzle Design	24
SD-10	Sidewall Instrument Ports	25
SD-11	Dip Tube	26
SD-12	Vessel Design Tangential Nozzles	26
SD-13	Vessel Sight Glass Design	27
SD-14	Side and Bottom Connections	28
SD-15	Dip Tube Nozzles: Removable Designs	29
SD-16	Sight Glass Design	30
SD-17	Internal Support Members	31
SD-18	Mitered Fittings	32
SD-19	Typical Nozzle Detail	32
SD-20	Double Tubesheet Heat Exchanger Bonnet Design	33
SD-21	In-Tank Couplings	34
SD-22	Removable Agitator Impeller Design	36
SD-23	Point-of-Use Piping	38
SD-24	Transfer Panel Tolerances	42
SD-25	Transfer Panel Looped Headers	43
SD-26	Transfer Panel Jumpers	45
MJ-1	Acceptable and Unacceptable Weld Profiles for Tube Welds	71
SG-1	Basic Components of a Seal	85

SG-2	Single Dry Running Contacting Seal	86
SG-3	Internally Mounted, Process Lubricated Contact Seal	86
SG-4	Externally Mounted, Process Lubricated Contact Seal	87
SG-5	Double Seal Installation	87
SG-6	Tandem Seal Installation	88
SG-7	Seal Piping and Lubrication Plans	89
SG-8	Gas Lubricated Noncontacting Double Seal	90
SG-9	Tandem Seal With Barrier System	90
SG-10	Typical Packing Installation	91
SG-11	V-Ring Packing for Reciprocating Applications	91
SG-12	Open Cross-Sectional Lip Seal	91
SG-13	Labyrinth Seal	91
SG-14	Typical Angle Valve With Rolling Diaphragm and Orifice	92
SG-15	Example of Sampling Valve With Uniformly Loaded Sliding Seal	93
SG-16	Typical In-Line Diaphragm Valve With Weir	93
SG-17	Typical Ball Valve Configuration	94
PM-1	Acceptable and Unacceptable Weld Profiles for Beadless Welds	100
Tables		
SD-1	L/D Dimensions for Flow-Through Tee: Full-Size Standard Straight Tee With Blind Cap	14
SD-2	L/D Dimensions for Flow-Through Tee: Short Outlet Reducing Tee With Blind Cap	15
SD-3	Annular Spacing Recommendations for Hygienic Dip Tubes	25
SD-4	Recommended Flow Rates to Achieve 5 fps (1.52 mps)	40
SD-5	Recommended Flow Rates for Cleaning Vertical Cylindrical Vessels Having Dished Heads	40
SD-6	Transfer Panel and Jumper Tolerances	44
DT-1	Nominal OD Tubing Sizes	50
DT-2	Hygienic Unions	51
DT-3	Chemical Composition for Automatic Weld Ends, %	51
DT-4	Tangent Lengths	51
DT-5	Final Tolerances for Mechanically Polished Fittings and Process Components	52
DT-5.1	Hygienic Clamp Ferrule Standard Dimensions and Tolerances	53
DT-6	Final Tolerances for Electropolished Fittings and Process Components	54
DT-7	Automatic Tube Weld: 90 deg Elbow	54
DT-8	Automatic Tube Weld: 45 deg Elbow	54
DT-9	Automatic Tube Weld: Straight Tee and Cross	55
DT-10	Automatic Tube Weld: Reducing Tee	55
DT-11	Automatic Tube Weld: Concentric and Eccentric Reducer	56
DT-12	Automatic Tube Weld: Hygienic Clamp Joint, 90 deg Elbow	56
DT-13	Automatic Tube Weld: Hygienic Clamp Joint, 45 deg Elbow	57
DT-14	Automatic Tube Weld: Short Outlet Hygienic Clamp Joint Reducing Tee	57
DT-15	Automatic Tube Weld: Short Outlet Hygienic Clamp Joint Tee	58
DT-16	Hygienic Clamp Joint: 90 deg Elbow	58
DT-17	Hygienic Clamp Joint: 45 deg Elbow	59
DT-18	Hygienic Clamp Joint: Straight Tee and Cross	59
DT-19	Hygienic Clamp Joint: Reducing Tee	60
DT-20	Hygienic Clamp Joint: Short Outlet Reducing Tee	60
DT-21	Hygienic Clamp Joint: Concentric and Eccentric Reducer	61
DT-22	Automatic Tube Weld: Ferrule	62
DT-23	Automatic Tube Weld: 180 deg Return Bend	63
DT-24	Hygienic Clamp Joint: 180 deg Return Bend	63
DT-25	Hygienic Mechanical Joint: Short Outlet Run Tee	64
DT-26	Hygienic Clamp Joint: Tube Weld Concentric and Eccentric Reducer	64

DT-27	Hygienic Clamp Joint: Short Outlet Tee	65
DT-28	Automatic Tube Weld: Instrument Tee	65
DT-29	Hygienic Clamp Joint: Instrument Tee	65
DT-30	Automatic Tube Weld: Cap	65
MJ-1	Acceptance Criteria for Welds on Pressure Vessels and Tanks	68
MJ-2	Acceptance Criteria for Welds on Pipe	69
MJ-3	Acceptance Criteria for Welds on Tube	70
SF-1	Acceptance Criteria for Product Contact Surface Finishes of Tubing	77
SF-2	R_a Readings for Tubing	77
SF-3	Acceptance Criteria for Product Contact Surface Finishes of Fittings	78
SF-4	R_a Readings for Fittings	78
SF-5	Acceptance Criteria for Product Contact Surface Finishes of Valve Bodies	79
SF-6	R_a Readings for Valves	79
SF-7	Acceptance Criteria for Product Contact Surface Finishes of Vessels	80
SF-8	R_a Readings for Vessels	80
SF-9	Acceptance Criteria for Product Contact Surface Finishes of Other Process Components	81
SF-10	R_a Readings for Other Process Components	81
SG-1	Common Rotary Seal Materials for Biochemical and Sterile Service	88
PM-1	Size Comparison of Common Thermoplastic Sizing Standards	96
Nonmandatory Appendices		
A	Commentary: Slag	103
B	Material Examination Log and Weld Log	104
Index	109